



User Instruction for estimation of CABAS Heavy Paint



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1. Preface

Trucks, buses and construction vehicles are included in the term *heavy vehicles*. Vehicles that are less than: length 5.5 m, width 2.5 m, total height 2.0 m, and that can be painted in a spray booth for passenger cars, must not be handled as heavy vehicles. Normal professional execution of painting is assumed. The times specified in the list are expressed in *periods* (1 hour = 100 periods). The time for dismantling and installing components for the execution of painting work is not included in the time standard for paint.

2. Paint type subdivision

Paint type 1	Paint type 2
Single layer solid paint	Double layer paint

3. Setup times

External painting, heavy vehicles	220 periods
Painting of loose component(s) only	110 periods
Painting of loose cab	220 periods

4. Calculation of time (surface factors)

4.1 External painting, cab

The painting surface can be found in CABAS or be calculated by measuring the surface in dm².

Paint type 1	Paint type 2
Surface in dm ² x 0.83 periods	Surface in dm ² x 1.00 periods

4.2 Other external painting:

4.2.1 Front protection

The surface is measured as follows: Length x Width x 2 = Surface in dm²

4.2.2 Timed on a case-by-case basis:

Triple layer painting.

Effect and motif painting.

Basic painting such as concrete skips, dumpers, plant, etc.



4.3 Cabinets and similar:

4.3.1 Paint type 1 or similar paint structure is timed as follows:

Up to 5 m ²	Surface in dm ² x 0.66 periods
From 5.1 m ² - 15 m ²	Surface in dm ² x 0.44 periods
Over 15 m ²	Surface in dm ² x 0.33 periods

4.3.2 Paint type 2 is timed as follows:

Up to 5 m ²	Surface in dm ² x 0.88 periods
From 5.1 m ² - 15 m ²	Surface in dm ² x 0.66 periods
Over 15 m ²	Surface in dm ² x 0.44 periods

5. Internal painting

Internal painting is timed as follows:

A-pillar	30 periods
B-pillar	30 periods
Door incl. door extension	50 periods
Sill (step)	30 periods
Roof edge (windscreen frames)	30 periods

Other internal painting is time at 50% of the external surface.

The above times are generated automatically when selecting internal painting in CABAS.

6. Coarse filling

6.1 Coarse filling

When filling surface aligned parts to their original shape sufficient quality from the sheet metal workshop is assumed.

Grinding with sanding paper P120 counts as coarse filling, sanding with finer paper counts as fine sanding.

Calculation of coarse filling:

- Setup time 35 [periods / objects]
- Surface factor 6,680 [periods / dm²]

The surface of the coarse filling is calculated with the MYSBY system in the sheet metal workshop (damage surface).

Coarse filling is added via a manual row in CABAS.



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6.2 Table of times for coarse filling

Area [dm ²]	Time [periods]
1	42
2	48
3	55
4	62
5	68
6	75
7	82
8	88
9	95
10	102
11	108
12	115
13	122
14	129
15	135

7. Colour supplement

Colour supplements are added when more than one colour is being painted at one and the same time.

In order to count as a colour supplement, the painting must not be able to be attributed to banding or decor/motif painting. Colour supplements are applied for each colour-changed surface with 10% of the component(s) being painted in more than one colour, although at least 60 periods.



8. Chassis with components, equipment as well as construction

The painting of the above is handled under “**Alternative painting**” in CABAS.
Repair painting (partial painting) is timed at 70 periods / m².

8.1 During repairs:

Mechanical or chemical cleaning is timed as follows:

Setup time 110 periods

Up to 2.0 m ²	60 periods / m ²
Over 2.0 m ²	35 periods / m ²

9. Other

The following actions (excl. materials) are timed on a case-by-case basis and handled under “Alternative painting” in CABAS:

Decor, banding and cleaning

Dismantling/installation of decor, figures and company emblems etc. made of tape.

Banding refers to colour changes that are created with a brush, banding machine or banding tape.

Extra cleaning such as steam-cleaning of the chassis before painting as well as cleaning and washing after painting.

10. General

The timing for painting heavy vehicles origins from Calculos LB-data.



11. Change log

Doc.	Version	Date	Change	Issued by
CABNET-904420094-1061	1.0	12-02-2021	New document. Translated from Swedish document CABNET-904420094-180.	Markus Carlén
CABNET-904420094-1061	2.0	16-02-2021	10. General: Clarified origin of times.	Markus Carlén