PRIMER SURFACER, CONDUCTIVE - THERMOPLASTIC SUBSTRATES - LOW GLOSS (EXTERIOR) **ESB-M6J127-A**

PRIMER SURFACER, CONDUCTIVE - THERMOPLASTIC SUBSTRATES - HIGH GLOSS (EXTERIOR) **ESB-M6J127-B**

1. SCOPE

The materials defined by this specification are conductive primer surfacers with good adhesion to thermoplastic substrate surfaces and good enamel holdout.

2. APPLICATION

These specifications were released originally for material used as primer surfacers for thermoplastic substrates, followed by exterior acrylic enamel color coat. The primers are defined as follows:

Type I Low bake - 25 min at 71 °C

Type II Regular bake - 30 min at 149 °C

3. REQUIREMENTS

The materials shall meet all detailed requirements of this specification. Tests shall be made on the basis of comparison with approved production material, applied and tested under identical conditions.

3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 COMPOSITION

3.2.1 Non-Volatile, min 25%
(FLTM BI 102-01)

3.2.2 Toxicity

The material shall be non-toxic and shall not cause skin rash or irritation (dermatitis) to exposed handlers in normal production operations.

Benzene and chlorinated hydrocarbon solvents are considered toxic and their use is strictly prohibited in compounding material to this specification.

3.3 PHYSICAL PROPERTIES

3.3.1 Weight Per Volume, min 8.55 lb/gal (1.03 kg/l)
(FLTM BI 002-02)

Date	Action	Revisions
2008 04 23	Revised	Revised 4; Format Updated
2002 07 26	Revised	Updated & Renumbered
1972 02 23	Released	AB1-810

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3.3.2 Viscosity (FLTM BI 111-01) — 30 - 80 s

3.3.3 Stability (FLTM BI 102-03)

The material shall not jell, settle hard or increase in viscosity in excess 10 s.

3.4 PREPARATION OF TEST PANELS
(FLTM BI 103-02, Method "C", with the following exceptions)

Panels: Thermoplastic substrate panels of any convenient size. A smooth surface with no glass pattern, pits or blow holes is required. Wipe panels with naphtha followed by isopropanol before applying primer.

Primer: Reduce to 22 +/- 2 s #4 Ford Cup using the reducer recommended by the supplier. Spray 0.0008 - 0.0012 in (20 - 30 µm) dry film thickness.

Sand 1/2 of panel.

Type I	Bake 25 min at 71 °C
Type II	Bake 30 min at 149 °C

Color Coat ESB-M50J100 Quality: ESB-M32J101 Quality

3.5 APPEARANCE

3.5.1 Color — Black or Gray

3.5.2 Leveling

The primer film shall level with a min of orange peel. The surface of the material under test shall be equal to or better than current approved production material for smoothness when applied and baked under identical conditions.

3.5.3 Holdout

There shall be no evidence of dulling or strike-in when enamel color coat applied over sanded and unsanded primer surfacer, and no difference in gloss of the color coat between sanded and unsanded primer. There shall be no prominence of sand scratches.

3.5.4 Gloss
(FLTM BI 110-01, 60° Glossmeter)

ESB-M6J127-A (Types I & II), max	40
ESB-M6J127-B (Types I & II), min	60

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