



PRIMER, WELDING - ZINC RICH, SOFT SETTLING TYPE - SPRAY - NON-EXEMPT SOLVENT	ESB-M6J74-A
PRIMER, WELDING - ZINC RICH, SOFT SETTLING TYPE - BRUSH - NON-EXEMPT SOLVENT	ESB-M6J75-A
PRIMER, WELDING - ZINC RICH, SOFT SETTLING TYPE - SPRAY - EXEMPT SOLVENT	ESB-M6J107-A
PRIMER, WELDING - ZINC RICH, SOFT SETTLING TYPE - BRUSH - EXEMPT SOLVENT	ESB-M6J108-A

NOT TO BE USED FOR NEW DESIGN**1. SCOPE**

These specifications were released originally for materials used as high metallic zinc content welding primers which consist primarily of metallic zinc dust or flake, an organic resin vehicle, and additives to prevent settling and chemical reactions during storage. The pigment particles shall be of sufficient fineness that the material may be sprayed utilizing high pressure airless spray equipment without clogging the nozzle orifices normally used in production. Two types of primers containing non-exempt or exempt solvents are defined and may be utilized interchangeably in production as follows:

Type I	High Solids
Type II	Low Solids

2. APPLICATION

These primers are generally used as anti-corrosion primers on fabricated sheet metal parts prior to assembly and welding. They are available in the following colors for processing control:

Gray - Basic Color	Light Green
Light Blue	Light Blue - Green

Exempt solvent materials are used when conformance to the legal requirements of air pollution control authorities is mandatory for an assembly plant or other painting facility.

3. REQUIREMENTS**3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS**

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

3.1 PHYSICAL PROPERTIES

	<u>Type I</u>	<u>Type II</u>
3.1.1 Non-Volatile Content; Percent Min By Weight (FLTM BI 102-01)	82	72
3.1.2 Metallic Zinc Content; Percent Min of Non- Volatile Content (FLTM AI 001-01)	90	83

Date	Action	Revisions	Rev 03
2012 05 10	N Status	No usage or replacement	N. Benipal, NA
2008 04 17	Revised	Inserted 3.0; Deleted 3.11 & 4	
1963 09 20	Released	AS1-1095	





ESB-M6J74-A
ESB-M6J75-A
ESB-M6J107-A
ESB-M6J108-A

	Type I	Type II
3.1.3 Weight per volume min, lb/gal(kg/l) at 23 +/- 2 °C (ASTM D 1475)	21 (2.52)	16 (1.92)
3.1.4 Viscosity (FLTM BI 111-01)		
. Sprayable Primer	24 - 30 s	
. Brushable Primer	60 - 70 s	
3.1.5 Flash Point, min (ASTM D 56)		
ESB-M6J74-A, ESB-M6J75-A	27 °C	
ESB-M6J107-A, ESB-M6J108-A	17 °C	
3.1.6 Storage Stability		

The material shall not jell, settle hard or have a viscosity change from the original in excess of 20 s when left undisturbed for 60 days at 23 +/- 2 °C.

Note: Conformance to this requirement is mandatory for all new materials submitted for engineering approval and for all production material supplied to the company and subsequently stored under the above conditions. This is not required as routine control test.

- 3.1.7 Gassing
(FLTM BI 102-03, 72 h)
- Shall not gas.

3.2 PREPARATION OF TEST PANELS (FLTM BI 103-04)

Control panels using current approved production material will be concurrently prepared and tested per paragraph 3.3, 3.4, and 3.5.

3.2.1 Drying

Material shall dry to handle in 10 min at 23 +/- 2 °C. For film property and resistance tests, material shall be baked 15 min at 177 +/- 2 °C, followed by 45 min at 149 +/- 2 °C.

For weldability and zinc phosphate wash-off tests, the material shall be air dried only for 72 h at 23 +/- 2 °C.

3.2.2 Aging

Baked panels shall be aged 72 h at 23 +/- 2 °C before running adhesion or resistance tests.

