



PAINT, COLOR COAT ACRYLIC PLASTIC - FIRST SURFACE - EXTERIOR

ESB-M99J250-A

**PAINT, COLOR COAT ACRYLIC OR POLYCARBONATE PLASTIC -
FIRST SURFACE - EXTERIOR**

ESB-M99J250-B

1. SCOPE

The materials defined by these specifications are pigmented lacquers or enamels suitable for first surface applications to polycarbonate or acrylic plastic.

2. APPLICATION

These specifications were released originally for materials as first surface finishes for decorative exterior polycarbonate or acrylic plastic lens or grille applications.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

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

3.1 COMPOSITION

Shall be acrylic lacquers or synthetic enamels pigmented to match the desired color. The materials shall be properly formulated to provide good adhesion without crazing or damaging the plastic substrates in any manner.

3.2 PHYSICAL PROPERTIES

3.2.1 Non-Volatile Solids (FLTM BI 102-01)

To be established by the supplier on the initial approved production batch. Tolerance to be +/- 2.0%.

3.2.2 Viscosity (FLTM BI 111-01, #4 Ford Cup)

Shall be established by the supplier on the initial approved production batch. Tolerance shall be +/- 5 s.

3.2.3 Stability (FLTM BI 102-03)

Shall not liver or jell upon standing and must be free from settling which is not dispersed by normal agitation. The viscosity of the material shall not increase more than 10 s.

Date	Action	Revisions
2005 09 12	Revised	Inserted 3.0; Deleted 3.7, 4
1978 11 17	Metricated & Retyped	CAH1-RD572066-1
1967 02 28	Released	AW1 #851

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3.2.4 Hiding
(FLTM BI 101-02)

Solid colors shall provide complete opacity at 0.0010 in (25 μm) film thickness.
Translucent colors shall be equal to approved samples.

3.3 PREPARATION OF TEST PANELS

Prepare panels per FLTM BI 103-02, Method "E" except use plastic in place of steel. In addition to the requirements in the test method, the following shall apply:

3.3.1 Substrate

Acrylic and polycarbonate plastic (See para 5.3).

3.3.2 Reducing Thinner

As recommended by supplier.

3.3.3 Spray Viscosity
(FLTM BI 111-01, #4 Ford Cup)

15 - 20 s

3.3.4 Film Thickness
(FLTM BI 117-01)

0.0010 - 0.0015 in
(25-38 μm)

3.3.5 Drying

When work area is properly ventilated and a temperature of 23 +/- 2 °C is maintained, the material shall dry dust free in 25 min.

3.3.6 Aging

All panels shall be aged 24 h minimum at 23 +/- 2 °C minimum before testing.

3.4 APPEARANCE

3.4.1 Color

Shall match the Ford Motor Company master panel approved by Styling.

3.4.2 Gloss
(FLTM BI 110-01)

Shall be specified by means of a letter suffix to the color number assigned by Styling, as follows:

A	92 min	F	35 +/- 3
B	80 +/- 4	G	20 +/- 3
C	70 +/- 4	H	10 +/- 3
D	62 +/- 3	J	6 max
E	50 +/- 3		