



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PAINT, COLOR COAT FOR MODIFIED POLYPHENYLENE OXIDE,
INTERIOR

ESB-M99J277-A

1. SCOPE

The material defined by this specification is a pigmented lacquer suitable for first surface application to modified polyphenylene oxide.

2. APPLICATION

This specification was released originally as a decorative first surface finish for interior plastic parts.

3. REQUIREMENTS

3.1 STATISTICAL PROCESS

Suppliers must conform to the requirements of Ford Quality System Standard Q-101. A mutually acceptable Control Plan as described therein is required for material/source approval. Appropriate statistical tools must be used to analyze process/product data so that variation in the final product is continuously reduced.

3.2 CONDITIONING AND TEST CONDITIONS

All test values indicated herein are based on material conditioned in a controlled atmosphere of 23 +/- 2 °C and 50 +/- 5 % relative humidity for not less than 24 h prior to testing and tested under the same conditions unless otherwise specified.

3.3 INFRARED SPECTROPHOTOMETRY AND/OR THERMAL ANALYSIS

Ford Motor Company, at its option, may conduct infrared and/or thermal analysis of material/parts supplied to this specification. The IR spectra and thermograms established for initial approval shall constitute the reference standard and shall be kept on file at the designated material laboratory. All samples shall produce IR spectra and thermograms that correspond to the reference standard when tested under the same conditions.

3.4 COMPOSITION

The material shall be an acrylic lacquer pigmented to match the desired color. The material shall be properly formulated to provide good adhesion without crazing or damaging the plastic substrate in any manner.

Date	Release No.	Release/Revision
1991 03 20	NE00E10043064041	Revised K. P. Minnich <i>KPM</i> <i>D. W. Moriarty</i>
1978 11 17	CAH1-RD572066179	Metricated and Retyped EAS JTP
1971 09 21	AB1-210	Released

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3.5 PHYSICAL PROPERTIES

3.5.1 Non-Volatile Solids, min
(FLTM BI 102-01)

To be established by the vendor on the initial approved production batch. Tolerance shall be $\pm 0.5\%$.

3.5.2 Viscosity
(FLTM BI 11-2, #4 Ford Cup)

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

3.5.3 Dry Hiding
(FLTM BI 101-03)

The visual hiding is over a black and grey checkerboard.

Black, Non-metallic	18 - 22 micrometre
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Metallic	18 - 22 micrometre
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Blue, Red (Thixotropic)	25 - 30 micrometre
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3.5.4 Solvents

All solvents used shall be noncarcinogenic in nature.

3.5.5 Stability
(6 months at 23 ± 2 C)

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 change more than 10 s.

3.5.6 Specific Composition:

The supplier will furnish such data upon request.

3.6 PREPARATION OF TEST PANELS

3.6.1 Substrate

All test specimens shall be injection molded plaques or parts having a nominal thickness of 2.5 ± 0.2 mm.

3.6.2 Substrate Preparation

All test specimens shall be free of mold release agents, finger prints, oils, dirt and any other detrimental surface contamination.

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