

ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

INK, MARKING, FLUID TYPE

ESF-M6B8-A

1. SCOPE

The material defined by this specification is a fluid type, quick drying marking ink with good adhesive properties for use in automatic printers.

2. APPLICATION

This specification was released originally for material used for marking identification on alternators, heater motors, windshield wiper motors, etc.

3. REQUIREMENTS

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 SOLIDS, min (FLTM BI 102-01)

Percent solids by weight varies with color as follows:

Tangerine	29%	Maroon	12%
Blue	12%	Silver	25%
Black	23%	Red	13%
Violet	13%	Orange	35%
Brown	12%	White	38%
Green	12%	Yellow	35%

3.3 VEHICLE

Percent vehicle by weight not less than 7-1/2%.

3.4 COLOR

To be specified on Engineering Drawing.

Date	Action	Revisions
2002 08 26	Revised	Updated and renumbered
1978 06 12		Metricated and Retyped CF4H-RD 567168-21
1964 06 30		Released F6-1393

Printed copies are uncontrolled

3.5 STABILITY

There shall be no setting, livering or curdling of the material after being stored for 30 days in a 3/4 filled, sealed container at 23 +/- 2 °C. (Some materials will tend to settle in storage, but must be readily re-dispersed).

3.6 TOXICITY

The material shall not contain any benzol, benzene, aniline oil or hydrolizable chlorinated hydrocarbons, nor will it have an obnoxious or objectionable odor.

3.7 QUALITY

The material shall be free from dirt, lumps and skins, shall adhere readily to painted and unpainted surfaces and be miscible with the recommended thinner (denatured ethyl alcohol, M-1044-C).

3.8 RESISTANCE PROPERTIES

- Must be resistant to grease, water, oil, gasoline and alcohol when thoroughly dry.
- Tangerine, Silver, White, Yellow, Black and Red must withstand 175 °C for 5 hours minimum with only slight darkening.
- Blue, Brown, Green, Maroon, Violet and Orange fade at 175 °C after 2 hours, but must retain legibility of color.