



SEALER, PVC, PRIMER OVEN CURING, PAINTABLE

ESK-M4G297-A

SEALER, PVC, PRIMER OVEN CURING, PAINTABLE

ESK-M4G297-A2

SEALER, PVC, PRIMER OVEN CURING, PAINTABLE

ESK-M4G297-A3

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ESK-M4G297-A4

1. SCOPE

The material defined by this specification is a solvent release, heat curing, stone peck resistant PVC sealer for exterior body areas.

2. APPLICATION

This specification was release originally for material used as a stone peck protective coating for wheel house lip. The material is applied by a foam roller or airless spray on baked electrocoat in a wet film thickness of approx. 160 - 320 micrometer wet on wet with spray primer.

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 TEST PANEL PREPARATION

Use 300 x 100 x 0.8 - 0.9 mm E-coated test panels according to FLTM BI 120-01. The sealer must be applied on the cured E-coated test panel within 30 minutes after oven curing.

3.3 COLOR

grey

3.4 SOLIDS

(FLTM BV 150-10)

97.0 min

3.5 ASH

(FLTM BV 150-10)

28.0 max

3.6 FLASH POINT

(ASTM D 93, Method A)

100 °C min

Note: In case testing at higher temperatures is not feasible because of gelling of test material, the supplier must certify in writing that each separate volatile ingredient has a flash point above 100 °C.

Date	Release No.	Revision	Rev. 2
2011 07 13	Revised	Odor Requirements added	W. Janitschke, EU
1993 02 01	EP00E10258804000	Revised A 3.9. released A2. A3. A4	W. Schel
1987-12-18	SM/EQ1579 TP	Release	



Documents

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3.7 DENSITY AT 20 °C
(ASTM D 1475)1.29 g/cm³ max**3.8 VISCOSITY AT 20 °C**
(Brookfield viscometer type RVT/D, No. 6 spindle)

Test Method

1. Condition material under test to 20 °C.
2. Stir material for 1 min by spatula.
3. Let the material rest for 30 min.
4. Insert spindle into material and start measuring with undisturbed material at a frequency of 2.5/min; measuring time 3 min.
5. Continue measuring in the same way at frequencies of 5.0/min and 10.0/min.

3.8.1	As received, Pa·s				+/- 10%
		A	A2	A3	A4
	at 2.5/min	25.0	60.0	100.0	130.0
	at 5.0/min	19.0	40.0	60.0	80.0
	at 10.0/min	15.0	30.0	40.0	5.0

3.8.2	After Aging, Pa·s				+/- 20 %
	(120 h at 35 +/- 2 C)				
	at 2,5/min	33.0	75.0	140.0	220.0
	at 5,0/min	26.0	55.0	85.0	130.0
	at 10,0/min	21.0	40.0	65.0	100.0

3.9 SURFACE CONDITION AFTER AGING

The material shall be dry to the touch after cooling to 23 +/- 2 °C. It shall be free from cracks or bubbles and shall show a uniform closed paint film without staining or discolouration. After bending 90 deg around a mandrel of 100 mm dia. within 2 s (see FLTM BV 153-4) there shall be no evidence of chipping or loss of adhesion between the various layers.

Test Method

1. Test panels per para 3.2., shall be coated with the material under test in such a manner (template 30 mm wide) that after curing a dry coating thickness of 150 - 300 micrometer is obtained.
2. After 10 min at 23 +/- 2 °C, coat specimens wet on wet with production epoxy spray primer, to a dry film thickness of 25 - 35 micrometer.
3. After 10 min at 23 +/- 2 °C, cure specimens separately according to FLTM BV 150-5, for each applicable region: a) Min. Curing Cycle b) Max. Curing Cycle.
4. After 10 min at 23 +/- 2 °C, spray separate specimens with light colored standard and metallic top coat enamel to a coating thickness of 30 - 40 micrometer.
5. After 10 min at 23 +/- 2 °C, cure specimens separately according to FLTM BV 150-5, for each applicable region: a) Min. Curing Cycle b) Max. Curing Cycle.

