



DRAFT ENGINEERING MATERIAL SPECIFICATION

PRIMER, ADHESION, ONE PACK, POLYPROPYLENE PLASTICS, GREY, 15 MICROMETER

ESK-M6J157-A

1. SCOPE

The material defined by this specification is a solvent based high flexible adhesion primer for polypropylene plastics.

2. APPLICATION

This specification was originally released for material used as adhesion primer for polypropylene bumpers (see also 4.3).

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 COMPOSITION

3.2.1 Resin: Synthetic resins

3.2.2 Pigments: Pigments to obtain the desired properties for the adhesion primer.

3.3 MATERIAL PROPERTIES

3.3.1 Non-volatile (FLTM BI 102-01) see Initial Sample +/- 1 %;
min. 35 %

The non-volatile content shall be determined at a spray viscosity of 20 s according to para 3.3.4.

3.3.2 Density (ASTM D 1475) see Initial Sample +/- 0.02 g/mL

3.3.3 Viscosity as supplied (FLTM BI 111-01) see Initial Sample +/- 5 s

3.3.4 Spray Viscosity (FLTM BI 111-01, FC #4) as specified by the supplier

The material can be reduced with Xylene, Butyl acetate or any other suitable thinner.

Date	Action	Revisions	Rev 03
2014 06 10	Reactivated	See Summary of Revisions	M. Corley, EU
2012 05 15	N Status	No usage or replacement	N. Benipal, NA
1989-11-07	SM/EQ 4967 TP	Release	K.Wolters D-MB/PQ-13

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3.3.5 Storage Stability

3.3.5.1 Heat Stability (FLTM BI 102-03)

Paint shall not jell, settle hard or increase viscosity in excess of 10s

3.3.5.2 Stability after aging

During storage of 90 days between 5 °C and 32 °C temperature the material as supplied shall not settle up or cake insoluble. After the storage the material must pass all specification requirements.

3.4 PREPARATION OF TEST PANELS

3.4.1 Substrate

Polypropylene as specified on Engineering Drawing. All tests shall be performed on panels with a smooth, ungrained surface.

3.4.2 Plastic Preparation (see also 4.1)

The surface to be painted shall be cleaned by an acceptable process, e.g. power wash, to remove mold releasing agents, fingerprints, oils, dirt and moisture.

3.4.3 Adhesion primer application

Dry film thickness:	15 - 25 micrometer
Flash off:	10 minutes at room temperature
Baking:	not required

3.4.4 Primer Surfacer (if required)

Wet on wet application of a primer surfacer, film thickness and baking as specified in the relevant material specification.

3.4.5 Top coat application

Application of currently used two pack high flexible top coat systems, film thickness and baking as specified in the relevant material specification.

3.4.6 Ageing

Test panels prepared under this specification shall be aged for at least 168 h at 23 +/- 2 °C or 16 h at 45 +/- 1 °C before testing for resistance properties.

3.5 APPEARANCE (Primer only)

3.5.1 Color light grey (FLTM BI 109-01)