



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PRIMER, REPAIR, AIR DRYING, WATER BASED BASECOAT

ESK-M6J9566-A2

1. SCOPE

The material defined by this specification is a solvent borne air drying repair primer surfacer.

2. APPLICATION

This specification was released originally for material used as spot repair primer on interior and exterior surfaces of vehicle bodies.

The primer is used over current production primer surfacer and on areas sanded through to bare metal.

The primer is designed for use with waterbased basecoats and solvent based solid colour topcoats but is also suitable for use in combination with solvent borne basecoats.

The material is suitable for electrostatic spray application.

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 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.

3.3 CONDITIONING

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.

3.4 COMPOSITION

3.4.1 Resin: Synthetic resins.

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1991-03-01	C01089482000	Released KW conc. J.Schult

WP 3948-a

Page 1 of 5

9009160 0037759 T16



- 3.4.2 Pigments: Pigments to obtain the desired colour, mechanical resistance and corrosion protection.

3.5 MATERIAL PROPERTIES

- 3.5.1 Non-volatile (FLTM BI 102-01) see Initial Sample +/- 1 %;
min 48 %

The non-volatile content shall be determined at a spray viscosity of 40 s according to para 3.5.4.

- 3.5.2 Density (ASTM D 1475) see Initial Sample +/- 0,02 g/mL

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

- 3.5.4 Spray Viscosity (FLTM BI 111-01, FC #3) as specified by the supplier

The primer can be reduced with Thinner S-M14J210-A or equivalent.

- 3.5.5 Storage Stability: 90 days

During a storage of 90 days between 5 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.

3.6 PREPARATION OF TEST SPECIMEN

- 3.6.1 Preparation of Test Panels (FLTM BI 103-02, Method A)

Substrate: Standard Steel Panels UMA18005.

Primer:

Dry film thickness: 20 - 25 micrometre;

Air drying: 15 minutes.

Sanding:

After air drying, the primer shall be sanded and wiped off with cleaning petrol

Top Coat:

Application of Ford Engineering approved current production top coat materials, film thickness and baking as specified in the relevant Material specification.

Colours: Two coat silver metallic and solid colour black and white.