



TWO PACK STONEPECK RESISTANT TOPCOAT

ESK-M99J312-A

TWO PACK STONEPECK RESISTANT TOPCOAT

ESK-M99J312-B

1. SCOPE

The materials defined by these specifications are two pack stonepeck resistant topcoats, suitable for exterior exposure.

2. APPLICATION

The materials will be pneumatic or airless applied with 2K spray equipment on baked enamel on lower body areas where high stonepeck resistance is required. The materials have to be used in combination with aliphatic polyisocyanate hardener ESK-M99J313-A.

The materials are as well curing by baking as by air drying. In general, ESK-M99J312-A is textured whereas ESK-M99J312-B is not textured and preferably used for air drying, forced air drying or infrared drying repair.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.1 COMPOSITION

3.1.1 Vehicle

Polyester, containing hydroxyl groups capable of reaction with polyisocyanate. For special effects, the additional use of polyamide powders is permitted.

3.1.2 Pigments

Inert pigments and fillers to provide the desired color. The use of non-inert pigments or fillers, e.g. zinc oxyde, zinc sulfide, calcium carbonate, is not permitted.

3.1.3 Special Data

All initial sample and batch submissions must indicate density (ASTM D 1475) and non-volatile content (FLTM BI 102-01) of material as supplied on sample report.

3.2 PHYSICAL PROPERTIES

3.2.1 Non-Volatile (FLTM BI 102-01)

According to approved initial sample report +/- 1%, but minimum 70%.

Date	Action	Revisions
2005 08 29	Revised	Inserted 3.0; Revised 3.8, Deleted 3.9 and 4
1994 12 06		Revised and Retyped, was 12 pages
1983 04 21	Last release	SM/EQ 5352 TP



3.2.2 Density
(ASTM D 1475)

According to approved initial sample report +/- 0.05, preferably 1.40.

3.2.3 Package Viscosity

1400 +/- 100 mPa.s/20 °C using a rotation viscometer.

3.2.4 Shelf Stability

During a storage of 3 months at room temperature, the material as received shall not gel or liver upon standing and must be free from settling which cannot be dispersed by normal agitation.

3.2.5 Mixing Ratio with Hardener

ESK-M99J312-A/B and aliphatic polyisocyanate hardener ESK-M99J313-A as specified by vendor, preferably 10:1 (by weight).

ESK-M99J312-A/B and ESK-M99J313-A shall be of same source.

The material shall be ready for spray application after mixing.

3.2.6 Pot Life

Minimum 3 h at 20 °C.

Minimum 1 h at 30 °C.

3.3 PREPARATION OF TEST PANELS
(FLTM BI 103-02, Section Bb)

Use materials according to the latest production status and bake according to the valid material specification. For repair air dry the material.

3.3.1 Baking Enamels to be Used

3.3.1.1 S-M32J100-E and/or SK-M98J9552-A

Lightest and darkest solid color of each manufacturer supplying to the plant where ESK-M99J312-A/ESK-M99J313-A are intended for use.

Do not sand test panels.

3.3.1.2 S-M32J110-A/B/SK-M32J9553-A

Silver metallic basecoat and clearcoat of that manufacturer supplying to the plant where ESK-M99J312-A/ESK-M99J313-A are intended for use.

Do not sand test panels.