



PRIMER FOR PLASTICS, ELASTIC

ESK-M99J329-A

1. SCOPE

The material defined by this specification is an elastic air drying primer for exterior plastic parts which shall be painted at dealer locations.

2. APPLICATION

This specification was released originally for material which is used as an elastic primer for all plastic parts except EPDM/PP or PE prior to application of top coats.

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 Synthetic resin

3.1.2 Pigments

Inert pigments in an amount to provide sufficient film properties.

3.2 PHYSICAL PROPERTIES

3.2.1 Non Volatile
(FLTM BI 102-01)

According to initial sample report +/- 1, but minimum 25%.

3.2.2 Viscosity as Received
(FLTM BI 111-01)

According to initial sample report +/- 5 s.

3.2.3 Spray Viscosity

If required, dilute with ESK-M14J233-A as recommended by supplier.

Date	Action	Revisions
2005 08 15	Revised	Inserted 3.0; Revised 3.7, Deleted 3.8 and 4
1994 12 13	Revised & Retyped	Was 4 pages
1985 03 12	Released	SM/EQ 5529 TP





3.2.4 Flash Point

The flash point shall conform to the safety regulations applicable to the workshop or plant where the material shall be used.

3.2.5 Density (ASTM D 1475)

According to initial sample report +/- 0.02.

3.2.6 Shelf Stability

During a storage of 12 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. The viscosity of the material shall not increase in excess of 10 seconds when tested according to FLTM BI 102-03.

3.3 PREPARATION OF TEST SPECIMENS

3.3.1 Substrate

Actual plastic substrate as quoted on Engineering drawing.

3.3.2 Cleaning

Careful removal of dirt, fingerprints or sanding residues with suitable solvents or process.

3.3.3 Application

Dilute to spray viscosity according to supplier's notice, if necessary. Apply material to a dry film thickness of 20 to 30 micrometer.

Drying: 15 minutes at room temperature.

3.4 COLOR

Preferably grey

3.5 ENAMELING

Apply intended enamel system according to relevant material specification.

3.6 FILM AND RESISTANCE PROPERTIES

Handle testing according to relevant material specification.

3.7 SUBSTANCE CONTROL

Legal, health, safety and environmental constraints may apply to the materials which are submitted for approval to this specification. Refer to Engineering Material Specification WSS-M99P9999-A1.