



STONE PECK RESISTANT ONE PACK MATERIAL

ESK-M99J340-A

1. SCOPE

The material defined by this specification is a one pack stone peck resistant topcoat, suitable for exterior application.

2. APPLICATION

This specification was released originally for material used as decorative stone peck resistant topcoat on baked enamel on lower body side areas. The material will be applied by airless or pneumatic spray equipments. For catalysed repair the material is used in combination with ESK-M99J341-A Hardener.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

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).

3.2 COMPOSITION

3.2.1 Vehicle Polyester melamine resin

For special effects the additional use of polyamide structure powders is permitted.

3.2.2 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.

3.2.3 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.

3.3 PHYSICAL PROPERTIES

3.3.1 Non-Volatile (FLTM BI 102-01) 68 +/- 1%

3.3.2 Density (ASTM D 1475) 1.25 +/- 0.05 g/cm³

Date	Action	Revisions
2006 03 08	Revised	Inserted 3.0; Deleted 3.1, 3.10, 4
1995 02 02	Revised & Retyped	Was 6 pages
1986 06 20	Released	SM/EQ5608TP





3.3.3 Package Viscosity

700 +/- 100 mPa.s at 20 °C using a rotation viscosimeter.

3.3.4 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.

3.4 PREPARATION OF TEST PANELS

(FLTM BI 103-02, section Bb)

Use the materials according to the latest production status and bake according to the valid material specification.

3.4.1 Baking Enamels to be used

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

Lightest and darkest solid color of each manufacturer supplying to the plant where ESK-M99J340-A is intended for use. Do not sand test panels.

3.4.1.2 S-M32J110-A/B; SK-M32J9553-A

Silver metallic basecoat and clearcoat of that manufacturer supplying to the plant where ESK-M99J340-A is intended for use. Do not sand test panels.

3.4.2 Application of ESK-M99J340-A

1 hour after enamel baking panels are treated as follows:

Apply material under test to a dry film thickness of 150 - 200 micrometers using pneumatic or airless spray equipments.

Flash-off 3 minutes at room temperature.

Bake 10 minutes/130 °C metal temperature.

3.5 REPAIR REQUIREMENTS

3.5.1 Repair Using Acid Catalyst

The enamel system shall show satisfactory color match, gloss and intercoat adhesion on the baked finish. Addition ratio of the hardener ESK-M99J341-A as specified by vendor, preferable 3 to 5% (by weight).

Bake 10 minutes at 100 °C metal temperature.