



PAINT QUALITY, EXTERIOR TEXTURED AND NON-TEXTURED - LOW GLOSS AIR DRY

ESR-M2P92-A

1. SCOPE

This specification defines the performance and product requirements for an air dry service repair material for automotive exterior textured and non-textured low gloss finishes. This specification is not intended to limit the service repair finish to any particular material or material system, but rather defines the performance of the entire system as applied per labeling directions to be provided by each supplier. The term "low gloss" as used herein refers to gloss designations D through J as explained in para 3.4.4.

2. APPLICATION

This specification was released originally for material used for service repair of low gloss automotive exterior surfaces.

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 GENERAL

- 3.1.1 Must be in a form that lends itself to ease of application. It must be in a ready-to-use or readily mixed form and must be capable of application as purchased or with equipment normally utilized for commercial automotive refinishing. Any mixing agents or other system application requirements must either be part of the system or be readily available commercial items.
- 3.1.2 The color coat shall produce a finish with luster, texture, and color comparable to the original factory finish.
- 3.1.3 Shall have good flowout characteristics and, when properly applied, shall dry to a homogeneous film, free from mottling and pitting.
- 3.1.4 Must be compatible with production automotive air dry and basked exterior finishes as well as all substrate systems such as primer surfacer and primer sealers. Shall cause no adverse effects on old paint surfaces, such as lifting, wrinkling, bubbling, poor adhesion, etc.
- 3.1.5 After thorough drying, shall show no detrimental effects from the application of common soaps, detergents, and cleaners; severe dulling, streaking, staining or color change will not be allowed.
- 3.1.6 Must meet the requirements of this specification both when air dried or when forced dried.

Date	Action	Revisions
2003 08 13	Revised	Para 3.0 inserted; Para 3.12, 3.13, 4, deleted
1978 12 08		CPH22-815800-3
1970 05 13		Released PZ22-260





3.2 PANEL PREPARATION

The repair material must meet all test requirements when test panels are prepared as described below:

Set I
(FLTM BI 103-02, Method "C")

Zinc phosphated 100 x 300 mm steel test panels shall be prepared using:

- ESB-M6J102-(Latest suffix) and ESB-M6J103-(Latest suffix) primer (or equivalent) baked 30 minutes at 149 °C.
- ESB-M32J100-(Latest suffix) white (1619) enamel (or equivalent) baked 17 minutes at 130 °C.
- Sand entire panel and wipe with M-14J147 naphtha (or equivalent). Spray 3 coats of repair color coat with 1 minute flash between coats to obtain 30-46 micrometers dry film thickness.

Set II

Zinc phosphated 100 x 300 mm steel test panels shall be prepared as follows:

- Apply ESB-M6J102-(Latest suffix) primer (or equivalent) reduced to a viscosity of 22 +/- 1 s to obtain a film thickness of approximately 19.1 micrometers. Bake 30 minutes at 149 °C and wet sand to a dry film thickness of approximately 13 micrometers.
- Apply ESR-M2P94-(Latest suffix) primer surfacer (M6J12-D, M6J13-D (or equivalent) in thin, wet coats with a short flash off time between coats to obtain a film thickness of approximately 38 micrometers. Air dry 30 minutes and sand to a dry film thickness of approximately 25 micrometers.
- Wipe the surface with M14J147 naphtha (or equivalent). Apply one medium wet coat of non-sanding sealer (AR60-13-A or equivalent). Apply one medium wet coat of non-sanding sealer (AR60-13-A or equivalent) to a dry film thickness of 13-19.1 micrometers. Air dry for 30 minutes.
- Spray three coats of repair color coat with 1 minute flash between coats to obtain 30 - 46 micrometers dry film thickness.

Age all panels 168 h at 23 +/- 2 °C followed by 16 h at 43 °C before testing.

3.3 APPEARANCE

3.3.1 Color

Shall match the appropriate Ford Motor Company master panel.

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| 3.3.1.1 | Color Class I | Low Gloss Textured |
| 3.3.1.2 | Color Class II | Low Gloss Non-Textured |

