METALLIC ACRYLIC ENAMEL, EXTERIOR QUALITY **S-M32J110-B**

METALLIC ACRYLIC ENAMEL, EXTERIOR QUALITY **S-M32J110-C**

1. SCOPE

The materials defined by these specifications are a physical drying metallic basecoat and a thermosetting acrylic clear topcoat, which are applied wet on wet and concurrently stoved.

2. APPLICATION

The materials are generally used as a color coat on automotive bodies and other exterior parts. They shall be satisfactory for use over primers and sealers as in repair operations.

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

S-M32J110-B	Synthetic resin
SK-M32J9553-A	Acrylic resins in combination with melamine formaldehyde resins

3.1.2 Pigmentation of S-M32J110-B/C

Weather and light resistant pigments.

Note: For critical colors (weather resistance) use of suitable additives (e.g. UV-absorber) are permitted.

3.1.3 UV Absorber in SK-M32J9553-A Sufficient amounts of suitable UV absorbers to be selected by the supplier.

3.1.4 Productivity

All initial sample and batch submissions must indicate density (ASTM D 1475), non-volatile content (FLTM BI 102-01) and volume solids (FLTM BI 154-02) of materials as supplied on sample report.

Date	Action	Revisions
2006 09 07	Revised	S-M32J110-A inactivated & removed; 3.0 inserted; 3.9, 3.10 & 4 deleted; 3.1.1, 3.1.2, 3.2.1, 3.2.3, 3.2.4, 3.2.5 & 3.3.1 revised R. Lord
1994 12 20		Revised and Retyped was: 25 pages
1982 11 15	Completely revised	B/656710 TP

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3.1.5 Wet on Wet Compatibility

Material must be compatible for wet on wet application with current production primer surfacer.

3.1.6 Infrared Spectroscopic Analysis

From materials approved with Initial Sample Report, an infrared curve (master curve) shall be recorded and filed by the FoMoCo - Quality Control or Testing Laboratories. Infrared curves recorded for control purposes shall correspond to the master curve and shall be filed with the master curve. For all further suppliers, new master curves shall be established provided the material meets all other requirements of this specification.

3.1.7 UV Spectroscopic Analysis

From materials approved with Initial Sample Report a UV spectroscopic analysis shall be recorded and filed by the FoMoCo Quality Control or Testing Laboratories. UV spectroscopic data recorded for control purposes shall correspond to the data of the Initial Sample.

3.2 PHYSICAL PROPERTIES

3.2.1 Non-Volatile
(FLTM BI 102-01)

S-M32J110-B: According to Initial Sample +/- 1%, minimum 12%

S-M32J110-C: According to Initial Sample +/- 1%, minimum 19%

SK-M32J9553-A: According to Initial Sample +/- 1%, minimum 32%

To determine the solids, S-M32J110-B/C shall be adjusted to 18 - 22 seconds, SK-M32J9553-A to 35 - 40 seconds, FC-3/25 °C (FLTM BI 111-01). Thinner as specified by vendor.

3.2.2 Density of Dry Film
(FLTM BI 154-02)

According to Initial Sample Report, +/- 0.03. Volume solids of batches must not be less than the level established on the initial sample.

3.2.3 Viscosity as Received
(FLTM BI 111-01)

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

According to Initial Sample Report +/- 5 seconds, referring to FC 3 at 25 °C.

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3.2.4 Stability

S-M32J110-B/C

During a period of 3 months storage at room temperature, the material as received shall not gel, liver upon standing or hard settle. An increase of viscosity of more than 25 seconds is not permitted (FLTM BI 102-03, FC 3/25 °C).

SK-M32J9553-A

The material shall not gel nor show any turbidity. Maximum increase of the viscosity 20 seconds (FLTM BI 102-03, FC 3/25 °C).

3.2.5 Hiding Power, Dry
(FLTM BI 158-01)

Complete coverage of substrate at a dry film thickness (S-M32J110-B/C) of maximum 15 micrometre.

3.2.6 Flash Point

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

3.2.7 Color

The cured clearcoat film shall be water white.

3.2.8 Tendency to Crystallization of the UV Absorber

Store one liter of the clearcoat as supplied in a beaker for 24 hours at -10 °C and then allow the temperature to increase to 20 °C. Do not stir. No turbidity nor tendency to crystallization nor any other visible change of the material permitted.

3.2.9 Reflectance

Measure and record reflectance of Florida test panels as a graph prior to and after each year of exposure up to five years using suitable equipment, e.g. spectrophotometer, Type DMR 21, with reflectance attachment ex Zeiss, or equivalent.

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

Substrate:	UMA 18005X standard panels or equivalent panels with equivalent phosphate

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