ENGINEERING MATERIAL SPECIFICATION

Material Name	Specification Number
TWO PACK REPAIR ENAMEL, EXTERIOR QUALITY	SK-M1J9559-A

1. SCOPE

The material defined by this specification is an air drying or forced drying two pact paint system suitable for service and in plant repair.

2. APPLICATION

This material is to be used in service and in plant as a final coat on exterior automotive surfaces. The material shall be satisfactory for use over repair primers, sealers and enamels.

3. REQUIREMENTS

3.1 COMPOSITION

3.1.1 Vehicle

Synthetic resin, addition of hardener SK-M99J9608-A necessary.

Supplier has to notify if formulation contains nitrocellulose.

3.1.2 Toxicity

Contents of toxic components, e.g. benzene, chlorinated hydrocarbons, lead compounds etc., shall conform to the safety regulations currently prevailing in the workshop where the material shall be used. The use of cadmium is prohibited.

3.2 PHYSICAL PROPERTIES

3.2.1 Solids
(FLTM EU-BI 2-1)

According to initial sample report as approved +/- 2 %.

3.2.2 Viscosity as Received
(FLTM EU-BI 11-1)

According to initial sample report as approved +/- 5 s referring to FC 4/25 C.

Date	Release No.	Released
1994 12 20		Revised and Retyped was: 10 pages
1982 06 24	B/656705 TP	revised 3.1.2
1976 08 23	SM/EQ 8139 TP	Released

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3.2.3 Hiding Power
(FLTM EU-BI 1-5)

Complete visual hiding over substrate at maximum 40 micrometers dry film thickness.

3.2.4 Density
(FLTM EU-BI 2-2)

According to initial sample report as approved +/- 0.05.

3.2.5 Flash Point

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

3.2.6 Shelf Stability
(Enamel less hardener)

During a storage of 6 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 EU-BI 2-3.

3.3 PREPARATION OF TEST PANELS
(FLTM EU-BI 3-2, Method Bb)

Substrate:

Body steel according to DIN Standard 1623 Type RRSt 14-05 or according to CRI (E) BS 1449 Part 1 B, 1962. Surface finish of 45-65 CLA (microinches).

Metal Pretreatment	According to S-M3P1-B

Test panels prepared according to FLTM EU-BI 3-2, Bb have to be wet sanded with paper 400.

Application of SK-M1J9559-A to a dry film thickness of 40 - 45 micrometers.

Spray Viscosity and Thinner	As specified by the vendor
Flash Off Time	15 minutes at room temperature

Mixing ratio with hardener SK-M99J9608-A, spray viscosity and thinner as specified by the vendor.

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