



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

DECORATIVE PAINT, AIR DRYING, BLACK

SK-M1J9561-A

1. SCOPE

The material defined by this specification is a semigloss black, air drying paint suitable for application on automotive finishes.

2. APPLICATION

The material is used as specified by the responsible Engineering System for decorative painting of interior and restricted exterior body areas non-visible or partially visible e.g wheel house, lower flange of rocker panel.

3. REQUIREMENTS

3.1 COMPOSITION

3.1.1 Vehicle

Physical drying synthetic resins, if necessary in combination with nitrocellulose and suitable plasticizers.

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 plant and/or country where the material shall be used. The use of cadmium is prohibited.

3.2 PHYSICAL PROPERTIES

3.2.1 Non-Volatile (FLTM EU-BI 2-1)

According to initial sample report +/- 1.0 %.

3.2.2 Package Viscosity (FLTM EU-BI 11-1)

According to initial sample report +/- 5 s FC-4, 25 C but minimum 90 s FC-4, 25 C.

Date	Release No.	Released
1994 12 19		Revised and Retyped was: 13 pages
1982 06 24	B/656705 TP	Revised 3.1.2
1980 01 21	SM/EQ 8611 TP	Released

WP 3948-a

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3.2.3 Density
(FLTM EU-BI 2-2)

According to initial sample report +/- 0.02

3.2.4 Flash Point

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

3.2.5 Compatibility

The material must be of such compatibility that it can be reduced with S-M14J19-A (nitro thinner).

3.2.6 Hiding Power Dry
(FLTM EU-BI 1-5)

Reducer	S-M14J19-A
Viscosity	20 s FC-4/25 C

Complete visual hiding over substrate at a maximum dry film thickness of 10 micrometre.

3.2.7 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. The viscosity of the material shall not increase in excess of 40 seconds when tested according to FLTM EU-BI 2-3.

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

3.3.1 Stone Peck Protective SK-M99J9587-A/B
(If applicable)

After electrocoat bake one half of the test panels to be treated as follows:

Application of stone peck resistant material SK-M99J9587-A/B to a dry film thickness of approximately 100 +/- 10 micrometre by suitable spray method. After a flash off time of 1 minute spray a full hiding coat (approximately 20 micrometre of SK-M6J9556-A or approved equivalent, spray primer of current production. After 3 minutes flash off time bake according to material specification requirements; further process of top coat application according to FLTM EU-BI 3-2, Method Bb.