



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PRIMER SURFACER FOR ACRYLIC AND ALKYD ENAMELS

SK-M6J9556-A

1. SCOPE

The material defined by this specification is an enamel sealer. The material should be so formulated as to obtain the ultimate in leveling and maximum hold out properties after baking. The material shall be suitable for pneumatic and electrostatic spray application.

2. APPLICATION

The material is generally used as an enamel sealer over electrophoretic primers on small parts.

3. REQUIREMENTS

3.1 COMPOSITION

3.1.1 Vehicle Synthetic resin

3.1.2 Non-Volatile, min 50 %
(FLTM EU-BI 2-1)

3.1.3 Pigment

Inert pigments and fillers to obtain the desired color and sanding properties. The use of non-inert pigments or fillers e.g. zinc oxide, zinc sulfide, calcium carbonate is not permitted.

3.1.4 Compatibility

The material shall be compatible with Xylene (S-M14J245-A) and Solvesso 100 (S-M14J210-A).

3.1.5 Wet on Wet Compatibility

Material must be compatible for wet on wet application with current production top coat enamels.

3.2 PHYSICAL PROPERTIES

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

35 +/- 5 seconds FC 4 at 25 C.

Date	Release No.	Released
1994 12 19		Revised and Retyped was: 13 pages
1985 09 11	B/001682 TP	3.3, 3.5.4, 3.6.6 number of sheets revised
1984 01 17	B/701886 TP	Last Release

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3.2.2 Density
(FLTM EU-BI 2-2)

According to initial sample report +/- 0.02.

3.2.3 Flash Point

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

3.2.4 Storage Stability
(FLTM EU-BI 2-3)

During a storage of 3 months at room temperature, the material as received shall not gel or liver upon standing. An increase of the viscosity of more than 15 seconds is not permitted.

3.3 Preparation of Test Panels
(FLTM Eu-BI 3-2, Method B,b)

Test panels according to DIN Standard 1623, Type RRSt 14-05 or according to CR 1 (E) BS 1449 Part 1B 1962 and a surface finish of 1.4 +/- 0.3 micrometre CLA.

Application SK-M6J9556-A

Spray viscosity
Film thickness

23 +/- 5 seconds FC 4 at 25 C
Not sanded; 25 micrometre

Stoving:

5 minutes at 165 C metal temperature. However, for Adhesion (3.5.4), Chipping Resistance (3.6.1) and Stone Chip Resistance (3.6.6) also 5 minutes at 190 C metal temperature. Both primer baking cycles on electrocoated panels baked 10 minutes at 175 C metal temperature as well as on electrocoated panels baked 10 minutes at 190 C metal temperature.

Note:

- a) For testing adhesion, chip resistance, and peeling resistance according to items 3.5.4 a, 3.6.1 a, 3.6.4 and 3.6.5 the panels are not to be sanded.