



PAINT, TWO PACK, PLASTIC SUBSTRATES, EXTERIOR

SK-M99J9578-B

1. SCOPE

The material defined by this specification is a flexible exterior paint for plastic substrates. It must be cured with a suitable isocyanate hardener.

2. APPLICATION

This specification was released originally for material used as two pack paint for various exterior applications such as radiator grilles, mirrors, body side molding, etc.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

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).

3.4 COMPOSITION

3.4.1 Resin: Synthetic polyhydroxy acrylic resins.

3.4.2 Pigments: Pigments to obtain the desired color and properties.

3.5 MATERIAL PROPERTIES

3.5.1 Non-volatile (FLTM BI 102-01) See Initial Sample +/- 1%

The non-volatile content varies depending on the color:

Black and dark colors:	min. 40%
Other colors:	min. 48%
White:	min. 56%

The non-volatile content shall be determined at a spray viscosity of 20 s according to para 3.5.4.

3.5.2 Density (ASTM D 1475) See Initial Sample +/- 0.02 g/mL

3.5.3 Viscosity as supplied (FLTM BI 111-01) See Initial Sample +/- 5 s

Date	Action	Revisions
2006 02 17	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.12 and 4
1993 06 01	Completely revised	EP00E110258817000
1983 01 12	Last release	B/656 712 TP





- 3.5.4 Spray Viscosity (FLTM BI 111-01, FC #4) As specified by the supplier
- The material can be reduced with Xylene (S-M14J245-A), Butyl acetate (ESK-M14J228-A) or any other suitable thinner.
- 3.5.5 Mixing ratio as specified by the supplier
- The material shall be cured with isocyanate hardeners ESK-M99J323-A1/A2, SK-M99J9608-A or any other suitable hardener.
- 3.5.6 Dry Hiding Power, max. (FLTM BI 158-01) 40 μm
- 3.5.7 Storage Stability: 90 days
- During a storage of 90 days between 5 and 32 °C temperature the material as supplied shall not settle up or cake insoluble. After the storage the material must pass all specification requirements.

3.6 PREPARATION OF TEST PANELS

- 3.6.1 Substrate
- ABS, Polyamide, Polycarbonate or Polypropylene, etc. as specified on Engineering Drawing. All tests shall be performed on panels with a smooth, ungrained surface.
- 3.6.2 Plastic Preparation
- The surface to be painted shall be cleaned by an acceptable process, e.g. power wash, to remove mold releasing agents, fingerprints, oils, dirt and moisture.
- Note: PP/EPDM plastics must either be primed with an adhesion primer or pretreated (flame process, etc.) prior to painting to provide sufficient paint adhesion.
- 3.6.3 Primer Surfacer (if required)
- Application of a primer surfacer, film thickness and baking as specified in the relevant material specification.
- 3.6.4 Topcoat application
- Dry film thickness: 40 - 45 micrometre;
Flash off time: 5 minutes at room temperature;
Baking: 20 minutes at 80 °C (Minimum Object temperature).
- 3.6.5 Ageing
- Test panels prepared under this specification shall be aged for at least 72 h at 23 +/- 2 °C or 16 h at 45 +/- 1 °C before testing for resistance properties.