PRIMER, STONE CHIP PROTECTION, 50 MICROMETER **SK-M99J9587-D**

PRIMER, STONE CHIP PROTECTION, 50 MICROMETER, LOW BAKE **SK-M99J9587-E**

1. SCOPE

The materials defined by these specifications are solvent based stone peck protective baking primers for exterior automotive applications, applied in certain areas in addition to current production primer surfacer.

2. APPLICATION

These specifications were released originally for materials used as stone chip protection primer over primer surfacer on the lower body side to improve stone chip resistance.

SK-M99J9587-D: This material is designed for baking together with primer surfacer at 165 °C.

SK-M99J9587-E: This material is designed for baking together with low bake primer surfacer at 120 °C.

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: PU modified solvent borne synthetic resins.

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

3.5 PHYSICAL PROPERTIES

3.5.1	Non-volatile (FLTM BI 102-01)	See Initial Sample +/- 2%; minimum 55%

The non-volatile content shall be determined at a spray viscosity of 35 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 22	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.10 and 4
1995 02 02	Revised and Retyped	
1993 09 01	Released	EPOOE10258825000

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3.5.4	Spray Viscosity (FLTM BI 111-01, FC #4)	As specified by the supplier

The material can be reduced with xylene (WSK-M14J239-A).

3.5.5	Storage Stability	90 days

During a storage 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
(FLTM BI 103-02, Method B,b)

3.6.1 Substrates as specified on Engineering drawing.

- Standard Steel Panels
- Precoated Steel Panels as used in the plant

All substrates shall be zinc phosphated and conform to the requirements of WSK-M3P1-C.

3.6.2 Cathodic Electrocoat

Ford Engineering approved current production electrocoat primer, application and film thickness as specified in the relevant material specification.

3.6.3 Stone Chip Primer

Dry film thickness	50 - 55 micrometre
Flash off time	1 minute

3.6.3.1 SK-M99J9587-D

Wet on wet application of Ford Engineering approved current production primer surfacer, film thickness as specified in the relevant material specification.

Baking (Metal Temperature)	5 minutes at 165 °C 5 minutes at 190 °C

3.6.3.2 SK-M99J9587-E

Wet on wet application of Ford Engineering approved current production low bake primer surfacer, film thickness as specified in the relevant material specification.

Baking (Metal Temperature)	5 minutes at 120 °C 5 minutes at 140 °C

3.6.4 Top Coat

Application of current approved top coat, film thickness and baking as specified in the relevant material specification.

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