



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

EC ADDITIVE

SK-M99J9590-A

1. SCOPE

The material defined by this specification is an additive.

2. APPLICATION

The material is used to adjust anodic electrocoat primer under production conditions, mainly with regard to ultrafiltration, dry film thickness, and flow.

The material shall have no adverse effect on the quality of the electrocoat primer in a production dipping tank. The material has only to be used on supplier's request and in an amount to be specified by the supplier in each case.

3. REQUIREMENTS

3.1 COMPOSITION

3.1.1 Vehicle

Waterborne synthetic acid resins compatible with those contained in the basic electrocoat dipping tank and of relatively high molecular weight.

3.1.2 Pigmentation

3.1.2.1 Ash Content (FLTM EU-BV 50-10)

According to approved initial sample test report
+/- 0.5, preferably 19 - 20 %.

3.1.3 NEUTRALIZATION

Consumption of ammonia (25 % NH₃) 1.7 - 2 % by weight
referring to the material as supplied to adjust pH 7.0 - 7.1.

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1994 12 19		Revised and Retyped was: 5 pages
1978 06 23	SM/EQ8377 TP	Released

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3.1.4 TOXICITY

The material shall not contain toxic components, e.g. lead or lead compounds, benzene, chlorinated hydrocarbons, etc., in excess of that permitted by the safety regulations currently prevailing in the country or plant where the material shall be used.

3.2 PHYSICAL PROPERTIES

3.2.1 Non-Volatile
(FLTM EU-BI 20-8)

According to approved initial sample test report $\pm 1\%$, preferably minimum 69 %.

3.2.2 Density
(FLTM EU-BI 2-2)

According to approved sample test report ± 0.05 .

3.2.3 Infrared Spectroscopic Analysis

From materials approved with Initial Sample Report as infrared curve (master curve) shall be recorded and filled by the Ford Motor Company Quality Control or Testing Laboratories. Infrared curves recorded for control purposes shall correspond to the master curve and shall be filed with the master curve. For all further suppliers new master curves shall be established provided the material meets all other requirements of the specification.

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 Storage 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.