



PRIMER, WATERBORNE CATIONIC ELECTROCOAT, 20 MICROMETRE FILM BUILD, INITIAL FILL, BLACK, 180 °C BAKING TEMPERATURE	WSB-M64J28-A1
MAKEUP FEED, WATERBORNE CATIONIC ELECTROCOAT 20 MICROMETRE FILM BUILD, RESIN	WSB-M64J28-A2
MAKEUP FEED, WATERBORNE CATIONIC ELECTROCOAT PIGMENT, BLACK	WSB-M64J28-A3
FLOW CONTROL ADDITIVE	WSB-M64J28-A4
PRIMER, WATERBORNE CATIONIC ELECTROCOAT, 20 MICROMETRE FILM BUILD, INITIAL FILL, GRAY, 180 °C BAKING TEMPERATURE	WSB-M64J28-C1
MAKEUP FEED, WATERBORNE CATIONIC ELECTROCOAT 20 MICROMETRE FILM BUILD, RESIN	WSB-M64J28-C2
MAKEUP FEED, WATERBORNE CATIONIC ELECTROCOAT PIGMENT, GRAY	WSB-M64J28-C3
FLOW CONTROL ADDITIVE	WSB-M64J28-C4

NOT TO BE USED FOR NEW DESIGN

1. SCOPE

The materials defined by these specifications are nominal 20 micrometre film build, black or gray waterborne electrocoat body primers and associated make-up feed components applied by the cathodic deposition process.

2. APPLICATION

These specifications were released originally for a paint system which, when properly electrodeposited on vehicle bodies, sheet metal components or small parts, will provide good corrosion resistance, adhesion and enamel appearance properties.

WSB-M64J28-A1, C1: This primer is applied directly over zinc phosphate coated cold rolled steel, electrodeposited zinc or zinc/zinc alloy coated steel and any other type of steel classified as precoated, as well as to aluminum substrates. Typical applications are as follows:

Date	Action	Revisions	Rev 03
2012 05 21	N Status	No usage or replacement	N. Benipal, NA
2010 04 15	Revised	Revised 3.8.2.2	A. Wedepohl, NA
1990 01 31	Released	NB00E10080067000	PAK, MP



WSB-M64J28-A1/A2/A3/A4/C1/C2/C3/C4

- Visible Exterior Surfaces: The electrocoated primer film may be followed by an approved primer-surfacer and exterior enamel color coat. The electrocoat primer, primer-surfacer, and enamel are all baked separately.
- Visible Interior Surface: The baked electrocoated primer film is followed by an enamel color coat.
- Non-visible Interior or Underbody Surfaces: The baked electrocoated primer film is not usually followed by an additional primer or enamel color coat.

WSB-M64J28-A2, C2: This material is make-up feed material used to replenish the resins of the initial fill electrocoat bath.

WSB-M64J28-A3, C3: This material is make-up feed material used to replenish the pigments of the initial fill electrocoat bath.

WSB-M64J28-A4, C4 are make-up feed materials that correct poor flow characteristics of the primer which may develop when the bath ages. This additive is used only as recommended by the supplier following ultrafiltrate purge or when discontinuous operation of an electrocoat tank results in evaporation of bath volatiles.

3. REQUIREMENTS

WSB-M64J28-A1, C1 cationic electrocoat primer shall meet all detailed requirements of this specification. The make-up feed material shall meet the requirements of para 3.5 and 3.6. When the feed material is used in production, the resultant primer film shall conform to the requirements detailed in para 3.7 through 3.11. These requirements apply to both laboratory prepared and assembly plant electrocoat tank 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 MATERIAL COMPATIBILITY

The supplier of this material shall keep abreast of changes in technology of related materials e.g., sealers and adhesives, which may affect the compatibility and performance of this product. The supplier shall notify the appropriate Ford Product Materials Engineering Office in writing when incompatibility is anticipated.



3.5 COMPOSITION

- 3.5.1 Density, kg/L at 25 °C
(ASTM D 1475)

The density of the materials defined by these specifications shall be within +/- .05 % of that shown on the Initial Sample Report.

- 3.5.2 Non-volatile, wt %
(FLTM BI 102-01)

The non-volatile content of the material types specified by these specifications shall match the values shown on the initial sample report within +/- 1 %.

- 3.5.3 Weight Loss, max
(FLTM BI 120-15, after 10 minutes
at 182 +/- 2 °C metal temperature
bake cycle)

Initial Fill and Assembly Plant Electrocoat Tank Material	12.0 %
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| 3.5.4 Solvent Emissions, max
(ASTM D 3960) | 0.096 kg/L of wet paint |
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This requirement is as determined by the United States Environmental Protection Agency Reference Method #24 but is only applicable to materials used in the USA.

3.6 STABILITY

- 3.6.1 Pumping Stability
(FLTM BI 120-04)

After 21 days minimum agitation, the bath prepared from the initial fill or feed materials shall meet all requirements of the specification.

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| 3.6.2 Storage Stability | 2 months |
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During a storage of 2 months between 5 and 32 °C temperature the material as supplied shall not settle or cake.

3.7 PREPARATION of TEST PANELS

Prepare panels per FLTM BI 120-01 with the exceptions noted below:

The substrates used shall be as follows, (ref. para. 5.1):