



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

CERAMIC COATINGS, GLASS - DECORATIVE

VWSB-M99G109-D

CERAMIC COATINGS, WITH ZINC (10 % MAX) GLASS -
DECORATIVE (WINDSHIELDS)

VWSB-M99G109-E

CERAMIC COATINGS, WITH ZINC (30 % MAX) GLASS -
DECORATIVE (BODY GLASS AND MOONROOFS)

VWSB-M99G109-F

1. SCOPE

The materials defined by these specifications are ceramic coatings for glass.

2. APPLICATION

This specification was released originally for material used to trademark or decorate glazing material, such as backlites, sidelites, moonroofs and windshields on the interior surface.

3. REQUIREMENTS

3.1 STATISTICAL PROCESS

Suppliers must conform to the requirements of Ford Quality System Standard Q-101. A mutually acceptable Control Plan as described therein is required for material/source approval. Appropriate statistical tools must be used to analyze process/product data so that variation in the final product is continuously reduced.

3.2 CONDITIONING AND TEST CONDITIONS

All test values indicated herein are based on material conditioned in a controlled atmosphere of 23 +/- 2 C and 50 +/- 5 % relative humidity for not less than 24 h prior to testing and tested under the same conditions unless otherwise specified.

3.3 BASIC MATERIAL

3.3.1 Composition

3.3.1.1 Glass Enamel

VWSB-M99G109-D (For use on body glass, windshields and moon roofs.)

Shall consist of a glass frit and a light and temperature stable pigment milled together to the proper fineness (See para 3.3.2.2).

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1991 08 28	NB00110043054118	Released <i>RD Moore LWM</i>

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VWSB-M99G109-E (For use on windshields)

Shall consist of a glass frit and a light and temperature stable pigment and up to 10 % zinc, maximum, milled together to the proper fineness (See para 3.3.2.2).

VWSB-M99G109-F (For use on backlites, sidelites, and moonroofs)

Shall consist of a glass frit and a light and temperature stable pigment and up to 30 % zinc maximum, milled together to the proper fineness (See para 3.3.2.2).

3.3.1.2 Weight per Unit Volume

The weight tolerances for any one supplier shall be +/- 1.0 % based on the recorded weight per unit volume of his original approved production sample.

3.3.1.3 Toxicity

The material shall contain no benzene, chlorinated or other toxic compounds, or hydrolyzable chlorine derivatives, or have an obnoxious or objectionable odor.

3.3.2 Physical Properties

3.3.2.1 Viscosity

Decorative with Trademark

- Shall be formulated, so that it can be applied using a 150 - 200 mesh nylon screen to provide a smooth opaque coating which meets the requirements of this specifications.

Trademark Only

- Shall be formulated so that it can be applied using an offset printer to provide a smooth opaque coating which meets the requirements of this specification.

3.3.2.2 Particle Size

Decorative with Trademark

- 99.9 % of the material should pass through a 325 mesh screen and be controlled to a maximum Hegman Grind reading of 7.0 (0.013 mm).