



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PAINT, AIR DRYING, BLACK

WSK-M1J209-A

1. SCOPE

The material defined by this specification is an air drying finish suitable for application onto automotive radiators, radiator cores and associated parts.

2. APPLICATION

This specification was released originally for material to be applied over mild steel, brass, terne plate and soldered substrates. The material shall be suitable for pneumatic, airless and/or electrostatic spray application.

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 INFRARED SPECTROPHOTOMETRY AND/OR THERMAL ANALYSIS

Ford Motor Company in its option, may conduct infrared and/or thermal analysis of materials/parts supplied to this specification. The IR spectra and thermograms established for initial approval shall constitute the reference standard and shall be kept on file at the designated Material Laboratory. All samples shall produce IR spectra and thermograms that correspond to the reference standard when tested under the same conditions

3.3 CONDITIONING

All parts shall be aged for 7 days at 23 +/- 2 C before testing for resistance properties unless otherwise specified.

All tests according to this specification shall be performed in a controlled atmosphere of 23 +/- 2 C and 50 - 65 % relative humidity if not otherwise specified.

Date	Release No.	Release/Revision
1991 03 01	EP00E01089482000	Released C E Herriott concurred J Schult

WP 3948-a

Page 1 of 5

9009160 0013467 984



3.4 COMPOSITION

3.4.1 Resin

The vehicle shall be based on a suitable synthetic resin system, asphaltum, gilsonite and natural oils, to obtain the desired application and resistance properties.

3.4.2 Pigment

The pigment may contain carbon black and shall be balanced and blended so that the finished paint meets the requirements of this specification.

3.4.3 Solvents

Hydrocarbons and alcohols as required to provide performance.

3.4.4 Specific Composition

When it is necessary to obtain specific data regarding material formulation, it is understood that the supplier will furnish such data on request.

3.5 PHYSICAL PROPERTIES

3.5.1 Non-volatile Initial Sample +/- 1.0 %.
(FLTM BI 102-01)

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

3.5.3 Viscosity
(FLTM BI 111-01, Ford Cup 4, 25 C)

3.5.3.1 Package Viscosity

Initial Sample +/- 5 s or as supplied for ready thinned paint as agreed.

Batch variations shall not exceed +/- 2 s of the viscosity authorized by the affected Manufacturing areas.

3.5.3.2 Test Viscosity

Initial Samples 20 +/- 2 s or as supplied for ready thinned paint.

3.5.4 Wet Hiding Power, max 6.0 mm
(FLTM BI 101-01, Wedge 0.002
Viscosity 20 +/- 2 s)