



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

3.0 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

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
(FLTM BI 102-01)

Initial Sample +/- 1.0%

3.5.2 Density
(ASTM D 1475)

Initial Sample +/- 0.02 g/mL

Date	Action	Revisions
2007 11 30	Revised	Updated format, no technical change
2003 06 10	Revised	Para 3.0 inserted; para 3.1, 3.2, 3.3, 3.10 and 4 deleted
1991 03 01	Released	EP00E01089482000 C E Herold, concurred J Schult



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)

3.5.5 Shelf Stability

During a storage of three 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. The viscosity of the material shall not increase in excess of 15 s Ford Cup 4, 25 °C when tested according to FLTM BI 102-03.

3.5.6 Solvent Emissions, max 0.096 kg/L
(ASTM D 3960)

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 PREPARATION OF TEST PANELS (FLTM BI 103-02)

3.6.1 Substrate

3.6.1.1 Ford Engineering Approved Standard Mild Steel Test Panels, not phosphated.

3.6.1.2 Brass sheet of same quality and surface as used in production.

3.6.1.3 Terne plate sheet of same quality and surface as used in production.

All panels to be solvent degreased in accordance with FLTM BI 103-02. Method F, Procedures # 1, 2, 3, & 4, before paint application.