



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

LACQUER, CLEAR, CORROSION PROTECTION,
ENGINE COMPARTMENT

WSK-M1J211-A

1. SCOPE

The material defined by this specification is a solvent borne air drying rust preventive. It dries to a clear elastic film with high corrosion resistance and shows best performance after aging for at least 14 days. High temperatures will improve hardness, flexibility and adhesion.

2. APPLICATION

This specification was released originally for a material used as corrosion protection for the engine and engine compartment. It is applied after assembly of the engine.

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, at its option, may conduct infrared and/or thermal analysis of material/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 COMPOSITION

3.3.1 Non-Volatile, min 36 %
(FLTM BI 102-01)

3.3.2 Color Transparent

Note: When applied on top coat, the film shall not cause a change in the visual impression of the paint color underneath.

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1991-04-01	EP00E01089483000	Released CD

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- 3.3.3 Flash Point
(ASTM D 56) above 21 C
- 3.3.4 Shelf Stability, min 6 months
- 3.3.5 Weight per Volume
(ASTM D 1475)
According to approved Initial Sample +/- 0.05 kg/L
- 3.3.6 Viscosity
(ASTM D 1200, FC 4)
According to approved Initial Sample +/- 5 s
- 3.4 PREPARATION OF TEST PANELS
- 3.4.1 Substrates (if not otherwise required)
- 3.4.1.1 Substrate A
Ford standard mild steel test panels or current production mild steel panels, prepared according to FLTM BJ 106-01, solvent wiped.
- 3.4.5.2 Substrate B
Standard white painted panels in current production quality, cured according to respective Material Specification, if not otherwise required.
- 3.4.2 Application Procedure
Spray the material under test in one coat onto test panels.
- 3.4.3 Application Temperature 15 - 30 C
- 3.5 AGING
Prior to testing age test panels for 24 h at 90 C and recondition for 24 h in a controlled atmosphere of 23 +/- 2 C and 50 +/- 5 % relative humidity. Tests have to be performed under the latter conditions unless otherwise specified.
- 3.6 DRY FILM PROPERTIES
- 3.6.1 Drying Time 60 min
Dry to handle after the required time at 23 +/- 2 C.