



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PRIMER, POLYISOCYANATE/ETHYLACETATE, POLYURETHANE

WSK-M2G343-A2

1. SCOPE

The material defined by this specification is a polyisocyanate in ethylacetate based primer.

2. APPLICATION

This specification was released originally for materials used to prime WSD-M2D404-A1/A2 polyurethane. It is used in conjunction with WSK-M2G309-B direct glazing adhesive. The material is suitable for production and service repair applications.

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 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.

3.4 COLOR

Colourless/transparent

3.5 SOLIDS, min
(FLTM BV 150-10)

7 %

3.6 ASH, max
(FLTM BV 150-10)

2 %

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1992 04 01	EP00E10176266000	Released W. Scholz Conc. J. Schult

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- 3.7 DENSITY AT 23 C 0.92 kg/L
(ASTM D 1475)

The density tolerance for any one supplier shall be +/- .03 kg/L, based on the recorded density of the originally approved sample.

- 3.8 VISCOSITY AT 23 C, max 8 to 12 s
(FLTM BI 111-01, Ford Cup No. 4)

- 3.9 DRYING RATE, max 60 s

Apply an 8 - 13 micrometre film of primer in a film 25 mm wide to a 75 x 75 mm glass plate coated with clean polyurethane according to WSD-M2D404-A1/A2. To determine the primer drying rate, immediately, at rapid intervals, dab the primer with a wad of absorbent cotton. Observe if any of the cotton fibers adhere to the primed surface. Record the drying rate, as the time lapsed from the initial primer application until no cotton fibers adhere to the primer.

- 3.10 ODOR

Shall be free from objectionable or irritating odors, both in the "as received" condition and at application temperatures.

- 3.11 STORAGE STABILITY, min 9 months
(From date of receipt at Ford Motor Company)

When stored in sealed unopened containers out of direct sunlight at ambient temperatures between 5 and 32 C.

The supplier must label each container to indicate expiration date of the material and production usage beyond expiration date is not permitted.

- 3.12 QUALITY

The material shall be of uniform quality, free from foreign materials and properties detrimental to normal production use. It shall not cause excessive soiling of handlers in normal production use.

- 3.13 NON-INTERCHANGEABILITY OF MATERIALS

Only approved materials all from the same production source shall be used in conjunction with one another.

- 3.14 ADDITIONAL REQUIREMENTS

Specific requirements for material and/or manufactured parts shall be specified on the Engineering drawing, Engineering parts specification and/or performance specifications. All critical areas with respect to these properties shall be clearly designated on the engineering drawing.