



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PAINT PERFORMANCE, SUEDE COATING, INTERIOR

WSK-M2P163-A

1. SCOPE

This specification defines the performance requirements for low gloss high abrasion resistant paint films on plastic substrates for interior use. The paint films provide a cloth-like surface.

2. APPLICATION

This specification was released originally to define paint performance requirements for various painted interior plastic applications such as instrument panels, pillar coverings, etc. It may also be used on metallic substrates.

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

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 SYSTEM COMPONENTS

3.3.1 Substrate

ABS, Polypropylene, Polycarbonate, other plastic substrates as well as metallic substrates as specified on Engineering Drawing.

3.3.2 Substrate Preparation (see also 5.1)

The surface to be painted shall be cleaned by an acceptable process, e.g. power wash, to remove mold releasing agents, fingerprints, oils, dirt and moisture.

Date	Release No.	Release/Revision
1991-06-03	EP00E01089485000	Released KPM, KW conc. J.Schult

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3.3.3 Primer (if required)

Where necessary in order to meet the requirements of this specification, an adhesion primer, primer surfacer or primer sealer must be used or as specified on Engineering Drawing.

3.3.4 Top Coat

Suitable to meet the requirements of this specification or as specified on Engineering Drawing.

3.3.5 Film Thickness

As specified in applicable paint Material Specification.

3.3.6 Ageing

Test panels or test specimens prepared for investigations according to this specification must be aged for at least 72 hours at 23 +/- 2 C or 16 hours at 45 +/- 2 C prior to testing.

3.3.7 Production Paint Repair

Repaired areas must meet the requirements of this specification. All repair materials and processes used must be approved by the affected Product Engineering Office. Maximum film thickness for repaired parts will be specified in the mutually agreed control plan.

3.4 APPEARANCE

Colour, gloss, grain and surface finish shall match master Trim Sample and/or Master Appearance Sample as approved by Design.

3.4.1	Color (FLTM BI 109-01)	see approved sample
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3.4.2	Gloss, max (FLTM BI 110-01, 60 deg)	2 %
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3.5 RESISTANCE PROPERTIES

3.5.1	Adhesion (FLTM BI 106-01, Method B)	Grade 0
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3.5.2	Water Immersion Test (FLTM BI 104-01)	96 h
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No blistering, softening, colour change or loss of adhesion per 3.5.1.