Material Name	Specification Number
SEALER, WELDABLE, SOLVENT FREE, NON-FLAMMABLE	WSK-M4G333-A

1. SCOPE

The material defined by this specification is a weldable, solvent free, heat curing and non-flammable sealer based on synthetic resins and/or rubber.

2. APPLICATION

This material is used for sealing spot weld seams on the body-in-white and/or as specified on Engineering Drawing.

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	SOLIDS, min (FLTM BV 150-10)	99 %
3.5	ASH, max (FLTM BV 150-10)	40 %

Date	Release No.	Release/Revision		
1991 07 01	EP00E01089486000	Released	W. Scholz	J. Schult

9009160 0010490 595

Copyright by the Ford Motor Company

Mon Aug 29 00:14:56 2016

Full document details: FORD WSK-M4G333-A 1991

AVA Documents Document Sharing Hub

3.6	DENSITY AT 23 C (ASTM D 1475)	1.6 +/- 0.2 kg/L
3.7	VISCOSITY AT 23 C (FLTM BV 103-01, line pressure 275 kPa, nozzle dia 2 mm)	
3.7.1	As received	150 - 200 s
3.7.2	After Aging, max	230 s
3.8	FLOW RATE (FLTM BV 153-01, Method A, except oiled panels according to FLTM BV 150-11, "Normal Grade")	No flow
3.9	AGING (FLTM BV 153-02, Method D, except oiled panels according to FLTM BV 150-11, "Normal Grade")	No loss of adhesion or chipping
3.10	COLD ADHESION (FLTM BV 153-04, Method A, - 30 C)	No loss of adhesion or chipping
3.11	WASH RESISTANCE	No wash-off or displacement of sealer ribbon; slight deformation of sealer ribbon surface permitted

Test Method:

- Apply two ribbons of material under test 250 x 30 x 3 mm and 50 mm apart from each other to a 300 x 300 mm oiled panel. Prepare in accordance with FLTM BV 150-11, "Normal Grade".
- After conditioning for 2 h at 23 +/- 2 C, expose test assembly in horizontal position to a water jet of 50 +/- 5 C using a nozzle No. 1/2 GG-25 Full Jet (Spraying System Co.) and a pressure of 200 kN/m2. The distance between the nozzle and test material shall be 300 mm. The water jet shall be applied between the beads for 1 minute.

9009160 0010491 421

Copyright by the Ford Motor Company

Mon Aug 29 00:14:56 2016

Full document details: FORD WSK-M4G333-A 1991

AVA Documents Document Sharing Hub