



PAINT, NITROCELLULOSE, AIR DRYING REPAIR, INTERIOR

WSK-M4J209-A

1. SCOPE

The material defined by this specification is a nitrocellulose lacquer composed of a combination of nitrocellulose, synthetic resin, plasticizers and pigments, suitable for use over baked primer or already painted surfaces.

2. APPLICATION

This specification was released originally for material used on visible and non eye level visible interior parts. The material shall be suitable for application by brush and spray.

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 FLASH POINT

The flash point shall conform to the safety regulations applicable to the plant and/or country where the material shall be used.

3.5 COMPOSITION

3.5.1 Resin

Essentially a mixture of nitrocellulose, suitable plasticizers, hardeners, and alkyd/polyester modifying resins.

3.5.2 Pigment

The pigment shall be balanced and blended so that the finished enamel matches the Master Appearance Sample (MAS) Panel in color and luster and meets the requirements of this specification.

Date	Action	Revisions
2008 01 24	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.14 & 4
1990 03 01	Released	C01031533



3.5.3 Solvent

The volatile portion shall contain sufficient active solvents to give satisfactory adhesion when the enamel is applied over a previously baked coat of the enamel.

The properties of solvents in the volatile portion shall be arranged so that the enamel will level out satisfactory on spray application. The volatility of the solvents is to be so chosen that the material will give a dry film thickness of 40 micrometer without sagging and with satisfactory freedom from roughness or dry spray.

3.5.4 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.

3.5.5 Special Data

All initial and batch submissions must indicate density and non-volatile content of the material as supplied on the sample report.

3.6 PHYSICAL PROPERTIES3.6.1 Non-volatile
(FLTM BI 102-01)

Initial Sample +/- 1.0%

Minimum solid content for various color classes are shown in tabular form, item 3.8.3.

These solid limits apply to enamels adjusted to a delivered viscosity of 120 s Ford Cup 4, at 25 °C (FLTM BI 111-01).

3.6.2 Density, as delivered
(ASTM D 1475)

Initial Sample +/- 0.02 g/mL

3.6.3 Viscosity
(FLTM BI 111-01, Ford Cup 4, 25 °C)

Viscosity, as delivered

120 s +/- 2 s

Viscosity, spray

18 - 25 s

3.6.4 Solvent Compatibility

The material as received shall be fully compatible with WSK-M14J247-A Cellulose Solvent. After diluting the material as received 1 to 1 by volume with this solvent, the viscosity shall be 18 - 25 s, Ford Cup 4, 25 °C).

It is no cause for rejection when the viscosity of 18 - 25 s is obtained by addition of less than 100% solvent.