



PAINT, METALLIC BASECOAT IN BASECOAT/CLEARCOAT SYSTEM, AIR DRYING REPAIR INTERIOR

WSK-M4J210-A

1. SCOPE

The material defined by this specification is an air drying metallic basecoat of a basecoat/clearcoat system required to provide the best interior quality finish. It consists of a physically drying metallic basecoat nitrocellulose lacquer system, suitable for repair of the stoved basecoat/clearcoat system, in connection with a complementary clearcoat repair enamel and for use over primed 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 brush and spray application.

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

Mixture of nitrocellulose, suitable plasticizers and nondrying alkyd/polyester resins.

3.5.2 Pigment

The pigment shall have weather and light resistant properties and be balanced and blended so that the finished enamel matches the Master Appearance Sample (MAS) Panel in appearance, color and luster, and shall give sufficient performance to meet the requirements of this specification.

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 enamel.

The properties of solvents in the volatile portion shall be so arranged 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 20 micrometer without sagging and with satisfactory freedom from roughness or dry spray.

Date	Action	Revisions
2008 01 28	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3,
1990 02 01	Released	C01031532



3.5.4 Clear Top Coat

Basecoat meeting this specification shall be totally compatible with the Ford Engineering approved repair clearcoat WSK-M4J211-A or approved equivalent materials applied on it. After application the repair basecoat/repair clearcoat system shall present an interior finish of the highest quality.

3.5.5 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.

3.5.6 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 PROPERTIES

3.6.1 Non-volatile (FLTM BI 102-01) Initial Sample +/- 1.0%

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

Solvent may be specified by vendor but shall be Ford Product Engineering Approved prior to use.

3.6.2 Density (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 Initial Sample +/- 3 s

Preferred minimum 25 s

Viscosity, as spray 20 s

3.6.4 Solvent Compatibility

The material as received shall be fully compatible with WSK-M14J247-A or WSK-M14J248-A Cellulose Solvent. The application viscosity depends upon plant conditions. A recommended spray viscosity is 20 s Ford Cup 4, 25 °C.

3.6.5 Accelerated Shelf Stability (FLTM BI 102-03)

The material shall not gel or liver upon standing. After cooling it must be possible to reduce the material to the desired viscosity as required by item 3.6.4.

