



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PAINT, WATERBORNE, PLASTIC SUBSTRATES, INTERIOR

WSK-M62J27-A

1. SCOPE

The material defined by this specification is a waterborne interior baking paint for plastic parts.

2. APPLICATION

This specification was released originally for material used as one coat baking paint for various interior 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

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 COMPOSITION

3.4.1 Resin: Waterbased synthetic resins.

3.4.2 Pigments: Pigments to obtain the desired colour and properties.

Date	Release No.	Release/Revision
1991 12 02	EP00E01089491000	revised 3.5.1 and 4.; added 5.2
1990-10-08	EP00E01031541000	Released KW conc. J.Schult

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- 3.4.3 Solvent Emissions see Initial Sample +/- 1 %
(ASTM D 3960)

This requirement is as determined by the United States Environmental Protection Agency Reference Method #24 and is only applicable to materials used in the USA.

3.5 MATERIAL PROPERTIES

- 3.5.1 Non-volatile see Initial Sample +/- 1 %;
(FLTM BI 102-01) min. 25 %

The non-volatile content shall be determined at a spray viscosity of 35 s according to para 3.5.4.

- 3.5.2 Density see Initial Sample +/- 0,05 g/mL
(ASTM D 1475)

- 3.5.3 Viscosity as supplied see Initial Sample +/- 5 s
(FLTM BI 111-01)

- 3.5.4 Spray Viscosity as specified by the supplier
(FLTM BI 111-01, FC #4)

The material can be reduced with deionized water.

- 3.5.5 Organic solvent content see Initial Sample +/- 5 g

The content of organic solvents is defined as:
g organic solvents per kg material at spray viscosity,
determined under the conditions of para 3.5.1

- 3.5.6 Dry Hiding Power, max. 15 um
(FLTM BI 158-01)

- 3.5.7 Storage Stability: 90 days

During a storage of 90 days between 5 and 32 C temperature the material as supplied shall not settle up or cake insoluble. After the storage the material must pass all specification requirements.

3.6 PREPARATION OF TEST PANELS

- 3.6.1 Substrate

ABS, Polycarbonate, Polypropylene, etc. as specified on Engineering Drawing.

Note: PP/EPDM plastics must be primed with an adhesion primer prior to painting.