ENGINEERING MATERIAL SPECIFICATION

Material Name	Specification Number
PAINT, WATERBASED, BASECOAT, LOW BAKE, METALLIC	WSK-M62J30-A1
PAINT, WATERBASED, BASECOAT, LOW BAKE, NONMETALLIC	WSK-M62J30-A2

1. SCOPE

The materials defined by these specifications are waterbased one pack low bake basecoats for 90 C baking temperature. They must be coated with an additional clear coat.

2. APPLICATION

These specifications were released originally for materials used as two coat basecoat on primed plastic bumpers. The materials may also be used for other exterior plastic applications such as radiator grilles or body side moldings, (see 5.1).

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 COMPOSITION

3.4.1	Resin	Water based synthetic resins.
3.4.2	Pigments	Pigments to obtain the desired colour and properties.

Date	Release No.	Release/Revision
1991-06-03	EP00E01089485000	Released KW

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

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	Nonvolatile (FLTM BI 102-01)	See Initial Sample	+/- 1 %
	WSK-M62J30-A1, min		16 %
	WSK-M62J30-A2, min		20 %

The nonvolatile content shall be determined at spray viscosity of 35 s per para 3.5.4.

3.5.2	Density (ASTM D 1475)	See Initial Sample	+/- 0.02 g/mL
3.5.3	Viscosity as supplied (FLTM BI 111-01)	See Initial Sample	+/- 5 s
3.5.4	Spray Viscosity (FLTM BI 111-01, FC #4)	As specified by the supplier	

The material can be reduced with deionized water.

3.5.5	Organic Solvent Content, max	17 %

The content of organic solvents is defined as:
Weight-% of organic solvents at spray viscosity.

3.5.6	Dry Hiding Power (FLTM BI 158-01)	
	WSK-M62J30-A1, max	15 micrometre
	WSK-M62J30-A2, light red, max	40 micrometre
	WSK-M62J30-A2, other colours, max	25 micrometre
3.5.7	Storage Stability	90 days

During the storage 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.

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