

**PRIMER, TWO PACK, PLASTIC SUBSTRATES, HIGH FLEXIBLE****WSK-M6J147-B****1. SCOPE**

The material defined by this specification is a highly flexible primer for plastic substrates. It must be cured with a suitable isocyanate hardener.

2. APPLICATION

This specification was released originally for material used as two pack primer for plastic bumpers made from polycarbonate prior to the application of top coats. The primer is suitable for use with solvent based highly flexible solid color topcoats and with water based as well as solvent based basecoats in combination with highly flexible clearcoats.

3. REQUIREMENTS**3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS**

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 COMPOSITION

3.2.1 Resin: Synthetic resins

3.2.2 Pigments: Pigments to obtain the desired properties

3.2.3 Solvents

3.3 MATERIAL PROPERTIES

3.3.1 Non-volatile (FLTM BI 102-01) see Initial Sample +/- 1%; 60% min.

The non-volatile content shall be determined at a spray viscosity of 25 s according to para 3.3.4.

3.3.2 Density (ASTM D1475) see Initial Sample +/- 0.02 g/mL

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

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

The material can be reduced with xylene, butyl acetate or any other suitable thinner.

Date	Action	Revisions	Rev 03
2014 04 10	Reactivate	See Summary of Revisions	M. Corley, FoE
2012 05 14	N Status	No usage or replacement	N. Beninal, NA
1990 08 01	Released	EP00E01031538000 KW	Conc. J. Schult



- 3.3.5 Mixing ratio as specified by the supplier

The material shall be cured with isocyanate hardener WSK-M99J359-A, WSK-M99J360-A.

- 3.3.6 Dry Hiding Power (FLTM BI 158-01) 20 µm max

- 3.3.7 Storage Stability

- 3.3.7.1 Accelerated Shelf Stability (FLTM BI 102-03)

Paint shall not jell, settle hard or increase viscosity in excess of 10s

- 3.3.7.2 Stability after aging

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

3.4 PREPARATION OF TEST PANELS

- 3.4.1 Substrate

Polycarbonate, polyurethane, polyamide, polypropylene or ABS as specified on the Engineering Drawing.

Note: PP/EPDM plastic surfaces must be suitably activated using flaming or primed with an adhesion primer prior to painting.

- 3.4.2 Plastic Preparation

The surface to be painted shall be cleaned by an acceptable process, e.g. power wash, to remove mold releasing agents, fingerprints, oils, dirt and moisture.

- 3.4.3 Primer application (see also 4.2)

Dry film thickness: 25 - 35 micrometer;
Flash off time: 3 minutes;
Baking (optional): 20 minutes at 80 °C (Object temperature).

- 3.4.4 Top coat application

Application of currently used two pack high flexible top coat systems, film thickness and baking as specified in the relevant material specification.

- 3.4.5 Aging

Test panels prepared under this specification shall be aged for at least 168 h at 23 +/- 2 °C or 16 h at 45 +/- 1 °C before testing for resistance properties.