ENGINEERING MATERIAL SPECIFICATION

Material Name

PRIMER, REPAIR, BAKING

Specification Number

WSK-M6J161-A

1. SCOPE

The material defined by this specification is a solvent borne baking repair primer surfacer.

2. APPLICATION

This specification was released originally for material used as spot repair primer on interior and exterior surfaces of vehicle bodies.
The primer is used over current production primer surfacer and on areas sanded through to bare metal.
The primer is suitable for use with either solvent borne topcoats or waterborne basecoats.
The material is suitable for electrostatic spray application.

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: Synthetic resins.

Date	Release No.	Release/Revision
1991-02-01	C01089481	Released KW conc. J.Schult

9009160 0013760 272

Copyright by the Ford Motor Company

Mon Aug 29 21:49:36 2016

Full document details: FORD WSK-M6J161-A 1991

AVA Documents Document Sharing Hub

3.4.2 Pigments: Pigments to obtain the desired colour, mecanical resistance and corrosion protection.

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 Non-volatile (FLTM BI 102-01) — see Initial Sample +/- 1 %; min 45 %

The non-volatile content shall be determined at a spray viscosity of 29 s according to 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 #3) — as specified by the supplier

The primer can be reduced with Xylene (WSK-M14J239-A).

3.5.5 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 SPECIMEN

3.6.1 Preparation of Test Panels
(FLTM BI 103-02, Method A)

Substrate: Standard Steel Panels UMA18005.

Primer:
Dry film thickness: 20 - 25 micrometre;
Flash off time: 1 minute.

Top Coat:
Wet on wet application of Ford Engineering approved current production top coat materials, film thickness and baking as specified in the relevant Material specification.
Colours: Two coat silver metallic and solid colour black or white.

9009160 0013761 109

Copyright by the Ford Motor Company

Mon Aug 29 21:49:36 2016

Full document details: FORD WSK-M6J161-A 1991

Documents
Document Sharing Hub