



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PRIMER, TWO PACK, SUEDE COATING, INTERIOR

WSK-M6J164-A

1. SCOPE

The material defined by this specification is a two pack primer. It must be cured with a suitable isocyanate hardener.

2. APPLICATION

This specification was released originally for material used as two pack primer for the "Suede Coating" paint system.

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.

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

Date	Release No.	Release/Revision
1991-08-01	EP00E01089487000	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 42 %

The non-volatile content shall be determined at a spray viscosity of 20 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 shall be reduced with Thinner WSK-M14J246-A or equivalent.

- 3.5.5 Mixing Ratio As specified by the supplier

The material shall be cured with isocyanate hardener WSK-M99J363-A.

- 3.5.6 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: Polycarbonate, ABS, Polyamide or metallic substrates as required on Engineering Drawing.

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

- 3.6.2 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.