



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

PRIMER, STONE CHIP PROTECTION, 120 MICROMETRE

WSK-M6J165-A

1. SCOPE

The material defined by this specification is a solvent based stone peck protective baking primer for exterior automotive applications.

2. APPLICATION

This specification was released originally for material used as stone chip protection primer over baked EC surfaces on certain areas of bodies or assemblies where high stone chip resistance is required. The material is designed for baking together with primer surfacer.

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: Solvent borne synthetic resins.

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

Date	Release No.	Release/Revision
1991 09 02	EP00E01089488000	Released KW

WP 3948-a

Page 1 of 6

9009160 0013779 349



- 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 +/- 2 %;
(FLTM BI 102-01) min 70 %
- 3.5.2 Density See Initial Sample +/- 0.05 g/mL
(ASTM D 1475)

- 3.5.3 Viscosity As specified by the supplier

The primer is thixotropic. It shall be supplied in spray-viscosity.

- 3.5.4 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.

3.6 PREPARATION OF TEST PANELS (FLTM BI 103-02, Method B,b)

3.6.1 Substrates

- Standard steel panels per para 5.2

For Initial Approval only:

- Precoated steel panels as used in the plant

All substrates shall be zinc phosphated and conform to the requirements of WSK-M3P1-C.

3.6.2 Cathodic Electrocoat

Ford Engineering approved current production electrocoat primer, application and film thickness as specified in the relevant material specification.