



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

REPAIR PRIMER FILLER, TWO PACK,
AIR DRYING

WSK-M6J172-A1

1. SCOPE

The material defined by this specification is an acrylic based component forming part of a two pack airdrying or forced drying refinishing primer system. It is to be used in combination with the appropriate hardener in the ratio suggested by the supplier.

2. APPLICATION

This specification was released originally for a material to be used in conjunction with the designated hardener component as a priming system for sand-through areas on exterior automotive body surfaces.

The primer is applied directly over the substrate following damage and sand-through. The primed surface may then be lightly sanded and overcoated with either acid catalysed body stoving enamel or an approved two pack repair enamel system depending on the particular stage in the painting process in which the damage has been sustained in.

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 continually reduced.

3.2 INFRARED SPECTROPHOTOMETRY AND/OR THERMAL ANALYSIS

Ford Motor Company in its option, may conduct infrared and/or thermal analysis of materials/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.

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3.3 CONDITIONING

Test panels with stoved paint systems shall be aged for 72 h at 23 +/- 2 C or 16 h at 43 +/- 2 C before testing for resistance properties unless otherwise specified.

Test panels with completely air drying paint systems shall be aged for 7 days at 23 +/- 2 C or 36 h at 43 +/- 2 C before testing for resistance properties unless otherwise specified.

All tests according to this specification shall be performed in a controlled atmosphere of 23 +/- 2 C and 50 - 65 % relative humidity if not otherwise specified.

3.4 COMPOSITION

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|-------|------------------------------------|--|
| 3.4.1 | Resin | Acrylic or alternative synthetic resin with similar properties |
| 3.4.2 | Pigments/Extenders | Pigments and extenders to obtain the desired colour and sanding properties |
| 3.4.3 | Solvent Emissions
(ASTM D 3960) | Initial Sample +/- 1 % |

This requirement is as determined by the United States Environmental Protection Agency Method #24 and is only applicable to materials used in the USA.

3.5 MATERIAL PROPERTIES

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|-------|--|--|
| 3.5.1 | Non-volatile
(FLTM BI 102-01) | Initial Sample +/- 1 % |
| 3.5.2 | Density
(ASTM D 1475) | Initial Sample +/- 0.02 g/mL |
| 3.5.3 | Viscosity as
supplied
(FLTM BI 111-01) | Initial Sample +/- 5 s Ford 4 Cup
at 25 C |
| 3.5.4 | Spraying Viscosity
(FLTM BI 111-01) | As specified by the supplier |
| 3.5.5 | Mixing Ratio | As specified by the supplier |
| 3.5.6 | Dry Hiding Power, max
(FLTM BI 158-01) | 20 micrometre |
| 3.5.7 | Storage Stability | 90 days |

During a storage of 90 days between 5 and 32 C temperature the material shall not settle up or cake.