



**CAVITY WAX, SOLVENT BASED, 65% SOLIDS**

**WSK-M7C79-A**

**CAVITY WAX, HIGH SOLID, SOLVENT BASED, 85% SOLIDS**

**WSK-M7C79-A2**

## 1. SCOPE

The materials defined by these specifications are solvent based rust preventive compounds.

## 2. APPLICATION

These specifications were released originally for materials used as corrosion protective compound for automotive cavities. They form a soft, homogeneous film with good creepage and excellent corrosion protection. The material is applied to the vehicle after the paint process.

## 3. REQUIREMENTS

### 3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

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

### 3.4 COMPOSITION

Solvent based waxes and resins.

### 3.5 PHYSICAL PROPERTIES

3.5.1 Non Volatile Content  
(FLTM BI 102-01)

WSK-M7C79-A, min 65%

WSK-M7C79-A2, min 85%

3.5.2 Viscosity See Initial Sample

A flow diagram to identify the characteristic properties of the material shall be added to the Initial Sample Report, together with a list of the relevant test parameter (temperature, shear rate, time, etc.) and equipment details.

3.5.3 Density (ASTM D 1475) See Initial Sample  
+/- 0.05 g/mL

3.5.4 Creeping Ability, min (FLTM BJ 128-02) 20 mm

3.5.5 Flow Rate (FLTM BJ 128-01) See Initial Sample  
+/- 5 mm

The flow rate shall be determined at 20 °C and at 40 °C.

| Date       | Action  | Revisions                                                  |
|------------|---------|------------------------------------------------------------|
| 2004 03 17 | Revised | Pare 3.0 inserted; paras 3.1, 3.2, 3.3, 3.10 and 4 deleted |
| 1999 02 09 | Revised | Revised para 3.5.8                                         |
| 1991 02 01 |         | Released                                                   |



- 3.5.6 Color Beige or Amber
- 3.5.7 Appearance  
The wax shall dry to a smooth homogeneous film.
- 3.5.8 Storage Stability, min  
The storage stability must be adapted to the climate conditions at the individual plant.  
Min storage conditions for all waxes: 6 months at 32 °C  
and 6 months at 5 °C  
Additionally for tropical climates: 3 months at 40 °C  
After the storage, the material shall not show any insoluble separation or coagulation and must meet all specification requirements.

### 3.6 PREPARATION OF TEST PANELS

The back side of test panels shall be protected to avoid excessive rusting during the following resistance tests.

Panel edges, being subject of the investigation, must not be protected by any additional action.

- 3.6.1 Substrate  
(FLTM BJ 106-01, solvent wiped)
- 3.6.1.1 Ford Standard Steel Panels according to SAE J403 Steel or U-MA 18006, if not otherwise specified.
- 3.6.1.2 Welded test assemblies per para 5.2.
- 3.6.2 Wax Application  
Prior to application, the wax must be stirred for 15 minutes.  
Test Panels:  
The wax may be sprayed airless or air assisted as recommended by the supplier to provide a homogenous film.  
Test Assemblies:  
An excess of wax shall be sprayed to the vertically positioned assemblies to enable the wax creeping into the welded joint.  
Two minutes after the wax application, the assemblies shall be turned into a horizontal position for drying.
- 3.6.3 Application Temperature 20 – 25 °C
- 3.6.4 Drying Time 5 minutes  
(23 +/- 2 °C)
- 3.6.5 Dry Film Thickness on Test Panels 40 - 50 micrometer  
(FLTM BI 156-01 or gravimetrically)

