ACID CATALYST, CLEAR COAT SYSTEM, BAKING, EXTERIOR TOP COAT **WSK-M99J365-A**

1. SCOPE

The material defined by this specification is a solution of acid catalyst in organic solvents. It is to be used in a clear coat of a base coat/ clear coat system required to provide the best exterior quality metallic finish. It shall be suitable for spray application.

2. APPLICATION

This specification was released originally for a material to be used as an acid catalyst to make base coat/clear coat top coats suitable to use with relatively low baking temperatures.

The catalyst shall only be used for top coats/clear coats from the same source as required by the vendor. The amount of addition may vary depending on the quality of the top coats/clear coats specified. It is permitted to use acid catalysts from a source different to that of the top coat/clear coat if approved by Materials Laboratory of Product Engineering and agreed by the respective vendors.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

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).

3.3 ULTRA VIOLET SPECTROGRAPHIC ANALYSIS

All approved materials shall contain with Initial Sample Report an UV-spectroscopic analysis. The equipment used for this measurement is a Lambda 6 Integrating Sphere spectrophotometer or equivalent. This shall be recorded and filed by Quality Control or relevant Testing Laboratories of the Ford Motor Company.

Subsequent material UV-spectroscopic analysis shall correspond to the data of the Initial Sample.

3.5 FLASH POINT

The flash point shall conform to the safety regulations applicable to the plant and/or country where the material shall be used.

Date	Action	Revisions
2006 03 23	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.4, 3.11 and 4
2000 11 28	Revised	Updated & revised para 3.3 A. Cochran
1990 02 01	Released	C01031532 C. E. Herriott, concurred: J. Schult

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3.6 COMPOSITION

3.6.1 Acid

Essentially an acid dissolved in organic media in sufficient quantity and nature to effectively cure the acrylic resin clear coat system at reduced temperature.

3.6.2 Chlorinated Compounds

No chlorinated compounds permitted.

3.6.3 Specific Composition

When it is necessary to obtain specific data regarding material formulation, it is understood that the supplier will furnish such data on request.

3.7 PHYSICAL PROPERTIES

3.7.1	Non-volatile (FLTM BI 102-01)	No Requirement
3.7.2	Density (ASTM D 1475)	Initial Sample +/- 0.05 g/mL
3.7.3	Acid Number (ASTM D 1467)	Initial Sample +/- 5

3.7.4 Shelf Stability

During a storage of 6 months at room temperature, as supplied in the original container, it shall not discolor or gel. When mixed with the clear coat as received, it shall cause no gel or turbidity and must be free of settling which cannot be dispersed by normal agitation. The viscosity of the material shall not increase

3.8 PREPARATION OF TEST PANELS
(FLTM BI 115-02)

3.8.1 Amount of catalyst

Amount of acid catalyst % to be added to WSK-M32J125-A shall be specified by supplier.

3.8.2 Baking Cycles

In Plant Repair

Enamels containing acid catalyst. Bake 10 minutes at 100 °C metal temperature.

3.9 FILM AND RESISTANCE PROPERTIES

Film and Resistance properties shall be in accordance to the relevant requirements of Specification WSK-M32J125-A.

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