



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

GLAZING PASTE

WSK-M99J372-A

1. SCOPE

The material defined by this specification is a glazing paste.

2. APPLICATION

This specification was released originally for material used as glazing material for soldered areas on automobiles.

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.

3.3 ULTRA VIOLET SPECTROGRAPHIC ANALYSIS (FLTM tbd)

All approved materials shall contain with Initial Sample Report a UV-spectroscopic analysis. 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.

Date	Release No.	Release/Revision
1991 03 01	EP00E01089482000	Released C E Herriott concurred J Schult

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3.4 CONDITIONING

All panels 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.

In the event of differences between test results, the results after aging at room temperature shall govern.

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.

3.5 COMPOSITION

3.5.1 Resin

Epoxy Ester based on semi-drying fatty acids.

3.5.2 Pigment

Suitable materials to provide the physical and resistance properties of this specification. The material must contain an adequate amount of metallic and non-metallic pigments in order that electrocoating of dried glazing paste with Ford approved current electrocoat is possible.

3.5.3 Solvent

Ethylglycolacetate

3.5.4 Specific Composition

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

3.5.5 Special Data

All initial and batch submissions must indicate density and non-volatile content as supplied on the sample report.