



ENAMEL, AIR DRY CHASSIS

WSS-M1J217-A1

ENAMEL, AIR DRY CHASSIS

WSS-M1J217-A2

1. SCOPE

The materials defined by these specifications are air drying enamels suitable for application over chassis and transmission components such as gearbox housings, rear axle assemblies, drive shafts and suspension units.

2. APPLICATION

These specifications were originally released to describe black or suitably colored air drying enamels, for use as one-coat finishes over ferrous substrates, or on previously primed surfaces. The coatings specified should be suitable for pneumatic, electrostatic, and airless spray application.

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

3.4.1 Vehicle

The resin shall be based on a suitable synthetic system to obtain the desired application and resistance properties.

3.4.2 Pigment

The pigment shall be balanced and blended to give the desired color, normally black, unless specified on the component drawing.

3.4.3 Solvent

Solvents should be balanced in order to provide suitable storage and application viscosity's, whilst at the same time avoiding flocculation and maintaining correct solvent emission levels.

Date	Action	Revisions
2007 12 18	Revised	Updated Format; No Technical Change
2003 06 10	Revised	Para 3.0 inserted; para 3.1, 3.2, 3.3, 3.10, 3.11 and 4 deleted
1998 11 17	Activated	



3.4.4 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.

It may be necessary to supply such information in order to clarify the toxicological status of the material with respect to National or Local Protection Agency constrictions.

3.5 PHYSICAL PROPERTIES

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|-------|---|--|
| 3.5.1 | Non-Volatile
(FLTM BI 102-01) | Initial Sample +/- 1.00% |
| 3.5.2 | Density
(ASTM D 1475) | Initial Sample +/- 0.05 g/mL |
| 3.5.3 | Viscosity As
°C Received
(FLTM BI 111-01) | Initial Sample +/- 5 s FC-4/25 |
| 3.5.4 | Viscosity As Used
(FLTM BI 111-01) | As Recommended by Supplier |
| 3.5.5 | Shelf Stability
(Storage Stability)
(FLTM BI 102-03) | No excessive change in
viscosity and no noticeable
hard settling |
| 3.5.6 | Flash Point
(ASTM D 56) | |
| | The flash point shall conform to the safety regulations applicable to the plant and/or country where the material is used. | |
| 3.5.7 | Solvent Emissions | |
| | The volatile portion of this material shall meet the applicable requirements of the local air pollution control for the assembly plants in which the coating is used. | |

3.6 PREPARATION OF TEST PANELS (FLTM BI 103-02)

3.6.1 Substrate

Ford Engineering Approved Standard Body Steel, or Steel used in the manufacture of the associated Chassis component.

In the absence of the appropriate Steel, Ford Standard Paint Test Panels may be used, UMA 18001 or UMA 18006.