



PRIMER, ACTIVATOR, FOR ANAEROBIC PRODUCTS

WSS-M2G414-A1

1. SCOPE

This specification outlines the characteristics and properties of a single component, non-CFC solvent based organo-copper salt adhesive accelerator designed to decrease the cure time of anaerobic adhesives.

2. APPLICATION

This specification was released as a material used to promote cure speed and increased gap fill. The primer is intended to be used on ferrous and aluminum metals with anaerobic adhesives such as WSK-M2G349-A_ retaining compounds and WSK-M2G351-A_ thread locking compounds.

3. REQUIREMENTS

3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

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

3.2 PREVAILING TORQUE TEST

4.5 - 28.3 Nm

(ASTM D5649, ISO 10964, 6 hours at 23 °C)

Breakaway Torque – the initial torque required to break the bond measured at the first movement between the nut and bolt when unscrewing an unseated assembly.

Prevailing Torque – after the initial breakage of the bond, the average of four torque readings measured at 90°, 180°, 270° and 360° rotation of the nut.

Use Loctite Grade A thread sealant for all testing.

Test Specimens

Threaded fasteners, 3/8 inch diameter, 24 threads per inch. Unified National Fine thread series, Class 2A/2B fit hexcap screws and nuts. The minimum length of the hexcap screws is one inch. Hex nuts, conforming to Federal Specification FF-N-836D, are nominally 21/64 inch thick, heavy.

Take all hexcap screws and nuts in a series of tests from one lot.

3.3 OPEN TIME

The substrate shall be dry to the touch prior to applying the anaerobic adhesive/sealant. Maximum open time shall not exceed one hour and primer applied surfaces shall be kept free of contamination (e.g. dirt, heavy dust, oils, grease, alcohol, etc.).

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3.4 STORAGE STABILITY

Shall be stored at the temperature range of 4 - 26 °C in a tightly closed container away from all sources of heat such as ovens, direct sunlight, etc., and oxidizing materials. Under these storage conditions the maximum shelf life of the material from date of shipment from the supplier shall be 12 months.

4. GENERAL INFORMATION

The information below is provided for clarification and assistance in meeting the requirements of this specification. Contact gmfs@ford.com for questions concerning Engineering Material Specifications.

4.1 FLASH POINT, min -20 °C (-4°F)
(ASTM D 56, tag closed cup)

4.2 COLOR Transparent green liquid
(Visual Evaluation)

4.3 DRYING TIME

Primer may be applied by brush, spray or dipping. The primer has a drying time of less than 2 minutes. After the primer is dry, the parts are ready for bonding with the anaerobic adhesive.