



PAINT PERFORMANCE, PRIMED PLASTIC PARTS, INTERMEDIATE STORAGE

WSS-M2P164-B

1. SCOPE

This specification defines performance requirements for primed plastic parts that are stored or shipped after priming prior to top coat application.

2. APPLICATION

This specification was released originally to define performance requirements of primed plastic parts such as filler flaps or body side moldings. They shall be topcoated later with current approved paint materials. This specification may also be used for interior applications.

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 SYSTEM COMPONENTS

3.2.1 Substrate

ABS, Polycarbonate, Polyamide, Polyurethane, Polypropylene or as specified on Engineering Drawing.

3.2.2 Plastic Preparation

The surface to be painted shall be cleaned by an acceptable process, e.g. power wash, to remove mold releasing agents, fingerprints, oils, dirt and moisture.

For Polypropylene Substrates a pretreatment, e.g. by flame process, corona discharge or plasma, may be necessary prior to painting to provide sufficient paint adhesion.

3.2.3 Primer

Application of an adhesion primer or primer surfacer, film thickness and baking as required in the relevant Material Specification or as specified on Engineering Drawing.

Date	Action	Revisions	Rev 01
2015 01 27	Editorial	See Summary of Revisions	M. Corley EU
2006 10 23	Activated		A. Weakley



3.2.4 Ageing

Test panels or test specimens prepared for investigations according to this specification must be aged for at least 72 hours at 23 +/- 2 °C or 16 hours at 45 +/- 1 °C prior to testing if not otherwise required in the relevant primer Material Specification.

3.2.5 Production Paint Repair

Repaired areas must meet the requirements of this specification. All repair materials and processes used must be approved by the affected Product Engineering Office. Maximum film thickness for repaired parts will be specified in the mutually agreed control plan.

3.3 APPEARANCE

Color and gloss of the primed part shall be as required in the relevant primer material specification or as specified on Engineering Drawing.

Color and gloss of the finished part shall meet the requirements of the relevant paint performance specification.

3.4 RESISTANCE PROPERTIES

3.4.1	Adhesion (FLTM BI 106-01, Method B)	Grade 0
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3.4.2	Water Immersion Test (FLTM BI 104-01)	24 h
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No blistering, softening or loss of adhesion per 3.4.1.

3.4.3	Resistance to Water Spotting max. discoloration (FLTM BI 113-01, no soap spotting)	Rating 4
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Evaluation according to the AATCC Scale.

3.4.4	Abrasion Resistance (SAE J948, CS-10 wheels, 1,000g load)	200 cycles
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Abrasion resistance shall be determined on flat sections cut from components. If that is not possible, flat ungrained test panels processed through the production facility, with the production paint film thickness, may be used. The PSW and the Control Plan shall state the film thickness.

The paint film shall show no abrasion through to the substrate.

3.5	ENVIRONMENTAL CYCLING (Initial Approval Only) (FLTM BQ 104-07, Procedure 5)	3 cycles
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Evaluation after 20 h conditioning at 23 +/- 2 °C.

No cracking, no blistering, no loss of adhesion per 3.4.1.