



PRIMER, GLASS, SILANE, ONE STEP, UV DETECTABLE

▽ WSS-M5B280-C4

PRIMER/CLEANER, GLASS, TRANSPARENT

▽ WSS-M5B280-C5

1. SCOPE

The materials defined by these specifications are glass cleaners/adhesion promoters that deposit monomolecular films and also remove surface contaminants.

2. APPLICATION

These specifications were released originally for materials used to clean and condition windshield glass prior to the application of adhesion promoting primer (▽ WSS-M2G314-B2). (These primers should be applied by means of a brush, felt or other suitable applicator.

WSS-M5B280-C4 is a one step glass primer. WSS-M25B280-C4 is not to be used as a one step glass primer with adhesive materials conforming to WSB-M2G316-B, and WSS-M2G316-B2/B3/B5.

2.1 MANUFACTURING PROCESS RECOMMENDATION

These primers are moisture sensitive and require special handling for manual and automated process. Please contact supplier or the Material Engineering for current process standards.

- Approved suppliers are responsible for maintaining the accuracy and relevancy of these process parameters (in their Process Standard). Approved suppliers must submit any changes to these process parameters in a timely manner (within 30 days) for review and approval by Materials Engineering, Vehicle Operation, and Product Development Engineer.

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).

Date	Action	Revisions
2008 11 06	Revised	Completely revised; Updated 2.1 and deleted Table 1 and Table 2, See summary of Revisions. Mukta Mehandru, FNA
2007 04 19	Revised	Inserted 2.1, 4.4.4, Table 1 and Table 2; Revised 4.4 M. Mehandru
1990 02 08	Released	NB00E00179051000 K. King, E. R. Rezendes

**3.2 COLOR**

▽ WSS-M5B280-C4
▽ WSS-M5B280-C5

Transparent Light Yellow
Transparent Red/Any
color but clear

3.2.1 Fluorescence on Glass Under Long-Wave UV Light

This provision applies to WSS-M5B280-C4 primer. When the primer (within shelf life) is applied to glass, it will fluoresce when a BLAK-RAY Model B 100AP lamp or similar source illuminate the glass. The fluorescence is not a permanent feature of the primer after it is applied to the glass.

3.3 VISCOSITY, max
(FLTM BI 111-01, No. 1, Zahn Cup)

▽ WSS-M5B280-C4
▽ WSS-M5B280-C5

25 – 40 s
25 – 40 s

3.4 WEIGHT PER VOLUME
(ASTM D 1475)

The weight tolerance for any one supplier shall be +/- 0.075 kg/L based on the weight of the original approved production sample (see para 4.3).

3.5 DRYING RATE, max

▽ WSS-M5B280-C4
▽ WSS-M5B280-C5

30 minutes
1 minute

Test Method: Apply a 0.008 - 0.013 mm film of primer 25 mm wide to a 75 x 75 mm clean glass plate. To determine the primer drying rate, immediately at rapid intervals, dab the primer film with a wad of absorbent cotton. Observe if any of the cotton fibers adhere to the primed surface. Record the drying rate, as the time elapsed from the initial primer application until the cotton fibers do not adhere to the primer. Note: The drying rate is longer for the C3 suffix material due to the type of solvent. C4 is a one step clear primer and thus has a different drying rate. Actual differences in drying rate as processed through the assembly plant are negligible.

▽ **3.9 STORAGE STABILITY**

Shall be stored at ambient room temperature below 35 °C, away from all sources of heat such as ovens, direct sunlight etc. The material should not be stored outside. Under these storage conditions, the maximum shelf life of the material in unopened containers shall be six (6) months from date of **receipt at Ford Motor Co.**

Material may not be used after the expiration date unless the supplier has given written documentation to Materials Engineering and the affected Manufacturing Plant that the material conforms to requirements outlined in the material control plan. The supplier shall also indicate in the letter the number of additional days the material will be usable.