PRIMER SURFACER, MODIFIED POLYESTER, CHIP AND SCRATCH INHIBITING	**WSS-M6J152-B1**
PRIMER SURFACER, MODIFIED POLYESTER, CHIP AND SCRATCH INHIBITING, REDUCED VISCOSITY	**WSS-M6J152-B2**
PRIMER SURFACER, MODIFIED POLYESTER, CHIP AND SCRATCH INHIBITING, FOR USE WITH WATERBORNE BASECOATS	**WSS-M6J152-B3**
PRIMER SURFACER, MODIFIED POLYESTER, CHIP AND SCRATCH INHIBITING, FOR UNIVERSAL USE WITH WATERBORNE OR SOLVENT BORNE BASECOAT SYSTEMS	**WSS-M6J152-B4**
PRIMER SURFACER, MODIFIED POLYESTER, CHIP AND SCRATCH INHIBITING, REDUCED VISCOSITY, FOR UNIVERSAL USE WITH WATERBORNE OR SOLVENT BORNE BASECOAT SYSTEMS	**WSS-M6J152-B5**

1. SCOPE

The materials defined by these specifications are polyester primer surfacers, modified with either urethane or acrylic resins, possessing good gloss, enamel holdout, and protect against chip damage. They are formulated to cure at 135 °C min metal temperature.

2. APPLICATION

These specifications were originally released as guidecoats over currently approved cathodic electrocoat primer, conforming to performance requirements or related specifications, for both steel and primed plastic substrates. Application is targeted for high efficiency electrostatic equipment. Automotive exterior baking enamels, solvent borne basecoats, and/or water borne basecoats will be applied over these primers in exterior body applications.

WSS-M6J152-B1, B3, and B4

The material defined by these specifications is supplied at normal viscosity and solids level as shown in this document.

WSS-M6J152-B2 and B5

The material defined by these specifications is supplied with reduced viscosity such that they are ready for use in the assembly plants. The reduced viscosity and associated reduced solids levels shall be agreed upon by the supplier, the affected assembly plant, Global Paint Engineering, and Production Purchasing prior to delivery of the materials to the respective assembly plant.

3. REQUIREMENTS

Tests shall be made on the basis of comparison with approved production material applied and tested under identical conditions.

Date	Action	Revisions
2008 05 30	Revised	NO TECHNICAL CHANGES MADE; Inserted 3.0; Deleted 3.1, 3.2, 3.10, 3.12 & 4
1997 12 01	Released	T. Weingartz

Printed copies are uncontrolled
Copyright © 2008, Ford Global Technologies, LLC
Licensee=/, User=,
Not for Resale,
Copyright Ford Motor Company
Provided by IHS Markit under license with FORD
No reproduction or networking permitted without license from IHS
Full document details: FORD WSS-M6J152-B2 2008
Documents Document Sharing Hub

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).

3.3 COMPOSITION

3.3.1 Vehicle

Modified Polyester crosslinkable resin(s), with melamine or blocked isocyanate crosslinker(s).

3.3.2 Pigmentation

Colorants, extender, and filler pigments obtain the desired color and resistance properties. Photo-oxidizable pigments are not permitted.

3.3.3	Volatile Organic Compounds (V.O.C.), max (ASTM D 3960 except bake schedule is 60 minutes at 110 +/- 2 C)	0.5 kg/L as sprayed

The volatile portion of this material shall meet the applicable requirements of the local air pollution control for the assembly plants in which the primer is used.

3.3.4	Non-Volatile (FLTM BI 102-01)	Initial Sample +/- 2%, min 60%

3.4 PHYSICAL PROPERTIES (LIQUID STATE)

3.4.1 Stability
(FLTM BI 102-03)

Heat Stability	Shall not jell, settle hard or increase viscosity in excess of 10 s
Room Temperature	No hard settling after 16 h with stability test sample reduced to spray viscosity with the supplier's recommended solvent or blend

3.4.2	Electrical Properties	Resistivity: 0.05-0.5 megaohms

Suitable to permit application at high transfer efficiencies using electrostatic equipment.

3.4.3	Viscosity (FLTM BI 111-01)	Initial sample +/- 10 s

Final approval of a specific material viscosity shall be made by the affected manufacturing activity. In all cases the viscosity shall be within specification limits as identified on the material control plan.

--`,,```,,,,````-`-`,,`,,`,`,,`---

Documents
Document Sharing Hub

Copyright Ford Motor Company
Provided by IHS Markit under license with FORD
No reproduction or networking permitted without license from IHS
Full document details: FORD WSS-M6J152-B2 2008

Printed copies are uncontrolled

Copyright © 2008, Ford Global Technologies, LLC
Licensee=/, User=,
Not for Resale,

3.4.4	Density (weight per volume) (ASTM D 1475)	Initial Sample +/- 0.05 g/ml

3.5 PREPARATION OF TEST PANELS

Prepare test panels per FLTM BI 103-02, Method C, using the viscosity specified by the supplier and a dry film build of 30 +/- 5 micrometers. Use the following substrates:

3.5.1 Substrates

. Unpolished cold rolled steel zinc phosphated panels conforming to the requirements of WSK-M3P1-C.

. WSB-M1A250 galvanized steel zinc phosphated panels conforming to the requirements of WSK-M3P1-C.

. Exterior thermoplastic and thermosetting plastic parts primed to conform to current production requirement.

On metal substrates, all candidate primers shall be tested as a guidecoat, directly over an approved current production electrocoat primer. On plastic substrates, all candidate primers shall be tested as a guidecoat, over primed plastic. Two sets of plastic panels shall be prepared:

. Set I: An electrocoat primer bake is simulated. The panels are allowed to return to room temperature prior to applying the candidate primer.

. Set II: The candidate primer is applied without simulating an electrocoat primer bake.

All submissions will be tested at both min and max primer surfacer bake cycles (para 3.5.8).

3.5.2 Primers Only with Sand-through Area

Prepare panels in the following manner:

. Substrates: Cold rolled steel, galvanized steel, and plastic with conductive primer.

. Electrocoat primer (metal substrates only): Prime per FLTM BI 120-01 and bake at 10 minutes at 182 +/- 2 °C metal temperature (20 minutes at 182 +/- 2 °C laboratory oven).

. Sanding: Allow panel to cool to room temperature. Using 320 grit sandpaper, make a 30 mm diameter bullseye through the primer, exposing the substrate. Clean the substrate and primer dust off of the panel.

. Primer surfacer: Apply 30 +/- 5 micrometers of the candidate primer. Bake at both cycles shown in para 3.5.8.

Documents
Document Sharing Hub
Copyright Ford Motor Company
Printed copies are uncontrolled
Provided by IHS Markit under license with FORD
No reproduction or networking permitted without license from IHS
Full document details: FORD WSS-M6J152-B2 2008
Copyright © 2008, Ford Global Technologies, LLC
Licensee=/, User=,
Not for Resale,