

**PRIMER, ADHESION, ONE PACK,  
PREPRIMED PLASTIC PARTS, 5-15 MICROMETER****WSS-M6J157-C****1. SCOPE**

The material defined by this specification is a solvent based high flexible adhesion primer for preprimed parts which have been shipped from a different location.

**2. APPLICATION**

This specification was originally released for material used as adhesion primer on preprimed exterior plastic components for Explorers made in Russia

**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 COMPOSITION**

3.2.1 Resin: Synthetic resins

3.2.2 Pigments: Pigments to obtain the desired properties for the adhesion primer.

**3.3 MATERIAL PROPERTIES**

3.3.1 Non-volatile (FLTM BI 102-01) see Initial Sample +/- 1 %;  
min. 10 %

The non-volatile content shall be determined at a spray viscosity of 20 s according to para 3.3.4.

3.3.2 Density (ASTM D1475) see Initial Sample +/- 0.02 g/mL

3.3.3 Viscosity as supplied (FLTM BI 111-01) see Initial Sample +/- 5 s

3.3.4 Spray Viscosity (FLTM BI 111-01, Ford Cup 4) as specified by the supplier

The material can be reduced with xylene, butyl acetate, or any other suitable thinner.

| Date       | Action    | Revisions                      | Rev. 0 |
|------------|-----------|--------------------------------|--------|
| 2013 10 24 |           | Editorial correction to header |        |
| 2013 09 24 | Activated |                                |        |

**Documents**

M. Corley, Ford

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## 3.3.5 Storage Stability

### 3.3.5.1 Heat Stability (FLTM BI 102-03)

Paint shall not jell, settle hard, or increase viscosity in excess of 10s

### 3.3.5.2 Stability after Aging

During a storage of 90 days between 5 and 32 °C the material as supplied shall not settle or cake and must pass all specification requirements.

## 3.4 PREPARATION OF TEST PANELS

### 3.4.1 Substrate

Preprimed plastic parts as specified on Engineering Drawing. All tests shall be performed on panels with a smooth, ungrained surface.

### 3.4.2 Plastic Preparation (see also 3.6)

The surface to be painted shall be cleaned by an acceptable process, e.g. IPA wipe, pressurized air, to remove fingerprints, oils, dirt and moisture, etc.

### 3.4.3 Adhesion primer application

Dry film thickness:

5 - 15 micrometer

Flash off:

10 minutes at room temperature

Baking:

not required

### 3.4.4 Top coat application

Application of currently used one pack base and two pack clear coat systems, film thickness and baking as specified in the relevant material specification.

### 3.4.5 Aging

Test panels prepared under this specification shall be aged for at least 72 h at 23 +/- 2 °C or 16 h at 45 +/- 1 °C before testing for resistance properties.

## 3.5 APPEARANCE (Primer only)

### 3.5.1 Light grey color (FLTM BI 109-01)

### 3.5.2 Gloss matte or semi gloss

## 3.6 RESISTANCE PROPERTIES

Test Panels and plastic parts painted according to para 3.4 of this specification shall meet all the requirements of the applicable performance specification: WSS-M2P180-D/Latest for rigid substrates or WSS-M2P181-C/Latest for flexible substrates).

## 3.7 APPLICATION

The adhesion primer must be adaptable for application in accordance with the appropriate Ford Motor Company Process Specification.

The adhesion primer must be compatible with all related materials, e.g. top coat, primer, substrate, etc.

