



CAVITY WAX, HEAT KICK 60 °C,
IMPROVED CREEP CHARACTERISTIC
CORROSION PROTECTION, AUTOMOTIVE CAVITIES

WSS-M7C97-A

CAVITY WAX, HEAT KICK 60 °C,
IMPROVED CREEP CHARACTERISTIC, LOW VISCOSITY
CORROSION PROTECTION, AUTOMOTIVE CAVITIES

WSS-M7C97-A2

1. SCOPE

The materials defined by these specifications are solvent free based rust preventive compounds with minimum >99% solid content and contain an UV- marker.

2. APPLICATION

These specifications were originally released for cavity waxes sprayed into box sections below the floor panel (rocker panel, side and cross members, etc.), in the engine compartment and to lower areas of pillars, doors, hood and tailgate. They are applied to the vehicle body after the paint process, prior to final assembly.

WSS-M7C97-A is designed for the standard process where the tilting table is located after the heat kick oven.

WSS-M7C97-A2 was designed for paint shops where the tilting table is located before the bodies enter the heat kick oven

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 MATERIAL PROPERTIES

3.2.1 Non Volatile content >99% min
(FLTM BI 102-01)

3.2.2 Rheology

A flow diagram to identify the characteristic properties of the material shall be added to the Initial Sample Report, together with a list of the relevant test parameter (temperature, shear rate, time, etc.) and equipment details.

Date	Action	Revisions	Rev. 1
2011 09 02	Revised	Revised document and added A2 suffix	U. Mueller, FoE
2009 03 31	Activated		U. Mueller



- 3.2.3 Flow rate
(FLTM BJ 128-01, apply 0.1ml droplets)

Immediately after the application

	For WSS-M7C97-A	WSS-M7C97-A2
At 23°C	55 - 65 mm (+/-5 mm)	165 – 265 mm (+/-15 mm)
At 60°C	165 –325 mm (+/-15 mm)	150 – 235 mm (+/-15 mm)

- 3.2.4 Creeping Power
(FLTM BJ 128-02, Method A)

At 23°C 20 mm (+/-2mm) min

At 60°C 35 mm (+/-2mm) min

- 3.2.5 Drying

Film thickness on test panels 35 +/- 5 µm,
Oven heat ("Heat kick") material to 60°C for 1 min

Wax according to this specification requires a heat kick to change the material to a drip free state

Immediately after heating and cooling down to RT the material must be drip free.

- 3.2.6 Storage Stability 6 months at 32 °C
3 months at 40 °C

General storage must be frost free.
After the storage, the material shall not show separation or coagulation and must meet all specification requirements.

3.3 PERFORMANCE PROPERTIES

Wax according to these specifications must meet all requirements of WSS-M21P35-A2.

3.4 REMOVAL

The wax film must be removable from automotive topcoats and application facilities at any time without damaging the painted surface. The supplier must recommend a suitable solvent/cleaner process in the Initial Sample Report.

Relevant topcoat systems are: Body enamel, catalyzed repair enamel, plastic paint, repair paint materials.