

ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

**FELT, PAPER - ASPHALT SATURATED - PRESSURE SENSITIVE
ADHESIVE ONE SIDE**

Ñ ESB-M2E73-C

1. SCOPE

The material defined by this specification is a paper felt, asphalt saturated with a pressure sensitive adhesive on one side.

2. APPLICATION

This specification was released originally for material used as access hole sealers for the 1982 Ford/Mercury.

3. REQUIREMENTS

The requirements herein are based on material without release paper unless otherwise specified.

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 WEIGHT 1.3 +/- 0.1 kg/m²
(ASTM D 461)

3.3 THICKNESS, AS RECEIVED 2.3 +/- 0.2 mm
(ASTM D 461)

3.4 ASPHALT CONTENT 12-20 %
(ASTM D 461, Trichlorethylene Method)

3.5 WATER ABSORPTION, max 20 g
(FLTM BS 4-2, test adhesive surface)

3.6 BREAKING STRENGTH, min
(ASTM D 461)

WMD 111 N
AMD 66 N

Date	Action	Revisions
2002 10 15	Revised	Updated and renumbered
1983 02 23	3.5, 3.7, 3.9	Revised A3D40895/CDM1-MF 502508-1
1981 11 12		Released AM1-6000-66

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3.7 STIFFNESS, 30° DIRECT READING, max 82
(ASTM D 747, 25 x 100 mm sample,
50 mm span, 0.08 N.m moment, adhesive
side down, avg. of 3)

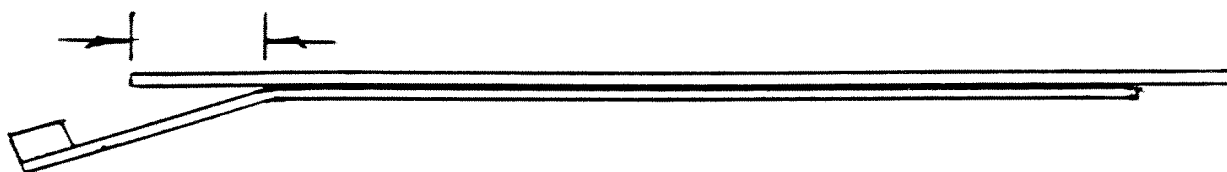
3.8 FLEXIBILITY AT 23 +/- 2 °C

No cracking when bent 180° around a 51 mm mandrel with the adhesive side to the outside.

3.9 ADHESIVE PERFORMANCE, max 25 mm
(Avg. of 3)

Test Procedure: The adhesive coated felt paper must support a 70 g dead load in a peel condition over a 71 mm wide area when tested as follows:

- A Cut three 71 x 254 mm test specimens and remove release liner.
- B Bond test specimens to a 76 x 305 mm "E" coated test panel, allowing a 25 mm overhang.
- C Roll each test specimen with 910 g +/- 5% (25 mm diameter x 203 mm long) roller, one forward and one return roll.
- D Firmly press a 70 +/- 2 g (11 x 11 x 71 mm) steel bar onto the outermost edge of the exposed adhesive surface.
- E Suspend each panel so that it is in a horizontal plane with the test specimen bonded to the underside. Expose panels for 24 h at room temperature followed by 24 h at 71 +/- 2°C in a mechanical convection oven.
- F Measure the amount of felt separation from the steel panel. Measure from the front of the steel panel to the felt portion still bonded.



3.10 ODOR

Shall be free of obnoxious odors.

3.11 MILDEW RESISTANCE

No visual evidence of mildew growth and no mildew odor after 7 days exposure in a humidity cabinet controlled to 100% R.H. at 38 °C