FIBERBOARD (PANEL), COATED **ESB-M3E13-A**

FIBERBOARD (PANEL), COATED **∇ ESB-M3E13-B**

PAPERBOARD, KRAFT LINED - BENDING GRADE, COATED **ESB-M3E13-C**

1. SCOPE

The material defined by these specifications is a vinyl, pyroxylin or equivalent coated, semi-waterproof ESB-M2E13 panel-board containing a maximum of 13% asphalt resin in the core ply. The ESB-M3E13-C board has outer plies of virgin kraft paper.

2. APPLICATION

These specifications were released originally for material used for constructing automotive cowl panels or for similar interior trim applications. The ESB-M3E13-C specification was released originally for materials used for the construction of luggage compartment front and sides where a better bending board was desired in the 1982 T'Bird and XR7 carlines.

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 APPEARANCE
(FLTM BI 109-01)

The color, pattern, and finish shall match the approved Design Center master sample, or shall be as specified on the engineering drawing.

3.3 MOISTURE CONTENT — 4 – 9%
(ASTM D 644, 4 x 4 in (100 x 100 mm) samples, based on original weight)

3.4 WATER ABSORPTION, max — 25%
(SAE J315, 1-1/2 h immersion)

3.5 WARP, max
(FLTM BS 002-01, 1-1/2 h water immersion)

WMD	5%
AMD	9%

Date	Action	Revisions
2006 10 17	Revised	ESB-M3E13-D inactivated and removed, replaced by ESB-M3E13-C; Revised 1, 2, 3.16 & 3.18 R. Lord
2003 01 29	Revised	Para 3.0 inserted; para 3.2, 3.19, 4 deleted
1963 07 02	Released	ESB-M3E13-A AS1-965

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
Printed copies are uncontrolled
Copyright © 2006, Ford Global Technologies, LLC
Licensee=/, User=,
Not for Resale,
Full document details: FORD ESB-M3E13-A 2006

3.6 DIMENSIONAL STABILITY
(SAE J315, Methods "B & C")

	Expansion, % max	Contraction, % max
WMD	+0.5	-0.5
AMD	+1.5	-1.5

3.7 BURSTING STRENGTH, min
(ASTM D 774, 5 bursts on each side of 3 specimens) — 4 psi/0.001 in (1.1 MPa/mm) of thickness

3.8 STIFFNESS, min
(ASTM D 747, Tinius Olsen Stiffness Tester, direct load reading at 5° angle, 2 in (51 mm) span, 2.5 lb. in (0.28 N m) load on a 1 x4 in (25 x 100 mm) sample (4 test average)

WMD	65
AMD	15

3.9 DIMENSIONS
(ASTM D 645, Method "A") — As specified on engineering drawings

Coating and embossing the basic panel-boards, ESB-M2E13, may result in an allowable 0.004 in (0.10 mm) maximum thickness loss.

Example:	Coated Board (ESB-M3E13)	Basic Board (ESB-M2E13)
	0.066 - 0.075 in (1.68 - 1.91 mm)	0.070-0.075 in (1.78-1.91 mm)

3.10 COATING QUALITY

Shall be of a good grade, containing sufficient oils and pigments to give the film the desired color and softness. The plasticizer content shall be rigidly controlled to prevent "spewing", as determined in para 3.11.

3.11 HEAT AGING

The coating shall exhibit no evidence of spewing and no more surface discoloration than that of the master sample (as approved for production by the Textile and Acoustic Engineering Laboratory, Body Materials and Corrosion Protection Engineering Department) on file in the testing laboratories after heat aging in a mechanical convection oven maintained at 82 +/- 3 °C for 7 days. Vinyl, pyroxylin or equivalent coatings, which exhibit properties equal to that used on the master sample (as approved for production by the Textile and Acoustic Engineering Laboratory, Body Materials and Corrosion Protection Engineering Department) may be used.

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
Printed copies are uncontrolled
Full document details: FORD ESB-M3E13-A 2006
Copyright © 2006, Ford Global Technologies, LLC
Licensee=/, User=,
Not for Resale,