



ADHESIVE, FILM - PRESSURE SENSITIVE ACRYLIC WITH BIOCID

ESB-M3G133-A

1. SCOPE

The material defined by this specification is an acrylic pressure sensitive adhesive film protected with a release liner on both sides.

2. APPLICATION

This specification was released originally for material used to bond landau roof construction supported vinyl and pad materials to each other and to painted metal surfaces. The adhesive film is pre-applied to the vinyl or padding material. The composite material is then die cut into parts and shipped to the assembly plant for use.

3. REQUIREMENTS

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 PHYSICAL CHARACTERISTICS

In addition to the requirements listed herein, parts utilizing this material shall meet all the requirements of applicable composite specifications and performance specifications

3.4 THICKNESS, WITHOUT RELEASE LINERS 127 μm +/- 13 μm
(ASTM D 1000)

3.5 WEIGHT, WITHOUT RELEASE LINERS, min 112 g/m^2
(BN 106-01)

3.6 RELEASE LINER REMOVAL, max
(ASTM D 413, Machine Method,
mm/min crosshead speed)

The pull necessary to separate the release liner from the adhesive on a 51 mm wide strip in the machine and across machine directions shall not be greater than as follows:

3.6.1	Liner:	29 kg/ream, Kraft paper Silicone treated one side	150 g
3.6.2	Carrier:	.06 mm polyethylene Silicone treated one side	300 g

Destruction of the release liner or removal of adhesive with the release line shall be cause for rejection.

Date	Action	Revisions
2005 10 19	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.15, 4
1983 12 01	Released	CAN1-AF504764





3.7 180 ° PEEL ADHESION, min
(ASTM D 903, the material shall
be tested in composite form as
described in paragraph 2)

- Prior to testing condition composites 72 h at 23 +/- 2 °C
- After environmental exposure, condition exposed composites 72 h at 23 +/- 2 °C.

Top Material To:			Foamed Pad To:	Fiber Pad* To:
<u>Painted/Plastic Surfaces</u>	<u>Foamed Surfaces</u>	<u>Fiber Pad* Surfaces</u>	<u>Painted/Plastic Surfaces</u>	<u>Painted/Plastic Surfaces</u>
3.7.1 Original				
1587 g	1814 g	1360 g	2267 g	1587 g
3.7.2 Environmentally Exposed				
2494 g	1133 g	1814 g	1587 g	907 g

- 14 days at 70 +/- 2 °C
- 7 days at 102 +/- 2 °C
- 14 days at 95-100% RH and 38 +/- 2 °C
- Thermally Cycled (10 times) as listed:
4 h at 88 +/- 2 °C, 4 h at -29 +/- 2 °C,
16 h at 95-100% R.H. and 38 +/- 2 °C

- 1600 h Weatherometer (FLTM BO 101-01)
- 1 year Florida exposure (direct weathering, variable angle south)

NOTE: Adhesive peel adhesion shall be as specified, or greater than internal strength of the substrate.

*Pre-Calendared fiberpad surfaces

Sample Preparation: Prepare 3 specimens per test, specimen size 25 x 254 mm, laminate components with this adhesive per table above, and roll the bonded specimens with a 2.0 kg roller (ASTM D-1000) using two forward and back strokes along the length within 5 s after contact. Separate 5 mm of bond by hand for attaching to clamps of the testing machine. Cross head speed for testing to be 300 mm/min.

3.8 VACUUM RESISTANCE, min
(FLTM BN 027-02, applies only to landau tops
bonded directly to painted or plastic surfaces)

28 kPa

