



TAPE ADHESIVE, SINGLE SIDE, PVC

ESK-M3G142-A

1. SCOPE

The material defined by this specification is a vinyl pressure sensitive adhesive tape without release paper backing.

2. APPLICATION

This specification was originally released for an adhesive tape to protect the front spoiler against waxing/dewaxing compounds.

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).

3.1 DIMENSION

3.1.1	Width (Sliding gauge)	See clause 5.2
3.1.2	Thickness (ASTM D 1000)	0.13 +/- 0.03 mm

3.2 COLOR

See clause 5.3

3.3 MASS per m2

160 +/- 20 g

3.4 BREAKING STRENGTH, min (ASTM D 1000)

50 N/25 mm width

3.4.1 Elongation

150 +/- 30%

3.5 PEEL STRENGTH at 180 °C (ASTM D 1000)

3.5.1	Original, min (1 h at room temperature after bonding)	4.0 N/25 mm
3.5.2	After Ageing, max (14 d at 70 +/- 2 °C, 1 h at room temperature)	-10%

3.6 SHEAR ADHESION

Test Method: 2.5 cm² of a 25 mm wide tape shall be bonded to a polished stainless steel panel. The mating surface must be pressed firmly together to force out trapped air and insure a good bond. Determine shear strength at a rate of 300 mm/minute.

Date	Action	Revisions
2005 10 28	Revised	Inserted 3.0; Deleted 3.11, 3.12, 4
1994 11 29	Revised & Retyped	Was 8 pages
1984 11 20	Released	SM/EQ 5504 TP





3.6.1 Original, min
(1 h after bonding) 65 N/2.5 cm²

3.6.2 After Ageing, max
(14 d at 70 +/- 2 °C, 1 h at room temperature) -10%

3.7 SOFTENING POINT, min 110 °C
(ASTM D 816, except specimens per clause 3.6)

Test Method. Maintain oven temperature at 50 °C for 15 minutes and then increase 2.5 °C/minute until bond failure.

3.8 UNWIND PULL, max 18 N/25 mm

Test Method: Place a roll of tape around a fixture which will allow it to revolve and test in a tensile testing machine the unwind pull at a rate of 300 mm/minute.

3.9 UNWIND PROPERTIES AFTER AGEING

After exposure of a roll of tape to 40 +/- 2 °C for 14 days and conditioning at room temperature for 24 hours, there shall be no transfer of adhesive to the opposite layer while unrolling the tape.

3.10 REMOVABILITY No residue on substrate

Test Method: ASTM D 1000, clauses 40 to 42.2 with following supplements:

- 1) Prior to test and after bonding adhesive tape immerse test assemblies in waxing compound according to U-MG009-021 A/B for 1 minute.
- 2) After 1 hour at room temperature expose test assemblies in a mechanical convected air dry oven at 40 +/- 1 °C for 14 days.
- 3) After cooling to room temperature immerse test assemblies in dewaxing compound according to U-MB005-8000 for 1 minute.

5. GENERAL INFORMATION

The information given below is provided for clarification and assistance in meeting the requirements of this specification.

5.1 STORAGE STABILITY
(From date of receipt at Ford Motor Company)

Minimum 6 months when stored between 5 °C and 28 °C.

(To be certified by supplier on "Initial Sample Report").