



PVC SHEET, PRESSURE SENSITIVE

ESK-M99G143-A

PVC SHEET, PRESSURE SENSITIVE

▽ ESK-M99G143-B

1. SCOPE

The material defined by these specifications is a vinyl plastic film coated on one side with a pressure sensitive adhesive covered by release paper.

2. APPLICATION

These specifications were released originally for material used as a watershield for doors. The area of pressure sensitive adhesive coating shall be as specified on the Engineering Drawing.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

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 VINYL PLASTIC FILM

According to SK-M2F9504-A/B

3.2 WATERSHIELD

3.2.1 Shear Adhesion Strength
(FLTM BU 151-01, Method A, Fig. 4,
except bonding area 10 x 25 mm,
test panel preparation according to
FLTM BI 103-02, Method Bb)

3.2.1.1 2 h after Bonding, min

23 N/cm²

3.2.1.2 2 h after Heat Ageing, min

3 N/cm²

3.2.2 Peel Adhesion Strength
(ASTM D 1000, Method A, except test
panel preparation according to FLTM
BI 103-02, Method Bb, specimen
dimension 300 x 25 mm, test speed
25 mm/minute)

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ENGINEERING MATERIAL SPECIFICATION

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- 3.2.2.1 Original, min
(After 2 h conditioning at room temperature) 4 N/25 mm
- 3.2.2.2 After Humidity Ageing, max
as determined under
3.2.2.1 -50% based on value
- 2 hours after bonding expose for 24 hours at 38 +/- 1 °C and 98 +/- 2% relative humidity, cool to room temperature.
- 3.2.3 Resistance to Dewaxing Compound No leaks
- 1) Prepare 150 x 300 mm test panels according to FLTM BI 103-02, Method Bb.
 - 2) Bond a pocket of 70 mm width consisting of two appropriate stripes of watershield to test panel as shown in Fig. 1.
 - 3) After 2 hours at room temperature fill assembly with dewaxing compound (U-MB 005-8000) as shown in Fig. 1 and suspend in vertical position for 24 hours at room temperature.
- 3.2.4 Cold Adhesion Test
- Test Method:
- 1) Bond a 20 x 20 mm self adhesive piece of watershield to a degreased aluminum foil (150 x 60 x 0.2 mm) using maximum finger pressure.
- Test Specimens:
- a) After 2 hours at room temperature
 - b) After 4 weeks ageing at 70 +/- 2 °C
- 2) Expose assembly and a 10 mm mandrel at -40 +/- 2 °C for 2 hours in cold box.
 - 3) While still in the cold box bend specimen with the watershield facing outward through an angle of 180° around the mandrel within 1 second.
- 3.2.4.1 After 2 h Conditioning at Room Temperature No chipping
- 3.2.4.2 After Ageing 4 Weeks at 70 +/- 2 °C No chipping
- 3.2.5 Liner Removal
- The release paper must remove easily without tearing both as received and after storage.