

**ADHESIVE TAPE, POLYURETHANE, CLEAR, PAINTABLE,
STONE CHIP RESISTANT****SK-M3G9523-B1****1. SCOPE**

The material defined by this specification is a heat resistant colorless clear polyurethane tape single coated by a self adhesive and covered by release paper.

2. APPLICATION

This material was originally released as a stone chip protection on wheel arch flare. Application is possible prior to paint application as well as after paint curing oven.

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).

3.4 DIMENSIONS

3.4.1 Width (Sliding gauge) As specified on Engineering drawing

3.4.2 Thickness (ASTM D 1000) 0.29 - 0.39 mm

Or as specified on Engineering drawing.

3.5 COLOR

Colorless clear or as specified on Engineering drawing

3.6 MASS per m²

0.30 - 0.50 kg

3.7 TENSILE STRENGTH, min
(ASTM D 882, Method A, separation rate 300 mm/minute, clamp distance 50 mm)

150 N/25 mm

3.7.1 Elongation at Break, min 350%

3.8 180° PEEL ADHESION
(ASTM D 1000, on polished stainless steel)

3.8.1 Original, min 35 N/25 mm
(24 h at room temperature)

Date	Action	Revisions
2006 07 27	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.15, 3.17, 3.8, 4
1999 01 29	Revised	Deleted B2; Revised & Updated
1982 07 12	Released	SM/EQ9044TP





3.8.2 After Ageing
(14 days at 70 +/- 2 °C,
1 h at room temperature) No loss of adhesion

3.8.3 After Humidity Ageing
(72 h at 38 +/- 2 °C and
98 +/- 2.5 relative humidity) No loss of adhesion

3.9 SHEAR ADHESION, min 40 N/2.5 cm²

Test Method: 2.5 cm² of a 25 mm wide tape shall be bonded to a polished stainless steel panel. The mating surfaces must be pressed firmly together to force out trapped air and ensure a good bond.

Determine shear strength at a rate of 25 mm/minute.

Free tape length maximum 5 mm.

3.10 SOFTENING POINT, min 95 °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/5 minute until bond failure.

3.11 PAINTABILITY If required on Engineering
drawing

The surface shall be dry to touch after cooling to room temperature. It shall be free from cracks or bubbles and shall show a uniform closed paint film without staining or discoloration.

Test Method:

- 1) Prepare test panels of 300 x 100 mm according to FLTM BI 120-01 A and C.
- 2) Bond 250 x 25 mm pieces of tape on the test panels. The mating surfaces must be pressed firmly together to force out trapped air and ensure a good bond.
- 3) 10 minutes after bonding, coat test assemblies with production epoxy spray primer at a dry film thickness of 0.025 - 0.035 mm.
- 4) After 10 minutes at room temperature cure specimens separately according to FLTM BV 150-05, Table 2.
 - a) Minimum Curing Cycle, Phase 1
 - b) Maximum Curing Cycle, Phase 1
- 5) After another 10 minutes at room temperature spray separate specimens with light colored standard and metallic top coat enamel (production material at a coating thickness (dry) of 0.04 - 0.05 mm.

