ENGINEERING MATERIAL SPECIFICATION

Material Name	Specification Number
TAPE, TWO SIDED, SYNTHETIC RUBBER, PRESSURE SENSITIVE, 0.13 mm NOMINAL THICKNESS	SK-M3G9524-A
TAPE, TWO SIDED, SYNTHETIC RUBBER PRESSURE SENSITIVE, 0.9 mm NOMINAL THICKNESS	SK-M3G9524-A2

1. SCOPE

The materials defined by these specifications are two sided pressure sensitive transparent tapes with high initial tack. One side of the tape is covered with a release paper.

2. APPLICATION

These specifications were released originally for materials used as an assembly aid to temporarily fix plastic parts to steel or painted substrates.

3. REQUIREMENTS

3.1 STATISTICAL PROCESS

Suppliers must conform to the requirements of Ford Quality System Standard Q-101. A mutually acceptable Control Plan as described therein is required for material/source approval. Appropriate statistical tools must be used to analyze process/product data so that variation in the final product is continuously reduced.

3.2 CONDITIONING

All test values indicated herein are based on material conditioned in a controlled atmosphere of 23 +/- 2 C and 50 +/- 5 % relative humidity for not less than 24 h prior to testing and tested under the same conditions unless otherwise specified.

3.3 COLOR

Colorless transparent or according to Engineering drawing

3.4 THICKNESS
(ASTM D 1000, without release paper)

SK-M3G9524-A	0.10 - 0.16 mm
SK-M3G9524-A2	0.07 - 0.11 mm

3.5 WIDTH
(ASTM D 1000)

See 5.2

Date	Release No.	Released
1991 06 01	EP00E01089485000	Revised, minor changes C.Dittebrandt
1991 03 01	EP00E01089482000	Revised and added SK-M3G9524-A2
1980 04 02	SM/EQ8628 TP	Release

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3.6 LINER REMOVAL, max — 20 N/m
(ASTM D 1000, Method A)

Apply the unlined side of the tape to a clean metal panel and measure the force to peel the liner from the adhesive.

3.7 BREAKING STRENGTH — 400 - 1800 N/m
(ASTM D 1000)

3.8 ELONGATION, MIN
(ASTM D 1000)

SK-M3G9524-A	20 %
SK-M3G9524-A2	5 %

3.9 PEEL STRENGTH, min — 400 N/m
(ASTM D 1000, clause 40 to 42 except substrate)

Substrate: Painted panels according to FLTM BI 103-02, Method C.
Age: 2 h at 23 +/- 2 C

Prior to testing cover unlined side of the tape with a polyester film of 0.1 mm thickness to avoid elongation during testing.

3.10 SHEAR STRENGTH, min — 20 N/cm2
(FLTM BU 151-01, Method A, Fig. 2)

Age 2 h at 23 +/- 2 C

Prior to testing cover the unlined side of the tape with a polyester film of 0.1 mm thickness.

3.11 SOFTENING POINT
(ASTM D 816)

Prepare test specimens according to clause 3.10. Maintain oven temperature at 30 C for 15 minutes, then increase temperature in steps of 2.5 C/5 minute until bond failure.

SK-M3G9524-A, min	50 C
SK-M3G9524-A2, min	105 C

3.12 SUPPLIER'S RESPONSIBILITY

All materials supplied to this specification must be equivalent in all characteristics to the material upon which approval was originally granted.

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