

ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

WINDLACE, VINYL, PINCHWELD

WSB-M1G150-C

1. SCOPE

The material defined by this specification is an extruded polyvinyl chloride or vinyl copolymer windlace having a fully encased steel insert.

2. APPLICATION

This specification was released originally for material used as a pinchweld windlace for trimming and/or sealing interior automotive body assemblies such as door openings.

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 APPEARANCE (FLTM BI 109-01)

The color, pattern, and finish shall match the approved Design Center master sample, or shall be as specified on the engineering drawing.

3.5 VINYL COPOLYMER

The properties of molded slabs, made from production stock or from the finished windlace shall conform to the following requirements or as specified on engineering drawing.

3.5.1	Hardness, Durometer "A", +/- 10 (ASTM D 1706, 15 s delay)	80
3.5.2	Specific Gravity, max (ASTM D 792)	1.4
3.5.3	Tensile Strength, min (ASTM D 412)	10.3 MPa
3.5.4	Elongation, min (ASTM D 412)	225 %

Due to the difficulty in obtaining appropriate samples from production parts, the above information is provided as a guide for manufacturers. Ford Quality Control evaluations will not be required, except for approval of new sources.

Date	Action	Revisions
2003 01 23	Revised	Para 3.0 inserted ; Para 3.1, 3.2, 3.3, 3.15, 3.22, 4 deleted
1991 05 14	NB00E1013465001	Released D.A. Ruona

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3.6 DIMENSIONS

The dimensions of the individual components and of the finished windlace shall be as specified on the engineering drawings.

3.7 COLOR STABILITY AND WEATHER RESISTANCE

3.7.1 Xenon Arc Weatherometer (SAE J1885)

3.7.1.1	150 kJ/m ²	Rating 5
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3.7.1.2	1241 kJ/m ²	Rating 4
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3.7.2	Florida Exposure (SAE J1976, 1 year direct weathering inland)	Rating 4
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After exposure in accordance with 3.7.1 and 3.7.2 the material shall show no color change or change in hue in excess of the specified AATCC rating (AATCC Gray Scale for Evaluating Change in Color, 10 step). In addition, the material shall not stain or chalk.

Material shall not exhibit mildew growth and shall not exhibit mildew growth and/or staining after exposure according to 3.7.2.

3.8 COLD FLEXIBILITY

(FLTM BN 102-01, except use a 300 mm long test specimen and bend over a 75 mm diameter mandrel)

The windlace cover shall exhibit no evidence of fracture when bent 180 ° over a 75 mm diameter mandrel at - 30 °C.

3.9 RESISTANCE TO H₂S STAINING (FLTM AN 102-01)

No discoloration

3.10 FOGGING (FLTM BO 116-03)

Fog Number, min	60
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Formation of clear film, droplets or crystals is cause for rejection.