Ford Motor Company

ENGINEERING MATERIAL SPECIFICATION

Material Name	Specification Number
POLYVINYL CHLORIDE (PVC) FLOOR MATS, EMBOSSED, FLAT	**WSB-M2F174-A1**
POLYVINYL CHLORIDE (PVC) FLOOR MATS, EMBOSSED, MOLDED	**WSB-M2F174-A2**

1. SCOPE

The material defined by these specifications is a polyvinyl chloride floor mat of good quality and uniform construction suitable for flat die cut and molded parts.

2. APPLICATION

These specifications were released originally for material used in 1992 Econoline van floor mats.

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 CONSTRUCTION

		A1	A2
3.5.1	Weight, min	1562 g/m^2	2136 g/m^2

Test Method: Calculate weight, vs. area of finished mat without attachments.

3.6 PROPERTIES PRIOR TO MOLDING

		A1	A2
3.6.1	Hardness, Durometer A (ISO 868/ASTM D 2240, except test unembossed side of specimen, single ply)	75 - 85	75 - 85

Date	Action	Revisions
2003 01 02	Revised	Para 3.0 inserted ; Para 3.1, 3.2, 3.3, 3.17, 3.15, 4 deleted
1991 06 05	NB00E10014501148	Release J.D. Salow B.C. Ferns

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3.6.2	Tensile Strength, min (ASTM D 412, Die A, crosshead speed 250 mm/ minute)		
	WMD	67 N	133 N
	AMD	87 N	111 N
	3.6.2.1 Elongation, min WMD and AMD	80 %	120 %
3.6.3	Tear Strength, min (ISO 34, Method B, Procedure A/ASTM D 624, Die C, except 50 mm/minute test speed)		
	WMD	35 N	40 N
	AMD	40 N	50 N
3.6.4	Bend Test (FLTM BN 102-01, except sample size 25 X 150 mm)	No cracking	

Test Method: Bend unembossed side of sample 180 ° around a 1.6 mm diameter mandrel at room temperature, WMD and AMD.

3.6.5	Cold Flexibility (FLTM BN 102-01, except sample size 25 x 150 mm)	Shall remain flexible and not crack.

Test method: Bend unembossed side of sample 180 ° around a 6 mm diameter mandrel at - 34 +/- 1 °C, WMD and AMD.

3.7 PROPERTIES AFTER MOLDING (WSB-M2F174-A2 only)

Material from a relatively flat area at, or adjacent to the deepest draw areas of the molded mat shall meet the minimum original requirements of the flat mat, WSB-M2F174-A1.

3.8 AGED PROPERTIES
(ASTM D 573, 2 weeks at 70 +/- 1 °C and condition)

Must meet flat mat requirements specified under section 3.6

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