

ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

ADHESIVE, HOT MELT, POLYESTER BASE, POWDER FORM
ADHESIVE, HOT MELT, POLYESTER BASE, WEB FORM

WSB-M2G279-B
WSB-M2G279-B2

1. SCOPE

The materials defined by these specifications are polyester based hot melt adhesives which can be fused by heat and used to laminate materials. WSB-M2G279-B is in powder form and WSB-M2G279-B2 is in web form.

2. APPLICATION

These specifications were released originally to bond fabric to foam in seating applications.

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 PHYSICAL CHARACTERISTICS

In addition to the requirements listed herein, the adhesive bonded assemblies employing component materials as specified under lamination construction, must also meet engineering requirements of WSB-M8P1-H or other applicable specifications.

3.5 LAMINATION CONSTRUCTION As specified on the Engineering drawing

3.6 COLOR Off-white or as specified
on the Engineering drawing

3.7 DESCRIPTION

3.7.1 Particle Size of Powder	B
0 - 74 micrometers	< 3.5 %
75 - 210 micrometers	26 - 42 %
211 - 500 micrometers	56 - 73 %
501 - 840 micrometers	< 1 %

Particle size must be functionally approved for production use for specific application.

Date	Action	Revisions
2003 01 16	Revised	Para 3.0 inserted ; Para 3.1, 3.2, 3.3, 3.19, 3.20, 4 deleted
1994 01 12	NB00I10043054309	Released A.W.B. K.P.M B.C.F

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WSB-M2G279-B/B2

3.7.2	Weight of Web, g/m ² (FLTM BN 106-01)	B2	
	20 gram web	20	+/- 2
	22 gram web	22	+/- 2
	25 gram web	25	+/- 2
	40 gram web	40	+/- 2
		B	B2
3.8	DENSITY OF SOLID POLYMER, g/cm ³ (ASTM D 1505)	1.26 - 1.31	1.26 - 1.31
3.9	DSC MELTING POINT OF SOLID POLYMER, C (ASTM D 3418)	125 +/- 7	126 +/- 7
3.10	THERMOSEL VISCOSITY OF SOLID POLYMER, mPa.s (Brookfield RUTDV-1 thermosel spindle #27 at 1 rpm and 215 °C)	80,000-126,000	80,000-150,000
3.11	SOLIDS, %, min (ASTM D 2834, except heat at 175 +/- 3 °C for 4 h, save sample for next test)	98	98
3.12	ASH, %, max (Based on weight of solids)	5.0	5.0
	Test Method: Place the crucible containing the solids residue in a cool muffle furnace. Slowly heat to and maintain at 760 +/- 30 °C for 1 h. Cool to 23 +/- 2 °C in a desiccator and weigh.		
3.13	ORIGINAL PLY ADHESION OF ADHESIVE TO LAMINATE, min (B2 only) (FLTM BN 151-05)		9 N/50 mm or Foam Tearing Bond
3.14	ODOR (FLTM BO 131-01/SAE J1351)		Rating 2
3.15	FOGGING (SAE J1756, 3 h at 100 °C heating, 21 °C cooling plate, post test conditioning 1 h and 16 h)		
	Fog Number, min		60
	Formation of clear film, droplets or crystals is cause for rejection.		