

**ADHESIVE, FAST MOISTURE CURING URETHANE, ONE COMPONENT, HIGH VISCOSITY****▽ WSB-M2G316-B****1. SCOPE**

The material defined by this specification is a one component moisture curing urethane adhesive.

2. APPLICATION

This specification was released originally for material used in conjunction with a one or two stage glass priming operation and a body priming operation (primers identified per para 4) to bond glass windshields, backlites, and quarter glass to painted metal surfaces. This material is suitable for production and service repair applications. The translucent glass Primer, ▽WSS-M5B280-C5, is referred to as glass primer wipe in this specification.

2.1 MANUFACTURING PROCESS RECOMMENDATION

- These adhesives are moisture sensitive and require special handling for manual and automated process.
- Approved suppliers are responsible for maintaining the accuracy and relevancy of these process parameters (in their Process Standard). Approved suppliers must submit any changes to these process parameters in a timely manner (within 30 days) for review and approval by Materials Engineering, Vehicle Operations, and Product Development Engineer.

3. REQUIREMENTS**3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS**

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 UNCURED ADHESIVE PROPERTIES

3.2.1 Viscosity
(FLTM BV 103-01, 4 mm orifice,
550 kPa air pressure)

As received 25 - 50 s

Aged, max

. 72 h at 54 +/- 3 °C 70 s

. 90 days at 23 +/- 2 °C 70 s

Date	Action	Revisions
2009 03 13	Revised	See Summary of Revisions M. Mehandru, FNA
2007 04 19	Revised	Inserted 2.1, 5.1.4, 5.1.5 & Table 2 M. Mehandru
1990 02 08	Released	NB00E00179051000 K. P. King, E. R. Rezendes



3.2.2 Solids, min 98%
(ASTM D 2834, except heat for 3 h
at 100 +/- 3 °C in a mechanical
convection oven, or FLTM BV 150-10)

3.2.3 Ash, based on solids weight, max 21%
(ASTM D 482, or FLTM BV 150-10)

3.2.4 Weight per Volume
(ASTM D 816)

The weight tolerance for any one supplier shall be +/- 0.02 kg/L based on the weight of the original approved production sample. Reference paragraph 4.3.

3.2.5 Sag, max 4 mm

Test Method:

- Apply a 76 mm long right triangular shaped bead of material 6 mm wide at the base and 15 mm high on a glass or steel panel.
- Permit the panel to air dry for 30 minutes at R.T. in a plane 60° angle from the horizontal. Measure the sag.

3.2.6 Sensitivity to Alcohol

CAUTION: Slight traces of alcohol will inhibit the cure of this adhesive. The use of alcohol or alcohol containing solvents is prohibited for cleanup or other uses.

▽ 3.2.7 Storage Stability
(From date of receipt at
Ford Motor Company)

Shall be stored at ambient room temperature below 40 °C, away from all sources of heat, such as ovens, direct sunlight, etc. Shall not be stored outside. Under these storage conditions, the max shelf life to the material, from date of shipment from the supplier, shall be 4months.

The supplier must label each container to indicate the expiration date of the material, and production usage beyond the expiration date is not permitted. When stored at temperatures below 23 °C, it must be conditioned at R.T. for 72 h prior to use.

3.2.8 Odor Rating 3
(FLTM BO 131-03), cured material per 7 days at RT)

3.2.9 Fogging Test
(SAE J1756, 3 h at 100 °C heating, 21 °C cooling
plate, post test conditioning 1 h and 16 h)

Fog Number, min 70

Formation of clear film, droplets or crystals is cause for rejection. Cured samples shall be tested.