



**TAPE, LOW DENSITY POLYVINYL CHLORIDE FOAM
PRESSURE SENSITIVE, SUPERSOFT**

WSB-M3G102-B

**TAPE, LOW DENSITY POLYVINYL CHLORIDE/NITRILE FOAM,
PRESSURE SENSITIVE, ULTRA SOFT**

WSB-M3G102-B2

1. SCOPE

The material defined by WSB-M3G102-B is a soft, closed cell polyvinyl chloride foam tape with one side adhesive coated and the other protected by a coated release paper.

Note: This product is manufactured so that as the tape is unrolled the adhesive surface is exposed. While rolled, the top surface of the release paper serves as a liner to protect the adhesive and prevent sticking. The release paper remains on the adhesive free surface of the foam tape and is not removed until after installation.

The material defined by WSB-M3G102-B2 is a soft, closed cell polyvinyl chloride/nitrile foam tape with one side adhesive coated and protected by a coated release paper.

Note: This material can be supplied extruded into very complex cross sections, die cut or in roll form.

2. APPLICATION

These specifications were released originally for materials used as a filler between exterior moldings and painted metal to seal against air leaks, water leaks, and wind noise. They are used in areas where low force to compress is required. The pressure sensitive adhesive used in these materials is often intended as an assembly aid. The adhesive strength of this material may not be adequate where the foam material is not mechanically retained in a final assembly. The design and manufacturing process should be evaluated for failure modes with respect to exceeding adhesion limits.

WSB-M3G102-B2 may also be used to seal areas where the design requires complex extrusions.

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 DIMENSIONS (WSB-M3G102-B2)

Cross sections/dimensions as specified on the Engineering drawing.

3.5 DENSITY

(ASTM D 3574, Test A)

The density tolerance for any given supplier shall be +/- 15 kg/m³ based on the recorded density of the original approved production sample. See para 5.2.

Date	Action	Revisions
2007 11 21	Revised	Revised 2. B. Witkowski
2005 09 30	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.14, 3.15, 4
1991 06 01	Released	NBQ7E10117602000 W. Curtiss; E. A. Perchard

**3.6 TENSILE STRENGTH, min**
(ASTM D 3574, Test E, 6.4 mm material thickness)

70 kPa

3.6.1 Elongation, min

120%

3.7 COMPRESSION DEFLECTION
(ASTM D 3574, Test C)

3.7.1 Instantaneous, max

7.0 kPa

3.7.2 After 60 s 1.0 - 3.5 kPa

3.8 COMPRESSION SET, max
(ASTM D 1667, except at 70 +/- 1 °C for 22 h)

90%

Ply tape adhesive to adhesive for 13 mm/min thickness and measure recovered height 30 minutes after clamps are removed.

3.9 WATER SEAL, minNo leak after
60 minutes

Test Method: Wipe two glass plates with mineral spirits using a clean cotton cloth. Shape a 12 x 12 x 300 mm sample into a "U" configuration between the surfaces of the glass plates. The plates should be spaced and clamped so that the material between them is compressed 30% of the original thickness for 3.9.1 and 50% of the original thickness for 3.9.2. After the assemblies have been processed as specified below, pour water into the "U" so that the deepest point measures 100 mm. Examine the assembly after 60 minutes.

3.9.1 Condition the assembly for 30 minutes at 23 +/- 2 °C.

3.9.2 Expose the assembly for 30 minutes at 121 +/- 2 °C, then cool to 23 +/- 2 °C prior to test.

3.10 LOW TEMPERATURE FLEXIBILITY

No cracking

Test Method: Condition a minimum of three 150 mm samples of tape as received at -30 +/- 1 °C for 4 h and bend the samples 180° around a temperature conditioned 6.4 mm diameter mandrel.

3.11 PAINT STAINING

No migration staining

Test Method: Securely attach a 50 x 100 mm sample of the material to a 100 x 150 mm steel panel coated with currently released body enamels with top surface of foam against the paint. Expose the assembly for 500 h in a Q.U.V. cabinet described in SAE J2020. Examine for any evidence of staining beyond the boundaries of the test specimen.