



**LABEL, VINYL FILM, PRESSURE SENSITIVE,
INTERIOR QUALITY**

WSB-M3G148-B

1. SCOPE

The material defined by this specification is a pressure sensitive, paper backed, vinyl film, suitable for interior applications.

2. APPLICATION

This specification was originally released for labels used in the luggage compartment to provide instructional information.

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

The labels shall be free of streaks, blisters, wrinkles, ragged edges, and any other surface imperfections which will make them unsuitable for the intended usage. The design and color shall be as specified on the engineering drawing.

3.5 SETTING TIME FOR NORMAL HANDLING

The label shall set sufficiently to permit normal handling immediately after application.

3.6 FILM PROPERTIES

3.6.1 Appearance

Shall match the Ford Motor Company styling master sample.

3.6.2 Thickness (ASTM D 1000)

Tape Plus Adhesive, min 0.10 mm

Release Paper, min 0.05 mm

3.6.3 Gloss (FLTM BI 110-01)

The gloss of production material shall not vary more than +/- 7 units with a 60° (1 rad) glossmeter from the master sample approved by the Design Center.

Date	Action	Revisions
2005 11 29	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.12, 3.13, 4
1992 09 03	Released	NB00110043054198



Documents

Document Sharing Hub



3.7 PREPARATION OF LABELS ON TEST PANELS

Except where otherwise noted, tests shall be conducted on test panels of the substrates listed in paragraph 5.1, by applying the film or label per the following procedure:

- Peel off the backing paper from the film or label in a smooth, continuous motion. Do not pull the film from the paper.
- Position the film or label on the panel.
- Using a plastic squeegee, smooth out the film or label using firm overlapping strokes, working from the center of the panel. Carefully work out all air bubbles.

Test panels with applied film or label shall be conditioned for 48 h at 23 +/- 2 °C and 50% relative humidity prior to exposure. Tests shall be completed within 4 h after removal from the conditioning environment unless otherwise noted.

3.8 ADHESION

(ASTM D 1000, except determine adhesion to substrates listed in para 5.1)

The adhesive shall produce a durable bond between the film and the substrates surface with the following minimum peel strength:

As received (Conditioned for 48 h at 23 +/- 2 °C at 50% relative humidity)	175 N/m width
--	---------------

Aged	175 N/m width
------	---------------

Test Method: Expose duplicate samples to each of the following conditions:

- 72 h at 70 +/- 2 °C
- 48 h at 38 +/- 2 °C and 95 - 100% relative humidity
- 5 cycles consisting of 4 h at 70 +/- 2 °C, 4 at 38 +/- 2 °C and 95 - 100% relative humidity, and 16 h at - 29 +/- 2 °C

3.9 RESISTANCE PROPERTIES

After each of the resistance properties exposures, the film or label must not show evidence of delamination, loss of printing, loss of adhesion, or any other effect which would detract from its proper function or appearance.

3.9.1 Humidity Resistance

No curling of edges or visible loss of adhesion, blistering, and no loss of readability or any other effect which would detract from its proper function or appearance.

Test Method: Place the test panel in the humidity cabinet for 48 h at 38 +/- 2 °C and 95 - 100% relative humidity.