



TAPE, ELASTOMERIC, PRESSURE SENSITIVE

WSB-M3G210-A

1. SCOPE

The material defined by this specification is an elastomeric (butyl) extruded, pressure sensitive tape. The adhesive surface is protected on one side with a removable release liner.

2. APPLICATION

This material was released originally for material used to aid in retention of EPDM weatherstrips to painted body surfaces. The tape shall be used in conjunction with mechanical retention. The tape may also be used where adhesion to non-polar surfaces is required.

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 TAPE DIMENSIONS

As specified on the
Engineering Drawing

3.5 PHYSICAL TAPE REQUIREMENTS

Tests shall be conducted on material having an original thickness of 1.15 +/- 0.15 mm.

3.5.1 Density (ASTM D 1564)

The density tolerance for any one supplier shall be +/- 10%, based on the recorded density of their original approved production sample.

3.5.2 Cone Penetration (ASTM D 217, 150 g load)

Test Method: Ply tape to achieve a 13 mm thick sample.

The cone penetration tolerance for any one supplier shall be +/- 10 dmm, based on the recorded cone penetration of their original approved production sample.

3.5.3 Tensile Strength, min (ASTM D 412, Die "C")

As Received	50 kPa
Aged 70 h at 100 +/- 2 °C	120 kPa

Date	Action	Revisions
2006 02 08	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.9, 3.10, 3.11, 4
1995 08 07	Activated	



3.5.4 Elongation, min
(ASTM D 412, Die "C")

As Received	800%
Aged 70 h at 100 +/- 2 °C	800%

3.6 TAPE ADHESION REQUIREMENTS

Tests shall be conducted on material having an original thickness of 1.15 +/- 0.15 mm.

3.6.1 Peel Adhesion, min
(FLTM BU 112-02, Method A) 1.5 N/mm width

- Aged 3 d at 23 +/- 2 °C
- Aged 7 d at 70 +/- 2 °C
- 5 cycles consisting of:

8 h at 90 +/- 2 °C
16 h at - 40 +/- 2 °C
8 h at 38 +/- 2 °C and
98 +/- 2% R.H.
16 h at -40 +/- 2 °C

Prepare three specimens using painted steel substrates per para 5.1. Condition the assemblies for 72 h at 23 +/- 2 °C prior to exposure. Condition for 1 to 4 h at 23 +/- 2 °C after exposure.

3.6.2 Liner Removal, max
(ASTM D 1000 with exceptions below)

- | | |
|----------------|----------|
| • As Received | 1.0 N/mm |
| • 1 h at 54 °C | 1.0 N/mm |

ASTM D 1000, except apply the unlined adhesive side of the tape to a clean metal panel with light finger contact and no added roller weight. Measure the force required to peel the liner from the tape.

3.6.3 Holding Power, min
(FLTM BU 101-06, Method B)

- | | |
|------------|-------|
| • At 23 °C | 100 h |
| • At 90 °C | 100 h |

Prepare 2 enamel/enamel plate 645 mm² overlap shear test specimens. After conditioning for 24 h, hang 1 test specimen vertically at 23 °C and one at 90 °C. Gently attach 250 g weights to both specimens. Both bonded assemblies must support 250 g weights for the specified time.

3.6.4 Heat Resistance, max displacement 1.5 mm

Prepare 3 enamel/enamel plate 645 mm² overlap shear test specimens as described in para 3.6.3. After conditioning for 1 h at 23 +/- 2 °C, attach a 100 g weight to one end of the test specimen and hang it vertically in a mechanical convection oven at 120 +/- 2 °C for 30 minutes. Allow the specimen to cool to 23 +/- 2 °C and determine whether any displacement from the original bonded position has occurred.

