



TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED, ACRYLIC, MEDIUM TACK, INTERIOR

WSB-M3G221-A

1. SCOPE

The material defined by this specification is a two sided acrylic based pressure sensitive adhesive film with a medium to firm tack. One side is protected by a release liner.

2. APPLICATION

This specification was released originally for material to bond flexible (PVC) foam to interior trim substrates.

Prior to approval for other applications, the performance of the tape must be verified on the intended substrates to the requirements of the specifications and requirements defined in any associated component or assembly specifications.

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 GREEN STRENGTH

The tape shall develop sufficient adhesion to permit normal handling immediately after application.

3.5 MATERIAL PROPERTIES

3.5.1	Color	Clear
3.5.2	Tape Dimension	As specified on engineering drawing
3.5.3	Tape Thickness (ASTM D 1000)	
	Adhesive	0.13 +/- 0.03 mm
	Release Liner, nominal	0.10 mm

3.6	LINER REMOVAL, max (ASTM D 1000, Method A)	25 N/m
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3.7 PREPARATION OF TEST SPECIMENS

Steel panels, painted with current production enamel according to respective paint specification if not otherwise specified.

Date	Action	Revisions
2006 02 15	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.12, 3.13, 3.14, 4
1994 11 17	Released	NBOOI10043054396



Documents

AWB, KPM

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Apply the tape per the following procedure.

Clean test panels with a 50/50 blend (volume) of isopropyl alcohol and water and allow to air dry.

Peel the liner from the film in a smooth continuous motion. Do not peel the film from the liner.

Position the tape on the test substrate.

Using the roller described in ASTM D 1000 with no additional pressure, pass the roller over the full length of the tape once in each direction.

Test samples with applied tape 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 specified.

3.8 ADHESION PROPERTIES (ASTM D 1000)

To minimize elongation during testing, apply aluminum foil or polyester film of about 50 micrometer thickness to the reverse side of the tape.

3.8.1	Peel Adhesion (ASTM D 1000)	
	1 h at 23 +/- 2 °C	400 N/m
3.8.2	Heat Resistance (7 d at 100 +/- 2 °C)	500 N/m
3.8.3	Humidity Resistance (7 d at 38 +/- 2 °C, 95 - 100% relative humidity)	500 N/m
3.8.4	Environmental Cycle Resistance	500 N/m
	5 cycles, each cycle consisting of the following:	
	4 h at 90 +/- 2 °C 4 h at 38 +/- 2 °C and 95 - 100% relative humidity 16 h at -30 +/- 2 °C	
3.8.5	Heat Resistance (30 minutes at 120 +/- 2 °C)	500 N/m

3.9 FOGGING (FLTM BO 116-03, 3 h at 100 °C heating, 21 °C cooling plate)

Fog Number, min 60

Formation of a clear film, droplets or crystals is cause for rejection.

Perform the test with the tape bonded to aluminum foil with the release liner removed.