Material Name	Specification Number
FABRIC, COLOMBO PATTERN, KNITTED, UNLAMINATED	WSD-M1H563-A
FABRIC, COLOMBO PATTERN, KNITTED, 3 mm	WSD-M1H563-B1
FABRIC, COLOMBO PATTERN, KNITTED, 6 mm	WSD-M1H563-B2
FABRIC, COLOMBO PATTERN, KNITTED, 15 mm	WSD-M1H563-B5
FABRIC, COLOMBO PATTERN, KNITTED, 3 mm	WSD-M1H563-C1
FABRIC, COLOMBO PATTERN, KNITTED, 6 mm	WSD-M1H563-C2
FABRIC, COLOMBO PATTERN, KNITTED, 15 mm	WSD-M1H563-C5
FABRIC, COLOMBO PATTERN, KNITTED, 6 mm	WSD-M1H563-D2
FABRIC, COLOMBO PATTERN, KNITTED, 3 mm PU	WSD-M1H563-F1
FABRIC, COLOMBO PATTERN, KNITTED, 6 mm PU	WSD-M1H563-F2
FABRIC, COLOMBO PATTERN. KNITTED, HFW	WSD-M1H563-G
FABRIC, COLOMBO PATTERN, KNITTED, HFW	WSD-M1H563-H
FABRIC, COLOMBO PATTERN, KNITTED, HFW	WSD-M1H563-J
FABRIC, COLOMBO PATTERN, KNITTED, HFW	WSD-M1H563-K

1. SCOPE

The material defined by this specification is a 6 bar 44 gauge DBR knitted, simulated velour, polyester bodycloth.

2. APPLICATION

This specification was released originally for material used as an interior trim polyester fabric for the CDW27 program. The face fabric is flame laminated to polyester or polyether urethane foam and a knitted fabric or polyurethane film backing for seating applications. The face fabric is flame laminated to polyether foam alone for inner door and quarter trim panel applications. The face fabric is supplied unlaminated for seat piping applications. It can be backed with HFW weldable backcoating.

COLOMBO PATTERN

WSD-M1H563-A	Unlaminated
WSD-M1H563-B1	3.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H563-B2	6.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H563-B5	15.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H563-C1	3.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)
WSD-M1H563-C2	6.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)
WSD-M1H563-C5	15.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)

Date	Release No.	Released
1994 04 08	C10391299	Released B5,C1,C2,C5, rev.3.14.1/2/3/4 N.Komatsu
1993 10 08	C10341266	Released F1, F2, G, H, J, K N J Komatsu
1992 04 16	C10206048	Released P.Osman

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WSD-M1H563-D2	6.0 mm, flame laminated to polyether foam
WSD-M1H563-F1	3.0 mm flame laminated to polyester foam and polyurethane film (EAO use only)
WSD-M1H563-F2	6.0 mm flame laminated to polyester foam and polyurethane film (EAO use only)
WSD-M1H563-G	HF weldable vinyl film adhesive bonded or an engineering approved alternative
WSD-M1H563-H	HF weldable acrylic backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative
WSD-M1H563-J	HF weldable vinyl backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative
WSD-M1H563-K	HF weldable PU backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative

3. REQUIREMENTS

In addition to the requirements listed herein, the fabric or laminate shall meet all requirements of WSB-M8P1-H.

3.1 STATISTICAL PROCESS

Suppliers must conform to the requirements of Ford Quality System Standard Q-101. A mutually acceptable Control Plan as described therein is required for material/source approval. Appropriate statistical tools must be used to analyze process/product data so that variation in the final product is continuously reduced.

3.2 INFRARED SPECTROPHOTOMETRY AND/OR THERMAL ANALYSIS

Ford Motor Company, at its option, may conduct infrared and/or thermal analysis of material/parts supplied to this specification. The IR spectra and thermograms established for initial approval shall constitute the reference standard and shall be kept on file at the designated material laboratory. All samples shall produce IR spectra and thermograms that correspond to the reference standard when tested under the same conditions.

3.3 CONDITIONING AND TEST CONDITIONS

All test values indicated herein are based on material conditioned in a controlled atmosphere of 23 +/- 2 C and 50 +/- 5 % relative humidity for not less than 24 h prior to testing and tested under the same conditions unless otherwise specified.

3.4 FABRIC CONSTRUCTION

3.4.1 Fabric Count, +/- 5 % tolerance (ASTM D 3887)

Wales	90 wales/10 cm
Courses	110 courses/10 cm

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3.4.2	Fabric Weight, range (FLTM BN 106-01)	280 - 320 g/m2
3.4.3	Pile Height, min (Microscope technique)	1.7 mm

3.5 COMPOSITION
(ASTM D 629)

Fabric	100 % polyester

3.6 YARN CONSTRUCTION
(ASTM D 1244)

No. 1 Bar	100 dtex f20, (polyester, spun dyed grey, texturised)
No. 2 Bar	100 dtex f40, (polyester, semi-dull)
No. 3 Bar	270 dtex f64-72, (polyester, bright)
No. 4 Bar	270 dtex f64-72, (polyester, bright)
No. 5 Bar	100 dtex f40, (polyester, semi-dull)
No. 6 Bar	100 dtex f20, (polyester, spun dyed grey, texturised)

3.7	METHOD OF DYEING	Yarn dyed and space dyed or as approved by Materials Engineering
3.8	FINISHING OPERATIONS	As approved by Materials Engineering
3.9	REQUIREMENTS FOR POLYETHER FOAM	As specified in WSD-M2D243-A2
3.10	REQUIREMENTS FOR POLYESTER FOAM	As specified in SKM-4D9502-A
3.11	REQUIREMENTS FOR THE BACKING FABRIC (B1, B2, B5)	As specified in WSD-M9H111-B
3.12	REQUIREMENTS FOR THE BACKING FABRIC (C1, C2, C5)	As specified in WSD-M9H136-A
3.13	REQUIREMENTS FOR THE POLYURETHANE BACKING FILM	As specified in ESD-M99H134-A

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