



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

FABRIC, GALLENA DESIGN, WEFT KNITTED, UNLAMINATED	WSD-M1H617-A
FABRIC, GALLENA DESIGN, WEFT KNITTED, 3 mm	WSD-M1H617-B1
FABRIC, GALLENA DESIGN, WEFT KNITTED, 6 mm	WSD-M1H617-B2
FABRIC, GALLENA DESIGN, WEFT KNITTED, 3 mm	WSD-M1H617-C1
FABRIC, GALLENA DESIGN, WEFT KNITTED, 6 mm	WSD-M1H617-C2
FABRIC, GALLENA DESIGN, WEFT KNITTED, HFW	WSD-M1H617-G
FABRIC, GALLENA DESIGN, WEFT KNITTED, HFW	WSD-M1H617-H
FABRIC, GALLENA DESIGN, WEFT KNITTED, HFW	WSD-M1H617-J
FABRIC, GALLENA DESIGN, WEFT KNITTED, HFW	WSD-M1H617-K

1. SCOPE

The material defined by this specification is a weft knitted Jacquard 20 gauge polyester velour fabric.

2. APPLICATION

WSD-M1H617-A is used for moulded headrests and also adhesive coated for use on inner door panels.

WSD-M1H617-B1, B2, C1, C2 are used for seat wearing surfaces.

WSD-M1H617-G, H, J & K are used for inner door, quarter trim panels and/or as specified on Engineering Drawings.

GALLENA DESIGN

WSD-M1H617-A	Unlaminated
WSD-M1H617-B1	3.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H617-B2	6.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H617-C1	3.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)
WSD-M1H617-C2	6.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)
WSD-M1H617-G	HF-weldable vinyl film, adhesive bonded, or an engineering approved alternative
WSD-M1H617-H	HF-weldable acrylic backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative

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WSD-M1H617-J	HF-weldable vinyl backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative
WSD-M1H617-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 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 24h 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	105.5 wales/10 cm
Courses	144 courses/10 cm

3.4.2 Fabric Weight, +/- 5 % tolerance (FLTM BN 106-01)

330 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)

Ground* 240/48 dTex polyester, semi-dull dyed yarn

Pile 167/30 dTex polyester, semi-dull dyed yarn and
167/30 dTex polyester shiny dyed yarn

*Ground construction based on a knitted jersey.

3.7 METHOD OF DYEING

Yarn dyed and spun dyed or as approved by Materials Engineering

3.8 FINISHED 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

As specified in WSD-M9H111-B or an engineering approved alternative

3.12 REQUIREMENTS FOR THE FLAME
LAMINATED MATERIAL

3.12.1 Thickness, range
(ASTM D 1777, circular presser foot
area 645 mm², 2,8 g Force, 43 Pa
pressure)

WSD-M1H617-B1	3.0 +/- 1.0 mm
WSD-M1H617-B2	6.0 +/- 1.0 mm
WSD-M1H617-C1	3.0 +/- 1.0 mm
WSD-M1H617-C2	6.0 +/- 1.0 mm

3.12.2 Weight, min

WSD-M1H617-B1	475 +/- 30 g/m ²
WSD-M1H617-B2	580 +/- 40 g/m ²
WSD-M1H617-C1	460 +/- 30 g/m ²
WSD-M1H617-C2	545 +/- 40 g/m ²