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|--------------------------------------------|---------------|
| FABRIC, ROMA PATTERN, KNITTED, UNLAMINATED | WSD-M1H654-A  |
| FABRIC, ROMA PATTERN, KNITTED, 3 mm        | WSD-M1H654-B1 |
| FABRIC, ROMA PATTERN, KNITTED, 6 mm        | WSD-M1H654-B2 |
| FABRIC, ROMA PATTERN, KNITTED, 3 mm        | WSD-M1H654-C1 |
| FABRIC, ROMA PATTERN, KNITTED, 6 mm        | WSD-M1H654-C2 |
| FABRIC, ROMA PATTERN, KNITTED, 6 mm        | WSD-M1H654-D2 |
| FABRIC, ROMA PATTERN, KNITTED, 3 mm PU     | WSD-M1H654-F1 |
| FABRIC, ROMA PATTERN, KNITTED, 6 mm PU     | WSD-M1H654-F2 |
| FABRIC, ROMA PATTERN, KNITTED, HFW         | WSD-M1H654-G  |
| FABRIC, ROMA PATTERN, KNITTED, HFW         | WSD-M1H654-H  |
| FABRIC, ROMA PATTERN, KNITTED, HFW         | WSD-M1H654-J  |
| FABRIC, ROMA PATTERN, KNITTED, HFW         | WSD-M1H654-K  |

## 1. SCOPE

The material defined by this specification is a 7 bar 44 gauge DBR knitted, simulated velour, polyester bodycloth.

## 2. APPLICATION

WSD-M1H654-A is used for moulded headrests and also adhesive coated for use on inner door panels.

WSD-M1H654-B1, B2, C1, C2, F1, F2 are used for seat wearing surfaces.

WSD-M1H654-D2 is used for adhesively bonded inner door and quarter trim panels.

WSD-M1H654-G, H, J & K are used for inner door, quarter trim panels and or as specified on engineering drawing.

### ROMA PATTERN

|               |                                                                                |
|---------------|--------------------------------------------------------------------------------|
| WSD-M1H654-A  | Unlaminated                                                                    |
| WSD-M1H654-B1 | 3.0 mm, flame laminated to polyether foam and knitted fabric                   |
| WSD-M1H654-B2 | 6.0 mm, flame laminated to polyether foam and knitted fabric                   |
| WSD-M1H654-C1 | 3.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)    |
| WSD-M1H654-C2 | 6.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)    |
| WSD-M1H654-D2 | 6.0 mm, flame laminated to polyether foam                                      |
| WSD-M1H654-F1 | 3.0 mm, flame laminated to polyester foam and polyurethane film (EAO use only) |
| WSD-M1H654-F2 | 6.0 mm, flame laminated to polyester foam and polyurethane film (EAO use only) |

| Date       | Release No. | Released             |
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|              |                                                                                                                        |
|--------------|------------------------------------------------------------------------------------------------------------------------|
| WSD-M1H654-G | HF-weldable vinyl film, adhesive bonded, or an engineering approved alternative                                        |
| WSD-M1H654-H | HF-weldable acrylic backcoating applied by the doctor-knife spreading technique or an engineering approved alternative |
| WSD-M1H654-J | HF-weldable vinyl backcoating applied by the doctor-knife spreading technique or an engineering approved alternative   |
| WSD-M1H654-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 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 | 120 courses/10 cm |

##### 3.4.2 Fabric Weight, range (FLTM BN 106-01)

340 - 380 g/m<sup>2</sup>