



FABRIC, TRIANGLE DESIGN, WEFT KNITTED, UNLAMINATED	WSD-M1H658-A
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, 3 mm	WSD-M1H658-B1
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, 6 mm	WSD-M1H658-B2
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, 3 mm	WSD-M1H658-C1
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, 6 mm	WSD-M1H658-C2
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, 6 mm	WSD-M1H658-D2
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, 3 mm PU	WSD-M1H658-F1
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, 6 mm PU	WSD-M1H658-F2
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, HFW	WSD-M1H658-G
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, HFW	WSD-M1H658-H
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, HFW	WSD-M1H658-J
FABRIC, TRIANGLE DESIGN, WEFT KNITTED, HFW	WSD-M1H658-K

1. SCOPE

The material defined by this specification is a weft knitted Jacquard 20 gauge polyester velour face fabric which can be flame laminated to polyester and polyether urethane foam and backed with a knitted fabric or polyurethane film. It can also be backed with an HFW weldable backcoating.

2. APPLICATION

WSD-M1H658-A is used for moulded headrests and also adhesive coated for use on inner door panels.

WSD-M1H658-B1, B2, C1, C2, F1 & F2 are used for seat wearing surfaces.

WSD-M1H658-D2 is used for adhesively bonded door and quarter trim panel applications.

WSD-M1H658-G, H, J & K are used for inner door and quarter trim panels and/or as specified on Engineering drawings.

TRIANGLE DESIGN

WSD-M1H658-A	Unlaminated
WSD-M1H658-B1	3.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H658-B2	6.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H658-C1	3.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)
WSD-M1H658-C2	6.0 mm, flame laminated to polyester foam and knitted fabric (EAO use only)
WSD-M1H658-D2	6.0 mm, flame laminated to polyether foam

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WSD-M1H658-F1	3.0 mm flame laminated to polyester foam and polyurethane film (EAO use only)
WSD-M1H658-F2	6.0 mm, flame laminated to polyester foam and polyurethane film (EAO use only)
WSD-M1H658-G	HF-weldable vinyl film, adhesively bonded, or an engineering approved alternative
WSD-M1H658-H	HF-weldable acrylic backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative
WSD-M1H658-J	HF-weldable vinyl backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative
WSD-M1H658-K	HF-weldable polyurethane 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-M8Pl-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	95 wales/10 cm
Courses	135 courses/10 cm



3.4.2	Fabric Weight, g/m2, range (FLTM BN 106-01)	300 - 3702 (335 average)
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*	220 dtex f40 - 72 (polyester, semi-dull) x 2
	Pile	167 dtex f30 - 48 (polyester, bright)
	*Ground construction based on a 1.1 tricot.	
3.7	METHOD OF DYING	Yarn dyed and spun dyed or as approved by Materials Engineering
3.8	FINISHING OPERATIONS	As approved by Materials Engineering
3.9	REQUIREMENTS FOR POLYESTER FOAM	As specified in SKM-4D9502-A
3.10	REQUIREMENTS FOR POLYETHER FOAM	As specified in WSD-M2D243-A2
3.11	REQUIREMENTS FOR THE BACKING FABRIC	As specified in WSD-M9H134-B
3.12	REQUIREMENTS FOR THE POLYURETHANE BACKING FILM (F1, F2)	As specified in ESD-M99H134-A
3.13	REQUIREMENTS FOR THE FLAME LAMINATED MATERIAL	
3.13.1	Thickness, range (ASTM D 1777, circular presser foot area 645 mm2, 2.8 g force, 43 Pa pressure)	
	WSD-M1H658-B1	3.5 +/- 1.0 mm
	WSD-M1H658-B2	6.5 +/- 1.0 mm
	WSD-M1H658-C1	3.5 +/- 1.0 mm
	WSD-M1H658-C2	6.5 +/- 1.0 mm
	WSD-M1H658-D2	6.0 +/- 1.0 mm