



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

LABEL, EMISSION CERTIFICATION, INTERIOR QUALITY
NONTRANSFERABLE

WSE-M3G193-A1

1. SCOPE

The material defined by this specification is a paper base covered with a plastic coating.

2. APPLICATION

This specification was released originally for labels used to state the vehicle emission control information as required by the Federal regulations or as specified on the engineering drawing. It is applied to the mounting surface by removing the release paper and pressing firmly into place. The label is for permanent installation and must not be able to be relocated or removed without defacing or destroying it.

3. REQUIREMENTS

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.

Date	Release No.	Release/Revision
91-02-13	NE01-E 10000474-091	Released E. J. Duda 2-8-91

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3.4 FINISHED LABEL

- 3.4.1 Thickness - Without Release Paper (ASTM D 1000) As specified on engineering drawing

3.4.2 Appearance

Shall be free of streaks, blisters, wrinkles, ragged edges and any other surface imperfections which will make them unsuitable for the intended usage. The design and color shall be as specified on the engineering drawing.

3.4.3 Preparation of Labels on Glass Panels

Clean glass panels with alcohol and allow the surface to dry. Place the label on the glass panels with a 2.0 kg rubber roller with one edge or side not adhered (about 20 % of the total area). Condition for 24 h minimum at 23 +/- 2 C and 50 +/- 5 % relative humidity.

3.4.4 Environmental Testing of Panel Assembly

Test shall be performed immediately after removal from the conditioning environment.

After each of the following environmental exposures, the label must not show evidence of delamination, loss of printing, loss of adhesion or any other effect that would render it to be transferable or illegible. The unadhered edge or side of the label when pulled must be defaced or destroyed.

- 3.4.4.1 Direct a stream of air 400 - 550 kPa pressure with a 2.4 mm diameter orifice and at a distance of approximately 75 mm from the decal's edge for 3 minutes at a right angle to the surface and then for 3 minutes at a 10 degree angle to its edge.

- 3.4.4.2 Humidity cabinet for 3 h at 38 +/- 2 C and 98 +/- 2 % relative humidity.

- 3.4.4.3 Hold for panel for 1 h at - 40 C, then expose heat for 1 h at 100 +/- 2 C. Repeat for 4 cycles. Maximum shrinkage 5 %.

- 3.4.4.4 Weathering Resistance, min 225 kJ (SAE J1885)

Lettering must be legible.