



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

LABEL, RUBBER SATURATED PAPER, COMPUTER PRINTABLE
PRESSURE SENSITIVE, REMOVABLE, NON-STAINING

WSE-M3G218-A

1. SCOPE

The material defined by this specification is a totally removable rubber saturated paper label with a pressure sensitive adhesive protected by a suitable release liner. The label can accept various printed images from computer terminals, typewriters, ball point pens, pencils and grease pens.

2. APPLICATION

This specification was released originally for material used as a label to provide identification information for marine engines.

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.

3.4 MATERIAL

The material shall be a rubber saturated paper supplied with a precoated adhesive on its backside. The label must be removable in one piece and must not leave an adhesive residue on the surface part.

Date	Release No.	Release/Revision
93 06 17	NEO-E 10127076-092	Released E. Duda E. J. Duda

WP 3948-a

Page 1 of 3

93 06 18

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3.5 APPEARANCE

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

3.6 SETTING TIME FOR NORMAL HANDLING

The label shall set sufficiently to permit normal handling immediately after application.

3.7 PREPARATION OF LABELS ON TEST PANELS

The labels shall be tested on actual parts or on laboratory panels which are representative of production parts with respect to substrate, coating and all other process operations. The label must be tested with the printed images affixed by the on-site printing equipment.

3.8 ADHESION, 90 deg Peel, min 0.14 N/mm width
(ASTM D 1000)

3.9 ENVIRONMENTAL EXPOSURE

Samples shall be conditioned for 48 h at 23 +/- 2 C and 50 +/- 5 % relative humidity prior to exposure. Tests shall be completed with 4 h after removal from the conditioning environment.

After each environmental exposure, the label must not show evidence of delamination, loss of printing and no adhesive staining or adhesive and label residue after the label is removed from the surface of the substrate.

3.9.1 Adhesion, 90 deg Peel after 0.18 N/mm width
Humidity Aging, min
(ASTM D 1000, 160 h at 38 +/- 2 C
and 98 +/- 2 % relative humidity)

3.9.2 Adhesion, 90 deg Peel after 0.15 N/mm width
Heat Aging, min
(ASTM D 1000, 1 h at 95 +/- 2 C)

3.10 LABEL STRENGTH

During installation the film or label must not break, tear or deface. The release backing shall not tear or delaminate while being removed from the film or label.