



TAPE, REINFORCED POLYESTER COMPOSITE FILM, PRESSURE SENSITIVE THERMOSETTING ADHESIVE, ELECTRICAL

WSF-M3G39-B

1. SCOPE

The material defined by this specification is a reinforced polyester composite film tape with thermosetting rubber-resin, pressure sensitive adhesive.

2. APPLICATION

This specification was released originally to be used for electrical insulation in automotive assemblies, i.e. starter motor solenoid coil. The pressure sensitive properties of the adhesive assist in the assembly operations.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.4 CONSTRUCTION

The material shall consist of a lamination of polyester matt and polyester film, coated on one side with a non-corrosive thermosetting rubber-resin pressure sensitive adhesive.

3.5 THICKNESS 0.1143 - 0.1524 mm
(ASTM D 1000)

3.6 BREAKING STRENGTH, min 5.6 N/mm
(ASTM D 1000)

3.7 ULTIMATE ELONGATION, range 15 - 70%
(ASTM D 1000)

3.8 DIELECTRIC BREAKDOWN
(ASTM D 1000)

Total Thickness Reading, min 4000 volts

3.9 ADHESION TO STEEL, min 450 N/m width
(ASTM D 1000)

3.10 ADHESION TO BACKING/UNWIND, range 55 - 330 N/m width
(ASTM D 1000)

3.10.1 Flagging No flagging
(2 h at 130 °C)

Date	Action	Revisions
2005 09 19	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.16, 3.17, 4
1993 05 28	Revised & Updated	A. Vallabhanathan, L. Ruman
1991 08 05	Released	DF00E00107002050



3.11 COPPER CORROSION
(FLTM BU 106-01)

No evidence of the characteristic green color of cupric chloride and/or the characteristic blue-black color of copper sulfide on the copper plate.

3.12 CHLORIDES, max 64 ppm
(ASTM D 202)

3.13 pH 6.5 - 7.5
(ASTM D 202)

3.14 THERMOSETTING VALUE 2 h
(ASTM D 1000, except 120 +/- 2 °C)

3.15 SHELF LIFE

Materials supplied to this specification shall meet the above requirements for 18 months from date of manufacture when storage conditions do not exceed 30 °C and 25 - 50% relative humidity.