



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

TAPE, PERFORMANCE, PRESSURE SENSITIVE ADHESIVE,
TWO SIDED, EXTERIOR, BODY SIDE MOLDING

WSK-M11P49-A

1. SCOPE

This specification defines performance requirements of adhesive foam tapes used for exterior automotive applications. The tapes have two sides with two side pressure sensitive adhesive and are protected by either release paper or polymer liner.

The tapes may be used in combination with a suitable primer which would be specified separately on the Engineering drawing.

2. APPLICATION

This specification was released originally to define adhesion performance requirements for automotive body side molding applications.

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 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.

3.3. PREPARATION OF TEST SPECIMENS

Test Specimens shall be prepared from production body side molding parts and painted steel panels, prepared according to FLTM BI 103-02, method B/2, using current approved production paint materials.

The surfaces to be bonded shall be cleaned with Isopropanol/water (1:1) and dry wiped prior to applying the tape. The Tape shall be applied to the weatherstrip sample surface with the liner intact.

Date	Release No.	Release/Revision
1993 01 04	EP00E10258796000	Revised 3.5.1, 3.5.2 W.Scholz
1992 03 02	EP00E01076262000	Released KW conc. J.Schult

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Test Specimens shall be aged for 72 h at room temperature prior to testing unless otherwise specified.

Usage of a primer shall be noted in the Initial Sample Report.

3.4 AGING CONDITIONS

Expose Test Specimens per 3.3 to each of the following conditions before testing per para 3.5.

3.4.1 Humidity Aging

14 d at 38 +/- 2 C, 98 +/- 2 % RH

3.4.2 Heat Aging

14 d at 90 C +/- 2 C;
Reconditioning: 1 h at 23 C and 50 +/- 5 % RH

3.4.3 Paint Repair Oven

30 minutes at 120 C +/- 2 C;
Reconditioning: 1 h at 23 C and 50 +/- 5 % RH

3.4.4 Environmental Cycling (FLTM BQ 104-07, Procedure 5)

3.4.5 Immersion: Wax/Dewaxing Fluid

Use current production waxing and dewaxing compounds as follows: Immerse 1 minute in protective wax compound and condition for 72 h at 23 +/- 2 C. Remove wax coating by immersing 1 h 60 +/- 2 C into dewaxing compound. Allow to cool down to room temperature.

3.4.6 Immersion: Fuel C (ISO 1817, liquid 4, 1 h at 23 +/- 2 C)

3.4.7 Accelerated Weathering 2000 h (SAE J1960)

3.4.8 Florida Exposure 2 years (FLTM BI 160-01, 5 deg south, direct weathering)

This applies to Initial Approval only. Initial approvals will be based on accelerated weathering results, pending Florida results for final approval.

Note: In case of differences between the results of Florida exposure and accelerated weathering, the Florida results shall take precedence.