ENGINEERING MATERIAL SPECIFICATION

Material Name

ADHESIVE, SYNTHETIC RUBBER, SOLVENT RELEASE

Specification Number

WSK-M2G352-A1

1. SCOPE

The material defined by this specification is a synthetic rubber based, solvent release adhesive with good heat resistance.

2. APPLICATION

This specification was released originally for material used for bonding felt, rubber, carpet, wood, hardboard and foam to each other or to porous surfaces.

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
1991 01 02	C01089480	Released W. Scholz Conc. J. Schult

WP 3948-a

9009160 0008992 2T2

Copyright by the Ford Motor Company

Sun Aug 28 23:33:13 2016

Documents Document Sharing Hub

Full document details: FORD WSK-M2G352-A1 1991

3.4	Solids, min (FLTM BV 150-10)	36 %
3.5	Ash, max (FLTM BV 150-10)	20 %
3.6	DENSITY AT 20 C (ASTM D 1475)	0.83 +/- 0.02 kg/L
3.7	VISCOSITY (FLTM BU 104-01, 51 hole disc, total load 1 N)	
3.7.1	As received	35 +/- 5 s
3.7.2	After Aging, max	50 s
3.8	COLD FLEXIBILITY (FLTM BU 152-04)	No chipping
3.9	AGING (FLTM BU 152-05, film thickness 0.4 mm wet)	No chipping or poor adhesion
3.10	SHEAR STRENGTH (FLTM BU 151-01, Method B2, canvas, double coat, film thickness each 0.25 - 0.3 mm wet, open time 5 minutes)	No peel-off length up to 100 C
3.11	PEEL ADHESION (FLTM BU 151-01, Method A, Fig 3, canvas fabric, double coat, film thickness each 0.25 - 0.3 mm wet, open time 5 minutes)	
3.11.1	Original, min	
	a) 10 minutes after bonding	40 kPa
	b) 2 h after bonding	160 kPa
	c) 24 h after bonding	500 kPa
3.11.2	After Correction, min	

Test Method: 5 minutes after bonding, according to 3.11, separate the bond and immediately rebond. Measure the shear strength.

a) After 10 minutes	80 kPa
b) After 2 hours	160 kPa
c) After 24 hours	500 kPa

9009160 0008993 139
Copyright by the Ford Motor Company
Sun Aug 28 23:33:13 2016
Full document details: FORD WSK-M2G352-A1 1991
Documents
Document Sharing Hub