



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

ADHESIVE, SYNTHETIC RUBBER, SOLVENT RELEASE

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

3.0 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 SOLIDS, min 36 %
(FLTM BV 150-10)

3.5 ASH, max 20 %
(FLTM BV 150-10)

3.6 DENSITY AT 20 °C 0.83 +/- 0.02 kg/L
(ASTM D 1475)

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

Date	Action	Revisions
2003 02 27	Revised	Para 3.0 inserted; Para 3.1, 3.2, 3.3, 3.14, 3.15, 4 deleted
1991 01 02	C01089480	Released W. Scholz Conc. J. Schult

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| <p>3.8 COLD FLEXIBILITY
(FLTM BU 152-04)</p> | <p>No chipping</p> |
| <p>3.9 AGING
(FLTM BU 152-05,
film thickness 0.4 mm wet)</p> | <p>No chipping or
poor adhesion</p> |
| <p>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)</p> | <p>No peel-off length
up to 100 °C</p> |
| <p>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)</p> | |
| <p>3.11.1 Original, min</p> | |
| <p>a) 10 minutes after bonding
b) 2 h after bonding
c) 24 h after bonding</p> | <p>40 kPa
160 kPa
500 kPa</p> |
| <p>3.11.2 After Correction, min</p> | |
| <p>Test Method:</p> | <p>5 minutes after bonding, according to 3.11, separate the bond
and immediately rebond. Measure the shear strength.</p> |
| <p>a) After 10 minutes
b) After 2 hours
c) After 24 hours</p> | <p>80 kPa
160 kPa
500 kPa</p> |
| <p>3.12 QUALITY</p> | |
| <p>The material shall be of uniform quality, free from foreign material and properties
detrimental to normal production use.</p> | |
| <p>3.13 STORAGE STABILITY, min
(From date of receipt at Ford Motor Company)</p> | <p>3 months</p> |
| <p>When stored in sealed containers out of direct sunlight at ambient temperatures between
5 °C and 28 °C.</p> | |