

ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

ADHESIVE, BODY, SOLVENT RELEASE

WSK-M2G352-A2

1. SCOPE

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

2. APPLICATION

This specification was released originally for material used for bonding PVC-sheeting to hardboard or grease-free surfaces and/or other applications as specified on Engineering Drawing.

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 (FLTM BV 150-10)	20 %
3.5 ASH, max (FLTM BV 150-10)	3 %
3.6 DENSITY AT 23 °C (ASTM D 1475)	0.86 +/- 0.02 kg/L
3.7 VISCOSITY AT 23 °C (FLTM BU 104-01, 51 hole disc., total load 1 N)	
3.7.1 As Received	15 +/- 3 s
3.7.2 After Aging, max	20 s
3.8 COLD FLEXIBILITY (FLTM BU 152-04, except 70 °C, - 30 °C and mandrel dia 50 mm)	No chipping
3.9 AGING (FLTM BU 152-05, film thickness 0.3 mm wet)	No chipping or poor adhesion

Date	Action	Revision
2003 02 27	Revised	Para 3.0 inserted; Para 3.1, 3.2, 3.3, 3.14, 3.15, 4 deleted
1991 01 02	CO1089480	Released W. Scholz

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3.10 PEEL ADHESION AT ELEVATED TEMPERATURES

(FLTM BU 151-01, Method B2, released PVC sheeting, double coat, film thickness each 0.15 - 0.2 mm wet, open time 2 minutes)

Max 40 mm peel-off length up to 70 °C

3.11 SHEAR STRENGTH, min

(FLTM BU 151-01, Method A, released PVC sheeting, double coat, film thickness each 0.15 - 0.2 mm wet, open time 2 minutes)

- a) 10 minutes after bonding
- b) 2 hours after bonding
- c) 24 hours after bonding
- d) 2 hours after heat aging

80 kPa
130 kPa
280 kPa
380 kPa

3.12 QUALITY

The material shall be a smooth homogeneous mixture, free from foreign materials and properties detrimental to normal production use. The material must be capable of regaining its initial physical characteristics and performance after recirculation or agitation prior to use.

3.13 STORAGE STABILITY, min

(From date of receipt at Ford Motor Company)

3 months

When stored in sealed containers out of direct sunlight at ambient temperatures between 5 °C and 28 °C.

5. GENERAL INFORMATION

The information given below is provided for clarification and assistance in meeting the requirements of this specification.

5.1 COLOR

Transparent yellow or as specified

5.2 FLASHPOINT (ASTM D 56)

Below 21 °C

5.3 OPEN TIME

(Film thickness 0.2 mm wet)

2 minutes