



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

ADHESIVE, SOLVENT RELEASE

WSK-M2G353-A

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 sewn seat inserts in sandwich construction (vinyl coated knitted fabric - polyurethane foam - cotton sheeting) to moulded polyurethane foam parts and/or as specified on Engineering Drawing.

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 03 01	C01089482000	Released	W. Scholz	Conc. J. Schult

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- 3.4 COLOR Light yellow or as specified on engineering drawing
- 3.5 VISCOSITY AT 20 C
(Brookfield LVT, Spindle No. 2,
Rotational Frequency 12/rpm)
- 3.5.1 As Received 1.3 +/- 0.2 Pa.s
- 3.5.2 After Aging, max 2.0 Pa.s
(Aging according to FLTM BU 104-01)
- 3.6 DENSITY AT 20 C 0.8 +/- 0.1 kg/L
(ASTM D 1475)
- 3.7 SOLIDS, min 30 %
(FLTM BV 150-10)
- 3.8 ASH, max 1 %
(FLTM BV 150-10)
- 3.9 STAINING None
(FLTM BU 152-02, Method B)
- Light colored vinyl coated seat fabric, adhesive application double coat, film thickness each 0.2 mm wet, open time one minute.
- 3.10 AGING No chipping or poor adhesion
(FLTM BU 152-05)
- 3.11 SHEAR ADHESION
(FLTM BU 151-01, Method A,
standard canvas fabric, double coat each 0.2 mm wet, open time two minutes)
- a) 10 minutes after bonding, min 80 kPa
b) 2 h after bonding, min 150 kPa
c) 24 h after bonding, min 250 kPa
- 3.12 ADHESION TO FOAM
- The adhesion of the canvas fabric to the foam shall be greater than the cohesive strength of the foam.