

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 molded polyurethane foam parts and/or 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 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 (ASTM D 1475)

0.8 +/- 0.1 kg/L

3.7 SOLIDS, min (FLTM BV 150-10)

30 %

3.8 ASH, max (FLTM BV 150-10)

1 %

Date	Action	Revision
2003 02 27	Revised	Para 3.0 inserted; Para 3.1, 3.2, 3.3, 3.15, 3.16, 4 deleted
1991 03 01	CO10894820000	Released W. Scholz Conc. J. Schult

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3.9 STAINING

(FLTM BU 152-02, Method B)

None

Light colored vinyl coated seat fabric, adhesive application double coat, film thickness each 0.2 mm wet, open time one minute.

3.10 AGING

(FLTM BU 152-05)

No chipping or poor adhesion

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.

Test Method:

Coat a sample of polyurethane foam cut from molded production seat padding and a specimen of standard canvas fabric (see BU 151-01) each with adhesive at a wet film thickness of approx. 0.2 mm.

Bond specimens together after an open time of two minutes and peel apart after conditioning as follows:

- a) 16 h at room temperature
- b) 16 h at room temperature followed by 24 h at 38 +/- 2 °C and 98 +/- 2 % relative humidity.

3.13 PEEL STRENGTH AT ELEVATED TEMPERATURES

(FLTM BU 151-01, Method B2, standard canvas fabric, double coat 0.2 mm wet, open time two minutes)

Peel-off-Length up to 70 °C: max 40 mm.

3.14 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.