



## ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

BODY ADHESIVE, BRUSHABLE, SOLVENT RELEASE

WSK-M2G363-A

### 1. SCOPE

The material defined by this specification is a brushable solvent release body adhesive based on synthetic rubber.

### 2. APPLICATION

This material was originally used to bond supported vinyl roof material to spray-primed or enameled surfaces or other applications as specified by the Materials Engineering Activity.

### 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.

#### 3.4 COLOR

As specified on the Engineering drawing

#### 3.5 SOLIDS, min (FLTM BV 150-10)

24 %

#### 3.6 ASH, max (FLTM BV 150-10)

3 %

| Date       | Release No.      | Release/Revision |           |                 |
|------------|------------------|------------------|-----------|-----------------|
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|            |                  |                  |           |                 |
| 1991 09 02 | EP00E01089488000 | Released         | W. Scholz | Conc. J. Schult |

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- 3.7 DENSITY at 23 C 0.87 +/- 0.03 kg/L  
(ASTM D 816)
- 3.8 VISCOSITY at 23 C 55 +/- 5 s  
(FLTM BU 104-01, 51 hole disc,  
100 g total load)
- 3.9 STAINING No staining  
(FLTM BU 152-02, 200 h, Method B  
with approved vinyl roof material)
- 3.10 HEAT AGING 200 h

After this test, the bonded as well as the unbonded section of the material shall show no change in color, change in gloss or shall be equal to or better than the sample approved by the Materials Engineering Activity.

Test Method: Bond one half of a 150 x 300 mm specimen of the vinyl roof material released for production parallel to the longer edge of the painted panel (FLTM BI 103-02, Method C) using the adhesive WSK-M2G363-A. Expose assembly for 200 hours in a mechanical convection oven maintained at 93 +/- 2 C.

Application: Double coat, each 0.25 - 0.3 mm wet  
Bonding: Dry (vinyl material) on wet (metal)

After bonding and prior to heat aging test condition assembly at room temperature for 24 hours.

- 3.11 COLD FLEXIBILITY No failure  
(FLTM BU 152-04)
- 3.12 AGING No failure  
(FLTM BU 152-05)
- 3.13 QUALITY

The material shall be of uniform quality free from foreign material and properties detrimental to normal production use. It shall not cause excessive soiling of handlers in normal production use.

3.14 ADDITIONAL REQUIREMENTS

Specific requirements for material and/or manufactured parts shall be specified on the Engineering drawing, Engineering parts specification and/or performance specifications. All critical areas with respect to these properties shall be clearly designated on the engineering drawing.