



**TAPE, PRESSURE SENSITIVE ADHESIVE, TWO SIDED,
EXTERIOR ACRYLIC FOAM**

WSK-M3G183-A3

**TAPE, PRESSURE SENSITIVE ADHESIVE, TWO SIDED,
EXTERIOR ACRYLIC FOAM, HEAT ACTIVATED**

WSK-M3G183-A4

1. SCOPE

The materials defined by these specifications are adhesive coated foam tapes based on acrylic polymers. The tapes are protected by a release paper or polymer liner.

2. APPLICATION

WSK-M3G183-A3: This specification was released originally for materials used to affix body side moldings.

WSK-M3G183-A4: This specification was released originally for materials used for weatherstrip applications. The tape is one side heat activatable.

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).

WSK-M3G183-A3: Adhesive tapes according to this specification shall meet the requirements of performance specification WSK-M11P49-A for body side moldings or WSK-M11P51-A for emblems.

WSK-M3G183-A4: Adhesive tapes according to this specification shall meet all requirements of performance specification WSK-M11P48-A for weatherstrip applications.

3.4 PREPARATION OF TEST PANELS

Resistance tests shall be conducted using stainless steel panels (ASTM D 1000) 125 x 50 mm, unless otherwise noted. Test panels shall be cleaned with laboratory grade wiping paper and acetone prior to applying the tape. The tape shall be applied to the sample with liner. Use of primer is not permitted. Test specimens shall be aged for 72 h at room temperature prior to testing unless otherwise specified.

3.5 MATERIAL PROPERTIES

3.5.1	Dimensions	As specified on Engineering Drawing
3.5.2	Color	As specified on Engineering Drawing
3.5.3	Density, kg/m ³ (ASTM D 3574, A)	Must be within +/- 10% of initial sample

Date	Action	Revisions
2006 01 24	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.8, 4
1996 06 17	Revised	Updated and Revised para 3.6.2
1992 03 02	Released	EP00E10176262000

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3.6 PROPERTIES

The figures below are minimum requirements. The original values and the type of failure (cohesive/adhesive failure) shall be noted in the Initial Sample Report.

3.6.1	90° Peel Adhesion, N/cm, min (FLTM BU 112-02, Method A)	A3	A4
	20 min RT	8.5	16
	72 h RT	15	25
3.6.2	T-Peel Adhesion, N/cm, min (FLTM BU 112-02, Method B)	14	22
3.6.3	T-Block Adhesion, N/cm ² , min* (FLTM BU 112-02, Method D)	70	N.A.
3.6.4	Dynamic Shear Adhesion, N/cm ² , min* (FLTM BU 101-06, Method A)	62	N.A.
3.6.5	Tensile Strength, N/cm ² , min (ASTM D 412, Die C)	50	60
3.6.6	Elongation, %, min (ASTM D 412, Die C, 500 mm/minute)	500	500

* For initial approval only

3.7 QUALITY

The adhesive tapes must be adaptable for application in accordance with the appropriate Ford Motor Company Process Specification.

The adhesive tapes must be compatible with all related materials, e.g. paint materials, primers, substrate materials, etc.

5. GENERAL INFORMATION

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

5.1 STORAGE STABILITY 12 months

Store at temperatures below 30 °C or according supplier's technical data sheet. The release liner shall remove easily when measured by hand peel examination and shall not change appreciably after storage.

5.2 MATERIAL REFERENCE

All related materials as well as the tape dimensions, used for approval of adhesive tapes according to this specification, e.g. paint materials, cleaners or substrate materials, shall be noted in the Initial Sample Report of the tape.

5.3 MINIMUM APPLICATION TEMPERATURE 15 °C

The adhesive tape shall not be used if the temperature of the parts to be bonded is below 15 °C.