Material Name	Specification Number
TAPE, PRESSURE SENSITIVE ADHESIVE, TWO SIDED, EXTERIOR, POLYETHYLENE/VINYLACETATE	WSK-M3G184-A1
TAPE, PRESSURE SENSITIVE ADHESIVE, TWO SIDED, EXTERIOR, CHLOROPRENE/NEOPRENE	WSK-M3G184-A3
TAPE, PRESSURE SENSITIVE ADHESIVE, TWO SIDED, EXTERIOR, POLYETHER	WSK-M3G184-A4

1. SCOPE

The materials defined by these specifications are adhesive foam tapes based on polymer material. The tapes are protected by release paper or polymer liner.

2. APPLICATION

WSK-M3G184-A1: This specification was released originally for materials used for retaining bodyside moldings as well as emblems to painted surfaces and to bond rubber parts to bumpers.

WSK-M3G184-A3/A4: This specification was released originally for materials used for fixing script ornaments, emblems and moldings.

3. REQUIREMENTS

Adhesive tapes according to these specifications shall meet the requirements of the performance specification as required on Engineering Drawing, e.g. WSK-M11P48-A for weatherstrip application, WSK-M11P49-A for Body Side Moldings, WSK-M11P50-A for bumper inserts or WSK-M11P51-A for emblems.

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.

Date	Release No.	Released	
1994 08 03	EP00E10428885000	WSK-M3G184-A4 added	W. Scholz
1992 03 02	EP00E10176262000	Released KW	conc. J. Schult

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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 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 hours 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/m3 (ASTM D 3574, A)	Must be within +/- 10 % of initial initial sample

3.6 RESISTANCE 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.

		A1	A3	A4
3.6.1	90 Degree Peel Adhesion, N/cm, min (FLTM BU 112-02, Method A)			
	20 minutes RT	7	5.5	6
	72 hours RT	15	5.5	7.5
3.6.2	T-Peel Adhesion, N/cm, min (FLTM BU 112-02, Method B)	10	9	7.5
3.6.3	T-Block Adhesion, N/cm2, min* (FLTM BU 112-02, Method D)	80	45	55
3.6.4	Dynamic Shear Adhesion, N/cm2, min* (FLTM BU 101-06, Method A)	150	55	88

* For initial approval only.

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