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.

3.0 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 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

Date	Action	Revisions
2004 02 20	Revised	Para 3.0 inserted; para 3.1, 3.2, 3.3, 3.8 and 4 deleted para 3.6.4 revised — W. Scholz
1994 08 03	EP00E10428885000	WSK-M3G184-A4 added — W. Scholz
1992 03 02	EP00E10176262000	Released — H.W. conc. J. Schult

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3.5.3	Density, kg/m^3 (ASTM D 3574, A)	Must be within +/- 10% of 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° 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/cm^2, min* (FLTM BU 112-02, Method D)	80	45	55
3.6.4	Dynamic Shear Adhesion, N/cm^2, min* (FLTM BU 101-06, Method A)	70	55	88
	* For initial approval only.			
3.6.5	Tensile Strength, N/cm^2, min (ASTM D 412, Die C)	200	170	200
3.6.6	Elongation, %, min (ASTM D 412, Die C, 500 mm/minute)	440	200	300

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

Storage 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.

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