



TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED, NON WOVEN FIBER, INTERIOR

WSK-M3G198-A

1. SCOPE

The material defined by this specification is a two sided pressure sensitive non-woven fiber tape, protected with release paper. The adhesive is based on acrylic resins.

2. APPLICATION

This specification was released originally for a material used to bond PVC sheeting to clean and grease free surfaces (e.g. door inner panel) or for other applications as specified on Engineering Drawing.

Prior to the release for a particular application and in addition to the requirements specified within this specification, full evaluation as a component of specific trim products must be tested by the responsible Component Engineering activity on substrates intended for use in the final application.

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 MATERIAL PROPERTIES

3.4.1	Color	Colorless, transparent
3.4.2	Thickness (ASTM D 1000)	0.065 - 0.130 mm
	Without release paper	
3.4.3	Width (ASTM D 1000)	See 5.3
3.4.4	Breaking Strength, min (ASTM D 1000)	500 N/m
3.4.5	Elongation, max (ASTM D 1000)	10%

3.5 PREPARATION OF TEST SPECIMENS

Steel panels, painted with current production enamel according to respective paint specification if not otherwise specified.

Test specimens shall be wiped with isopropanol/water (1:1) and dry wiped with a lint free tissue soaked with n-heptane prior to applying the tape or as recommended by supplier.

Usage of a primer shall be noted in the Initial Sample Report.

Date	Action	Revisions
2006 01 27	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.2, 3.10, 4
1992 07 01	Released	EPOOE10176272000



Documents

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3.6 AGING CONDITIONS

Expose Test Specimens to each of the following conditions before testing per para 3.6.

3.6.1 2 h at 23 +/- 2 °C

3.6.2 Humidity Aging

14 d at 38 +/- 2 °C, 98 +/- 2% RH
Reconditioning: 4 h at 23 °C and 50 +/- 5% RH

3.6.3 Heat Aging

14 d at 80 +/- 2 °C;
Reconditioning: 4 h at 23 °C and 50 +/- 5% RH

3.6.4 Paint Repair Oven

30 minutes at 120 +/- 2 °C;
Reconditioning: 4 h at 23 °C and 50 +/- 5% RH

3.6.5 Environmental Cycling
(FLTM BQ 104-07, Procedure 5)

Reconditioning: 4 h at 23 °C and 50 +/- 5% RH

3.7 ADHESION PROPERTIES

3.7.1 Peel Adhesion
(ASTM D 1000, Method A, clause 40 - 42)

Prior to testing cover unlined side of the tape with a polyester film of approx. 0.04 mm thickness to avoid elongation during testing.

Aged per 3.6.1, min	400 N/m
Aged per 3.6.2, min	600 N/m
Aged per 3.6.3, min	800 N/m
Aged per 3.6.4, min	800 N/m
Aged per 3.6.5, min	800 N/m

3.7.2 Shear Adhesion, min
(FLTM BU 151-01, Method A, Fig 2)

0.5 N/mm²

24 h after bonding

Prior to testing cover unlined side of the tape with a polyester film of approx. 0.1 mm thickness to avoid elongation during testing.

3.7.3 Liner Removal, max
(ASTM D 1000)

400 N/m