



**TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED,
ACRYLIC, INTERIOR, 0.05 MM NOMINAL THICKNESS**

WSK-M3G199-A1

**TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED,
ACRYLIC, INTERIOR, 0.13 MM NOMINAL THICKNESS**

WSK-M3G199-A2

1. SCOPE

The materials defined by these specifications are two side pressure sensitive acrylic adhesive film tapes with high initial tack and plasticizer resistance, protected by release paper.

2. APPLICATION

These specifications were released originally for materials used for general interior purposes and were originally released to stick vinyl materials to each other on radio speaker assemblies or as specified on the Engineering drawing.

Prior to the release for a particular application and in addition to the requirements specified within these specifications, 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 Thickness Without Release Paper (ASTM D 1000)

WSK-M3G199-A1	0.04 - 0.07 mm
WSK-M3G199-A2	0.08 - 0.18 mm

3.4.2 Width

As specified on Engineering Drawing

3.4.3 Weight (FLTM BN 106-01)

WSK-M3G199-A1	45 - 65 g/m ²
WSK-M3G199-A2	107 - 147 g/m ²

3.5 PREPARATION OF TEST SPECIMENS

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

Date	Action	Revisions
2006 01 27	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.10, 4
1992 07 01	Released	EPOOE10176272000

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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.

3.6 AGING CONDITIONS

Expose test specimens to each of the following conditions before testing per para 3.6.

- 3.6.1 1 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 °C +/- 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	500 N/m
Aged per 3.6.3, min	500 N/m
Aged per 3.6.4, min	500 N/m
Aged per 3.6.5, min	500 N/m
- 3.7.2 Shear Adhesion, min
(FLTM BU 151-01, Method A, Fig.2)

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.

0.2 N/mm²
- 3.7.3 Liner Removal, max
(ASTM D 1000)

40 N/m