



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED, INTERIOR

WSK-M3G200-A

1. SCOPE

The material defined by this specification is a double sided adhesive tape with a PVC or PP carrier. One side is protected by a release liner.

2. APPLICATION

This specification was released originally for materials used for fixing headlining to enameled panel.

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

3.1 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.

3.3 CONDITIONING

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.

Date	Release No.	Release/Revision	
1992-07-01	EP00E10176272000	Released	C. Dittebrandt

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3.4 MATERIAL PROPERTIES

3.4.1	Color	White
3.4.2	Thickness (ASTM D 1000)	0.18 - 0.30 mm
3.4.3	Width	See 5.3
3.4.4	Breaking Strength, min (ASTM D 1000)	3800 N/m
3.4.5	Elongation (ASTM D 1000)	20 - 55 %

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.

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 +/- 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