



ENGINEERING MATERIAL SPECIFICATION

TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED,
SYNTHETIC RUBBER, INTERIOR, 0.13 MM NOMINAL THICKNESS

WSK-M3G202-A1

TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED,
SYNTHETIC RUBBER, INTERIOR, 0.09 MM NOMINAL THICKNESS

WSK-M3G202-A2

1. SCOPE

The materials defined by these specifications are two sided pressure sensitive transparent tapes with high initial tack. One side of the tapes is covered with a release paper.

2. APPLICATION

These specifications were released originally for materials used as an assembly aid to temporarily fix plastic parts to steel or painted substrates.

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	Color	Colorless transparent
3.4.2	Thickness (ASTM D 1000, without release paper)	
	WSK-M3G202-A1	0.09 - 0.16 mm
	WSK-M3G202-A2	0.07 - 0.11 mm
3.4.3	Width	See 5.3
3.4.4	Breaking Strength (ASTM D 1000)	
	WSK-M3G202-A1, min	400 N/m
	WSK-M3G202-A2, min	400 N/m
3.4.5	Elongation (ASTM D 1000)	
	WSK-M3G202-A1, min	5%
	WSK-M3G202-A2, min	2.5%

Date	Action	Revisions
2006 01 30	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.9, 4; Corrected numbering 3.4
1993 08 02	Revised	EPOOE10258823000 Renumbered 3.6 W. Schulz
1992 07 01	Released	EPOOE10176272000 C. Dittbrandt



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 ADHESION PROPERTIES

3.6.1 Peel Adhesion (ASTM D 1000, 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.

WSK-M3G202-A1, min	400 N/m
WSK-M3G202-A2, min	130 N/m

10 minutes after bonding.

3.6.2 Shear Strength, min (FLTM BU 151-01, Method A, Fig.2)

0.2 N/mm²

Age 2 h at 23 +/- 2 °C

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

3.6.3 Softening Point, min 50 °C (ASTM D 816)

Prepare test specimens according to clause 3.10. Maintain oven temperature at 30 °C for 15 minutes, then increase temperature in steps of 2.5 °C/5 minutes until bond failure.

3.6.4 Liner Removal, max (ASTM D 1000, Method A)

30 N/m

3.7 FOGGING (FLTM BO 116-03)

Fog Number, min 60

Perform the test with the tape between aluminum foils or steel panels.

3.8 FLAMMABILITY (ISO 3795/SAE J369)

Burn Rate, max 100 mm/minute

Perform the test with the tape between aluminum foils or steel panels.