



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED,
SYNTHETIC RUBBER, INTERIOR, 0.13 MM NOMINAL THICKNESS
TAPE, ADHESIVE, PRESSURE SENSITIVE, TWO SIDED,
SYNTHETIC RUBBER, INTERIOR, 0.09 MM NOMINAL THICKNESS

WSK-M3G202-A1

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

3.1 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.

Date	Release No.	Release/Revision	
1993 08 02	EP00E10258823000	Renumbered 3.6	W. Scholz
1992-07-01	EP00E10176272000	Released	C. Dittebrandt

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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.

3.4 MATERIAL PROPERTIES

3.4.1 Color Colorless transparent

3.4.1 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 %

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.