



TAPE, ADHESIVE, ONE SIDED, PVC FOAM, CLOSED
CELL PRESSURE SENSITIVE, EXTERIOR

WSK-M3G203-A1

TAPE, ADHESIVE, ONE SIDED, PVC FOAM, CLOSED
CELL PRESSURE SENSITIVE, EXTERIOR

WSK-M3G203-A2

1. SCOPE

The materials defined by these specifications are soft, closed cell polyvinyl chloride (PVC) foam tapes. One side is adhesive coated and the other protected by a coated release paper.

Note: These products are manufactured so that as the tape is unrolled, the adhesive surface is exposed. While rolled, the top surface of the release paper serves as a liner to protect the adhesive and prevent sticking. The release paper remains on the adhesive free surface of the foam tape and is not removed until after installation, except when supplied in cut length in which case the release paper is on the adhesive side.

2. APPLICATION

These specifications were released originally for materials used as fillers between exterior moldings and painted metal and for sealing windshield rubber weatherstrips against water leaks or for similar applications as specified on 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	Color	Black or as specified on Engineering Drawing
3.4.2	Dimensions (ASTM D 1000)	As specified on Engineering Drawing
3.4.3	Density (ASTM D 1667)	110 +/- 15 kg/m ³
	Use strips of the tape as received with adhesive.	
3.4.4	Breaking Strength, min. (ASTM D 1000)	400 N/m

Date	Action	Revisions
2006 01 30	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.3, 3.8, 4; Corrected numbering 3.4; Updated format
2000 08 11	Activated	



3.4.5 Elongation, min 100%
(ASTM D 1000)

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3.4.6 Compression Deflection 3 - 9 kPa 2 - 3 kPa
(ASTM D 1056)

3.4.7 Compression Set 90% 60%
(ISO 1856)

72 h at 23 +/- 2 °C

3.4.8 Dimensional Stability under Heat, max 5% volume change

Test Method:

- 1) Apply approx. 100 mm length of tape to a steel panel leaving the release paper on the top surface and place the steel panel in a Method "B" fixture per ASTM D 395.
- 2) Measure initial length and width of tape specimen and compress to 50% of nominal thickness and clamp in this position. In order to compensate for the release paper on the top surface, place a proper length of release paper beneath each spacer.
- 3) Expose assembly in an air mechanical convection oven for 30 minutes at 120 +/- 2 °C.
- 4) Remove panel and tape from fixture and condition for 2 hours at room temperature.
- 5) Measure final length and width, measure total thickness and subtract thickness of panel and release paper. Thickness is calculated on compressed thickness or spacer thickness.
- 6) Calculate volume change.

3.4.9 Water Seal

No leaks after one hour under a 50 mm static head of water.

- A: After 30 minutes at room temperature at 40% compression.
B: After 30 minutes at 120 °C +/- 2 °C at 60% compression.

Test Method:

- 1) Cut two 300 - 350 mm samples of tape and remove the release paper. Carefully position the tape without wrinkling in a "U" configuration of 155 - 165 mm inside diameter on a 300 x 300 mm clean flat glass plate with the tape adhesive surface towards the glass surface.
- 2) Place an identical 300 x 300 mm glass plate on the top surface of the "U" configuration of tape. Compress to appropriate thicknesses (40% and 60% compressions) using spacers and carefully clamp in these positions in order to maintain a uniform pressure on the full area of the "U".