



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

LABEL, PLASTIC SHEET, PRESSURE SENSITIVE

WSK-M3G204-A1

LABEL, PLASTIC SHEET, PRESSURE SENSITIVE, NOT REMOVABLE

WSK-M3G204-A2

1. SCOPE

The materials defined by these specifications are plastic labels. The back side of the labels is coated with a pressure sensitive adhesive, the surface is color printed according to Engineering Drawing and covered by a clear lacquer. The adhesive film is protected by release paper or polymer liner.

WSK-M3G204-A2 is designed to be destroyed when removed.

2. APPLICATION

This specification was released originally for certification labels fixed permanently to painted surfaces.

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 AND TEST CONDITIONS

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	
1991-11-04	EP00E01089490000	Revised 3.6 and 3.8	K. Wolters
1991-08-01	EP00E01089487000	Released KW	

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3.4 APPEARANCE

The labels shall be free of streaks, blisters, wrinkles, ragged edges or any other surface imperfections which make them unsuitable for the intended usage.

Color and design shall be as specified on the Engineering Drawing.

3.5 SETTING TIME FOR NORMAL HANDLING

The labels shall set sufficiently to permit normal handling immediately after application.

3.6 THICKNESS 0.065 - 0.1 mm or as specified on Engineering Drawing (ASTM D 1000)

Thickness of label plus adhesive without release paper or liner.

3.7 PREPARATION OF TEST SPECIMENS

Prepare painted test panels according to FLTM BI 103-02, Method C. Apply the labels and press firmly using a rubber roller or equivalent. Condition per para 3.3.

3.8 ADHESION

No loss of adhesion, no peeling, blistering or cracking permitted. The print shall not be removed by wiping with cleaning fuel.

Slight color change may be accepted if the printing is still visible after test end.

Labels per WSK-M3G204-A2 must be destroyed when removed, on original and on samples aged per 3.8.1, 3.8.2 and 3.8.3.

Test Method: Adhesion shall be evaluated on original and aged test specimens prepared according to para 3.7.

3.8.1 Heat Aging (2 h at 70 +/- 2 C)

Evaluation after cooling down to room temperature.

3.8.2 Paint Repair Oven (10 minutes at 100 +/- 2 C)

Evaluation after cooling down to room temperature.

3.8.3 Cold Aging (4 h at - 30 +/- 2 C)

Evaluation after warming up to room temperature.