



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

TAPE, PRESSURE SENSITIVE, ADHESIVE, ONE SIDED,
POLYETHYLENE, 0.28 mm NOMINAL THICKNESS

WSK-M3G217-A

1. SCOPE

The material defined by this specification is a heat resistant colorless clear polyethylene tape. One side is coated with a pressure sensitive adhesive and covered with release paper.

2. APPLICATION

This specification was released originally for material used to prevent body paint from abrasion due to vibration of attached bumper and/or brake fluid pipe. The material was applied to E-coated, spray primed or painted surfaces.

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 the 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	
1993 06 01	EP00E10258817000	Released	B. Lange

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3.4 MATERIAL PROPERTIES

3.4.1	Color	Colorless clear or as specified on the Engineering Drawing
3.4.2	Thickness (ASTM D 1000)	0.25 - 0.32 mm or as specified on the Engineering Drawing
3.4.3	Width	See 5.3 or as specified on the Engineering Drawing
3.4.4	Breaking Strength, min (ASTM D 1000, Method A)	7500 N/m
3.4.5	Elongation, min (ASTM D 1000)	150 %
3.4.6	Liner Removal, max	20 N/m

3.5 PREPARATION OF TEST SPECIMENS

Substrate:

Steel panels, painted with current production top coat materials according to respective specifications unless otherwise specified.

Test panels shall be wiped with Isopropanol/water (1:1) and dry wiped prior to applying the tape or as recommended by supplier.

Bond tape to test panel as specified by the respective test method. The individual top coat surface conditions used shall be mentioned in the Initial Sample Report.

3.6 AGING CONDITIONS

Expose test specimens to each of the following conditions before testing per para 3.7.

3.6.1 24 h at 23 +/- 2 C

3.6.2 Humidity aging

14 d at 38 +/- 2 C, 98 +/- 2 % relative humidity
Reconditioning: 4 h at 23 +/- 2 C and 50 +/- 5 % relative humidity

3.6.3 Heat Aging

14 d at 80 +/- 2 C;
Reconditioning: 4 h at 23 +/- 2 C and 50 +/- 5 % relative humidity