



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

SEALING STRIP, SELF ADHESIVE, INTERIOR

WSK-M4G339-A

1. SCOPE

The material defined by this specification is a self adhesive sealing strip based on thermoplastic rubber.

2. APPLICATION

This material was originally released for the sealing of interior nonvisible joints between rear wheel arch and floor panel, and is applied on EC coated surfaces before passing through the spray primer oven.

3. REQUIREMENTS

Note: Unless otherwise specified, use test panels EC coated according to FLTM BI 120-01.

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.

3.4 COLOR

Any

3.5 SOLIDS, min (FLTM BV 150-10)

99.0 %

Date	Release No.	Release/Revision
1991 10 01	EP00E01089489000	Revised 3.7 and 3.15
1991 02 01	C01089481000	Released W. Scholz Conc. J. Schult

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- 3.6 ASH, max
(FLTM BV 150-10) 56 %
- 3.7 DENSITY AT 23 C
(ASTM D 297, Hydrostatic Method) 1.45 +/- 0.10 kg/L
- 3.8 PENETRATION AT 23 C
(ASTM D 5, needle 2.5 g, 2 N total weight force, 5 s dwell time, ply up original parts for measuring to a minimum thickness of 15 mm)
- 3.8.1 As Received 3.5 - 6.5 mm
- 3.8.2 After Aging, max
(120 h at 70 +/- 2 C,
1 h at 23 C) 8 mm
- 3.9 DIMENSIONS As specified on Engineering Drawing
- 3.10 HEAT RESISTANCE AFTER AGING No loss of adhesion or chipping
- Test Method:
- . Apply 250 x 13 x 6 +/- 0.5 mm pieces of test materials to 300 x 10.0 x 0.8 - 0.9 m,m test panels and press together by hand.
 - . Expose separate test assemblies according to FLTM BV 150-05, Table 2.
 - a) minimum curing cycle
 - b) maximum curing cycle
 - . Expose test assemblies in a mechanically convected air dry oven at 80 +/- 2 C for 120 h.
 - . Proceed as outlined under FLTM BV 153-03, Method B, para 5, mandrel diameter 100 mm.
- 3.11 LOW TEMPERATURE FLEXIBILITY No loss of adhesion or chipping
- Test Method:
- . Prepare specimen according to para 3.10.
 - . Proceed as outlined under FLTM BV 153-04, Method B, para 4 and 5, - 30 +/- 1 C, mandrel diameter 100 mm.