

**LEATHER, GENUINE FULL GRAIN, CHROME FREE,
INSTRUMENT PANEL, DOOR TOP ROLL, CENTER CONSOLE,
AND OTHER INTERIOR TRIM****WSS-M1F25-B****1. SCOPE**

The material defined by this specification is finished, full grain, steer or heifers hide which has been chrome free tanned to retain the natural odor of the leather.

2. APPLICATION

This specification was released originally for material used as instrument panel leather for the CD345 Mondeo. This material must meet the requirements of WSS-M15P45-B/latest and the appropriate Instrument Panel SDS. If this material will be part of an integrated airbag/instrument panel system then the material must also meet the requirement of the appropriate airbag SDS.

3. REQUIREMENTS

For all test methods, no individual specimen shall fall below the minimum values specified herein. Material specification requirements are to be used for initial qualification of materials.

3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements for Production Materials (WSS-M99P1111-A).

3.1.1 Vehicle Interior Environment Quality Materials/Component Performance Requirements
Materials used in interior applications must meet the requirements outlined in WSS-M99P2222-C1 or latest. Data must be included in material submission package.

3.2 SAMPLE SELECTION

Samples for testing shall be selected no closer than 80 mm from edge of the hide.

3.3 APPEARANCE

3.3.1 Color Matching with Artificial Light
(FLTM BI 109-01, Visual Assessment)

The color, pattern and finish shall match the approved Design Center master sample or shall be as specified on the Engineering Document.

3.3.2 Gloss As specified on the Engineering Document
(FLTM BI 110-01)

The color, grain, visual aesthetics, hand and finish shall match the approved Design Center master sample, or shall be as specified on the engineering drawing.

Date	Action	Revisions	Rev. 2
2017 11 16	Editorial	See Summary of Revisions	S. Gatzek, NA
2014 03 03	Editorial	Removed selection A from Scope	L. Schmalz, NA.
2012 10 16	Released		

Controlled document at www.MATS.ford.com

Copyright © 2017, Ford Global Technologies, LLC

**Documents**

Document Sharing Hub

**3.4 GRADE**

Full grain dyed leather, not buffed. The leather must be through dyed to a sufficient depth to prevent undyed fibers from showing through after sewing. Also, the color of the dye must be compatible in appearance with the surface coating.

3.5 FINISH

All hides shall show no defects or surface blemishes affecting the appearance of the material, such as brush marks or stops and bad flows.

3.6 THICKNESS
(ASTM D1813)

0.9-1.3 mm*

*Specific thickness range required for wrapping will be noted in each program SCCAF.

3.7 BREAKING STRENGTH

(ASTM D2208, Grab Method, five samples from two locations)

Any direction

400 N min

3.8 ELONGATION at 100 N

(ASTM D2211, Grab Method, five samples from two locations)

15- 40%

3.9 TEAR STRENGTH (Trapezoid)

(ASTM D5733, average the total load of the 5 highest peaks. Average 5 samples.)

Any direction

70 N min

3.10 STIFFNESS, target
(FLTM BN 157-02)

65 +/- 10 mm*

Stiffness measurements shall be taken on either side of the backbone.

* Pending further data collection

3.11 STRETCH AND SET
(SAE J855)Stretch
Set25% max
10% max**3.12 ADHESION OF SURFACE COATING**

(ISO 11644, Adhesive: Cyanoacrylate - Sicomet 8400 or equivalent
Supplier: Henkel, or equivalent.
Condition bonded test specimens for 1 hour min.)

As received
After humidity per 3.13.34N/10mm min
4N/10mm min

**3.13 COLOR PROPERTIES****3.13.1 Resistance to Fade**
(FLTM BO 116-01, ISO 105 A-02/AATCC
Evaluation Procedure 1)

Instrument Panel Top
3609.6 kJ/m² Rating 4 min

Instrument Panel Lower
2406.4 kJ/m² Rating 4 min

Door Top Roll, Center Console/Other Interior Trim
977.6kJ/m² Rating 4 min

The heat aged sample shall not exhibit color tone change in excess of the above rating.

In addition, the material must remain flexible and exhibit no cracking when bent around a 6.4 mm mandrel.

3.13.2 Resistance to Heat Aging
(ISO 105-A02/
AATCC Evaluation Procedure 1)

Instrument Panel Top
500 hours at 120 +/- 2 °C Rating 4 min

Instrument Panel Lower
168 hours at 100 +/- 2 °C Rating 4 min

Door Top Roll, Center Console /Other Interior Trim
168 hours at 100 +/- 2 °C Rating 4 min

The heat aged sample shall not exhibit color tone change in excess of the above rating.

3.13.3 Resistance to Humidity
(ISO 105-A02/AATCC Evaluation Procedure 1)

Chrome Free Tanned

7 days at 70 +/- 2 °C/70 +/-5% RH Rating 4 min

There shall be no tone or gloss change or any loss of grain definition.
Samples to be suspended vertically in the test cabinet.

3.13.4 Soiling and Cleanability Rating 4 min
(FLTM BN 112-08, ISO 105-A03/
AATCC Evaluation Procedure 2)

Cleaned with Leather cleaner not multipurpose