



LEATHER, GENUINE, FULL GRAIN, LUXURY, CHROME TANNED OR CHROME FREE TANNED

WSS-M1F27-B

1. SCOPE

The material defined by these specifications is finished, full grain, steer or heifer hides which have been tanned and softened to provide maximum seating comfort without sacrificing the leather's remaining physical properties.

2. APPLICATION

Because the hand and appearance characteristics will be adversely affected, the leather shall not be subjected to steam heat or radiant heat or organic solvents during any manufacturing process. No correcting or repair of any kind shall be allowed including but not limited to buffing, filling or stuccoing. Specific usage guidelines and care instructions should be supplied with the vehicle. Customers and dealers should be advised that these products will not perform in the same way as traditional pigmented leathers. A limited warranty should also be considered.

It must be noted in the ASL if the leather is chrome tanned or chrome free tanned.

3. REQUIREMENTS

Materials manufactured to this Specification shall also meet the requirements contained in WSS-M99P43-B. For all test methods, no individual specimen shall fall below the minimum values specified herein.

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).

3.2 SAMPLE SELECTION

Samples for testing shall be selected according to paragraph 3.3 in WSS-M99P43-B.

3.3 APPEARANCE (FLTM BI 109-01)

The colour, grain, visual aesthetics, hand and finish shall match the approved Design Centre master sample, or shall be as specified on the Engineering Drawing.

It is the responsibility of the leather supplier/cutter, the first receiving location and/or the Tier One Seat Supplier to follow the direction of the relevant Natural Characteristics Standard, copies of which are available from Color and Materials NA or Thierry in Europe. (Addresses in Appendix I)

3.4 GRADE

The leather must be through dyed to prevent undyed fibers from showing through after sewing or perforation. Also, the colour of the dye must be compatible in appearance with the surface coating. No stuccoing permitted.

Date	Action	Revisions	Rev 02
2015 05 15	Editorial	Removed section 2 statement 'except as specified below'	L. Schmalz, NA
2014 03 03	Editorial	Removed selection A from scope	L. Schmalz, NA
2010 04 15	Activated		M. Dumitrescu, FORD J. Williams FOE

**3.5 FINISH**

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

3.6 THICKNESS, range
(ASTM D 1813)

1.0 – 1.5 mm
Or as specified on the
Engineering Drawing

3.7 SHRINKAGE, max.
(FLTM BN 105-03, except Heat
Cycle 100 +/- 2 °C, 3 cycles)

5.0%

3.8 ADHESION OF SURFACE COATING, min
(ISO 11644, . Adhesive Sicomet 8400 or equivalent
Supplier: Henkel, or equivalent
Condition bonded test specimens for 1 hour min.)

As received
After humidity (WSS-M99P43-B para. 3.5.1.4)

4N/10mm
4N/10mm

3.9 STIFFNESS, target range*
(FLTM BN 157-02)

55 +/- 10mm

Stiffness measurements shall be taken along either side of the backbone.
* Pending further data collection

3.10 STRETCH AND SET*
(SAE J855)

Stretch, max
Set, max

25%
10%

* Or as required by Seat Engineering.

Perforated

As specified by Seat
Engineering, dependant upon
perforation pattern

3.11 LEATHER FUNCTIONAL PROPERTIES

Leather wear and process capability tests are required for all seating applications. In addition, other trim applications may require unique functional evaluations. These tests should be evaluated by a cross-functional team prior to colour and trim strategy approval to assess the effects of the leather selection, seat style, sew style, leather perforation, foam hardness, etc. on the predicted level of customer satisfaction and long term durability.