



LEATHER, GENUINE, CORRECTED GRAIN, STANDARD, CHROME TANNED OR CHROME FREE TANNED

WSS-M1F29-B

1. SCOPE

The materials defined by this specification are corrected 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

These specifications were released originally for material used as interior trim and seating leather, excluding instrument panel covers and steering wheels. Because the hand and appearance characteristics will be adversely affected, the leather shall not be subjected to steam or radiant heat or organic solvents during any manufacturing process.

Corrected grain leather shall be snuffed using one pass of 320 grit paper. No stuccoing, filling or other repair is permitted. The method of correction shall be agreed upon with Materials Engineering, Color and Materials, Seat Engineering and Purchasing.

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 color, grain, visual aesthetics, hand and finish shall match the approved Design Centre master sample and 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.

Date	Action	Revisions	Rev. 2
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
2009 09 30	Activated		M. Dumitrescu, NA J. W. Williams, EU

**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 - 1.5mm
or as specified on the
Engineering Drawing

3.7 SHRINKAGE

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

5.0% max

3.8 ADHESION OF SURFACE COATING

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

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

4N/10mm min
4N/10mm min

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

65 +/- 10mm

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

* Pending further data collection

3.10 STRETCH AND SET*
(SAE J855)

Stretch
Set

25% max
10% max

Perforated:

As specified by Seat
Engineering, dependant
upon perforation pattern

* Or as required by Seat Engineering.

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 Materials 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.

4. GENERAL INFORMATION

The information given below is provided for clarification and assistance in meeting the requirements of this specification.

4.1 SOFTNESS, range
(FLTM BN 157-01, BLC ST300 Softness Tester,
using a 25 mm diameter (nominal) aperture)

3.5 +/- 0.5mm*

Softness measurements shall be taken along either side of the backbone.

