



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

FABRIC, ANGORA PATTERN, KNITTED, UNLAMINATED	WSD-M1H614-A
FABRIC, ANGORA PATTERN, KNITTED, 3 mm	WSD-M1H614-B1
FABRIC, ANGORA PATTERN, KNITTED, 6 mm	WSD-M1H614-B2
FABRIC, ANGORA PATTERN, KNITTED, 6 mm	WSD-M1H614-D2
FABRIC, ANGORA PATTERN, KNITTED, 3 mm	WSS-M1H614-C1
FABRIC, ANGORA PATTERN, KNITTED, 6 mm	WSS-M1H614-C2
FABRIC, ANGORA PATTERN, KNITTED, HFW	WSD-M1H614-G
FABRIC, ANGORA PATTERN, KNITTED, HFW	WSD-M1H614-H
FABRIC, ANGORA PATTERN, KNITTED, HFW	WSD-M1H614-J
FABRIC, ANGORA PATTERN, KNITTED, HFW	WSD-M1H614-K

1. SCOPE

The material defined by this specification is a 2 bar, 28 gauge, warp knitted, simulated velour, polyester bodycloth.

2. APPLICATION

WSD-M1H614-A is used for molded headrests and also adhesive coated for use on inner door panels.

WSD-M1H614-B1, B2, C1, C2 are used for seat wearing surfaces.

WSD-M1H614-B2 is used adhesive bonded for inner door and quarter trim panels.

WSD-M1H614-G, H, J, K, are used for inner door, quarter trim panels and/or as specified on Engineering Drawings.

ANGORA PATTERN

WSD-M1H614-A	Unlaminated
WSD-M1H614-B1	3.0 mm, flame laminated to polyether foam and knitted fabric
WSD-M1H614-B2	6.0 mm, flame laminated to polyether foam and knitted fabric
WSS-M1H614-C1	3.0 mm, flame laminated to polyester foam and knitted fabric
WSS-M1H614-C2	6.0 mm, flame laminated to polyester foam and knitted fabric
WSD-M1H614-D2	6.0 mm, flame laminated to polyether foam
WSD-M1H614-G	HF-weldable vinyl film adhesive bonded, or an engineering approved alternative
WSD-M1H614-H	HF-weldable acrylic backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative

Date	Action	Changes
1999 01 08	Revised	Revised para 3; Updated N. J. Komatsu
1996 04 22	Revised	Added C1,C2; rev para 3.9; updated N. J. Komatsu
1993 07 16	C10317931	Released N. J. Komatsu

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ENGINEERING MATERIAL SPECIFICATION

WSD-M1H614-A/B1/B2/D2/G/H/J/K/
WSS-M1H614-C1/C2

- WSD-M1H614-J HF-weldable vinyl backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative
- WSD-M1H614-K HF-weldable polyurethane backcoating applied by the doctor-knife spreading technique, or an engineering approved alternative

3. REQUIREMENTS

In addition to the requirements listed herein, the fabric or laminate shall meet all requirements of WSS-M8PI-I.

3.1 QUALITY SYSTEM REQUIREMENTS

Material suppliers and part producers must conform to Quality System Requirements, QS-9000. Material specification requirements are to be used for initial qualification of materials. A Control Plan for ongoing production verification is required. This plan must be reviewed and approved by the relevant Ford Materials activity and/or Ford Supplier Technical Assistance (STA) prior to production parts submission. Appropriate statistical tools must be used to analyze process/product data and assure consistent processing of the materials.

Part producers using this material in their products, must use Ford approved materials and must conform to a process control plan which has been approved by STA and/or the relevant Materials Activity.

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 FABRIC CONSTRUCTION

3.4.1 Fabric Count, +/- 8 % tolerance (ASTM D 3887)

Wales	210 wales/10 cm
Courses	300 courses/10 cm