



ADHESIVE, THERMOPLASTIC HOT MELT FOR HEADLINERS

WSS-M2G39-A1

1. SCOPE

The material defined by this specification is a poly alpha olefin thermoplastic hot melt adhesive to be used in Headliner Assembly.

2. APPLICATION

This specification was released originally for thermoplastic hot melt adhesive used for automotive headliner trim application for the Ford Petersburg, Russia Assembly plant.

2.1 LIMITATIONS

Functional testing must be completed when the assembly location has an atmospheric environment of humidity above 75% and temperature above 45°C.

3. REQUIREMENTS

In addition to the requirements listed herein, this material shall meet all requirements of the WSS-M11P62-A/(latest) Adhesive, Interior Performance specification. Fully finished, unitized formed headlining assembly must also meet WSS-M15P27-F, Performance, Headlining, Formed specification.

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 APPEARANCE

Color Amber

3.3 COMPOSITION

100 % Solids

3.3 DENSITY (ASTM D 792)

0.86 – 0.90 g/m³

3.3 SOFTENING POINT (DSC)

155 – 159 °C

3.4 VISCOSITY (ASTM D 3236)

at 177° C	26,000 – 36,000 mPa sec
at 191° C	15,000 – 21,000 mPa sec
at 204° C	10,000 – 14,000 mPa sec

3.5 TENSILE STRENGTH (ASTM D 1708 Ramp: 150 mm/min)

25.5 Kg/cm²

3.6 OPEN TIME (ASTM D 4497 6.35 mm bead)

20 – 40 sec

Date	Action	Revisions	Rev. 0
2015 05 19	Released		



3.7 POT STABILITY (ASTM D 4499)

Viscosity at 191°C after Heat Aging at 191°C for 48 hr., 18,000 – 24,000 mPa.sec

3.6 PERFORMANCE PROPERTIES

The material shall be of uniform quality, free from foreign materials and properties detrimental to normal production use.

4. GENERAL INFORMATION

The information given below is provided for clarification and assistance in meeting the requirements of this specification. Contact gmfs@ford.com for questions concerning Engineering Material Specifications.