TAPE, TRANSIT FILM, REMOVABLE, INTERIOR **WSS-M3G238-A1**
TAPE, TRANSIT FILM, REMOVABLE, WHEELS **WSS-M3G238-A2**
TAPE, TRANSIT FILM, REMOVABLE, EXTERIOR **WSS-M3G238-A3**

1. SCOPE

The material defined by this specification is a film with one side uniformly coated with low tack adhesive.

2. APPLICATION

This specification was released originally for material used as a manufacturing and shipping aid to protect interior and exterior surfaces (painted and non-painted) against soiling and damage prior to customer delivery. The temperature range and criteria for proper application and removal of the film should follow manufacturers recommended practices.

2.1 LIMITATIONS

Adhesive backed transit films are not to be used on leather surfaces.

A1 – Transit films shall not be left on the surface for longer than 30 days due to the adhesive permanently migrating to the substrate when left on for long periods of time. Contact Materials Engineering if requesting to keep it on longer.

A2 /A3 Transit films shall not be left on the surface for longer than 6 months due to the adhesive permanently migrating to the substrate when left on for longer periods of time.

3. REQUIREMENTS

3.1 APPROVED SOURCES

A3 - This specification requires the use of approved sources. Only the sources identified on the Ford Approved Source List (ASL) can be used when this specification is listed on the drawing, CAD file, or other documents. The list of approved sources is located within Ford at www.mats.ford.com or available externally through a Ford Materials Engineer.

A1/A2 This specification does not use approved sources. Any reliable supplier meeting these requirements may be used.

3.2 FUNCTIONAL APPROVAL

Functional trial results must be approved by the affected assembly operation and Design Engineering. Results shall be made available to Materials Engineering prior to material approval and release. No surrogate data is allowed. Testing needs to occur on every production representative part.

3.3 APPEARANCE

Date	Action	Revisions	Rev 03
2017 05 17	Revised	See Summary of Revisions	S. Gatzek, NA
2017 03 22	Editorial	See Summary of Revisions	L. Schmalz, NA
2010 01 14	Activated	M. Gramlic, L. Schmalz, C. Mracna, NA	

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Upon being unwound for application, the film shall present a smooth and uniform appearance, allowing for satisfactory application properties. The color and appearance shall be visually similar to the standard approved film.

3.4 GREEN STRENGTH

The tape shall develop sufficient adhesion to permit normal handling immediately after application.

3.5 PREPARATION OF TEST SPECIMENS

Substrate test specimens may be obtained from representative plaques or production parts. Unless otherwise specified, tests shall be conducted on production representative substrates by applying the tape per the following procedure:

Clean test panels with a suitable solvent, such as a 50/50 mix of isopropyl alcohol and water, and allow to air dry.

Peel the liner from the film in a smooth continuous motion. Do not peel the film from the liner.

Position the tape on the test substrate.

For flat test panels, use the roller described in ASTM D 1000 (except roller rate: 50 mm/s) with no additional pressure, pass the roller over the full length of the tape once in each direction. For test parts with curved substrates, use a squeegee to apply the film.

Test samples with applied tape shall be conditioned for 48 h at 23°C and 50% relative humidity prior to environmental exposure. Tests shall be completed within 24 h after removal from the conditioning environment unless otherwise specified.

3.6 ADHESION AFTER ENVIRONMENTAL EXPOSURE- INTERIOR (A1)

(ASTM D1000)

Acceptance Criteria
After each environmental exposure test (paragraphs 3.6.1-3.6.4), peel the tape from the substrate. The film must be removed in a continuous manner without breakage, damage to the substrate, adhesive stain, discoloration or gloss change. No adhesive transfer or residue that would attract dirt, after any environmental conditions is allowed.

3.6.1 Weathering Resistance
(FLTM BO 116-01, ISO 105 A-02/AATCC Evaluation Procedure 1), 752 kJ/m^2

3.6.2 Heat Resistance

Instrument Panels:
Sun Load per IP-105: 107 °C surface temperature via heat lamps with a chamber temperature of 90 °C for 242 hours.

All Other Interior Parts:
(10 days at 100 +/- 2 °C)

3.6.3 Humidity Resistance
(7 days at 38 +/- 2 °C and 95 - 100% relative humidity)

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