



**CARPET, BCF NYLON 6/6, LOOPED,
PATTERN, 713 g/m² (21 oz)**

WSS-M3H150-A

1. SCOPE

The materials defined by this specification are fine denier, bulked continuous filament (BCF) nylon, looped pile carpets, in a synthetic primary foundation. The mat may be backed with either rubber or other material.

2. APPLICATION

This material was originally released for floor mats for anniversary or specialty edition vehicles.

2.1 LIMITATIONS

Model year 2016 and beyond compression molding is not allowed to marry the face to backing material or to pull any B side features. Compression molding is only allowed as a secondary process to change geometry (3D shape).

3. REQUIREMENTS

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).

3.1.1 In addition to the requirements listed herein, the end-item mat assembly shall be tested to WSS-M15P44-B and any additional SDS requirements. The details for each of the suppliers specific construction shall be documented in the supplement attached and uploaded into the FMD (Ford Materials Database).

3.1.2 Vehicle Interior Environment Quality Materials/Component Performance Requirements

Materials used in interior applications must meet the requirements outlined in WSS-M99P2222-D1. Data must be included in material submission package.

3.2 SAMPLE SELECTION

All evaluations shall be conducted on test specimens taken from finished mat assemblies.

3.3 APPEARANCE (FLTM BI 109-01)

The color, pattern, and finish shall match the approved Design Center master sample, or shall be as specified on the engineering drawing.

3.4 COMPOSITION

3.4.1 Pile Yarn 100% Nylon 6/6
(ASTM D 276)

Date	Action	Revisions	Rev. 1
2015 05 08	Revised	See Summary of Revisions	L. Sinclair, NA
2014 02 03	Released		L. Sinclair, NA



3.4.2	Primary Foundation (ASTM D 276)	Polypropylene
3.4.3	Back Coating (ASTM D 276)	Report*
3.4.4	Pre Coat (ASTM D 276)	Report *
3.4.5	Secondary Foundation (ASTM D 276)	Report *
3.4.6	Secondary Backing (ASTM D 276)	Report *

* Materials approved for each suppliers construction can be found in the FMD (Ford Material Database).

3.5 CONSTRUCTION

3.5.1	Pile Yarn (ASTM D 1244)	1320 Denier
3.5.2	Pile Count (ISO 1763)	
	Rows / 100 mm	31.5
	Stitches / 100 mm	42.5
Rows and stitches per 100 mm shall be based on an average count on a 254 mm length of carpet and shall not exceed the tolerance provided on the approved construction supplement in the FMD for the approved material.		
3.5.3	Needle Gauge	3.18 mm
3.5.4	Filament Count	68 filaments per bundle
3.5.5	Ply Twist	2

3.6 THICKNESS

3.6.1	Pile (Loop) Height (ISO 1765)	4.75 mm Nominal
Pile Height tolerances approved for each suppliers construction can be found in the FMD (Ford Material Database).		
3.6.2	Primary Foundation (ISO 1765)	0.5 +/- 0.1 mm
3.6.3	Back Coating (ISO 1765)	(mm) Report *

The back coating shall thoroughly saturate the base of the pile fiber bundles to ensure adequate tuft lock. Penetration of the back coating through to the face shall be controlled to provide the required resistance to abrasion and fiber loss but it shall not be visible on the face of the pile fiber.