



SEALER, SILICONE RUBBER

WSS-M4G368-A1

1. SCOPE

The material defined by this specification is a one-component thixotropic spreadable silicone rubber based adhesive/sealant. This material is rapidly cured when exposed to air moisture to form a resistant rubber.

2. APPLICATION

This specification was released originally for sealing the drip rail to roof ditch.

Note: Care must be exercised to avoid contaminating paint or other silicone-sensitive manufacturing operations.

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).

3.2	COLOR	Black
3.3	SOLIDS, min (ASTM D 2834, at 150 °C for 3h)	93%
3.4	SPECIFIC GRAVITY (post cure) (ASTM D 792, Method A)	1.1 – 1.2
3.5	FLOW, max (ASTM D 2202)	5.0 mm
3.6	TACK FREE TIME, max (MIL-S-8802F)	45 minutes
3.7	EXTRUSION RATE (MIL-S-8802D)	300 – 700 g/minutes
3.8	PEEL STRENGTH, min (ASTM D 903)	25 N/cm
3.9	TENSILE STRENGTH, min (ASTM D 412, material thickness 2 mm, 72 h at 25 +/- 2 °C and relative humidity 50 +/- 5%)	1.4 MPa
3.10	ELONGATION, min (ASTM D 412)	510%

Date	Action	Revisions
2004 09 15	Activated	



Documents

A. Latado

Document Sharing Hub



3.11 TEAR STRENGTH, min
(ASTM D 624, material thickness 2 mm,
72 h at 25 +/- 2 °C and relative humidity 50 +/- 5%)

8 kN/m

3.12 HEAT AGING
(1000 h at 80 +/- 2 °C)

3.12.1 Tensile Strength, min
(ASTM D 412)

1.6 MPa

3.12.2 Elongation, min
(ASTM D 412)

380%

3.12.3 Tear Strength, min
(ASTM D 624)

9.2 kN/m

3.13 QUALITY

Shall be a smooth, homogeneous mixture, free from foreign materials and properties detrimental to normal production operations.

3.14 STORAGE STABILITY
(From date of receipt at Ford Motor Company)

Minimum 6 months when stored in sealed, unopened drums out of direct sunlight at ambient temperatures.