



FLOCK SPRAYED FINISHED PARTS, INTERIOR

WSS-M98P8-C1

1. SCOPE

This specification defines the requirements for interior plastic parts with sprayed flocking. The flock is retained by means of an adhesive.

2. APPLICATION

This specification was released originally to define the performance requirements for flocked interior parts such as glove box inners.

2.1 LIMITATIONS

Not for visible areas of the vehicle that are subjected to UV exposure.

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 All parts of the component that are visible after vehicle assembly, including terminating edges shall conform to the full requirements of this specification.

3.1.2 Materials used in interior applications must meet the requirements outlined in WSS-M99P2222-D1/Latest, *Performance, Vehicle Interior Environment Quality Material/Component Requirements, Clauses 1 - 5*.
Data must be included in material submission package.

3.2 SYSTEM COMPONENTS

Adhesives, primers or other surface treatments utilized to achieve adequate adhesion of the flock fiber to the substrate shall not adversely affect the physical properties of the substrate material.

3.2.1 Test Specimens

Testing must be conducted at DV and PV unless specified otherwise by Ford Engineering (See Table 1 for sample sizes and required testing). Testing must be done on actual or surrogate parts unless part geometry precludes the option, in which case plaques of the same materials and processing may be used.

Surrogate part or plaque usage must be clearly reported on the PSW or the laboratory test report.

3.2.2 Substrate

As specified on the Engineering Document.

Date	Action	Revisions	Rev. 01
2017 11 01	Editorial	See Summary of Revisions	M. Nestorowich, NA
2014 08 29	Released		R. Harris, NA



3.2.3 Plastic Preparation

The surface to be flocked may need to be cleaned by an acceptable process, to remove mold releasing agents, fingerprints, oils, dirt and moisture. This process must be noted in the initial submission package and identified on the drawing.

3.2.4 Primer

When necessary in order to meet the requirements of this specification, an adhesion promoter may be needed. Multiple coats may also be applied to meet the requirements of this specification.

Surface enhancements, such as flaming or plasma treatment that modify surface tension / surface resistivity may also be required in order to meet the requirements. This must be noted in the initial submission package and identified on the drawing.

3.2.5 Adhesive

Shall be a suitable non-staining type adhesive. This must be noted in the initial submission package and identified on the drawing.

3.2.6 Flock

Fiber material and geometry shall be noted in the initial submission package and identified on the drawing.

3.3 APPEARANCE (FLTM BI 109-01)

The color and finish shall be as specified on the engineering drawing.

3.4 INITIAL ADHESION

Any indication of chipping or brittleness of the flocked adhesive film shall be cause for rejection.

3.4.1 Adhesion to Substrate

Shall not pull free more than
2 mm before breaking

Test Method: FLTM BI 106-01, Method "C" except lift the flock/adhesive layer away from the substrate at one end of each strip so that it can be easily grabbed. Then peel the flock/adhesive strip away from the substrate by hand.

3.4.2 Flock to Adhesive (FLTM BN 108-08)

24 mg max

All flocked parts shall be thoroughly cleaned to limit the amount of loose flock on the finished part.

3.5 RESISTANCE TO ABRASION (SAE J948, 500 g load, CS-10 wheel, 250 cycles or as specified on the Engineering Document)

There shall be no wear
through to the substrate