



LABEL, ALUMINUM FOIL, PRESSURE SENSITIVE, BARCODE

WSS-M99J292-A2

1. SCOPE

The material defined by this specification is a full hard aluminum foil with an ink receptive vinyl topcoating and coated with a pressure sensitive high bonding strength synthetic adhesive. The adhesive prior to use, is protected by a kraft paper liner, specially treated with an easy release coating.

2. APPLICATION

This specification was released originally for material used in labels for in process identification of components with textured surfaces such as exhaust manifolds.

3. REQUIREMENTS

3.0 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 THICKNESS - WITHOUT RELEASE PAPER (ASTM D 1000)

315 - 395 micrometers
or as specified on
engineering drawing

3.3 APPEARANCE

The labels shall be free of streaks, blisters, wrinkles, ragged edges and any other surface imperfections which will make them unsuitable for the intended usage. The design and color shall be as specified on the engineering drawing.

3.4 TENSILE STRENGTH, min (ASTM D 1000)

6.0 kN/m width

3.5 PREPARATION OF LABELS ON TEST PANELS

Except where otherwise noted test shall be conducted on test panels of the substrates listed below. With form hand pressure, apply a 25 x 150 mm strip of label to a test panel of suitable size. The applied label must be free of all wrinkles and trapped air bubbles. The label film shall be applied at 23 +/- 2 °C and conditioned for 1 h at a relative humidity of 50 +/- 5% at 23 +/- 2 °C.

3.5.1 Substrates

3.5.1.1 Stainless steel panel

3.6 ADHESION, min (ASTM D 1000, Method A, 180° peel)

3.6.1 Stainless Steel

0.55 N/mm

Date	Action	Revisions
2005 08 15	Revised	Inserted 3.0; deleted 3.1, 3.11 and 4
1995 12 19	Activated	



Documents

E. Duda
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3.7 ENVIRONMENTAL TESTING OF PANEL ASSEMBLY

Test shall be completed within 1 - 4 h after removal from the conditioning environment.

After each of the environmental exposures, the label must meet the adhesion requirements of para 3.6 and must not show evidence of delamination or any other effect which would detract from its proper function or appearance.

3.7.1 Immersion in ASTM Fuel "B" for 1 h at 23 +/- 2 °C.

3.7.2 Immersion in ASTM Oil #3 for 2 h at 121 +/- 3 °C.

3.7.3 Humidity cabinet for 24 h at 98 +/- 2% relative humidity and 38 +/- 3 °C.

3.7.4 Hold the panel for 1 h at -40 °C then expose to heat for 1 h at 121 +/- 3 °C.

3.7.5 Heat Test - 15 minutes at 232 +/- 3 °C.

3.8 PRINT ADHESION

Place an ESB-M3G68-A cellophane or ESF-M3G40-A acetate fiber tape on the side of the label containing printing and remove with a quick snap. There shall be no effect on the printing.

3.9 LABEL STRENGTH

During installation the label must not break, tear or deface. The release backing shall not tear or delaminate while being removed from the label.

3.10 TOXICITY

No harmful fumes or disagreeable odors shall be emitted from the label when it is burned or subject to high heat for an extended period of time. The Industrial Hygiene Section of Ford Motor Company is responsible for testing and judging the level of toxicity.

