

NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS G-7107
		Former Designation: TMS-7107
TITLE: Interior Wood Grain Decorative Films		CURRENT REV No.: 1706
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<i>This specification may involve hazardous materials, equipment, and procedures. This specification does not purport to address all of the safety issues associated with its use. The user is responsible to consult appropriate safety and health practices and to determine the applicability of regulatory limits prior to use.</i>		

1.0 APPLICATION

This specification describes the requirements for four decorative laminated vinyls, foil, or urethane films. These films may have a pressure sensitive adhesive applied to the reverse side. They are intended for use on interior trim surfaces where a wood grain effect is desired.

2.0 SCOPE

This specification covers the material requirements, physical properties, performance requirements, quality, source approval and quality control, packaging, and approved sources for the six types.

2.1 Type I is a vinyl film.

2.2 Type II – DELETED – Type II is replaced by Type 1 of MPAPS G-4517.

2.3 Type III is a formed film intended for curved or molded applications.

2.4 Type IV – DELETED – Type IV is replaced by Type 2 of MPAPS G-4517.

2.5 Type V is a foil film intended for flat applications.

2.6 Type VI is a urethane film intended for flat applications

3.0 REFERENCE DOCUMENTS

Unless otherwise specified, the latest issue of all referenced standards shall apply. The following standards, specifications and regulations are referenced in this specification.

Quality System Standard ISO 9001 or TS-16949	NAVISTAR MPAPS P-9544
NAVISTAR IQR Quality Standard	NAVISTAR MPAPS P-9503
NAVISTAR Supplier Packing and Shipping Std. D-13	CFR Title 29, Part 1910
NAVISTAR MPAPS GT-Paint	FMVSS 302
NAVISTAR MPAPS GT-31	ASTM D 882
NAVISTAR MPAPS G-4517	ASTM D 903
NAVISTAR MPAPS P-9543	ASTM D2247
NAVISTAR MPAPS B-50	ASTM D3884
NAVISTAR Engineering Design Std. A-16	

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4.0 REQUIREMENTS

4.1 Appearance

The film should be of uniform construction and must conform to color, gloss, texture and/or printed pattern of the master samples of the pre-production material originally approved and on file in the Integrated Product Development (IPD) Industrial Design Department.

4.1.1 Gloss

The film will exhibit a 60° gloss value of 90 minimum, unless otherwise indicated on the engineering print or with written approval of Integrated Product Development (IPD) Industrial Design Department, when measured in accordance with MPAPS GT-Paint, section 6B. In all cases, the maximum loss of gloss shall be 20 points, after exposure to the ultraviolet and condensing humidity exposures listed in the Table on page 3.

4.1.2 Orange Peel

The film will exhibit a min orange peel rating of 3.0 as measured in accordance with MPAPS GT-Paint, section 29.

4.2 Adhesive

When specified as a pressure-sensitive film for plant application, an adhesive shall be uniformly applied to the backside of the film and the adhesive will meet all requirements of this specification. It shall have a low initial tack and shall not corrode or etch the surface to which the film is applied. It shall have sufficient bond strength to permit normal handling immediately after application.

4.3 Release Backing

The adhesive shall be protected with an easy release, moisture-resistant liner. The backing liner shall have sufficient strength to protect the adhesive film during shipment and handling, and it shall not break, tear, chip, or peel. The liner shall release evenly and cleanly during removal from the adhesive film.

4.4 Film Thickness (Excluding Backing)

	Type I	Type III	Type V	Type VI
Film Thickness	0.25 ± 0.05 mm	0.5 ± 0.1 mm	0.83 ± 0.15 mm	TBD

TBD – To be determined, please report result.

4.5 Property and Performance Requirements

Material shall meet all of the requirements of this section unless specifically excluded. Test samples shall be prepared to as closely match production materials, methods and conditions as possible. When possible, sets of duplicate test materials shall be prepared at the minimum and maximum production condition.

4.5.1 Tensile Strength and Elongation

4.5.1.1 Method: ASTM D-882, Method A, Sample Size: 25 x 150 mm (1 x 6 in); Gage Length: 50 mm (2 in); Jaw Spacing: 100 mm (4 in); Speed: 50 mm/min (2 in/min)

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