



Ford Specification WSS-M11P62

Annual Test Data

Technical Bulletin

The 3M IATD Quality Laboratory tested the following tapes to the Automotive Specification WSS-M11P62. The results of the testing are provided below in the following information. Tapes not listed on this document have not been tested to this specification.

3M™ High Performance Adhesive Transfer Tape 9627
3M™ Adhesive Transfer Tape 9472LE and 9672LE
3M™ Double Coated Tapes 9832 and 9832HL
3M™ Adhesive Transfer Tape 6035PC and 6035PL
3M™ Double Coated Tape 9490LE

3M™ Double Coated Tape 9495LE
3M™ Low VOC Double Coated Tissue Tape DCX1018
3M™ Adhesive Transfer Tape 9775WL
3M™ Double Coated Tape 93015LE

Approved by IATD Quality:

Eric Hanson
Test Coordinator

3M™ High Performance Adhesive Transfer Tape 9627			Expiration Date: June 30, 2023			
Lot Number	Substrate	Test	Test Method	Specification	As Received	
22062	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE**	
		Fog Test*** One hour 16 hours	SAE J1756****			
				70 min	85	
				70 min	97	
					No oily deposits	Pass
					No crystals	Pass
					No film	Pass
		Odor Dry Wet	SAE J1351*****			
					5 rating max	2
					5 rating max	2

*Samples were created with the adhesive applied to a 2 mil aluminum foil to support during the test

**Self extinguishing

***Samples were bonded between bleached kraft paper and 2 mil aluminum foil and results were taken from the paper side of the panel.

****For section 5.2 of SAE J1756, the dishwasher has been replaced with handwashing using Alconox™. Test washing with the closest equivalent dishwasher left water spots on the glassware. Handwashing has produced clean glassware. At this time, the difference in results cannot justify the purchase of a dedicated washing unit.

*****SAE J1351 updated odor ratings. New maximum is a 5 rating.

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3M™ Adhesive Transfer Tapes 9472LE, 9672LE				Expiration Date: March 31, 2024		
Lot Number	Substrate	Test	Test Method	Specification	As Received	
D010061784014	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE**	
		Fog Test***	SAE J1756****			
				One hour	70 min	94
				16 hours	70 min	95
					No oily deposits	Pass
					No crystals	Pass
					No film	Pass
		Odor	SAE J1351*****			
				Dry	5 rating max	2.33
				Wet	5 rating max	2.33

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****For section 5.2 of SAE J1756, the dishwasher has been replaced with handwashing using Alconox™. Test washing with the closest equivalent dishwasher left water spots on the glassware. Handwashing has produced clean glassware. At this time, the difference in results cannot justify the purchase of a dedicated washing unit.

*****SAE J1351 updated odor ratings. New maximum is a 5 rating.

3M™ Adhesive Transfer Tapes 6035PC and 6035PL				Expiration Date: December 31, 2023		
Lot Number	Substrate	Test	Test Method	Specification	As Received	
	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	DNI**	
		Fog Test***	SAE J1756****			
				One hour	70 min	98
				16 hours	70 min	99
					No oily deposits	Pass
					No crystals	Pass
					No film	Pass
		Odor	SAE J1351*****			
				Dry	5 rating max	3
				Wet	5 rating max	3

*Samples were created with the adhesive applied to a 2 mil aluminum foil to support during the test

**Did not ignite

***Samples were bonded between bleached kraft paper and 2 mil aluminum foil and results were taken from the paper side of the panel.

****For section 5.2 of SAE J1756, the dishwasher has been replaced with handwashing using Alconox™. Test washing with the closest equivalent dishwasher left water spots on the glassware. Handwashing has produced clean glassware. At this time, the difference in results cannot justify the purchase of a dedicated washing unit.

*****SAE J1351 updated odor ratings. New maximum is a 5 rating.

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3M™ Double Coated Tapes 9832 and 9832HL				Expiration Date: October 31, 2023	
Lot Number	Substrate	Test	Test Method	Specification	As Received
	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	DNI**
		Fog Test***	SAE J1756****		
		One hour		70 min	99
		16 hours		70 min	100
				No oily deposits	Pass
				No crystals	Pass
				No film	Pass
		Odor	SAE J1351		
		Dry		5 rating max	3
		Wet		5 rating max	2

*Samples were created with the adhesive applied to a 2 mil aluminum foil to support during the test

**Did not ignite

***Samples were bonded between bleached kraft paper and 2 mil aluminum foil and results were taken from the paper side of the panel.

****For section 5.2 of SAE J1756, the dishwasher has been replaced with handwashing using Alconox™. Test washing with the closest equivalent dishwasher left water spots on the glassware. Handwashing has produced clean glassware. At this time, the difference in results cannot justify the purchase of a dedicated washing unit.

*****SAEJ1351 updated odor ratings. New maximum is a 5 rating

3M™ Double Coated Tape 9490LE				Expiration Date: March 31, 2024	
Lot Number	Substrate	Test	Test Method	Specification	As Received
C242061502001	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE**
		Fog Test***	SAE J1756****		
		One hour		70 min	99
		16 hours		70 min	100
				No oily deposits	Pass
				No crystals	Pass
				No film	Pass
		Odor	SAE J1351*****		
		Dry		5 rating max	3.33
		Wet		5 rating max	4.33

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*****SAEJ1351 updated odor ratings. New maximum is a 5 rating.

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3M™ Double Coated Tape 9495LE				Expiration Date: May 31, 2023		
Lot Number	Substrate	Test	Test Method	Specification	As Received	
B327069873003	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE**	
		Fog Test***	SAE J1756****			
				One hour	70 min	94
				16 hours	70 min	96
				No oily deposits		Pass
				No crystals		Pass
				No film		Pass
		Odor	SAE J1351*****			
				Dry	5 rating max	4.67
				Wet	5 rating max	5

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*****SAEJ1351 updated odor ratings. New maximum is a 5 rating.

3M™ Low VOC Double Coated Tissue Tape DCX1018				Expiration Date: Pending Testing		
Lot Number	Substrate	Test	Test Method	Specification	As Received	
	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max		
		Fog Test***	SAE J1756****			
				One hour	70 min	
				16 hours	70 min	
				No oily deposits		
				No crystals		
				No film		
		Odor	SAE J1351			
				Dry	5 rating max	
				Wet	5 rating max	

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**Self extinguishing

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*****SAEJ1351 updated odor ratings. New maximum is a 5 rating.

Ford Specification WSS-M11P62–Annual Test

3M™ Double Coated Tape 9775WL			Expiration Date: Pending Testing			
Lot Number	Substrate	Test	Test Method	Specification	As Received	
	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max		
		Fog Test***	SAE J1756****			
			One hour		70 min	
			16 hours		70 min	
					No oily deposits	
					No crystals	
					No film	
		Odor	SAE J1351*****			
			Dry		5 rating max	
			Wet		5 rating max	

*Samples were created with the adhesive applied to a 2 mil aluminum foil to support during the test.

**Self-extinguishing.

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*****SAEJ1351 updated odor ratings. New maximum is a 5 rating.

3M™ Double Coated Tape 93015LE			Expiration Date: Pending Testing			
Lot Number	Substrate	Test	Test Method	Specification	As Received	
	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max		
		Fog Test***	SAE J1756****			
			One hour		70 min	
			16 hours		70 min	
					No oily deposits	
					No crystals	
					No film	
		Odor	SAE J1351*****			
			Dry		5 rating max	
			Wet		5 rating max	

*Samples were created with the adhesive applied to a 2 mil aluminum foil to support during the test.

**Self-extinguishing.

***Samples were bonded between bleached kraft paper and 2 mil aluminum foil and results were taken from the paper side of the panel.

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