



# 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  
3M™ Adhesive Transfer Tape 9472, 950, 9672 and 969

Approved by IATD Quality:

Eric Hanson  
Test Coordinator

3M™ High Performance Adhesive Transfer Tape 9627			Expiration Date: June 30, 2024			
Lot Number	Substrate	Test	Test Method	Specification	As Received	
21238	Bleached kraft paper	Flammability*	SAE J369	100 mm/min max	SE/0**	
		Fog Test***	SAE J1756****			
	Aluminum Foil	One hour		70 min	89	
		16 hours		70 min	96	
				No oily deposits	Pass	
				No crystals	Pass	
				No film	Pass	
	Odor		SAE J1351*****			
		Dry		5 rating max	1.7	
		Wet		5 rating max	2.7	

\*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.

# Ford Specification WSS-M11P62–Annual Test Data

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/0**
		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

\*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.

3M™ Adhesive Transfer Tapes 6035PC and 6035PL			Expiration Date: December 31, 2023		
Lot Number	Substrate	Test	Test Method	Specification	As Received
21134	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.

# Ford Specification WSS-M11P62–Annual Test Data

3M™ Double Coated Tapes 9832 and 9832HL			Expiration Date: October 31, 2023			
Lot Number	Substrate	Test	Test Method	Specification	As Received	
C13559367801	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	DNI**	
		Fog Test*** One hour 16 hours	SAE J1756****			
					70 min	99
					70 min	100
					No oily deposits	Pass
					No crystals	Pass
					No film	Pass
		Odor Dry Wet	SAE J1351			
					5 rating max	3
					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/0**	
		Fog Test*** One hour 16 hours	SAE J1756****			
					70 min	99
					70 min	100
					No oily deposits	Pass
					No crystals	Pass
					No film	Pass
		Odor Dry Wet	SAE J1351*****			
					5 rating max	3.33
					5 rating max	4.33

\*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.

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

# Ford Specification WSS-M11P62–Annual Test Data

3M™ Double Coated Tape 9495LE		Expiration Date: May 31, 2024				
Lot Number	Substrate	Test	Test Method	Specification	As Received	
D018061802017	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE/0**	
		Fog Test*** One hour 16 hours	SAE J1756****			
					70 min	96
					70 min	97
				No oily deposits	Pass	
				No crystals	Pass	
				No film	Pass	
		Odor Dry Wet	SAE J1351*****			
					5 rating max	2.7
					5 rating max	2.7

\*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.

3M™ Low VOC Double Coated Tissue Tape DCX1018		Expiration Date: October 31, 2024				
Lot Number	Substrate	Test	Test Method	Specification	As Received	
21123C16	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE/0**	
		Fog Test*** One hour 16 hours	SAE J1756****			
					70 min	90
					70 min	95
				No oily deposits	Pass	
				No crystals	Pass	
				No film	Pass	
		Odor Dry Wet	SAE J1351			
					5 rating max	1.7
					5 rating max	1.7

\*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.

# Ford Specification WSS-M11P62–Annual Test Data

3M™ Double Coated Tape 9775WL		Expiration Date: July 31, 2024				
Lot Number	Substrate	Test	Test Method	Specification	As Received	
D142594064020	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE/0**	
		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	3.0
				Wet	5 rating max	3.0

\*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.

3M™ Double Coated Tape 93015LE		Expiration Date: July 31, 2024				
Lot Number	Substrate	Test	Test Method	Specification	As Received	
D021061804011	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE/0**	
		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	2.6
				Wet	5 rating max	2.6

\*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.

# Ford Specification WSS-M11P62–Annual Test Data

3M™ Adhesive Transfer Tapes 9472, 950, 9672, 969			Expiration Date: June 30, 2024			
Lot Number	Substrate	Test	Test Method	Specification	As Received	
23045	Bleached kraft paper Aluminum Foil	Flammability*	SAE J369	100 mm/min max	SE/0**	
		Fog Test*** One hour 16 hours	SAE J1756****		70 min	92
					70 min	98
					No oily deposits	Pass
				No crystals	Pass	
				No film	Pass	
		Odor Dry Wet	SAE J1351*****			
					5 rating max	1.3
					5 rating max	2.3

\*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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ISO 9001: 2015

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