

## ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

**ADHESIVE, HOT MELT, GENERAL PURPOSE**

**ESL-M2G266-A**

### 1. SCOPE

The material defined by this specification is a general purpose hot melt adhesive. It has excellent bonding versatility for assembly and spot repair work involving wood, some metals, paper, fabrics, ceramics, leather and foam.

### 2. APPLICATION

This specification was released originally for material used to bond rubber to steel to reduce fuel system component vibration.

### 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).

**3.4 COLOR** Cream

**3.5 ODOR** Slight

**3.6 SOFTENING RANGE** 75 - 92 °C  
(ASTM E 28, ring and ball)

**3.7 DENSITY** 0.98 g/cm<sup>3</sup>  
(ASTM D 816)

**3.8 VISCOSITY, nominal**  
(ASTM D 4402, Brookfield RVT spindle SC4-21, 1 rpm)

177 °C 21,000 mPa.s  
192 °C 13,000 mPa.s

| Date       | Action            | Revisions                                               |
|------------|-------------------|---------------------------------------------------------|
| 2003 01 16 | Revised           | Para 3.0 inserted ; Para 3.1, 3.2, 3.3, 3.11, 4 deleted |
| 1994 02 24 | NC00E10244447-023 | Reactivated & Updated K. Bruley                         |
| 1984 02 21 | 702-035F-12       | Released R.J. Fekete                                    |

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**3.9 SHEAR ADHESION, min**

|                             |           |
|-----------------------------|-----------|
| After 24 h at 23 °C         | 4,000 kPa |
| After aging 336 h at 170 °C | 4,000 kPa |

Test Method: Using two 25 x 75 mm steel panels preheated to 220 °C apply sufficient material heated to 200 °C to one panel to provide a bond area of 6.5 cm<sup>2</sup> by 9 mm thick. Press the panels together allowing a 6.5 cm<sup>2</sup> overlap and allow to cool. Age at the indicated time and temperature. Mount in a tensile machine and apply load with a jaw separation rate of 25 mm per minute.

**3.10 FOGGING**

(SAE J1756, 3 H at 100 °C heating, 21 ° cooling plate, post test conditioning 1 h and 16 h)

|                 |    |
|-----------------|----|
| Fog Number, min | 60 |
|-----------------|----|

Formation of clear film droplets or crystals is cause for rejection.