

DETERMINATION OF FLOW PROPERTIES OF EXTRUDED BODY FILLERS

Application

This test method is used to determine the correct flow behaviour of extruded body fillers.

Apparatus Required

Mechanical Convection Oven

Preferably with horizontal airflow. Capable of maintaining temperatures up to 300 °C within 3 °C. Approximate internal volume 0.1 cubic metre, Electrical Rating 3 KW.

Test Panels

See drawing for dimensions; spray primed surfaces.

Conditioning and Test Conditions

All test values indicated herein are based on material conditioned in a controlled atmosphere of 23 +/- 2 °C and 50 +/- 5 % relative humidity for not less than 24 h prior to testing and tested under the same conditions unless otherwise specified.

Procedure

1. From the bars of material under test cut a total of 12 pieces of 90 +/-3 mm length so that the cutting surface is normal to the longitudinal axis of the bars.
2. Place 2 pieces of material in the channel of each test panel as shown in drawing.
3. Three assemblies are placed in the oven in a horizontal position according to FLTM EU-BV 050-05, Table 3.

(a) Minimum Curing Cycle

and three assemblies according to

(b) Maximum Curing Cycle

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2000 12 01	Revised	Editorial – no technical change A. Cockman
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The thermocouples must be inserted between panel and material under test during the total curing cycle.

Note: To prevent the materials from flowing out of the channel of test panel it is advisable that adhesive tape be applied to the channel ends.

4. Allow the assemblies to cool at 23 +/- 2 °C for 2 h.

Evaluation

After cooling, examine the material on the test panel visually for a flow to a smooth surface and for defects such as collapsed areas, cracks, blisters or flow-out through holes, as indicated in the relevant Material Specification.

Chemicals, materials, parts, and equipment referenced in this document must be used and handled properly. Each party is responsible for determining proper use and handling in its facilities.