



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

BONDED MOLDINGS, EXTERIOR

SK-M15P9500-A

1. SCOPE

This specification defines performance requirements for bonded exterior moldings.

2. APPLICATION

This specification was originally released for moldings bonded with a double coated pressure sensitive tape to plastic bumper using an adhesion primer for special surfaces.

3. REQUIREMENTS

3.1 TESTS FOR VISUAL CHECK

3.1.1 Complete Part or Representative Section

No loss of adhesion.

Test Method: Not less than 24 h after assembling the parts subject separate parts to each of the following conditions:

Per SK-M99D9600-A

a) Paint repair oven resistance (3.1.4.)

b) Environmental cycling (3.1.5.)

c) Resistance to waxing and dewaxing compounds (3.1.9.)

Heat ageing at 80 +/- 2 C for 14 days.

Specific requirements as specified on Engineering Drawing, e.g. automatic car wash, impact pendulum test, etc.

3.2 ADHESION TESTS

3.2.1 Shear Strength, min

30 N/cm²

Prepare specimens according to Figure 1, 2, 3 by cutting from finished part; determine shear strength at a rate of 25 mm/minute).

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1994 12 19		Revised and Retyped was: 8 pages
1982 12 10		Released

WP 3948-a

Page 1 of 6

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- a) As received; not less than 24 hours after assembling.
- b) After heat ageing; 30 minutes at 120 +/- 2 C, 1 h at room temperature.
- c) After 5 cycles environmental cycling
 - 4 h at -40 C +/- 1 C)
 - 4 h at 80 C +/- 2 C) 1 cycle
 - 16 h at 38 +/- 2 C and)
 - 98 +/- 2 % relative humidity)
- d) After waxing/dewaxing:
 - 1 minute immersion in waxing compound U-MG 009-21 A/B,
 - 30 minutes room conditions, 1 minute immersion in
 - dewaxing compound U-MB 005-8000.
- e) After fuel immersion:
 - 1 minute immersion in ASTM Fuel C + 15 % Methanol, and 30
 - minutes conditioning at room temperature.

3.2.2 Adhesion of Adhesive Tape to Molding

Minimum 2.5 N/cm or adhesion of adhesive tape to molding greater than cohesion of tape.

Test Method:

- 1) Use unbonded moldings with adhesive tape on the back sides as received.
- 2) Remove release film and cover with 0.1 mm thick polyester film.
- 3) Peel off tape from molding under 180 deg at a rate of 300 mm/minute.

3.3 SUPPLIER'S RESPONSIBILITY

All materials supplied to this specification must be equivalent in all characteristics to the material upon which approval was originally granted.

Prior to making any change in the properties, composition, construction, color, processing or labeling of the material originally approved under this specification, whether or not such changes affect the material's ability to meet the specification requirements, the Supplier shall notify Purchasing, Toxicology and the affected Materials Engineering activity of the proposed changes and obtain the written approval of the Materials Engineering activity. Test data, test samples and a new code identification are to be submitted with the request.