



DAMPING SHEET, HEAT FUSIBLE, HEAT RESISTANT

SK-M99G9510-A

1. SCOPE

The material defined by this specification is a heat resistant, moldable, heat fusible filled damping sheet based in plastic or bitumen/rubber with an anti-blocking surface finish or with release paper.

2. APPLICATION

The material is used for structure borne noise damping in the passenger compartment. It is used in areas where a good heat resistance is required. The material is applied before passing through the paint oven or as specified on the Engineering Drawing.

3. REQUIREMENTS

The material shall be conditioned for a minimum of 24 hours at 23 °C +/- 2 °C and 50% +/- 5% relative humidity prior to test.

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producer must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.1	COLOR	Black
3.2	SOLIDS (FLTM BV 150-10)	min. 99%
3.3	ASH (FLTM BV 150-10)	max. 85%
3.4	THICKNESS (mm) (ASTM D 374, Method A)	1.8 – 2.3 or as specified on Engineering Drawing
3.5	MASS (kg/m ²) (at 2 mm thickness)	max. 6.0
3.6	FORMABILITY	

The material must sag into the recessed area of the test panel.

Test Method

1. Apply pieces of material under test as shown in Fig. 1 to test panels prepared according to FLTM BI 120-01.

Date	Action	Revisions
2006 05 30	Revised	Inserted 3.0; Deleted 3.13, 3.15 & 4; Format Updated
1974 10 31	Revised	Revised Sheet 1-5 B/CP7049TP
1974 12 06	Released	SM/ET0759TP





2. Expose test assemblies separately acc. to FLTM BV 150-05
 - a. Table 3, Min. Curing Cycle
 - b. Table 1, Max Curing Cycle, Phase 2
3. Examine after cooling to room temperature.

3.7 HEAT STABILITY

The material shall fuse to the substance without evidence of blistering or cracking.

Test Method

1. Apply a 280 x 280 mm piece of material under test to a 300 x 300 mm test panel prepared according to FLTM BI 120-01. Expose test assemblies to Min. Curing Cycle, Table 3 of FLTM BV 150-05.
2. Expose subsequently according to FLTM BV 150-05, Table 1, Max Curing Cycle, Phase 2.

3.8 PEEL ADHESIVE

min. 8 N/cm

Test Method

1. Apply test material of 30 x 300 mm to test panels prepared according to FLTM BI 120-01 and fuse according to clause 3.6, section 2.
2. After 24 h at room temperature lift the test material from the panel in a length of 50 mm, then peel test material from panel under an angle of 90 at a rate of 25 mm/min.
3. Record the peel strength.

3.9 RESISTANCE TO SLUMPING

The material thickness at any point shall not be less than 50% of original thickness.

Test Method

1. Apply test material to panels as shown in Fig. 2, prepared according to FLTM BI 120-01, and expose to heat in horizontal position as described under clause 3.7, section 1, of test method.
2. Expose prepared test assemblies at an angle of 55° (Fig. 2) to heat as described under clause 3.7, section 2. of test method.

3.10 Cold Adhesive after Ageing

No chipping or detachment

Test Method

1. Apply 280 x 300 mm pieces of test material to 300 x 300 1.5 mm test panels prepared according to FLTM BI 120-01.
2. Expose test assemblies separately to heat according to FLTM BV 150-05:
 - a. Table 3, Min. Curing Cycle
 - b. Table 1, Max. Curing Cycle, Phase 2.

