ENGINEERING MATERIAL SPECIFICATION

Material Name | Specification Number

SINGLE PLY DEADENER SHEETING, MOLDED, HEAT FUSIBLE — SK-M99G9511-A

1. SCOPE

The material defined by this specification is a high filled, thermoplastic plastic sheeting covered on both sides with a non-blocking heat activating adhesive.

2. APPLICATION

This material is mainly used for structure born noise damping in the engine and/or passenger compartment e.g. cowl panel. It is applied to light oiled body parts or as specified on Engineering drawing and shall be fused at an object temperature of approx 200 C for minimum 15 minutes.

3. REQUIREMENTS

3.1	COLOR	Dark grey or as specified on Engineering drawing
3.2	SOLIDS, min (FLTM EU-BV 50-10)	99 %
3.3	ASH, max (FLTM EU-BV 50-10)	82 %
3.4	MASS (At 4 mm thickness)	10.0 +/- 1.0 kg/m2
3.5	TOTAL THICKNESS (Slide gauge)	4 +/- 0.2 mm or as specified on Engineering drawing

3.6 FUSIBILITY CHARACTERISTICS

The material shall fuse without sliding, blistering, shrinkage or deformation. The edges of test material shall not curl up.
Test Method:

1) Apply test material at a size of 290 x 280 x 4 mm +/- 0.2 mm to 300 x 300 mm test panels prepared according to FLTM EU-BV 50-11 "Normal Oiling Grade". Fuse test material at an object temperature of 200 +/- 3 C for 15 minutes to test panels. This temperature shall be reached within 10 - 12 minutes.

Date	Release No.	Released
1994 12 15		Revised and Retyped, was 12 pages
1974 07 08	SM/ET 0779 TP	Released

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2) After cooling to room temperature expose test panel assemblies (separately and in vertical position) to heat according to FLTM EU-BV 50-5, Table 1 for

a) Minimum Curing Cycle
b) Maximum Curing Cycle

3) Examine after cooling to room temperature.

3.7 COLD ADHESION AFTER AGEING — No chipping or cracking

Test Method:

1) Test panels prepared according to clause 3.6, section 1 and 2; except use 1.5 mm thick test panels.

2) Expose assemblies at 90 +/- 2 C air temperature for 2 weeks.

3) After cooling to room temperature test adhesion according to FLTM EU-BV 51-2, Method A, clause 5 to 8; Load B.

3.8 COMPATIBILITY WITH PRODUCTION PAINTS

The paint must form a uniform and closed film over the material surface.

Test Method:

1) Test assembly preparation according to clause 3.6, section 1, except use 100 x 300 mm test panels and test material at a size of 80 x 280 mm.

2) Enamel with a light colored production paint according to FLTM EU-BI 3-2 Bb.

3.9 PAINT STAINING

No staining or other deleterious effects.

Test Method: Condition a test assembly prepared as described under clause 3.8 for 24 hours at room temperature. Mask one half of the enameled test material and expose for 96 hours in the Fluorescent Sunlamp Cabinet (see FLTM EU-BU 52-2), with the enameled test material facing the light source. Examine the exposed and unexposed portions of the test specimen.

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