



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

Material specification requirements are to be used for initial qualification of materials.

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).

3.1	COLOR	Dark grey or as specified on Engineering drawing
3.2	SOLIDS, min (FLTM BV 150-10)	99%
3.3	ASH, max (FLTM BV 150-10)	82%
3.4	MASS (At 4 mm thickness)	10.0 +/- 1.0 kg/m ²
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 BZ 150-11 "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.

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- 2) After cooling to room temperature expose test panel assemblies (separately and in vertical position) to heat according to FLTM BV 150-05, 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 BV 151-02, 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 BI 103-02.

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 BU 152-02), with the enameled test material facing the light source. Examine the exposed and unexposed portions of the test specimen.

3.10 CORROSION RESISTANCE

No corrosion

Test Method:

- 1) Preparation of test assembly according to clause 3.8, section 1 and 2.
- 2) After 24 hours at room temperature test according to ASTM B 117 for 240 hours.
- 3) Remove a 30 mm wide strip from the longer edge of the test specimen and examine for corrosion.

