



## ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

DEADENER SHEETING, LOW TEMPERATURE FUSIBLE

SK-M99G9512-A

## 1. SCOPE

The material defined by this specification is a bitumen and/or rubber based heat fusible sheeting for structure born noise damping with an anti-blocking surface finish on one side. The other (heat fusible) side has an oil absorbing coating which can be protected by a release paper.

## 2. APPLICATION

This material was originally released for bonding to door inner panels by the induction heating process. The material is applied to the oiled panel.

## 3. REQUIREMENTS

- 3.1 COLOR Black or as specified on Engineering drawing
- 3.2 SOLIDS, min 99 %  
(FLTM EU-BV 50-10)
- 3.3 ASH, max 60 %  
(FLTM EU-BV 50-10)
- 3.4 THICKNESS, max 2.2 mm or as specified on  
(Slide Gauge) Engineering drawing
- 3.5 WEIGHT/m<sup>2</sup>, max 1.8 kg  
(Based on 1 mm thickness)
- 3.6 HEAT STABILITY

The material shall fuse properly to the substrate without evidence of flow-off, blistering or shrinkage.

## Test Method:

- 1) Prepare test panels (steel body skin panels 300 x 300 mm) in accordance with FLTM EU-BV 50-11, "Normal Grade".
- 2) Expose test panels in an air dry oven at 130 +/- 2 C for 1 hour.

| Date       | Release No. | Released                            |
|------------|-------------|-------------------------------------|
| 1994 12 15 |             | Revised and Retyped, was 9 pages    |
| 1975 05 12 | B/CP7055TP  | Revised 3.11 part 3 English version |
| 1975 03 11 | SM/ET0882TP | Released                            |

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- 3) Apply within 5 seconds specimens of 300 x 280 x 2.2 mm of material under test to the heated up panels while in oven.
  - 4) Maintain test assemblies in oven at 130 +/- 2 C for 90 seconds (horizontal position).
  - 5) Condition for 1 hour at room temperature.
  - 6) Expose test assemblies to heat according to FLTM EU-BV 50-5, Table 1, Maximum Curing Cycle, Phase 2 in vertical position.
- 3.7 COLD ADHESION 100 %  
(FLTM EU-BV 51-1, Method C, Load A, except  
- 30 C and bonding conditions according to 3.6.  
Test Method clause 2 to 5 and subsequently heat  
curing according to FLTM EU-BV 50-5, Table 1,  
Min Heat Curing Cycle, Phase 2)
- 3.8 ADHESION AFTER HEAT AGEING 100 %  
(FLTM EU-BV 55-2, Method A, Load A, except  
bonding conditions and subsequently heat  
curing as described under 3.7)
- 3.9 SALT FOG RESISTANCE No corrosion
- Test Method:
- 1) Prepare two test panels (steel body skin panels 300 x 150 mm) according to FLTM EU-BV 50-11, normal oiling grade.
  - 2) Cut two specimens 260 x 130 mm from the material under test and apply to the test panels at a distance of 10 mm respectively 30 mm from edges.
  - 3) Bond material under test according to 3.6, Test Method clause 2 to 5.
  - 4) Electrocoat and bake test assemblies under normal production conditions or according to FLTM EU-BI 20-1.
  - 5) Condition test assemblies for 24 hours at room temperature and subject to a salt fog according to ASTM B 117 for 144 hours.
  6. Remove a 30 x 260 mm strip of material from test panel and examine for evidence of corrosion.