



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

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 Black or as specified on Engineering drawing

3.2 SOLIDS, min 99%
(FLTM BV 150-10)

3.3 ASH, max 60%
(FLTM BV 150-10)

3.4 THICKNESS, max 2.2 mm or as specified on Engineering drawing
(Slide Gauge)

3.5 WEIGHT/m², 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 BZ 150-11, "Normal Grade".
- 2) Expose test panels in an air dry oven at 130 +/- 2 °C for 1 hour.

Date	Action	Revisions
2006 09 23	Revised	Inserted 3.0; Deleted 3.16 & 4
1994 12 15	Revised & Retyped	Was 9 pages
1975 03 11	Released	SM/ET0882TP





- 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 BV 150-05, Table 1, Maximum Curing Cycle, Phase 2 in vertical position.

3.7 COLD ADHESION

100%

(FLTM BV 151-01, 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 BV 150-05, Table 1, Min Heat Curing Cycle, Phase 2)

3.8 ADHESION AFTER HEAT AGEING

100%

(FLTM BV 155-02, 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 BV 150-11, 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 BI 120-01.
- 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.

