



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

DEADENER SHEETING, LOW TEMPERATURE FUSIBLE
DEADENER SHEETING, LOW TEMPERATURE FUSIBLE

SK-M99G9517-A
DELTA SK-M99G9517-B

1. SCOPE

The material defined by this specification is a bitumen synthetic resin and/or synthetic rubber based self adhesive heat fusible sheeting with an anti-blocking surface finish on one side. The adhesive side of sheeting is to be protected by a release paper.

2. APPLICATION

This material was originally released for bonding under heat to vertically EC primed resptively spray primed door inner panels in the paint oven.

3. REQUIREMENTS

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

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
(Slide gauge)

As specified on Engineering drawing in accordance with Figure 1.

3.5 WEIGHT/m2, max 2.2 kg
(Based on 1 mm thickness)

Date	Release No.	Released
1994 12 16		Revised and Retyped, was 11 pages
1983 11 21	B/64363TP	Renumbered, Revised 3.15, added 3.17.2 & Suffix B1
1976 12 17	SM/EQ8198MP	Released

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3.6 HEAT STABILITY

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

Test Method:

- 1) Apply 280 x 300 mm pieces of test material to 300 x 300 x 1.5 mm test panels prepared according FLTM EU-BI 20-1 with the tacky side facing to the panel and press together the whole area evenly using a roller according to ASTM D 1000.
- 2) Expose test specimens to heat according to FLTM EU-BV 50-5, Table 3 (use separate specimens for each curing cycle)
 - a) Minimum Curing Cycle
 - b) Maximum Curing Cyclein vertical position.
- 3) Examine after cooling to room temperature.

- 3.7 COLD ADHESION No chipping, no loss of adhesion
(FLTM EU-BV 51-2, Method B, Load A, - 30 +/- 2 C specimen preparation according to 3.6 of Test Method, section 1 and 2, test panel thickness 1.5 +/- 0.1 mm)

- 3.8 ADHESION AFTER HEAT AGEING No chipping, no loss of adhesion
(FLTM EU-BV 55-2, Method B, Load A, specimen preparation according to 3.6 of Test Method, section 1 and 2, heat ageing 14 d at 80 +/- 2 C, test panel thickness 1.5 +/- 0.1 mm)

- 3.9 SALT FOG RESISTANCE No corrosion

Test Method:

- 1) Specimen preparation according to 3.6 except specimen size of 280 x 280 mm, distance from panel edges 20 mm.
- 2) Condition test specimens for 24 hours at room temperature and subject to a salt fog according to ASTM B 117 for 240 hours.
- 3) Remove a 30 x 280 mm strip of material from test specimens and examine for evidence of corrosion.



3.10 TEMPERATURE CYCLING TEST

No chipping, no shrinkage, no blistering or loss of adhesion.

Test Method:

- 1) Specimen preparation according to 3.9, Test Method, section 1.
- 2) Condition test specimens for 24 hours at room temperature and subject three times to the following cycle:
 - 3 h at 80 +/- 2 C
 - 1 h at 23 +/- 2 C
 - 3 h at - 30 +/- 2 C
 - 1 h at 23 +/- 2 C
 - 16 h at 38 +/- 2 C and 98 +/- 2 % relative humidity
- 3) After conditioning at room temperature for 24 hours, test specimens according to FLTM EU-BV 55-2, Method A, test panel thickness 1.5 +/- 0.1 mm, load A.

3.11 PAINTABILITY

No shrinkage or blistering. The paint must form a closed film over the material surface. Discoloration and/or staining permitted.

Test Method:

- 1) Specimen preparation according to 3.6, Test Method, section 1.
- 2) Finish test specimens according to FLTM EU-BI 3-2, method Bb using light colored production paint.

3.12 PALLETIZING

The material and release paper shall separate easily from each other without tearing.

Test Method:

- 1) Cut from material under test 5 specimens 100 x 100 mm and determine weight and thickness per specimen.
- 2) Ply-up and cover with an aluminum plate of same size.
- 3) Load with a dead weight equalling a plied up height of 600 mm minus the weight of 5 specimens and cover plate.
- 4) Expose test assembly in a mechanical convection oven maintained at a temperature of 35 +/- 2 C for 2 weeks. Cool to room temperature, remove weight and cover plate and examine as described above.