DEADENER SHEETING, LOW TEMPERATURE FUSIBLE **SK-M99G9517-A**

DEADENER SHEETING, LOW TEMPERATURE FUSIBLE **∇ SK-M99G9517-B**

1. SCOPE

The material defined by these specifications 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 respectively spray primed door inner panels in the paint oven.

3. REQUIREMENTS

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

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 (FLTM BV 150-10) — 99%

3.3 ASH, max (FLTM BV 150-10) — 60%

3.4 THICKNESS (Slide gauge)

As specified on Engineering drawing in accordance with Figure 1.

3.5 WEIGHT/m^2, max (Based on 1 mm thickness) — 2.2 kg

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 BI 120-01 with the tacky side facing to the panel and press together the whole area evenly using a roller according to ASTM D 1000.

Date	Action	Revisions
2006 10 25	Revised	Inserted 3.0; Deleted 3.18 & 4
1994 12 16	Revised and Retyped	Was 11 pages
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2) Expose test specimens to heat according to FLTM BV 150-05, Table 3 (use separate specimens for each curing cycle)

   a) Minimum Curing Cycle
   b) Maximum Curing Cycle

   in vertical position.

3) Examine after cooling to room temperature.

3.7 COLD ADHESION — No chipping, no loss of adhesion

(FLTM BV 151-02, 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 BV 155-02, 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.

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