



ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

DEADENER SHEETING, HIGH TEMPERATURE FUSIBLE

SK-M99G9521-A

1. SCOPE

The material defined by this specification is a heat fusible sheeting for structure borne noise damping based on bitumen/synthetic resin or bitumen/rubber/synthetic resin with an anti-blocking surface finish on one side or alternatively covered with release paper.

2. APPLICATION

This material was originally released for heat bonding to EC primed floor panels in the passenger compartment during primer oven exposure.

3. REQUIREMENTS

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

If not otherwise specified use test panels EC-coated according to FLTM EU-BI 20-1.

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 2.5 +/- 0.2 mm
(Slide gauge)

3.5 MASS, max 1.85 kg/m²
(Based on 1 mm thickness)

3.6 MOLDABILITY

After curing the material shall fit closely to the panel without evidence of blisters or cracks.

Note: Test according to Figure 2 is only applicable if required on Engineering drawing.

Date	Release No.	Released
1994 12 16		Revised and Retyped, was 12 pages
1980 07 10	B/402956TP	Revised 3.8, 3.11
1978 10 20	SM/EQ8436TP	Released

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Test Method:

- 1) Apply test material to test panels according to Figure 1 and 2.
- 2) Cure test assemblies according to FLTM EU-BV 50-5, Table 2 (separate test assemblies for each curing cycle).
 - a) Minimum curing cycle
 - b) Maximum curing cycle
- 3) Examine after cooling to room temperature.

3.7 RESISTANCE TO SAGGING No sagging of test material

Test Method:

- 1) Apply test material to the panels as shown in Figure 3.
- 2) Further test assembly preparation according to clause 3.6, Test Method section 2, except only phase 1 each.

3.8 COLD ADHESION AFTER HEAT AGEING No chipping, no loss of adhesion
(FLTM EU-BV 51-2, Method B, Load "A", - 25 +/- 2 C, curing cycle according to Test Method, section 2, 14 d heat ageing at 80 +/- 2 C, test panel thickness 1.5 +/- 0.1 mm)3.9 ADHESION AFTER HEAT AGEING No chipping, no loss of adhesion
(FLTM EU-BV 55-2, Method B, 80 +/- 2 C heat ageing, Load "A", curing cycle acc to 3.6, Test Method, section 2, test panel thickness 1.5 +/- 0.1 mm)

3.10 CORROSION RESISTANCE No corrosion

Test Method:

- 1) Specimen preparation according to 3.9 (without ageing) except specimen size 280 x 280 mm; distance from panel edges 20 mm.
- 2) Condition test specimens for 24 hours at room temperature then store specimens in a humidity cabinet for 240 hours at 38 +/- 2 C and 98 +/- 2 % relative humidity.
- 3) Remove a 30 x 280 mm strip of material from test specimens and examine for evidence of corrosion.



3.11 TEMPERATURE CYCLING TEST

No chipping, shrinkage, blistering or loss of adhesion.

Test Method:

- 1) Specimen preparation according to 3.10, 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 +/- 1 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 the specimens according to FLTM EU-BV 55-2, Method A, clause 6 - 10, Load "A".

3.12 PAINTABILITY

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

Test Method:

- 1) Apply 280 x 280 mm test material centrally to 300 x 300 mm test panels.
- 2) Paint test specimens according to FLTM EU-BI 3-2, Method Bb using light colored production paint.

3.13 PALLETISING

The material 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 convected air dry 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.