



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 BI 120-01.

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 (FLTM BV 150-10)	99%
3.3	ASH, max (FLTM BV 150-10)	60%
3.4	THICKNESS (Slide gauge)	2.5 +/- 0.2 mm
3.5	MASS, max (Based on 1 mm thickness)	1.85 kg/m ²
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	Action	Revisions
2007 03 14	Revised	Inserted 3.0; Deleted 3.19 & 4
1994 12 16	Revised	Revised and Retyped, was 12 pages
1978 10 20	Released	SM/EQ8436TP





Test Method:

- 1) Apply test material to test panels according to Figure 1 and 2.
- 2) Cure test assemblies according to FLTM BV 150-05, 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

of (FLTM BV 151-02, 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)

No chipping, no loss adhesion

3.9 ADHESION AFTER HEAT AGEING

of (FLTM BV 155-02, 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)

No chipping, no loss adhesion

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.