



BITUMEN SHEETING, SELF-ADHESIVE, SOUND DEADENING

SK-M99G9523-A

1. SCOPE

The material defined by this specification is a bitumen-synthetic resin and/or bitumen synthetic rubber based self-adhesive sheeting. The adhesive side is covered by release paper.

2. APPLICATION

This material was originally released for after paint oven application to vertical EC and/or spray primer coated door inner panel areas.

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.

Use test panels in a thickness of 1.5 +/- 0.1 mm for all slamming tests.

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 a 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 2.5 mm or as specified on Engineering drawing in accordance with Figure 1
(Slide gauge)

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

3.6 ADHESION AT ROOM TEMPERATURE No chipping, no cracking, no loss of adhesion

Test Method:

- 1) Apply 280 x 300 mm pieces of test material to 300 x 300 x 1.5 mm test panels prepared according to FLTM BI 120-01 A and C with the adhesive side facing to the panel and press together the whole area evenly using a roller.

Date	Action	Revisions
2007 03 15	Revised	Inserted 3.0; Deleted 3.16 & 4
1994 12 16	Revised	Revised and retyped, was 12 pages
1980 04 16	Released	SM-EQ8633TP





- 2) Condition test specimens for 4 hours at room temperature and test according to FLTM BV 151-02, Method A, Load A, at room temperature.

3.7 Heat Resistance

No flow-off or sagging, no blistering or cracking, no chipping or loss of adhesion.

Test Method:

- 1) Specimen preparation according to 3.6 of test method, section 1.
- 2) Condition test specimen for 4 hours at room temperature and expose vertically in an air dry oven at 100 +/- 2 °C for 1 hour.
- 3) Condition test specimens for 4 hours at room temperature and test according to FLTM BV 151-02, Method A, Load A, at room temperature.

3.8 COLD ADHESION

3.8.1 4 Hours at Room Temperature After Bonding

No chipping, no cracking, no loss of adhesion.

Test Method:

- 1) Specimen preparation according to 3.6 of test method, section 1.
- 2) After 4 hours conditioning at room temperature test according to FLTM BV 151-02, Method A, Load A, -30 +/- 1 °C.

3.8.2 After Heat Ageing

No chipping, no cracking, no loss of adhesion.

Test Method:

- 1) Specimen preparation according to 3.6 of test method, section 1.
- 2) Expose test assemblies in a mechanically convected air dry oven at 80 +/- 2 °C for two weeks.
- 3) After conditioning at room temperature for 24 hours test specimens according to FLTM BV 151-02, Method A, Load A, at -30 +/- 1 °C.

3.9 SALT FOG RESISTANCE

3.9.1 After 24 Hours at Room Temperature

No corrosion

Test Method:

- 1) Specimen preparation according to 3.6 of test method, section 1, except specimen size of 280 x 280 mm, distance from panel edges 20 mm.