



BITUMEN FIBER BOARD, SELF-ADHESIVE, PAINT OVEN RESISTANT

SK-M99G9525-A

1. SCOPE

The material defined by this specification is a self-adhesive, heat resistant (paint oven temperature) fiber board with high bitumen content for structure borne noise damping. The adhesive side is covered by release paper.

2. APPLICATION

This material was originally released for application on EC respectively spray primer coated door inner panels before paint oven curing.

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.

3.0 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 THICKNESS 2.5 +/- 0.2 mm
(Slide gauge)

3.3 DENSITY, max 1.1 g/cm³
(Without release paper but with self-adhesive coating)

3.4 ASH, max 15%
(FLTM BV 150-10)

3.5 WATER ABSORPTION, max 30%
(SAE J 315, method B, without release paper but with self-adhesive coating)

3.6 BITUMEN CONTENT, min 50%

Test Method:

- 1) Cut 50 x 10 mm specimens from the finished part, remove release paper, determine weight and extract the bitumen content in a Soxhlet extraction apparatus with carbon tetrachloride. Continue extraction until solvent in tube is colorless.
- 2) Dry the bitumen-free sample in a mechanical convection oven at 105 +/- 2 °C for 2 hours. Cool in desiccator and reweigh.

Date	Action	Revisions
2007 03 16	Revised	Inserted 3.0; Deleted 3.17 & 4
1994 12 16	Revised	Revised and Retyped, was 12 pages
1981 02 16	Released	SM/EQ 8728 TP





3.7 HEAT STABILITY

After heat curing the material shall fit tightly to panel without evidence of blisters, cracks, displacement, or loss of adhesion.

Test Method:

- 1) Apply 280 x 280 mm pieces of test material to 300 x 300 x 1.5 +/- 0.1 mm test panels prepared according to FLTM BI 120-01, A and C (EC-coated), with the tacky side facing to the panel and press together evenly using a roller according to ASTM D 1000.
- 2) Expose test specimens in vertical position 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
- 3) Examine after cooling at room temperature.

3.8 ADHESION AFTER HEAT AGEING

No chipping, no loss of adhesion

Test Method:

- 1) Specimen preparation according to 3.7, test method, section 1 and 2.
- 2) Expose specimens for 14 days at 80 +/- 2 °C.
- 3) After 2 hours at room temperature test according to FLTM BV 151-01, Method A, clause 5 to 8. Load A, at room temperature.

3.9 COLD ADHESION AFTER HEAT AGEING

No chipping, no loss of adhesion

Test Method:

- 1) Specimen preparation according to 3.8, test method, section 1 and 2, test panel thickness 1.5 +/- 0.1 mm.
- 2) After 2 hours at room temperature test according to FLTM BV 151-01, Method A, clauses 5 to 8, Load A, at - 30 +/- 1 °C.

3.10 CORROSION RESISTANCE

No corrosion

Test Method:

- 1) Specimen preparation according to 3.7, test method, section 1 and 2.
- 2) Condition at room temperature for 24 hours and test according to ASTM B 117.
 - a) 240 hours for test assemblies with anodic EC-coated panels (FLTM BI 120-01).
 - b) 480 hours for test assemblies with cathodic EC-coated panels (FLTM BI 120-01).
- 3) Remove a 30 x 280 mm strip of material from test specimens and examine for evidence of corrosion.