



**ADHESIVE, SEALER, SYNTHETIC RUBBER, COLD APPLIED,
15 - 35 °C, HEAT CURING**

WSS-M2G413-A

1. SCOPE

The materials defined by this specification are solvent free, spot weldable adhesives and sealers.

2. APPLICATION

This specification was released originally for materials used to bond sheet metal body parts. The materials are applicable on oiled surfaces.

This specification was released originally for materials used to bond/seal rear wheelhouse to side panel, roof bow to roof, sliding roof frame to roof, etc. It cures during the electrocoat baking process at 175 °C.

3. REQUIREMENTS

3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 COLOR

Black or gray, or
as specified on
Engineering Drawing

3.3 DENSITY AT 20 °C (ASTM D 792)

See Initial Sample
+/- 0.05 g/cm³

3.4 SOLIDS, min (FLTM BV 150-10)

99.0%

3.5 ASH, max (FLTM BV 150-10)

47.0%

3.6 VISCOSITY (FLTM BV 103-01, nozzle 2 mm ID, conditioning time up to measurement 30 min, at test temperature. Line pressure 4 bar)

47.0%

3.6.1 As received

300 – 500 S

3.6.2 After aging
(14 days at 30 +/- 2 °C)

300 – 600 S

Date	Action	Revisions
2004 09 10	Activated	



Documents

A. Latado

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3.7 WATER ABSORPTION, max 0.5%
(FLTM BV 153-07)

3.8 SHEAR ADHESION, min Cohesion failure
(FLTM BV 154-03, Method B)

Prepare test specimens according to section A for oiled surfaces, coating thickness 3.0 mm.

Cure according to FLTM BV 150-05, Table 1, minimum and maximum cycle.

3.8.1 At 23 +/- 2 °C 120 N/cm²

3.8.2 At 90 +/- 2 °C 80 N/cm²

3.8.3 At -30 +/- 2 °C 140 N/cm²

3.9 PEEL ADHESION, min Cohesion failure
(FLTM BV 154-03, Method C)

Prepare test specimens according to section A for oiled surfaces, coating thickness 3.0 mm.

Cure according to FLTM BV 150-05, Table 1, minimum and maximum cycle.

3.9.1 At 23 +/- 2 °C 40 N/cm

3.9.2 At 90 +/- 2 °C 30 N/cm

3.9.3 At -30 +/- 2 °C 80 N/cm

3.10 HARDNESS DUROMETER A 35 - 50
(ISO 868, 3 s dwell)

Test Method: Prepare a test panel (300 x 100 x 0.8 -0.9 mm) according to FLTM BZ 150-11, oiling grade Normal. Apply a ribbon of test material (250 x 30 x 5 mm) to the Test Panel.

Conditioning: 10 minutes at
23 +/- 2 °C

Baking: 30 minutes at
175 +/- 2 °C

Conditioning: 4 h at 23 +/-2 °C

3.11 FLEXIBILITY AFTER AGEING No loss of adhesion
(FLTM BV 153-04, Method 4 3b, and no chipping
exceptions noted below)

Test panel dimensions: 300 x 100 x
0.8 - 0.9 mm

Conditioning: 2 h at 23 +/-2 °C

Test Temperature: -30 +/- 2 °C;
Mandrel diameter: 100 mm.