

CLEANING SOLVENT — URETHANE ADHESIVE/SEALANT

9981606 9981919 9981970

1 SCOPE. This specification covers the basic physical, chemical and performance requirements of a cleaning solvent used to remove polyurethane glass bonding materials such as 9985693 from adjacent body surfaces. The material must have no permanent adverse effect on the body paint, vinyl roof materials, or painted moldings. The cleaner is intended to be wiped dry from adjacent surfaces after removal of the adhesive.

1.1 The following cleaners are covered by this specification:

9981606 – This cleaner shall remove urethane adhesive from all surfaces including textured vinyl roof materials.

9981919 – This cleaner is used for general cleanup of painted body surfaces. It consists of a mixture of 1 part VM & P Naphtha (9981062) and 5 parts 9981606.

9981970 – This cleaner is slightly weaker than 9981606, for use where effect on paint may be a factor. Solvency must be at least equivalent to 9981194 emulsified cleaner.

2 REFERENCED STANDARDS.

9981062	ASTM D56
9981194	ASTM D1298
9985693	

3 REQUIREMENTS. Materials submitted for qualification to this specification must meet all the physical, chemical and performance requirements herein.

3.1 Physical Requirements. This specification covers individual solvents or blends having a range of physical properties. Upon submission, therefore, the following physical properties shall be provided for each cleaner and shall form the specification requirement for all subsequent lots.

3.1.1 Following data shall be provided for each approved product:

Specific Gravity at 25 C (ASTM D1298)

3.1.2 Flash Point (ASTM D56) 35 C min

3.2 Chemical Requirements.

3.2.1 Identification. Gas chromatographic and infrared analysis will be used to identify, characterize and qualify new materials for approval to this specification. All subsequent lots of the approved material must be compositionally identical to the initial samples submitted for qualification.

3.2.2 Purity. The material must be free of suspended particles, corrosion products, undissolved water, and silicones or any other materials which may be detrimental to paint repair processes.

3.2.3 Odor. The odor of the material shall be reviewed in comparison with current production materials. Any significant change in the material's characteristic odor must be

evaluated in a GM approved laboratory and production trial. Any change in formulation must be reassessed for effect on odor.

3.2.4 Hazardous Materials Documentation. The supplier must provide all required safety documentation upon initial submission. Toxicity and flammability will be assessed by the using plant's Hazardous Materials Committee to determine conditions for use. The supplier must comply with all governmental regulations regarding proper labelling of hazardous materials.

3.2.5 Solvent Emissions Compliance. The supplier must furnish to the using plant's Plant Engineering Department all information required to assess the effect of material's use on meeting governmental restrictions on the discharge of volatile organic compounds (VOC) and disposal of hazardous waste.

3.3 Performance Requirements. The cleaner shall be assessed in plant trials and found effective in the removal of the applicable urethane adhesive. Subsequently, the material must perform satisfactorily in the specified production application. Failure to do so shall constitute reason for rejection regardless of compliance with the other requirements of this specification. In addition, the material must exhibit no effect on other components as follows:

3.3.1 Effect On Production Paint System. The cleaner shall not cause any adverse affects such as softening, staining or etching on the body paint system or component painted parts. Drops of the cleaner applied to freshly painted panels and heat aged for 48 h at 70 C must show no more affect on the paint than approved cleaners as a control. There shall be no residue left which cannot be easily removed with water or solvent prior to paint repair

4 SOURCE SHIPMENT RESPONSIBILITY. It will be the responsibility of the supplier to insure that the material is not exposed to temperatures during shipment which would cause the material to fail to meet any of the requirements of this specification.

5 INITIAL SOURCE APPROVAL. No shipment shall be made by any supplier until representative initial production samples have been approved by engineering as meeting the requirements of this specification.

5.1 Completed copies of the GM Material Safety Data Sheet and Critical Material Register (available from the engineering department or laboratory), or equivalent, must be submitted with any new submissions or where a composition change has occurred.

6 INSPECTION AND REJECTION. All shipments of material or parts under contract or purchase order manufactured to this specification shall be equivalent in every respect to the initial samples approved by engineering. There shall be no changes in either formulation or manufacturing processes permitted without prior notification and approval by engi-

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neering. Lack of notification by the supplier constitutes grounds for rejection of any shipment. While samples may be taken from incoming shipments and checked for conformance to this specification, the supplier shall accept the responsibility for incoming shipments meeting this specification without dependence upon purchaser's inspection.

7 APPROVED SOURCES. Engineering qualification of an approved source is required for this specification. Only sources listed in the GM Corporate Materials File under this specification number have been qualified by engineering as meeting the requirements of this specification. Sources are available through the on-line MATSPC System.

8 GENERAL INFORMATION. Specification 9981606 and 9981970 were first issued by Fisher Body in January 1975 and 9981919 was first issued in May 1981. The latest revisions include

Rev	Date	Description	Div
A	6/76	Revised 9981606 & 9981970	FB
B	7/90	Complete revision combined with 9981919	PC