



Adhesive, Promoter, Foam Tape

1 Scope

This specification details the properties and requirements of a solvent based adhesion promoter that is designed for use on raw reaction injection molding (RIM), and flexible paint systems used as the topcoats for RIM and/or thermoplastic olefin (TPO) fascias and bumper covers.

1.1 Material Description. The adhesion promoter is an air dry system that can be applied with a pressurized flow gun, brush or similar applicator. The product is utilized as a means to increase the short term (quick tack) adhesion of foam pressure sensitive adhesive tapes used to mount insert strips, moldings, and other components.

1.2 Symbols. Not applicable.

1.3 Applicability. Tape-attached components bonding to RIM or flexible paint systems.

1.4 Remarks. The application surface must be clean, dry and free of foreign matter. Contaminated surfaces should be cleaned with a dry, untreated lint-free cloth and an alcohol/water or naphtha wipe. The promoter should be applied in a thin, uniform coat on the surface to be activated. Allow for thorough drying (1 to 3 minutes) prior to applying the tape. Tape should be applied within one hour for best results.

2 References

Note: Only the latest approved standards are applicable unless otherwise specified.

2.1 External Standards/Specifications.

None

2.2 GM Standards/Specifications.

GMW3059

GMW14444

GMW16853

3 Requirements

3.1 Requirements. See Table 1.

3.2 Emissions Testing of Interior Materials and Parts. For all Code E designated parts per GMW14444, reference GMW16853 for emissions testing of interior materials and parts.

Table 1: Physical Properties

Properties	Values
Color	Straw
Solids Content	13%
Drying Time	60 s $\pm$ 30 s
Density	0.865 kg/L
Flashpoint (Pensky-Martens); Closed Cup	7 °C
Coverage	20 m ² /L, 0.05 mm wet film build
Storage	15 °C to 27 °C, Shelf Life 90 days minimum

3.3 Drying Time. The promoter must be dry prior to the installation of the adhesive backed foam tape. The drying time is only 1 minute or less normally, but varies somewhat due to application environment (temperature or humidity).

3.4 Application Recommendations. The adhesion promoter should be applied at a temperature of 15 °C to 27 °C for best results. If the material is spilled, it can be removed with a Methyl Isobutyl Ketone (MIBK) base solvent system. When using the promoter, all ignition sources should be avoided, as well as contact with the eyes or prolonged skin contact.

4 Manufacturing Process

Not applicable.

5 Rules and Regulations

5.1 Legal Regulations. All materials must satisfy applicable laws, rules, regulations and recommendations valid in the country of usage.

5.2 Language. In the event of conflict between the English and domestic language, the English language shall take precedence.

5.3 Inspection and Rejection. Samples of components or materials released to a GM material specification shall be tested for conformity with the requirements of this material specification and approved by the responsible Engineering department prior to commencement of delivery of bulk supplies.

A new approval must be received for any changes, e.g., properties, manufacturing process, location of manufacture, etc. If not otherwise agreed, all testing and documentation normally required for initial release must be completed.

It is the responsibility of the supplier to inform the customer in a timely manner, without solicitation, and to include documentation of all modifications of materials and/or processes and to apply for a new release.

5.4 Material Safety Data Sheets/Safety Data Sheets (MSDS/SDS). For new product submissions, or when a change in chemical composition of an existing product has occurred, a complete copy of the Material Safety Data Sheet/Safety Data Sheet must be submitted in compliance with the Globally Harmonized System of Classification and Labeling of Chemicals (GHS) requirements or other country-specific MSDS/SDS requirements.

5.5 All materials supplied to this standard must comply with the requirements of the International Material Data System (IMDS) and GMW3059, **Restricted and Reportable Substances**.

6 Approved Sources

Materials supplied to this specification must be approved by General Motors.

A list of approved materials can be found in MATSPC. This GM Material File is provided to third parties to reduce redundant testing of materials. If approved material already listed is used, the part supplier can use GM Material File reference for Production Part Approval Process (PPAP) material approval. If the decision is made to use a not yet approved material, contact GM Materials Engineering for details on the approval process. The material approval process must be completed prior to PPAP start date of the part supplied to General Motors.

7 Notes

7.1 Glossary.

MATSPC: Global repository of GM approved materials for corresponding GM Engineering Standards.

7.2 Acronyms, Abbreviations, and Symbols.

GHS	Globally Harmonized System of Classification and Labeling of Chemicals
IMDS	International Material Data System
MIBK	Methyl Isobutyl Ketone
MSDS	Material Safety Data Sheet
PPAP	Production Part Approval Process
RIM	Reaction Injection Molding