



Adhesive, Glass Adhesion Promoter, Acrylic Foam Tapes

1 Scope

This specification covers adhesion promoters suitable for bonding acrylic foam tapes to conventional automotive glass for mounting objects such as appliqué, and antenna bases to the glass.

1.1 Material Description. Glass adhesion promoter for acrylic foam tapes.

1.2 Symbols. Not applicable.

1.3 Applicability. Application use of this adhesion promoter include lightweight hardware/trim bonded to automotive glass, e.g., rain sensors, lightweight brackets, emblems.

1.4 Remarks. Not applicable.

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

GMW14270

GMW15735

2.3 Additional References. None.

3 Requirements

The formulations must be allowed to age for 24 h before usage.

3.1 Color: Clear.

3.2 Odor: Isopropyl alcohol.

3.3 Specific Gravity: 0.9176 s.g.

3.4 Open Time: 30 s to 10 minutes (dependent upon temperature and humidity level).

3.5 Stability (GMW15735).

3.5.1 Storage Stability. GMW15735; section 4.3.5. The shelf life of the adhesive promoter in closed containers shall be 9 months at a temperature not to exceed 27 °C. Shelf life of the material commences upon the receipt of the material from the manufacture. The temperature of the material must not fall below 10 °C.

4 Manufacturing Process

4.1 The adhesion promoter is wiped, or sprayed on the glass surface. The surface is then wiped with a clean dry lint free cloth. The double-coated acrylic foam tape attached component is then bonded to the glass.

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.

The appropriate GM Materials Engineering Department (Product Engineering or Manufacturing Engineering) must confirm materials as meeting the requirements of this specification. Only materials/sources listed in the GM Materials Approved Source List under this standard number have been qualified by Engineering as meeting the requirements of this standard.

Engineering qualifications of an approved source are required for this standard. Only sources listed in the GM Materials File (i.e., GM SupplyPower) under this standard number have been qualified by engineering as meeting the requirements of this standard. To access this list, reference GMW14270 for latest location.

For other GM locations, the responsible engineering group should be contacted to obtain the approved source in that individual country.

7 Notes

7.1 Glossary. Not applicable.

7.2 Acronyms, Abbreviations, and Symbols.

GHS	Globally Harmonized System of Classification and Labeling of Chemicals
IMDS	International Material Data System
MSDS	Material Safety Data Sheet
PPAP	Production Part Approval Process
SDS	Safety Data Sheet

8 Coding System

This standard shall be referenced in other documents, drawings, etc., as follows:

Material per 9986208

9 Release and Revisions

This standard was originated in April 2001. It was first approved by the Trim Adhesives Specialist Team in September 2002. It was first published in August 2003.

Issue	Publication Date	Description (Organization)
1	AUG 2003	Initial publication.
2	NOV 2016	Refresh. (Materials - Adhesives Global Subsystem Leadership Team)