

EDS

Engineering,
GM DAEWOO Auto & Technology.
Standards

HEAT CURABLE TYPE DOUBLE SIDE ADHESIVE TYPE

EDS-M-6817

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VERSION: 2

1. PURPOSE

This specification specifies the requirements of basic property of double side heat curable double side adhesive tape used for the doorless process.

2. SCOPE

This specification applies to acryl double-side adhesive tape of heat curable type, which is used to attach the washer of bolt assembly to the door hinge plate.

3. REQUIREMENT

Only 3.1 test shall be conducted with butadiene film on.

DESIGNATION	TEST METHOD	SPECIFICATION
3.1. Thickness (mm)	EDS-T-7624-1A	0.18±0.02
3.1.1. Total thickness (masking paper excluded)		
3.1.2. Butadiene film thickness		
3.2. When uncuring	EDS-T-7676 EDS-T-7689	4.0 min. 1.0 min.
3.2.1. Peel strength(N/cm) (But, tensile speed = 50 mm/min)		
3.2.2. Shear strength(kg/cm ²)		
3.3. Shear strength after curing (kg/cm ²)	EDS-T-7689	140 min.
3.3.1. After curing at 160°C for 20 min.		
3.3.2. After curing at 180°C for 20 min.		
3.3.3. After curing at 205°C for 20 min.		
3.4. Storage stability (kg/cm ²) Conduct clause 3.3 test after aging the sample at 25°C for 30 days	EDS-T-7689	140 min.
3.5. Resistance to solvent (kg/cm ²) After curing at 180°C for 20 min., immerse the sample in the solvent for 72 hrs, place it at the room temperature for 1 hr and measure shear strength.	EDS-T-7689	120 min. 120 min. 80 min.
3.5.1. I-OCTANE : TOLUENE (50:50)		
3.5.2. 25°C of water		
3.5.3. 50°C of water		

4. ADDITIONAL REQUIREMENT

4.1. Tape, which unwoven fabric trim is inserted between epoxy adhesive-mixed acryl adhesive, shall be stucked by heat curing. Masking paper, silicon-coated paper, shall be easy to separate for manufacturers and workers.