

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1377
SHEET : 1 of 5
RELEASE : July, 1974
REVISION : April, 1992

NAME: PUTTY - PLASTISOL GAP FILLING - HAND TYPE

1. GENERAL DESCRIPTION:

This specification covers a plastisol type of sealer for use in sealing body joints under exposed acrylic lacquer paint finish surfaces. The sealer must adhere to phosphated and primed steel surfaces.

The as-received material shall be easy to handle without exhibiting a dry crumbly appearance. On working with the hands the material shall become tacky without being excessively so. Little or no material shall remain on the hands after 30 seconds of kneading.

On baking, the sealer will fuse into a tough resilient crack resistant material which is completely compatible with GMHA paint systems.

2. DETAILED REQUIREMENTS:

2.1 Odour -

The sealer must not be toxic or noxious. After curing, it must be relatively non-odorous.

2.2 Stability -

2.2.1 Elevated Temperature Stability - As shipped, the adhesive must be capable of withstanding a temperature of 54° C (130° F) for 72 hours and still conform to the requirements of this specification.

2.2.2 Storage Stability- The shelf life of the material shall be 90 days at a temperature not to exceed 35° C (95° F). Shelf life of the material commences upon receipt of material from the manufacturer.

2.3 Packaging -

The material must be packed in such a manner that no difficulty shall be encountered in removing it from the container.

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2. DETAILED REQUIREMENTS (Continued)

2.4 Solids Content -

98% minimum 24 hours at 100°C

2.5 Viscosity -

Needle penetration 160 - 180 unworked - ASTM D5 using a 50 g load.

2.6 Coefficient of Expansion -

Volume increase during cure - 5% maximum.

2.7 Characteristics of Cured Sealer -

The material must be paintable, adhere to phosphated and primed steel, have no plasticiser migration, stain or loss of gloss, shall not crack production top coats, nor lose adhesion after the following environments.

14 days S-1 Sunlamp

14 days ageing at 70°C

500 hours Atlas Weatherometer

6 months outdoor exposure at Townsville Corrosion Cycle
(HN 0127)

Cracking Cycle (HN 0127)

7 days humidity (38°C, 100% R.H.)

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