

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1837
SHEET : 1 of 4
RELEASE : August, 1982
REVISION :

NAME: ADHESIVE - HOT MELT - TRIM

1. GENERAL DESCRIPTION

This specification covers a hot melt adhesive to be used in bonding trim materials such as fabric backed PVC headlining and polyethylene backed carpets.

The adhesive shall be amber in colour and free of air and foreign unmixed particles. It must be capable of being dispensed between temperatures of 170°C and 190°C. The adhesive must not oxidise or char in the pot while at indicated temperatures.

The adhesive shall have sufficient pressure sensitivity that 1 week after application there shall still be sufficient tack to meet the adhesive requirement of the specification.

2. DETAILED REQUIREMENT2.1 Odour

The material shall not be toxic or noxious, and the odour shall not be more perceptible on heating.

2.2 Stability

As shipped, the adhesive must be capable of withstanding a temperature of 54°C for 72 hours without deleterious effects. The shelf life of the material must be at least 6 months at temperature not exceeding 35°C.

Material conditioned as above must be able to pass all applicable requirements of this specification.

2.3 Solids 100%
Test Method Sample heated for 3 hours at 110°C

2.4 Non-Staining Characteristics (HN0001)

The adhesive shall not stain production materials after 6 hours under a S1 Sunlamp and ageing according to the Test Method. Samples are prepared by applying adhesive to a lacquered panel and immediately bonding to the trim material. Exposure begins 24 hours after bonding.

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2. DETAILED REQUIREMENT (Continued)

2.5 Adhesion Requirements

The adhesive shall delaminate the substrate or pull a minimum of 26.6 N/Cm (6 lb/inch) after each of the exposures.

Samples are prepared as follows :

1. Apply a 3mm (1/8") round bead of adhesive to 16 steel panels
150mm x 25mm (6" x 1").
2. Immediately bond 125mm, (5") of a 25mm x 200mm (1" X 8") samples of headlining to the hot melt bead and press firmly.
3. Air dry assemblies for 24 hours prior to testing.
4. Three samples are peeled after 24 hours air dry.
5. Three samples are exposed to 7 days at 38°C and 100% humidity prior to peeling.
6. Three samples are exposed to 70°C for 14 days, then 24 hours at room temperature prior to peeling.
7. Seven samples go through the following cycle, and a peel is made at each step of the cycle and after the completion of the cycle.

- | | | |
|--------------------------------|--------------------------|---------------|
| 1. Tuesday humidity 8 am | 24 hours 38°C | 100% humidity |
| 2. Wednesday 8 am Out humidity | | |
| In 90°C 4 hours. | Cool to room temperature | |
| 3. Wednesday 3 pm | In 90°C | 17 hours |
| 4. Thursday 8 am | Out 90°C | |
| | In 70°C | 7 days |
| 5. Thursday 8 am | Out 70°C | |
| | In -20°C | 4 hours |
| 6. Thursday 12 noon | Out -20°C | |
| | In 70°C | 100 hours |
| 7. Monday 4 pm | Out 70°C | |

8. The above bonds are peeled at 150mm (6") per minute.

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