

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1986
SHEET : 1 of 2
RELEASE : December, 1989
REVISION : November, 1990

NAME: ADHESIVE - HOT MELT - PRESSURE SENSITIVE

1. SCOPE

The material described in this specification is a Hot Melt Pressure Sensitive Adhesive. It is suitable for the bonding of materials such as synthetic carpets, felts, triflex, etc., to plastics such as ABS, Polypropylene etc., where low to medium temperature resistance is required.

The adhesive may be applied via roller, slot nozzle or hot melt spray equipment.

2. PHYSICAL PROPERTIES

- | | | |
|-----|--|----------------------|
| 2.1 | <u>Colour</u> | - Amber |
| 2.2 | <u>Application</u> | - 150 - 180° C |
| 2.3 | <u>Viscosity</u> (Brookfield RV8 27/2.5 rpm) | |
| | at 150° C | - 2,700 CPS) ± 10% |
| | at 180° C | - 1,200 CPS) ± 10% |
| 2.4 | <u>Softening Point</u> (Ring and Ball) | 64° C |
| 2.5 | <u>Shear Adhesion</u> (180° C Application Temperature) | |
| | Steel/Steel | 50 kPa |
| | Polypropylene/Polypropylene | 50 kPa |
| | Assemblies allowed to cool for 4 hours prior to testing.
Jaw separation 100mm/minute. | |
| 2.6 | <u>Degradation Point</u> | Greater than 200° C. |
| 2.7 | <u>Flash Point</u> | Greater than 290° C. |
| 2.8 | <u>Storage life</u> | Indefinite at 25° C. |

3. APPROVAL, CERTIFICATION, INSPECTION AND REJECTION.)
) Refer HN 1000, Clauses A,B,C and G.

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THE COMPANY'S PRODUCTS THE RECIPIENT IS RESPONSIBLE TO
CONFIRM THE DOCUMENT ISSUE DATE IS STILL VALID.*

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APPROVED SUPPLIERS AND MATERIALS SHEET**APPROVED MATERIALS**

288-3983

HM 0038C

APPROVED SUPPLIERS

NATIONAL STARCH & CHEMICAL

H.B. FULLER

NOTE: Prior to supply of this

material to GMHA, for any purpose including test work, a safety datasheet must be forwarded to the Occupational Hygienist, Medical Centre, General Motors Holden's Automotive Limited.

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