

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1989
SHEET : 1 of 2
RELEASE : May, 1990
REVISION : November, 2003

NAME: HOT MELT - PRESSURE SENSITIVE

1. SCOPE

The material described in this specification is a Hot Melt pressure sensitive adhesive. It is applied by extrusion nozzle and is suitable for adhering plastic materials such as ABS, polypropylene and polyethylene to painted metals and is intended for adhering the inner door water shield to the door.

2. PHYSICAL PROPERTIES

2.1	Colour	Yellow
2.2	Application Temperature	170 to 190 °C
2.3	Viscosity	5000 to 9000 CPS @ 180 °C
2.4	Specific Gravity	0.95 ± 0.05
2.5	Softening Point (ASTM E-28)	95 to 100 °C
2.6	180° Peel Adhesive	1000 N/m

3. PROCEDURE

Apply a 25mm wide bead of adhesive at 180° to a metal panel. Immediately apply a strip of inner door seal material (or canvas) over the adhesive and roll with a 2 kg roller. Allow 4 hours at room temperature to cool. Peel at 180° and 100 mm/min.

4. APPROVAL, INSPECTION AND REJECTION

Refer HN 1000, Clauses C and G (line trial required for final approval).

5. HAZARDOUS MATERIALS

Refer HN 1000, Clause H

6. RESTRICTED CHEMICALS

Refer HN 1000, Clause J

*THIS DOCUMENT MUST NOT BE REPRODUCED. IF USED IN RELATION TO
THE COMPANY'S PRODUCTS THE RECIPIENT IS RESPONSIBLE TO
CONFIRM THE DOCUMENT ISSUE DATE IS STILL VALID.*

Documents
Document Sharing Hub

**HOLDEN**Holden Limited
Engineering Department**MATERIAL SPECIFICATION**NUMBER : HN 1989
SHEET : 2 of 2
RELEASE : May, 1990
REVISION : November, 2003

NAME: HOT MELT - PRESSURE SENSITIVE

7. APPROVED SUPPLIERS AND MATERIALS

APPROVED SUPPLIERS	APPROVED MATERIAL
Bostik	6501
National Starch	189.1540

8. REFERENCES

ASTM E-28 HN 1000

9. REVISIONS

- | | |
|----------------|--|
| December, 1996 | - Viscosity range increased.
- National Starch 189.1540 added to the Approved Source list. |
| May, 1998 | - Correction of Softening Point Test Method. |
| November, 2003 | - Section 3; bead size clarified.
- Section 2.6; Peel strength requirement clarified.
- Renumbered section 8 (APPROVED SUPPLIERS AND MATERIALS) to section 7.
- Added section 8 (REFERENCES). |

Prepared by: Mark Franke

*THIS DOCUMENT MUST NOT BE REPRODUCED. IF USED IN RELATION TO
THE COMPANY'S PRODUCTS THE RECIPIENT IS RESPONSIBLE TO
CONFIRM THE DOCUMENT ISSUE DATE IS STILL VALID.*

FORM : I:\CentralLaboratory\StandardForms\MaterialSpecification\Matspec.doc