

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2045
SHEET : 1 of 6
RELEASE : October, 1990
REVISION : February, 1999

NAME: SEALER – PREFORMED, PAINTABLE

1. SCOPE

This specification details the requirements of a preformed, high and low bake, paintable sealant tape. The material is intended to seal interior and exterior body joints against water, dust and air intrusion.

- 1.1 The material must be a smooth and homogeneous mixture free of air, lumps, unmixed particles, and foreign materials.
- 1.2 The material must adhere to production ELPO. It must have a good weatherability.

2. REFERENCES

GM4465P	GM9505P	GM9828P	ASTM D1475
GM9010P	GM9763P	GM9832P	ASTM D1002
GM9037P	GM9773P	ASTM D638	GM9801P
SAE J2020	SAE J1960	SAE J1976	HN 1000
GM 9763P			

3. REQUIREMENTS

Specific material requirement and appropriate test methods are listed under properties. (All bake schedules are specified in metal temperatures.)

3.1 Physical Properties**3.1.1 Specific Gravity (Refer ASTM D1475)**

1.6 to 2.0 typical. An individual specific gravity range for each approved source will be set at the time of approval to this specification. This specific gravity range will become a requirement of that material.

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3. REQUIREMENTS**3.1 Physical Properties (continued)****3.1.2 Solid Content (Refer GM9010P)**

95% min by mass.

3.1.3 Odour (Refer GM9832P)

The sealer must not have a toxic or noxious odour. After curing, the sealer must be relatively non-odorous.

3.1.4 Toxicity

The material must not adversely affect those personnel handling it.

3.2 Performance Requirements**3.2.1 Adhesion**

One set of sealer panels shall be prepared per GM9801P and baked as follows:

Bake Horizontal : 25 min @ 150°C.

The sealer material must not slide off the panel or have any sag from initial position. The sealer material must not crack nor lose adhesion to the panel during or after the following conditions.

Initial : After cooling at ambient conditions for a minimum of 24 hours.

Exterior Cycle (Refer GM9505P, Cycle F)	6 weeks
Heat Ageing	226 h @ 70°C
Cold Slam (Refer GM9773P)	10 slams @ -30°C

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