

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2076
SHEET : 1 of 6
RELEASE : October, 1991
REVISION : June, 2003

NAME: SEALER - WELD THROUGH - NON-EXPANDABLE

1. SCOPE

This material details the requirements of a high bake, non-paintable, non-expanding weld through sealer. The material is intended for use in the body shop on the mating surfaces of the joints as well as the applications to seal body joints against water, dust and air intrusion. The material must be a smooth and homogeneous mixture free of air, lumps, unmixed particles and foreign materials. It must be capable of being dispensed with standard production pumping equipment. The material must adhere to oily metal. It must have good weatherability and must not accelerate rusting of metal substrate over which it is applied.

2. PHYSICAL PROPERTIES

2.1 Specific Gravity - (ASTM D1475) - 1.1 to 1.5

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.

2.2 Solids Content

95% Min

2.3 Viscosity (ambient) - 6-11 Seconds

Viscosity (after 3 days conditioning at 40°C) – 30 Seconds maximum

Test Method: HN 0060. Except use 0.079" orifice 40 PSI, 20 gm at 25°C.

2.4 Colour

Black

2.5 Odour

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

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THE COMPANY'S PRODUCTS THE RECIPIENT IS RESPONSIBLE TO
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2. PHYSICAL PROPERTIES (continued)

2.6 Toxicity

The sealer must not adversely affect those personnel handling it.

2.7 Composition

Material must not contain chlorine containing components.

3. PERFORMANCE REQUIREMENTS

3.1 Adhesion

One set of sealer panels oiled as in HN 0233 shall be prepared as per HN 0234 and baked at 185°C for 30 minutes.

3.1.1 Initially the sealer material must not crack or lose adhesion to the panel during or after bake.

3.1.2 Heat Ageing

Panel from 3.1.1 shall be baked for 2 weeks @ 70°C. There shall be no cracking or loss of adhesion.

3.2 Corrosion Resistance

Prepare panel assembly by taking two 0.8 mm x 300 mm x 100 mm plain steel panels, placing a 250 mm x 3 mm bead of sealer centrally on one of them and placing the second panel directly over the first. Spotweld the panels together by placing 5 spotweld uniformly spaced along the centre line of the panels through the sealer bead.

Panel assembly is then put through production phosphate and elpo paint system.

Expose the panel assembly to 20 cycles of the procedure given in HN 0214.

After completion of the corrosion cycle, remove test panels and immediately rinse with warm water.

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