



Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2089
SHEET : 1 of 3
RELEASE : February, 1993
REVISION : March, 2005

NAME: ADHESIVE - STRUCTURAL - TWO COMPONENT - PART A

1. SCOPE

The material described in this specification is the Part A component of a two-part pumpable structural adhesive system. The adhesive system is used for bonding the hems of oily and unclean metal substrates, such as galvanized steel, zinc coated steel and CRLC as used for inner and outer panels of engine hoods, deck lids and doors.

2. PROPERTIES

2.1 Viscosity

Test Method HN 0060 Meter 1 Procedure A 550 kPa air pressure

2.1.1 As Received 4 - 6 seconds.

2.1.2 Aged Viscosity

7 days @ 40 ± 2°C 12 seconds Max.

2.1.3 After Storage

3 months @ 27 ± 2°C 15 seconds Max.

2.2 Solids (ASTM D2835) 100%

Sample dried at 102 ± 3°C for 3 hours

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TO THE COMPANY'S PRODUCTS THE RECIPIENT IS RESPONSIBLE TO
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NAME: ADHESIVE - STRUCTURAL - TWO COMPONENT - PART A

2. PROPERTIES (continued)

2.3 Uncured Shear Adhesion 400 N min.

Prepare 6 assemblies as shown in Fig. 1, placing Part A component in the area to be hemmed and close the hem in the hemming press.

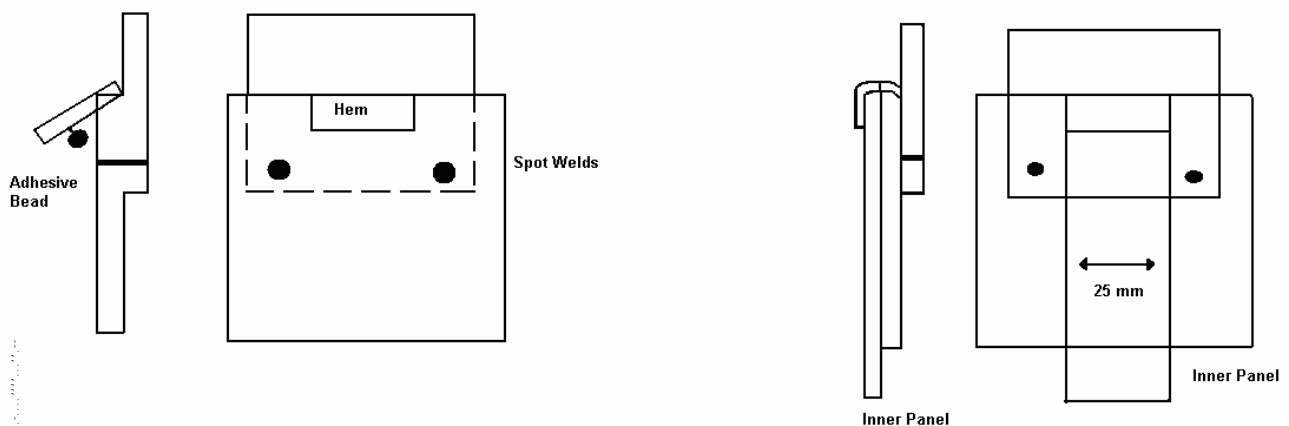


FIGURE 1

Pull the inner panel out of the hem at 12min/min and record load.

2.4 Storage

The material should be stored out of sunlight at a temperature no higher than 35° C.

2.5 Shelf Life

Under the conditions of Clause 2.4 the shelf life should be 6 months minimum.

2.6 Colour

White.

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