

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2090
SHEET : 1 of 3
RELEASE : February, 1993
REVISION : March, 2005

NAME: ADHESIVE - STRUCTURAL - TWO COMPONENT - PART B

1. SCOPE

The material described in this specification is the Part B (or catalyst) component of a two-part pumpable structural adhesive system. The adhesive system is used for bonding oily and unclean metal substrates, such as galvanized steel, zinc coated steel and CRLC as used for inner and outer panels (hems) 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	30 - 50 seconds
2.1.2 Aged Viscosity 7 days @ 40 ± 2° C	7 seconds maximum increase over initial Viscosity.
2.1.3 After Storage 3 months @ 27 ± 2° C	12 seconds maximum increase over initial Viscosity.

2.2 Solids (ASTM D2834) 100%

Sample dried at 102 ± 3° C for 3 hours.

2.3 Colour Black (Versilok 270), Grey (Versilok 254)

2.4 Storage

The material should be stored away from heat sources at a temperature no higher than 27° C. When the storage temperatures have been below 20° C it will be necessary to store the container for 24 hours at 20 - 27° C prior to pumping. This conditioning is necessary to allow optimum application properties.

2.5 Shelf Life

When stored under the conditions of Clause 2.4 the shelf life shall be 3 months minimum.

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MATERIAL SPECIFICATION

NUMBER : HN 2090
SHEET : 2 of 3
RELEASE : February, 1993
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NAME: ADHESIVE - STRUCTURAL - TWO COMPONENT - PART B

3. APPROVAL, INSPECTION AND REJECTION

Refer HN 1000, Clauses A, C and G(Line Trial).

4. HAZARDOUS MATERIALS

Refer HN 1000, Clause H.

5. RESTRICTED AND REPORTABLE SUBSTANCES

Refer HN 1000, Clause J.

6. APPROVED SUPPLIERS AND MATERIALS

Material known to meet the full requirements of this specification:

SUPPLIER	MATERIAL
LORD CHEMICAL PRODUCTS AUSTRALIA PTY LTD	Versilok 270 (Black –bulk material)
LORD CORPORATION, USA	
LORD CHEMICAL PRODUCTS AUSTRALIA PTY LTD	Versilok 254 (Grey for cartridge only)
LORD CORPORATION, USA	

7. REFERENCES

ASTM D2834 HN 1000

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