

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2185
SHEET : 1 of 2
RELEASE : June, 1995
REVISION : July, 2000

NAME: ADHESIVE - HOT MELT - HEAT RESISTANCE

1. SCOPE

The material described in this specification is a hot melt adhesive with a higher softening point than the adhesive in HN 1987. It has good adhesion to plastic materials such as ABS and painted metal surfaces.

It must have sufficient tack to adhere to painted surfaces at 18°C minimum.

2. PROPERTIES

2.1 Specific Gravity

1.0 ±0.1

2.2 Softening Point (Ring and Ball) 120° min.

2.3 Adhesive - Peel 180°C 1000 N/m.
ABS/Painted Metal.

2.4 Adhesion - Shear
ABS/Painted Metal
Test Method: Apply adhesive to painted panel and overlap ABS (400 sq. mm.) to form a shear assembly. Allow to cool. Hang a 1 kg wt to one end and place in an oven at 50°C.

)Assembly must support
)a 1 kg wt. for 24 hrs
)at 50°C.

3. APPROVAL, INSPECTION AND REJECTION

Refer HN 1000 , Clauses A and C.

4. HAZARDOUS MATERIALS

Refer HN 1000, Clause H.

5. RESTRICTED CHEMICALS

Refer HN 1000, Clause J.

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6. APPROVED SUPPLIERS AND MATERIALS

APPROVED SUPPLIER
National Starch

APPROVED MATERIAL
Durotak H203/A

7. REFERENCES

HN 1987

HN 1000

8. REVISIONS

July, 2000

-Section 3, expanded into sections 3, 4 and 5.
-Editorial and Formatting corrections.
-References section added.

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