

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2260
SHEET : 1 of 3
RELEASE : March, 1997
REVISION : February, 2000

NAME: ADHESIVE - CARPET BONDING

1. SCOPE

This specification covers an adhesive tape consisting of a pressure sensitive, rubber based adhesive.

- 1.1 The tape is used for bonding carpet to various interior substrates (ABS, polypropylene etc.). The adhesive provides a good balance of peel and shear strength.
- 1.2 Types I and II materials are supplied in the form of a transfer film.
- 1.3 Type III material, supplied is a double coated product, has an internal carrier film which enhances die cutting.

2. REQUIREMENTS

- 2.1 Physical and Adhesion Performance Properties, Refer to Table 1.

2.1.1 Shelf Life

Material shall pass all requirements of this specification after ageing material in the original container for 90 days at 35 °C.

2.1.2 Size of Product

Shall conform to the following:-

Width	To be called up on the Engineering Drawing
Thickness (ASTM D 3652)	
Type I	0.28 ± 0.03 mm
Type II	0.20 ± 0.02 mm
Type III	0.13 ± 0.02 mm
Liner Thickness	0.13 mm

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MATERIAL SPECIFICATION

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SHEET : 2 of 3
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2. REQUIREMENTS (continued)

2.2 Packaging

Tape to be supplied in evenly and uniformly wound rolls on suitable cores with a silicone treated paper, easily removable with no separation of material.

2.3 Other tests may be required to validate the specific application.

TABLE 1

PROPERTIES	VALUE	TEST METHOD
Colour	Amber	Visual
Liner Removability	60 N/m max	ASTM D 3330 90° Peel
Solids	99 % min	GM9010P
Mass	0.275 ± 0.05 Kg/m ² min	
180° Peel Strength		ASTM D 3330
At Ambient	875 N/m min	300 mm/min on polypropylene
After 24 hr at 35 °C and 95% RH	875 N/m min	
After 17 hr at 82 °C	875 N/m min	Peel 5 minutes after removal from the test environment.
Static Shear Strength. Time to remain bonded to test panel. Bonded area 645 mm ²		ASTM D 3654 Laminate adhesive to carpet. Apply the polypropylene test panel. Roll twice with 4.5 Kg roller. Allow 72 hour rest at ambient.
150 gm weight at 77 °C	24 hour min	
50 gm weight at 93 °C	24 hour min	
Tear Resistance	6.7 N min	ASTM D 1004
Tensile Strength	11 N min	ASTM D 412 Die A

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