

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2363
SHEET : 1 of 3
RELEASE : April, 2001
REVISION :

NAME: ADHESIVE – STRUCTURAL, TAPE

1. SCOPE

This specification covers a structural adhesive tape used for bonding double-sided hot dipped zinc-iron low carbon steel and Cold Rolled Steel (CRS) panels in areas inaccessible to spotwelding. The adhesive tape shall be supplied on a release paper backing, as die-cut parts. One side of adhesive tape shall be non tacky and shall not attract dust or dirt. The tape shall have adequate tack to its substrates to facilitate assembly of the parts without displacement of the adhesive tape.

- 1.1 This material shall be compatible with production phosphatizing, ELPO, and top coat systems and shall not be adversely affected by bake temperatures up to 204°C.
- 1.2 The material shall cure in the heat of the ELPO (and subsequent) paint ovens. The resulting adhesion of the material to the substrate following the cure shall render an adhesive strength that is, in all conditions, greater than the cohesive strength of the material.

2. REFERENCES

GM9763P	GM9828P	ASTM D4339	GM9010P
ASTM D1875	ASTM D502	SAE J1523	ASTM D1876
HN 0214	HN 1000		

3. REQUIREMENTS

3.1 Stability (GM9763P).

3.1.1 Elevated Temperature Stability

As shipped, the adhesive must be capable of withstanding a temperature of 55°C for 72h, without any deleterious affects.

3.1.2 Low Temperature Stability

As shipped, the adhesive must be capable of withstanding 0°C for 72h, without any deleterious affects.

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3. REQUIREMENTS (continued)

3.1 Stability (GM9763P)

3.1.3 Storage Stability

The shelf life of the material in closed containers shall be 60 days at 35°C. Shelf life of the material commences upon the receipt of the material from the manufacturer.

3.2 Non-smoking (GM9828P)

The adhesive shall not smoke up to 177°C and shall not be classified greater than a slight smoker at 191°C.

4. PERFORMANCE REQUIREMENTS

4.1 Material Properties – Uncured Adhesive

See Table 1.

TABLE 1

Properties	Values	Test Methods
Colour	Black	Visual
Odour	Not objectionable	ASTM D4339
VOC	<0.2%	
Solids Content	97% min by weight	GM9010P
Density	1.5 g/cm ³	ASTM D1875
Flash Point	> 200°C	ASTM D502
Overlap Shear 20'@171C	18 MPa	SAEJ1523
T-Peel	5.0 N/mm	ASTM D1876
Scab corrosion resistance (45x45mm patch, oily CRS)	No evidence of corrosion under tape.	HN 0214
Homogeneity	Material must be homogeneous and free of lumps or air bubbles	Visual

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