

**HOLDEN**

Holden Limited  
Engineering Department

**MATERIAL SPECIFICATION**

NUMBER : HN 2383  
SHEET : 1 of 2  
RELEASE : May, 2002  
REVISION :

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NAME: ADHESIVE- STRUCTURAL-TWO-PART

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## 1. SCOPE

This specification outlines the requirements of a two-part chemically cross-linking, rubber toughened, acrylic structural adhesive. This rubber toughened/ polymethacrylate adhesive may be used for applications such as bonding aluminium components used in the construction of luggage carrier rails.

## 2. REFERENCES

GMW 3059                  HN1000                  ASTM D1876                  ASTM D1002

## 3. REQUIREMENTS

3.1 See Table 1

| Specific Requirement                                                                                     | Result                                         |
|----------------------------------------------------------------------------------------------------------|------------------------------------------------|
| Chemical type                                                                                            | Elastomer/methyacrylate                        |
| Specific gravity @25°C                                                                                   | 1.04 (Part A), 1.06 (Part B),                  |
| Viscosity @25°C, mPa.s (cP)<br>Brookfield RVT Spindle 4 @20rpm<br>(DIN 54453), MV-D=36 1/S after<br>180s | 2300 to 4200 (Part A)<br>2300 to 4200 (Part B) |
| Flash point (COC), °C                                                                                    | >70 (Part A)<br>>70 (Part B)                   |
| Peel strength (ASTM D1876)<br>(grit blasted aluminium)                                                   | 0.5 N/mm min                                   |
| Shear strength<br>(grit blasted mild steel)<br>(ASTM D1002)                                              | 8.0 MPa min                                    |

Table 1

## 4. APPROVAL, INSPECTION AND REJECTION

Refer HN 1000, Clauses A and C.

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5. HAZARDOUS MATERIALS

Refer HN 1000, Clause H.

6. RESTRICTED CHEMICALS

Refer HN 1000, Clause J.

7. APPROVED SUPPLIERS AND MATERIALS

APPROVED SUPPLIER

APPROVED MATERIAL

Loctite

Loctite 3271 A/B

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