

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2424
SHEET : 1 of 4
RELEASE : June, 2003
REVISION :

NAME: DEADENER PATCH - PRESSURE SENSITIVE

1. SCOPE

This specification covers the requirements of a pressure sensitive deadener patch. The deadener patch is supplied with release paper on one side and a suitable constraining layer (polyethylene, aluminium, fibreglass, stainless steel etc.) on the other. A typical application would include dampening sheet metal closure panels such as decklids, hoods or doors.

The deadener must adhere to CRS, zinc anneal, zinc-iron and galvanised panels and be compatible with production processing oils.

Material must be supplied to ensure dimensional stability, no blocking and ease of release paper removal under typical production conditions.

2. REFERENCES

HN 1000	HN 0013	ASTM D570	HN 0214
GM4465P	GM9832P	ASTM E502	ASTM D1475

3. MATERIAL REQUIREMENTS

3.1 Solids content (HN 0013)

99% min

3.2 Odour (GM9832P)

Material must not have a noxious or toxic odour when received or after curing.

3.3 Flash Point (ASTM E502)

200 °C min

3.4 Specific Gravity (ASTM D1475)

2.0 - 2.5 g/ml

3.5 Formability

The patch must not crack or delaminate when folded 180° upon itself at 10°C.

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3. MATERIAL REQUIREMENTS (continued)

3.3 Adhesion to oily steel

Max slide 5mm

Apply 3g/m² of standard production press oil to a 100mm x 300mm CRS panel. Bend the panel at its mid-length point to form a 60° acute angle. Attach a 50mm x 100mm piece of material to one inside face and apply 2kPa pressure for 10 seconds uniformly over the area of the patch. Stand up the test assembly so that the test piece is on the underside of the folded panel and 60° to horizontal per Figure 1. Leave in standard conditions (20°C, 65% RH) for 3h, then examine for evidence of deformation, slippage or loss of adhesion. Place in same orientation in an oven for 20 minutes (hold) at 190°C. Remove and allow to cool to room temperature. There shall be no deformation or loss of adhesion.

Max slide 5mm

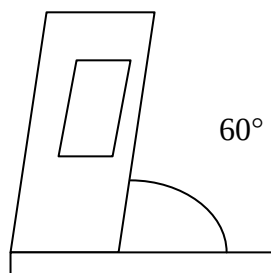


Figure 1- Panel orientation for adhesion test

3.7 Water Absorption (Refer ASTM D570)

Values shall be less than 1% when laminates are tested according to the specification.

3.8 Phosphate and Elpo Compatibility

Test samples exposed to Holden production phosphate and Elpo system shall exhibit no loss of adhesion from the test substrate.

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