

**HOLDEN**

GM Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 2484
SHEET : 1 of 2
RELEASE : September, 2006
REVISION :

NAME: PANEL BONDING ADHESIVE

1. SCOPE

This specification covers the performance requirements for a two-part toughened epoxy adhesive system suitable for bonding steel, aluminium and plastic surfaces. These types of adhesives are intended to be used to bond and seal replacement body panels.

The material should comply with the full technical requirements of GM6449G of which some are shown below.

2. REFERENCES

GM6449G

ASTMD1002

HN 1000

GMW3059

3. PROPERTIES

3.1	Consistency	Viscous Paste
3.2	Pot Life (23 °C)	60 minutes
3.3	Working Time (23 °C)	90 minutes
3.4	Handling time (23 °C)	4 hours
3.5	Cure Time (23 °C) Cure time may be accelerated with heat	24 hours
3.6	Lap Shear (ASTMD1002), Cohesive Failure	
	3.6.1 Cold Rolled Steel	13 MPa min
	3.6.2 Galvanized Steel	13 MPa min
	3.6.3 Aluminium	13 MPa min

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THE COMPANY'S PRODUCTS THE RECIPIENT IS RESPONSIBLE TO
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4. COMPATIBILITY

The material must be compatible with GM Holden ELPO and Paint system.

5. APPROVAL, INSPECTION AND REJECTION

Refer HN 1000, Clauses A and C.

6. HAZARDOUS MATERIALS

Refer HN 1000, Clause H

7. RESTRICTED AND REPORTABLE SUBSTANCES

(i) All substances and parts must meet the compositional requirements of GMW3059.

(ii) All chemical components present in materials supplied to this specification must comply with Australian NICNAS (National Industrial Chemicals Notification and Assessment Scheme) obligations.

8. APPROVED SUPPLIERS AND MATERIALS

Material known to meet the full requirements of this specification:

APPROVED SUPPLIER	APPROVED MATERIAL
3M	Automix 8115

Prepared by: Y. Zia

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