



ENGINEERING STANDARDS

Material Specification

LIMITED USE
HN2489

Sealer, Preformed, Flowable

Do Not Use on New Programs; No Replacement

1. SCOPE

This specification covers the requirements of an extruded, rigid, flowable sealer. The material is intended to melt and flow during oven bake in order to seal body joints.

1.1 This material must be smooth homogeneous mixture free of air, lumps and foreign objects.

1.2 The material must adhere to Steel, E-coated steel and SMC.

2. REFERENCES

HN1000	ASTM D792	GM9010P	GM4465P
GM9011P	GM9828P	GM9763P	9984182
GM9832	GM9505P	HN 1000	GMW3059

3. PHYSICAL REQUIREMENTS

3.1 Specific Gravity (ASTM D792)

1 to 2 typical.

3.2 Solids Content (GM9010P)

98% minimum.

3.3 Odour (GM9832)

The sealer must not have a toxic or noxious odour.

3.4 Toxicity

The material must not adversely affect those personnel handling it.

4. PERFORMANCE REQUIREMENTS

4.1 Adhesion

One set of sealer panels per each Steel or ELPO primed substrate shall be prepared and baked as follows:

High Bake System

25 minutes at 157°C

Cool to room temp

25 minutes at 115°C

Low Bake System

25 minutes at 115°C

Cool to room temp

25 minutes at 115°C

The material when baked as described above must not crack nor lose adhesion to the substrate during or after the following conditions:

Initial

After cooling at ambient conditions for 24 hours.

Exterior Cycle (GM9505P, Cycle F)

6 weeks.

Heat aging

14 days at 70°C

Humidity (GM4465P)

168 hours at 38°C /100% RH

Cold Resistance (GM9011P)

Two 1.7 J impacts at -30° C.

4.2 Corrosion Resistance

Apply 2 beads of sealer, 35 x 2.5 x 180 mm to the surface of a phosphated steel panel (inspect first to be sure it is free of surface corrosion). Bake panel for 1 hour at 205°C. Remove the panel from the oven and allow to cool to room temperature.

4.2.1 Remove one sealer bead from the panel. There must not be any corrosion on the panel surface under the sealer bead.