

ADHESIVE - WINDSHIELD GLASS

1. SCOPE

1.1 This specification describes a one part system, with a high modules, short tack-free and curing times, odorless, flexible polyurethane sealant. This sealant should be used with 86509008 per standard 86557984 (FNHA-2-E-001.50).

1.2 This specification may involve hazardous materials, procedures and apparatus. This specification does not address the health and safety problems associated with its application or use. It is the specification user's responsibility to follow appropriate health or safety practices and determine the application or regulatory limitation before use.

2. APPLICATION

This specification was originally released to provide a non-corrosive sealant between the window glass and on primed/painted sheet metal body sections (pinch welds). Also seals coach joints in body repair. This material can also be painted. Manufacturing application requirements for good bonding shall be described in standard 86513273 (FNHA-4-C-001.00).

FIGURE 1

REV	DESCRIPTION	DATE	BY	ECN NO.	DATE
1	STD ADH PRIMER	9/99	IE	113869	9/99
2	STD ADHESIVE WINDSHIELD	7/29/99	IE	113869	7/29/99

THE FOLLOWING TOLERANCES APPLY UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS: .005" ± .001" (MILS) ± .001" (MILS)
 SURFACE FINISH: 63/32 (RA) ± .001" (MILS)
 POSITION TOLERANCES: .005" (MILS) ± .001" (MILS)

3. DESIGNATION

The Engineering drawing shall contain the following notation for the specification of the subject adhesive. This notation is seen in Figure 1. As seen in Figure 1, the quantity shall be noted and the unit of measure shall be in liters (LT). The part number shall be the number of this specification and the name shall be the name of this specification. The primer shall be noted as shown on Figure 1 and description notation is indicated in standard 86557984 (FNHA-2-E-001.50)

4. RELATED SPECIFICATIONS

4.1 REFERENCE STANDARDS

ASTM D412 - Test Method for Vulcanized Rubber and Thermoplastic Rubbers and thermoplastic Elastomers-tension.

ASTM D624 - Test Method for Tear Strength of Conventional Vulcanized Rubber and thermoplastic Elastomer.

ASTM D1002 Test Method for Strength Properties of adhesives in shear by Tension Loading (metal-to-metal).

86513273(FNHA-4-C-001.00) - Adhesive Application

86557984(FNHA-2-E-001.50) - Windshield Primer

4.2 This specification replaces the following company standard:

VERSATILE MS - 010

					NAME	STD ADHESIVE-WIND	
					 NEW HOLLAND	ENGINEERING SPECIFICATION	
						FRAME 1	OF 3
						PART NUMBER	
						86557984	
L	B	RE	113869	9/99	THE INFORMATION HEREON IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF NEW HOLLAND N. V. AND/OR ITS SUBSIDIARIES. ANY USE, EXCEPT THAT FOR WHICH IT MAY BE LOANED, IS PROHIBITED.		
FRAME NO.	REV	BY	ECN NO.	DATE			
APP.	DRAWN		IE	7/29/99			
GES 9/99	CHECKED						

5. REQUIREMENTS**5.1 MATERIAL**

The material shall be a compound composed of polyurethane. The chemical reaction is initiated as soon as the adhesive is extruded or the cartridge is open. The material has a smooth, plastic consistency which will cure to form a high-grade elastomer.

5.2 PHYSICAL AND MECHANICAL PROPERTIES

Typical physical and mechanical requirements are list in Table 1.

5.3 CHEMICAL RESISTANCE

The subject adhesive shall offers effective long - term resistance to water, seawater, limewater, automotive type cleaning fluids, caustic agents and dilute acids.

5.4 SHELF LIFE

The compound shall have a minimum shelf life of 9 months when stored in a cool ,dry condition. Storage at or below 25°C (77°F) for best stability.

5.5 PACKAGING

The cartridge shall be 0.310 LT.

5.6 MANUFACTURING PROCESSES

For manufacturing application, see standard 86513273 (FNHA-4-C-001.00).

6. APPROVAL OF MATERIALS

Materials defined by this specification must have prior approval by the responsible Materials Engineering Activity. Suppliers desiring approval of their materials shall first obtain an expression of interest from the effected Purchasing, Design or Supplier shall submit to the affected Materials Engineering Activity its own Laboratory report to the specification (test results, not nominal values), the material designation and code number, and test specimens for New Holland evaluation. Upon approval, the material will be added to the Materials Engineering Activity. Upon request, the Engineering Materials Approved Source List.

7. SUPPLIER'S RESPONSIBILITY

All materials supplied to this specification shall be equivalent in all characteristics to the material upon which approval was originally granted. Prior to the making of any changes in the properties, composition, construction, color, dimensions, processing or labeling of the material originally approved under this specification, the supplier shall notify Purchasing and the affected Materials Engineering activity of the proposed changes and obtain the written acknowledgement of the Material Engineering activity. Test data, test samples and a new identification code are to be submitted with the request.

 NEW HOLLAND	NAME STD ADHESIVE-WIND			PART NUMBER 86557983	
	ENGINEERING SPECIFICATION			REV. B	FRAME 2
			OF 3	Documents Document Sharing Hub	