

ENGINEERING MATERIAL SPECIFICATION

Material Name

Specification Number

FIBERBOARD (KRAFT), FLEXIBLE TACKING STRIP

ESB-M2E22-A

1. SCOPE

The material defined by this specification is a kraft fiberboard with good flexibility and internal ply strength.

2. APPLICATION

This specification was released originally for material used for headlining tacking strips.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.3	MOISTURE CONTENT, max (SAE J 315)	7 %
3.4	WATER ABSORPTION, max (SAE J 315, 1-1/2 h immersion)	20 %
3.5	BURSTING STRENGTH, min (SAE J 315)	3.5 psi/0.001 in (950 kPa/mm) of thickness
3.6	TENSILE STRENGTH, min (ASTM D 828, 1 in (25 mm) wide specimens)	
	WMD	3 lb/0.001 in (526 N/mm) of thickness
	AMD	1.5 lb/0.001 in (263 N/mm) of thickness

Date	Action	Revisions
2003 01 30	Revised	Para 3.0 inserted ; Para 3.1, 3.2, 3.15, 4 deleted
2002 03 07	Revised	Removed ▽ ESB-M2E22-B, Updated D. Whyte
1971 08 17		Released AB1-302-14

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3.7 FLEXIBILITY, WMD and/or AMD

3.7.1 As Received

No breaking or delaminating

Test Method: Bend strips 180 ° over a mandrel 60 times the material thickness.

3.7.2 Aged

No breaking or delaminating

Test Method: Condition strips for 24 h in a mechanical convection oven maintained at 88 +/- 3 °C. Cool to 23 +/- 2 °C, then bend strips 180 ° over a mandrel 60 times the material thickness.

3.8 DRY STAPLING STRENGTH, min

15 lb (67 N)

Test Method: Staple a strip of #10 duck to the board with one staple. Use production staples in an air gun stapler (Cenco C-10028-NF or equivalent). Pull immediately in a tensile tester and record the number of lb (N) necessary to pull the staple.

3.9 WET STAPLING STRENGTH, min

13 lb (58 N)

Test Method: Immerse the board in water at 23 +/- 2 °C for 2 h, remove, 2 h later staple the #10 duck to it as described in para 3.7. Pull immediately and record the number of lb (N) necessary to pull the staple.

3.10 HEAT STAPLING STRENGTH, min

11 lb (49 N)

Test Method: Heat the board for 2 h at 135 +/- 3 °C, cool for 2 h at 23 +/- 2 °C and staple the #10 duck to it as described in para 3.7. Pull immediately and record the number of lb (N) necessary to pull the staple.

3.11 DIMENSIONAL STABILITY

(SAE J 315, Expansion - Method "B", 24 h, Contraction - Method "C")

	Expansion, % max	Contraction, % max
WMD	+0.7	-0.7
AMD	+1.5	-1.5

3.12 STAINING

(FLTM AN 101-03, Procedure "A" & "B")

No staining of the contact fabric