



TAPE, VINYL FOAM - PRESSURE SENSITIVE - HIGH STRENGTH

ESB-M3G101-A

1. SCOPE

The material defined by this specification is a natural skin, polyvinyl chloride foam tape, pressure sensitive with the adhesive side protected by a treated release paper removable without soaking in water or solvents.

2. APPLICATION

This specification was released originally for material used as a shim and anti-rattler between the fender skirt and wheel opening flange.

3. REQUIREMENTS

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).

3.2 COLOR

Black, or as specified on the engineering drawing and/or Trim and Sealing Manual.

3.3 PHYSICAL PROPERTIES

		Type I	Type II	Type III
3.3.1	Tape Nominal Thickness, in (mm)	0.25 (6.4)	0.12 (3.0)	0.06 (1.5)
3.3.2	Hardness-Durometer "00" (instantaneous reading)	45 +/- 5	55 +/- 5	55 +/- 5
3.3.3	Tensile Strength, psi (kPa), min (ASTM D 1564, except Die "A", as described in ASTM D 412, with natural skin and as received thickness)	75 (520)	100 (690)	140 (970)
3.3.4	Elongation, % min (ASTM D 1564)	200	200	200
3.3.5	Cold Flexibility, -18 °C	No cracking	No cracking	No cracking

Test Method: Condition 4 h at -18 +/- 1 °C. Bend 180° around a 1/4 in (6.4 mm) mandrel, conditioned at -18 +/- 1 °C.

Date	Action	Revisions
2005 09 29	Revised	Inserted 3.0; Deleted 3.1, 3.12, 4
1978 09 01		Metricated, Renumbered & Retyped CAH1-RD572066-86
1969 08 14	Released	CVY1-DR523784-3





ENGINEERING MATERIAL SPECIFICATION

ESB-M3G101-A

	Type I	Type II	Type III
3.3.6 Compression Deflection			
As Received, psi (kPa)	3 - 7 (21-48)	4 - 8 (28-55)	9 - 13 (62-90)
After Air Oven Aging 7 days, +/- % change at 70 +/- 1 °C (ASTM D 1056, except 1.0 in ² (6.5 cm ²) hand cut sections of tape are plied adhesive to adhesive)	30	30	30
3.3.7 Compression Set, % max (ASTM D 1056, except at 25% compression set and 1.0 in ² (6.5 cm ²) hand cut sections of tape plied adhesive to adhesive.)	80	80	60
3.4 WATER ABSORPTION , Vacuum, max (ASTM D 1056, except 2.0 x 0.5 in (51 x 13 mm) hand cut sections of tape are used at thickness received.)		20%	
3.5 MIGRATION STAIN		None	
Test Method: The material shall be placed with the adhesive in contact with a freshly painted light colored (white or blue) enameled panel prepared with ESB-M32J100 enamel per FLTM BI 103-02, and subjected to 48 h in the fluorescent sunlight cabinet described in FLTM BO 115-01.			
3.6 DIMENSIONAL STABILITY CHANGE , max		+/- 5.0%	
Test Method: Place a 10 in (250 mm) length of tape on an enameled panel prepared as described in para. 3.5. Record length of sample, then place assembly as follows:			
- Mechanical convection oven for 30 min at 121 +/- 3 °C - Remove from oven and condition at 23 +/- 2 °C for 1 h. - Re-measure the 10 in (250 mm) length and report change calculated as a percent of the original measurement.			
3.7 ADHESION			
3.7.1 Normal Adhesion, min			
Steel (ASTM D 1000)		15 oz/in (164 N/m) width	
Enamel (ASTM D 1000, panels prepared per para. 3.5)			
Air Dry at 23 +/- 2 °C		oz/in width (N/m)	
20 - 25 min		10 (109)	
24 h		15 (164)	
7 days		20 (219)	



Documents
Document Sharing Hub

Page 2 of 3