



TAPE, POLYVINYL CHLORIDE FOAM PRESSURE SENSITIVE

ESB-M3G137-A

1. SCOPE

The material defined by this specification is an extruded polyvinyl chloride foam tape displaying a skin on all sides with an adhesive on one side protected by a polyethylene release liner.

2. APPLICATION

This specification was released originally for material used as a dam or shim for windshields and backlites. This material provides protection from glass breakage during installation and seals against water leaks and wind noise.

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).

3.3 COLOR

Black or as specified on the engineering drawing.

Dimension 6 mm x 6 mm or as specified on engineering drawing.

3.4 TENSILE STRENGTH

276 - 827 kPa

3.4.1 Elongation

50 - 120%

3.5 LOW TEMPERATURE FLEXIBILITY

No Cracking

Test Method: Condition three 150 mm length samples of tape at -29 +/- 1 °C for 4 h. Bend each sample 180 ° around a temperature conditioned mandrel 6.4 mm diameter.

3.6 HARDNESS - DUROMETER "00"

30 +/- 10

(ASTM D 2240 except samples are single ply and instantaneous reading is used. Testing is to be done on the non-adhesive side)

3.7 COMPRESSION DEFLECTION

3.7.1 Instantaneous

14 - 41 kPa

3.7.2 After 60 s

3.4 - 14 kPa

(ASTM D 1667, except test tape as received. A sample of extrusion 25 mm in length by sample width 6.35 mm and single ply is compressed 25% at a rate of 50 mm/min. Record both instantaneous load and load 60 s after compressed height is reached.)

Date	Action	Revisions
2005 10 19	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.13, 4
1984 03 05	Released	C3N1-AF523183



**3.8 COMPRESSION SET, max** 90%

(ASTM D 1667 except at 70 +/- 1 °C for 22 h. Sample is tested single ply. Measure recovered height 30 min after clamps are recovered.)

3.9 WATER ABSORPTION, max 8%

Test Method: A 100 mm sample is weighed and immersed under a 50 mm head of water for 24 h. Sample is then removed, bottled, dried of all surface water and reweighed.

Calculate % Absorption

$$\% \text{ by wt.} = \frac{\text{New Wt.} - \text{Orig. Wt.}}{\text{Original Wt.}} \times 100$$

3.10 DENSITY 132 - 184 kg/m³

(ASTM D 1667, except use strips of tape as received with adhesive using a steel rule to measure length and width and a dead weight load for thickness determination.)

3.11 RELEASE LINER

The seal assembly shall have a suitable release liner which shall be readily removed, but shall not fall off in shipping and handling. There shall be no transfer of the release agent to the tape after 6 months storage at temperatures not exceeding 32 °C or accelerated storage of 14 days at 49 °C. Approval of the release liner shall be predicated on storage stability and production processing feasibility.

3.12 ADHESION, min 438 N/M

Test Method: A glass panel is cleaned and primed. After 15 minutes dwell time, a sample of the extrusion is bonded to the primed glass rolled down with a 2.04 kg roller once in each direction. The extrusion is reinforced with a non-stretch backing tape and pulled in a tensile tester after the 15 minute dwell time at 23 +/- 2 °C. The sample is pulled at a 90° angle with a crosshead speed of 305 mm/min.

ADHESION PRIMERS FOR ELASTOMERIC BONDING TAPE

Adhesion Primer for Elastomeric Bonding Tape - Fast Drying

▽ ESB-M2G157-AD

▽ ESB-M2G157-BD

Adhesion Primer for Elastomer for Elastomeric Bonding Tape

▽ ESB-M2G171-AB

▽ ESB-M2G171-BB

SUPPLIER'S IDENTIFICATION

▽ ESB-M3G95-AB

▽ ESB-M3G95-BB

Protective Treatments, Inc.
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