



TAPE, RUBBER - GLASS MOUNTING

ESB-M3G44-A

1. SCOPE

The material defined by this specification is a rubber composition tape.

2. APPLICATION

This specification was released originally for material used for sealing glass in metal channels in automotive applications.

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 TENSILE STRENGTH, avg min (ASTM D 412)

3.2.1 Normal

Both Directions	250 psi (1.7 MPa)
Cross Grain	150 psi (1.0 MPa)

3.2.2 After Aging*

Both Directions	400 psi (2.7 MPa)
Cross Grain	240 psi (1.6 MPa)

Test Method: Test 3 samples each in both directions and average the results. Test sample to be 1 x 6 in (25 x 150 mm).

3.3 ULTIMATE ELONGATION, min (ASTM D 412)

3.3.1 Normal	25%
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3.3.2 After Aging*	25%
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* Age the material in a mechanical convection oven at 70 +/- 1 °C for 70 h.

3.4 COMPRESSION

No loss of its original shape

Test Method: Test 8 specimens 1/16 x 4 x 1.125 in (1.6 x 100 x 28.57 mm) or equivalent, compressed to 1/2 their original thickness, with a load of 3000 - 6000 lb (13 000 - 27 000 N), at a compression head speed of 0.100 in (2.54 mm)/min.

Date	Action	Revisions
2005 09 20	Revised	Inserted 3.0; Deleted 3.1, 3.11, 4
1978 09 01	Metricated & Retyped	CAH1-RD572066-86
1963 06 27	Released	AS1 #955



3.5 SPLICING

All splices shall be bevel lapped with a 1/4 in (6.4 mm) maximum overlap.

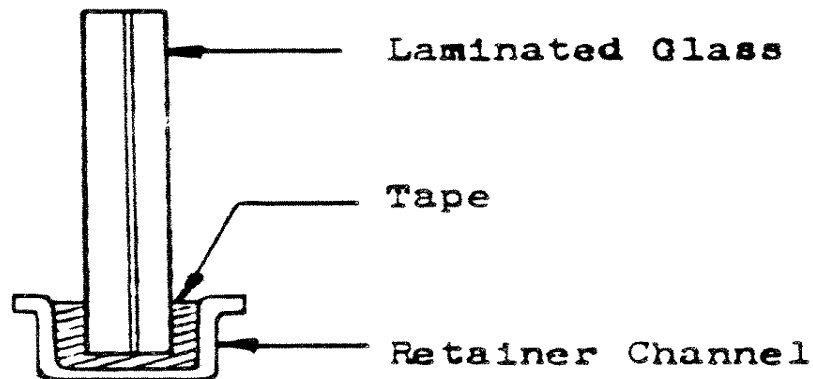
3.6 SIZE OF ROLLS

14 to 14-1/2 in (356 to 368 mm) in diameter with a 2-1/2 in (64 mm) center hole.

3.7 MIGRATION STAINING
(FLTM BO 115-01)

Staining of glass and vinyl laminate shall not extend beyond 1/16 in (1.6 mm).

Test Method: Place glass in retaining channel with rubber tape in position as shown in sketch. Subject for 240 h to a cycle of 4 h at 98 +/- 2% relative humidity and 38 +/- 1 °C, and 20 h in a fluorescent sunlamp cabinet.

**3.8 PACKAGING**

Packaged with waxpaper or equivalent separators between rolls to prevent adhesion.

3.9 UNWIND ADHESION

No evidence of injurious adhesion and shall not tear when unwound from its roll, after 90 days storage (para. 3.10).

3.10 STORAGE

The material shall pass all the standard requirements after 90 days storage at temperatures up to 38 °C maximum.