



TAPE, PAPER BACKED - PRESSURE SENSITIVE

ESB-M3G54-A

1. SCOPE

The material defined by this specification is a paper backed pressure sensitive tape.

2. APPLICATION

This specification was released originally for tape used to retain the polyethylene coated paper water shield on the lower door inner panel assembly.

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 BREAKING STRENGTH, min
(ASTM D 1000, 20 in (508 mm)/min rate of pull)

3.2.1 Dry 15 lb/in (2.6 N/mm) width

3.2.2 Wet 10 lb/in (1.8 N/mm) width

Test Method: Immerse specimens in tap water at 23 +/- 2 °C for 6 h. Remove, and blot off excess water from surfaces of specimens and pull immediately.

3.3 UNWIND PULL, max 48 oz/in (525 N/m) width

Test Method: Condition roll of tape for 22 h at 23 +/- 2 °C in a relative humidity atmosphere of 50 - 55%. Place core of tape around a fixture which will allow it to revolve. Attach the free end of the tape to a 10 lb (4.5 kg) maximum limit spring scale. Pull tape from its roll at the rate of 12 in (305 mm)/min. Measure and record the unwind pull as a direct scale reading.

3.4 ADHESION TO BACKING, min 10 oz/in (109 N/m) width
(ASTM D 1000)3.5 ADHESION TO STEEL, min 18 oz/in (197 N/m) width
(ASTM D 1000)

3.6 ADHESIVE SOLUBILITY

The adhesive shall be soluble in M-14J167, Special Spirits and M-14J147, Petroleum Light Naphtha.

3.7 MOISTURE VAPOR TRANSMISSION RATE, max 23 g
(FLTM BU 001-01)

Date	Action	Revisions
2005 09 21	Revised	Inserted 3.0; Deleted 3.1, 3.12, 4
1978 09 01	Metricated, Renumbered & Retyped	CAH1-RD572066-86
1963 05 31	Released	DS1 #615





3.8 WATER PENETRATION RATE, max 50 g
(FLTM BU 001-02)

3.9 ACCELERATED AGING, Storage Stability
(ASTM D 1000, except maintain the humidity cabinet at 95 - 100% relative humidity and 38 +/- 1 °C)

No signs of separating from its backing, nor loss in adhesion or tack. It shall not become a pasty or stringy mass. The backing shall not become brittle.

3.10 WATERFASTNESS OF DYE Waterfast

Test Method: Vigorously shake a 4 in (100 mm) strip of tape in 200 ml of distilled water at 23 +/- 2 °C. Allow to stand in the water at 23 +/- 2 °C for 6 h. Any discoloration of the water shall be cause for rejection.

3.11 MIGRATION STAINING None
(FLTM BU 105-01, 72 h)