



TAPE, UNTREATED CLOTH - PRESSURE SENSITIVE - BLACK
TAPE, UNTREATED CLOTH - PRESSURE SENSITIVE – WHITE

ESB-M3G56-A
ESB-M3G57-A

1. SCOPE

The materials defined by these specifications are untreated cloth adhesive tapes.

2. APPLICATION

These specifications were released originally for tapes used as follows:

ESB-M3G56-A As an anti-squeak material at the contact points of the instrument panel where the panel joins the body.

ESB-M3G57-A As a dust-proof protective covering for large openings.

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

ESB-M3G56-A	Black
ESB-M3G57-A	White

3.3 BACKING FABRIC

3.3.1	Finish	Untreated
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3.3.2	Thread Count, min
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MD	44/in (17/10 mm)
AMD	44/in (17/10 mm)

3.4	BREAKING STRENGTH , Dry, min (ASTM D 1000, except pull at the rate of 20 in (508 mm)/min.)	28 lb/in (4.9 N/mm) width
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3.5	BREAKING STRENGTH , Wet, min	28 lb/in (4.9 N/mm) width
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Test Method: Immerse test specimens in tap water at 23 +/- 2 °C for 6 h. Remove and blot off excess water from surfaces of specimens and test immediately as in para 3.4.

Date	Action	Revisions
2005 09 22	Revised	Inserted 3.0; Deleted 3.1, 3.14, 4
1978 05 05		Metricated, Renumbered & Retyped CAH1-RD572066-30
1963 06 21	Released	AS1 #945

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**3.6 UNWIND PULL, max** 56 oz/in (613 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.

3.7 ADHESION TO BACKING, min 20 oz/in (219 N/m) width
(ASTM D 1000)**3.8 ADHESION TO STEEL, min** 25 oz/in (274 N/m) width
(ASTM D 1000)**3.9 DUST PENETRATION**

No penetration through tape with titanium tetrachloride fumes.

Test Method: Mast a 2 in (50 mm) diameter hole drilled into a piece of 0.035 in (0.89 mm) body stock with a 3 in (75 mm) wide piece of tape. Blow titanium tetrachloride fumes from a putty bulb at the underside of the tape. Nozzle of bulb should be approximately 1 in (25 mm) from tape.

3.10 ADHESIVE SOLUBILITY

The adhesive shall be soluble in M-14J167 special spirits and M-14J147 petroleum light naphtha.

3.11 ACCELERATED AGING, Storage Stability

The adhesive shall show 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.

Test Method: ASTM D 1000, except maintain the humidity cabinet at 95 - 100% relative humidity and 38 +/- 1 °C.

3.12 FINISHED TAPE

The tape shall be wound evenly on rolls so that the surface of the roll shall be free from depressions. The tape shall have no liner over the adhesive. It shall unroll evenly and uniformly without unraveling. The adhesive material shall not separate from the backing so as to leave bare spots or show offsetting of the adhesive from one layer to another when the tape is unwound. When unwound from the roll, the tape shall remain reasonably flat with no tendency to curl transversely. The tape shall adhere snugly to work without wrinkling, curling, or buckling. The edges of the tape shall be straight, true and unbroken so as to provide sharp distinct boundaries to finished areas. The tape shall be wound on standard 3 in (75 mm) cones in lengths of 60 yd (55 mm).

3.13 WATERFASTNESS OF DYE Pass

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 at 23 +/- 2 °C for 1/2 h. Observe for discoloration of water. Slight discoloration no greater than standards established by the Materials Engineering Section.