



TAPE, POLYESTER - TWO SIDED PRESSURE SENSITIVE

ESB-M3G76-B1
ESB-M3G76-B2

1. SCOPE

The materials defined by these specifications are polyester films with pressure sensitive adhesives on both sides.

2. APPLICATION

These specifications were released originally for materials used to bond foam gaskets in rear view sail mirror assemblies. Tape application to substrates not specified is permitted provided specification adhesion requirements are attained.

3. REQUIREMENTS

Requirements shall apply to both the B1 and B2 materials unless otherwise specified.

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 THICKNESS, POLYESTER FILM ONLY (ASTM D 1000)

To be selected from the following and specified on engineering drawing.

	<u>Nominal Thickness</u>
ESB-M3G76-B1	0.18 mm
ESB-M3G76-B2	0.013 mm

3.4 BREAKING STRENGTH, min (ASTM D 1000, except use samples cut with Die "A" per ASTM D 412 and hold with standard jaws)

ESB-M3G76-B1	50 N/mm width
ESB-M3G76-B2	3.5 N/mm width

3.5 ELONGATION, min (ASTM D 1000)

ESB-M3G76-B1	60%
ESB-M3G76-B2	70%

3.6 180 ° PEEL ADHESION, min

3.6.1	Immediately After Bonding	219 N/m width
3.6.2	72 h After Bonding	657 N/m width

Date	Action	Revisions
2005 09 26	Revised	Inserted 3.0; Deleted 3.1, 3.2, 3.10, 4
1983 06 16	Released	CDN1-DC-503571-1

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3.6.3 24 h After Sample Exposure 438 N/m width
to the following thermal cycle (5 times)

- 4 h at 70 +/- 1 °C
- 4 h at 38 +/- 1 °C and 95-100% RH
- 16 h at -29 +/- 1 °C
- 4 h at 38 +/- 1 °C and 95-100% RH
- 4 h at 70 +/- 1 °C
- 16 h at -29 +/- 1 °C

Test Method: Apply the adhesive tape to each substrate as indicated per para 5.1 and measure the force required to peel the adhesive with liner using the procedure in ASTM D 1000. Evaluate adhesion to foam after bonding to an enameled panel. Bond strengths less than that specified are permitted provided cohesive failure occurs within the foam substrate.

3.7 **MIGRATION STAIN** None

Test Method: Apply a 250 mm length of adhesive tape to a 100 x 305 mm painted panel. The painted panel shall be prepared with current production white enamel per para 5.1. Place test panel in a fluorescent sunlight cabinet described in FLTM BO 115-01 for 48 h.

3.8 **LINER REMOVAL**, max 55 N/m width

Test Method: Apply the adhesive tape to an enameled panel described in para 5.1 and measure the force required to peel the liner from the adhesive using the procedure in ASTM D 1000.

3.9 **STORAGE STABILITY**

The unwind pull and ease of paper backing removal measured by hand peel examination shall not change appreciably after 12 months storage at temperatures below 32 °C.

5. **GENERAL INFORMATION**

The information given below is provided for clarification and assistance in meeting the requirements of these specifications.

5.1 **SUBSTRATE**

- Current production white enameled panel prepared per FLTM BI 103-02.
- Chrome plated panel meeting ESB-M1P18-A specification.
- ESB-M4D233-C vinyl foam.