



TAPE, VINYL FOAM - PRESSURE SENSITIVE

ESB-M3G77-A

1. SCOPE

The material defined by this specification is a polyvinyl chloride foam tape with one side adhesive coated and protected with release paper.

2. APPLICATION

This specification was released originally for material used as a shim material to insure proper fit of and provide a secondary seal for roof rail weatherstrips. As such, it is intended as an assembly aid and should be specified for applications where it is mechanically retained in the final 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 COLOR

Black, or as specified on the engineering drawing and/or the Trim and Sealer manual.

3.3 TENSILE STRENGTH, min 100 psi (690 kPa)
(ASTM D 1564, Die "A")

Elongation, min 150%

3.4 HARDNESS - DUROMETER "OO" 50 - 60
(ASTM D 676)

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

3.6 ADHESION TO PAINTED METAL, min 5 oz/in (55 N/m) width
(ASTM D 1000, panels as prepared in para. 3.8)

3.7 LOW TEMPERATURE FLEXIBILITY

3.7.1 As Received No cracking

3.7.2 Aged

Heat Aged 72 h at 82 +/- 1 °C No cracking
Heat aged 7 days at 70 +/- 1 °C No cracking

Date	Action	Revisions
2005 09 27	Revised	Inserted 3.0; Deleted 3.1, 3.12, 4
1978 04 25	Metricated & Retyped	CAH1-RD572066-17
1965 07 03	Released	AU1 #960





Test Method: Three samples 6 in (150 mm) x thickness x width shall be subjected to each of the above conditions. After exposure cool them to a temperature of -29 ± 1 °C for 4 h and bend them 180° (3.1 rad) around a 1/4 in (6.5 mm) diameter mandrel. No cracking is allowed.

3.8 MIGRATION STAIN None

Test Method: The material shall be placed with the adhesive side in contact with a freshly painted light colored (white or blue) enameled panel prepared with ESB-M30J100 or ESB-M32J100 enamel per FLTM BI 103-02, and subjected to 48 h in the Fluorescent Sunlight cabinet described in FLTM BO 115-01.

3.9 COMPRESSION SET, max 80%

(ASTM D 1667, except at 70 ± 1 °C for 22 h. Measure the recovered height 30 min after the clamps are removed.)

3.10 WATER ABSORPTION, max

3.10.1 Vacuum 60%
(ASTM D 1056)

3.10.2 Static 35%
(ASTM D 1056, except immerse for 24 h at 23 ± 2 °C under atmospheric pressure)

3.11 CELL STRUCTURE

Shall have a homogeneous, medium sized cell structure with no large voids or hard spots.

