

NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS K-6914
		Former Designation: TMS-6914
Sealer Tape, Door		CURRENT REV No.: 1608
		DATE: Aug. 2016
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<i>This specification may involve hazardous materials, equipment, and procedures. This specification does not purport to address all of the safety issues associated with its use. The user is responsible to consult appropriate safety and health practices and to determine the applicability of regulatory limits prior to use.</i>		

1.0 APPLICATION

This specification covers a smooth, black crepe paper tape recommended and designed for sealing access holes in truck door panels.

2.0 SCOPE

This specification covers the general requirements, property and performance requirements, quality, packaging, storage and identification, source approval and quality control.

2.1 Restricted Chemical Substances

Effective January 1, 2007, all product supplied to the requirements of this specification must comply with the requirements of the MPAPS B-50 specification.

3.0 REFERENCE DOCUMENTS

Unless otherwise specified, the latest issue of all referenced standards shall apply. The following standards, specifications and regulations are referenced in this specification.

Quality System Standard ISO 9001 or TS-16949	SAE J243
CFR Title 29, Section 1910	ASTM B 117
NAVISTAR Supplier Packing and Shipping Std. D-13	ASTM D 193
NAVISTAR Eng. Design Std. A-16	ASTM D 1000
NAVISTAR MPAPS B-50	ASTM D 1938
NAVISTAR MPAPS P-9543	

4.0 GENERAL REQUIREMENTS

4.1 Material

The crepe paper tape shall be a tough, general purpose, heat resistant type treated with a saturant and a pressure sensitive synthetic rubber resin adhesive. The tape shall have the capability of withstanding oven temperatures of 138°C (280°F) for one hour. The tape shall have long aging qualities and be water resistant. The adhesive shall be formulated for high tack characteristics.

4.2 Thickness

0.17 mm (0.0065 in) minimum.

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AUGUST 2016

NUMBER: MPAPS K-6914	TITLE: Sealer Tape, Door	REVISION: 1608
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4.3 Property and Performance Requirements

4.3.1 Tensile Strength and Elongation

4.3.1.1 Method

ASTM D 1000 - The stressing jaw speed shall be constant and at the rate of 300 ± 13 mm ($12 \pm 1/2$ in) per minute. Specimen shall be 25 mm (1 in) in width.

4.3.1.2 Required

Tensile Strength: 14.5 MPa (2 100 psi) minimum.

Elongation: 9% minimum.

4.3.2 Tear Strength

4.3.2.1 Method

ASTM D 1938

4.3.2.2 Required

0.88 N/cm (8 ozf/in) width minimum

4.3.3 Peel Strength

4.3.3.1 Method

ASTM D 1000 - Apply tape to panels: 1) steel-plain, 2) steel-painted, 3) aluminum-plain, 4) aluminum-painted. Allow to age for one hour before performing test.

4.3.3.2 Required

Tape shall meet 4.38 N/cm (2.5 lbf/in) width minimum peel strength to plain or painted surface on each type of panel.

4.3.4 Heat Aging

4.3.4.1 Method

Mount tape on steel or aluminum panel with painted and unpainted surfaces and age for one hour at 138°C (280°F), then return to room temperature before inspection. Inspect visually.

4.3.4.2 Required

No loss of adhesion, embrittlement or loss of water resistant qualities.

4.3.5 Resistance to Corrosive Atmosphere

4.3.5.1 Method

Two steel panels 30 cm x 30 cm x 1.6 mm (12 x 12 x 1/16 in) with 1.3 cm (1/2 in) diameter holes drilled 10 cm (4 in) apart over the entire panel. Apply tape completely covering the panel and holes overlapping the tape 3 mm (1/8 in). Perform corrosion testing as specified per ASTM B 117 for a total of 96 hours.

4.3.5.2 Required

No visible permeation of the corrosive atmosphere shall be exhibited when the tape is removed from the surface it was protecting, indicating the tape is water resistant and not corrosive to the metal surface it contacts. Also, there shall be no visible loss of adhesion of the tape from the metal panel or around the perimeter of the drilled access holes.

4.3.6 Chemical Resistance

4.3.6.1 Method

Apply tape to steel and aluminum panels and immerse individual panels in window wash solvent, car washing detergent and SAE Multi-Grade oil for two hours.

4.3.6.2 Required

No visible loss of adhesion, bubbling, shrinking, or disintegration of the mounted specimen.

4.3.7 Cold Resistance

4.3.7.1 Method

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