

NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS L-6007
		Former Designation: TMS-6007
TITLE: Molded Rubber		CURRENT REV No.: 1602
		DATE: February 2016
WRITTEN/EDITED BY: J. Goldschmidt	APPROVED BY: R. Goluch	SUPERSEDES: Rev. 1308 – August 2013
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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>		
Change Notice: Updated to MPAPS and reformat		

1.0 APPLICATION

This specification covers three process used to manufacture molded rubber parts and the various types of synthetic or natural rubber materials that are used in each process. The molded rubber parts covered in this specification may be suitable for either interior or exterior applications.

Process	Material	Grade (description)
Dipped	Type 1	A (natural rubber) B (chloroprene) C (PVC)
Slush Mold	Type 2	C (PVC)
Injection Molding	Type 3	D (EPDM)

2.0 SCOPE

This specification covers the general requirements, properties, performance requirements, and quality. Molded rubber parts such as seals and boots are used on the truck. Some metal parts such as brackets, clips, and supports, are coated with rubber, chloroprene, and PVC using the dipped process.

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 Specifications, Standards, and Regulations are referenced in this specification.

Quality System Standard ISO 9001 or TS-16949
CFR Title 29, Part 1910
NAVISTAR Manufacturing Std. MS-D-13
NAVISTAR MPAPS B-50
NAVISTAR TMS-9544

NAVISTAR MPAPS P-9543
FMVSS 302
ASTM D412
ASTM D471
ASTM D573

ASTM D624
ASTM D1149
ASTM D2137
ASTM D2240
ASTM G154

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3.1 CONVERSION OF OBSOLETE DRAWING DESIGNATIONS

Existing drawing reference:	Use:
TMS-6007 with no type specified	MPAPS L-6007, Type 1, Grade A
TMS 6007, Type I	MPAPS L-6007, Type 1, Grade A
TMS-6007, Type II	MPAPS L-6007, Type 1, Grade B
TMS-7013	MPAPS L-6007, Type 1, Grade C

4.0 REQUIREMENTS

4.1 General Requirements

4.1.1 Finish

Parts shall be free of pin holes, blow holes, bubbles, mold flash and present a smooth exterior surface.

4.1.2 Color

Parts shall be black unless otherwise designated on the engineering drawing.

4.1.3 Thickness

The tolerance on all thickness dimensions shall be $\pm 25\%$.

4.2 Property and Performance Requirements

4.2.1 Hardness ASTM D 2240

Durometer Shore A: 45-60 points.

4.2.2 Tensile Strength ASTM D 412

Grade A, B and D shall be 13.8 MPa (2000 psi) min.

Grade C shall be 6.9 MPa (1000 psi) min.

4.2.3 Tear Strength ASTM D 624, Die B

Grade A, B, and D shall be 26 kN/m (148 lb/in) min.

Grade C shall be 13 kN/m (74 lb/in) min.

4.2.4 Elongation

400% min.

4.2.5 Ozone Resistance ASTM D 1149, Method B – Not applicable to Grades C and D

4.2.5.1 Test Method: Expose finished part 70 hours in 50 ± 5 pphm (50 pphm) ozone atmosphere at 38°C (100°F).

4.2.5.2 Required: No visible attack, cracks, crazing or deformation.