



Standard Specification for Reinforced and Plain Gummed Tape for Sealing and Securing¹

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^{ε1} NOTE—15.1 was corrected editorially in March 1998.

1. Scope

1.1 This specification covers plain and reinforced paper gummed adhesive tapes suitable for securing and banding paper products and closing fiberboard boxes.

1.2 This specification is intended to replace Fed. Specs. CID A-A-1492, CID A-A-1671, and PPP-T-45 in part.

1.3 The values stated in inch-pound units are to be regarded as standard.

1.4 The following safety hazards caveat pertains only to the test methods portion, Section 11, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

D 685 Practice for Conditioning Paper and Paper Products for Testing²

D 828 Test Method for Tensile Breaking Strength of Paper and Paperboard²

D 996 Terminology of Packaging and Distribution Environments²

D 1974 Practice for Methods of Closing, Sealing and Reinforcing Fiberboard Shipping Containers²

D 3951 Practice for Commercial Packaging²

2.2 TAPPI Standards:

T 401 Fiber Analysis of Paper and Paperboard³

T 410 Weight per Unit Area (Basis Weight or Substance)³

T 414 Internal Tearing Resistance of Paper (Elmendorf-Type Method)³

UM 575 Water Resistance of Adhesive Bond in Laminated Paper and Paperboard³

2.3 Military Standards:

MIL-STD-105 Sampling Procedures and Tables for Inspection by Attributes⁴

MIL-STD-414 Sampling Procedures and Tables for Inspection by Variables for Percent Defective⁴

2.4 Federal Specifications:

PPP-T-45 Tape, Gummed, Paper, Reinforced and Plain, for Sealing and Securing⁵

PPP-T-681 Tape, Gummed, Packaging and Packing of⁵

CID A-A-1492 Commercial Item Description Tape, Gummed, Paper, Plain⁵

CID A-A-1671 Commercial Item Description Tape, Gummed, (Paper, Reinforced, Laminated)⁵

2.5 ISO Standard:

ISO 9002 Quality Systems Model for Quality Assurance in Production and Installations⁶

3. Terminology

3.1 *Definitions*—General definitions for packaging and distribution environments are found in Terminology D 996.

4. Classification

4.1 Type I Reinforced, Laminated:

4.1.1 *Class 1*—Strippable.

4.1.2 *Class 2*—Nonstrippable.

4.2 Type II Plain, Single Ply, Strippable:

4.2.1 *Grade A*—Light duty, for lightweight packages.

4.2.2 *Grade B*—Medium duty, for medium-sized packages.

4.2.3 *Grade C*—Heavy duty, for heavy-duty packages.

5. Significance and Use

5.1 Type I is a reinforced gummed tape which may be strippable (Class 1) or nonstrippable (Class 2). It is intended for use in Methods 2C2, 2C3, and any other methods in Practice D 1974.

5.2 Type II is a plain paper-backed nonstrippable gummed tape. It is intended for use in Methods 2C4, 2C5, and other

¹ This specification is under the jurisdiction of ASTM Committee D-10 and is the direct responsibility of Subcommittee D10.14 on Closure and Reinforcement.

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² *Annual Book of ASTM Standards*, Vol 15.09.

³ Available from the Technical Association of the Pulp and Paper Industry, P.O. Box 105113, Atlanta, GA 30348.

⁴ Available from Standardization Documents Order Desk, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn:NPODS.

⁵ Available from Superintendent of Documents, U.S. Government Printing Office, Washington, DC 20402.

⁶ Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

methods in Practice D 1974.

6. Ordering Information

- 6.1 The inquiry or order shall include the following:
 - 6.1.1 ASTM designation and date of issue,
 - 6.1.2 Type, class, and grade required (5.1),
 - 6.1.3 When core plugs are required (7.7),
 - 6.1.4 If tape is to be wound gummed side out (7.7),
 - 6.1.5 Roll width and length (9.1 and 9.2),
 - 6.1.6 Acceptance sampling plan and desired acceptance quality level (Section 12),
 - 6.1.7 When backing certification is required (15.1),
 - 6.1.8 When testing and inspection certification is required (15.1),
 - 6.1.9 Level of packaging and packing if other than commercial (Section 17), and
 - 6.1.10 When packaging for shipments to the U.S. Government (17.2).

7. Materials and Manufacture

7.1 The materials used in the construction of the tape shall be such as to ensure performance of the tape over the range of - 65 to + 160°F (-55 to + 71°C) and shall conform to the requirements of this specification.

7.2 Paper:

7.2.1 *Stock*—The paper used in the fabrication of the tape shall be a kraft paper. The use of recycled pulp in the paper is encouraged.

7.2.2 *Weight*—The weight of the paper prior to gumming shall conform to the requirement of Table 1, when tested as described in TAPPI T 410.

7.3 *Adhesives*—The adhesives used shall not have an offensive odor (dry or wet) and shall meet the environmental considerations of 16.1.

7.3.1 Type I, Class 1 adhesive shall be capable of being quickly activated with water. The wetted adhesive shall show pronounced tackiness and shall cause the tape to remain so firmly affixed that it cannot be removed without leaving a thin film of paper from the tape on the test paper, when tested in accordance with 13.6.1.

7.3.2 Type I, Class 2, and Type II adhesive shall be capable of being quickly activated with water. The wetted adhesive shall show pronounced tackiness and shall cause the tape to remain so firmly affixed that it cannot be removed without failure of either the tape or paper when tested in accordance with 13.6.1.

7.4 *Reinforcing Materials*—The reinforcing fibers used in fabricating Type I tapes shall be composed of glass of such size as to permit the reinforced tape to meet the requirements set forth in Table 2 when tested as described in 13.5.

TABLE 1 Weight of Ungummed Paper

	Minimum Weight	
	lb	g/m ²
(24 × 36 — 5500 sheets)		
Type I, Classes 1 and 2	55	49
Type II		
Grade A	35	57
Grade B	60	98
Grade C	90	146

TABLE 2 Physical Properties

Type	Tensile Strength, lb/in. width (kN/m) min		Tearing Resistance, grams force mN min ^A	
	Machine direction	Cross direction ^B	Machine direction	Cross direction
Type I	63 (11)	30 (5.25)		
Type II				
Grade A	26 (4.5)		55 (540)	66 (647)
Grade B	45 (8)		113 (1109)	134 (1315)
Grade C	68 (12)		203 (1991)	224 (2197)

^A This requirement does not apply to tapes less than 2 ½ in. (63 mm) in width.
^B This requirement does not apply to tapes less than 3 in. (76 mm) in width.

7.5 *Laminating Materials*—The laminating material for Type I tape shall be non-asphaltic, water resistant, flexible, and non-staining. Water resistance of the finished tape shall be tested in accordance with TAPPI UM 575.

7.6 *Construction*—Type I tape shall consist of two strips of paper in roll form, securely laminated together with reinforcing fibers embedded in the laminate. The reinforcing laminated tape shall be completely and uniformly coated on one side with an adhesive.

7.6.1 The tape shall be reinforced by crosswise reinforcing fibers spaced not less than 2 fibers/1 in. (50 mm) on average and by lengthwise fibers spaced not more than an average of ½ in. (25 mm) apart. If a diamond pattern is employed for crosswise reinforcement, the spacing between the parallel sides of the diamond shall not be more than 1¼ in. (32 mm). The three-way tape shall be reinforced in both the machine direction and cross direction with reinforcing fibers spaced not less than 2 fibers/1 in. on average, in addition to the diamond-patterned reinforcement.

7.6.2 Type II tapes, all grades, shall consist of one strip of paper in roll form of the applicable grade, completely and uniformly coated on one side with an adhesive.

7.7 *Rolls*—Unless otherwise specified, the tape shall be evenly wound and tightly wound in rolls with the gummed side in (6.1.4). Type II shall be wound on a core having sufficient rigidity to prevent distortion of the roll under normal conditions of transportation and use. The inside diameter of the core shall be not less than ½ in. (13 mm). When specified, Type II tape shall have the core secure with a plug (6.1.3). Type I tape shall not be required to have a core. The end of the outer leaf of the tape shall be adhered to the next layer to prevent unwinding. The tape in each roll shall be furnished in one continuous length and have no more than three splices per roll. All splices shall be neatly and evenly made with glue and shall not separate upon unwinding.

8. Physical Properties

8.1 The tape shall meet the physical property requirements in Table 2.

9. Dimensions, Mass, and Permissible Variations

9.1 The width of the roll for Type I shall be 1½, 2, and 3 in. (8.5, 50, and 75 mm) for Type II 1, 1½, 2, and 3 in. (25, 38.5, 50, and 75 mm).

9.1.1 A width tolerance of ± ¼ in. (±1.5 mm) shall be allowed on all widths.

9.2 *Length:*