



Designation: D 3759/D 3759M – 96^{e1}

Standard Test Method for Tensile Strength and Elongation of Pressure-Sensitive Tapes¹

This standard is issued under the fixed designation D 3759/D 3759M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

^{e1} NOTE—D 3759 and D 3759M were combined editorially in December 1997.

1. Scope

1.1 This test method covers the measurement of tensile strength (breaking strength) and stretch properties (elongation and “F” value) for pressure-sensitive tapes. It includes procedures for machine direction cross-direction tests and tests for tapes with low and high stretch and reinforced backings. It also includes a procedure for obtaining stretch force (“F” value) in conjunction with a determination of tensile strength. These procedures employ a constant-rate-of-extension (CRE)-type testing machine. They apply to the principle of stretching the specimen at a fixed strain rate of 25 mm per 25 mm [1 in. per inch] of specimen length per minute with the exception of the procedure for reinforced tapes.

1.2 The values stated in either SI or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system must be used independently, without combining values in any way.

1.3 *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 996 Terminology of Packaging and Distribution Environments²
- D 2904 Practice for Interlaboratory Testing of a Textile Test Method that Produces Normally Distributed Data³
- D 2906 Practice for Statements on Precision and Bias for Textiles³
- D 3715 Practice for Quality Assurance of Pressure-Sensitive Tapes²

¹ This test method is under the jurisdiction of ASTM Committee D-10 on Packaging and is the direct responsibility of Subcommittee D10.14 on Tape and Labels.

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

³ *Annual Book of ASTM Standards*, Vol 07.01.

- D 4332 Practice for Conditioning Containers, Packages, or Packaging Components for Testing²
- E 122 Practice for Choice of Sample Size to Estimate a Measure of Quality for a Lot or Process⁴

3. Terminology

3.1 Terminology found in Terminology D 996 shall apply.

4. Significance and Use

4.1 This test method provides information that can be used in material specifications for product design and quality assurance applications. It can be used in comparing different products.

4.2 The use of this test method must be related to the purpose for which the test is performed. One purpose is for determining the relative strength of the tape in the size in which it is purchased or used. Another purpose is to identify or characterize a particular backing material.

4.2.1 When relative strength is of interest, the test should be performed on the tape as-received, that is, without cutting the material to a specimen width less than the as-received width.

4.2.1.1 Usually tapes wider than 48 mm [2 in.] are not tested due principally to the limitations of equipment. Tapes as narrow as approximately 3 mm [0.125 in.] can be tested.

4.2.1.2 Comparison of materials by different test methods should be avoided because the test parameters of specimen dimensions and crosshead velocity determine the outcome. Changes in the parameter levels will produce different results for the same material.

NOTE 1—It is usual to find the tensile strength increasing significantly with increasing crosshead velocity and, therefore, strain rate.

4.2.2 When identity or material characterization is of interest, the test should be performed on a specimen cut from within the sample material boundaries using a sharp razor cutter, such as that defined in Section 5.

NOTE 2—Some of the traditional tools for specimen preparation must be avoided when the backing is comprised of thin plastic sheeting. These include chopping dies and sample cutters operating on a shearing

⁴ *Annual Book of ASTM Standards*, Vol 14.02.

principle. The reason for this restraint is that edges sufficiently ragged and damaged resulting from chopping or shearing cause tearing to occur before the true tensile strength level is reached. Tapes with fibrous backings may be cut to satisfactory specimens with these tools.

4.2.3 Stretch characteristics can be related to the tape's intended use or for identifying or characterizing a material.

NOTE 3—Elongation measurements become difficult to perform on stretchy materials (greater than 25 % ultimate elongation) when the ratio of specimen length to width is small (approaching 2). The results show high variability and do not allow for practical use of this information except when one wishes to demonstrate large differences between a material.

5. Apparatus

5.1 Tension Tester—A constant-rate-of-extension (CRE) type with load cell capacity such that the maximum expected specimen strength does not exceed 90 % of its normal limit.

5.1.1 Test Information should be displayed in at least an alphanumeric digital display or a load-elongation curve plotted by a pen or stylus responding to load and with a chart driven synchronously with the crosshead.

5.1.2 Load-Elongation Curve, plotted by a pen or stylus responding to load and with a servo-chart drive or x-y recorder driven by an extensometer.

5.1.3 Clamps, preferably the pneumatic action type.

5.1.3.1 Clamp faces at least 50 mm [2 in.] wide by 38 mm [1½ in.] deep. Faces shall have a light cross-hatch serration.

NOTE 4—Plastic materials are reduced in width and thickness while being stretched. This causes them to be drawn out of the clamps. Pneumatic clamps minimize this effect. It can be further reduced by the appropriate choice of surface of the clamps. The greatest improvement, both with respect to the above mentioned shrinkage problem and simple slippage, may be found from the use of urethane film which can be obtained as a pressure-sensitive tape approximately 20 mils thick. This material has a very high coefficient of friction, is somewhat malleable, and is easily replaced. Alternative materials are coated abrasive, rubber (neoprene or other synthetic type), or other tape.

5.1.4 Cylinders, in place of clamps for testing reinforced tapes. Each of two cylinders shall be 100 mm [4 in.] in diameter by 38 mm [1.5 in.] thick held in the position ordinarily occupied by the clamps so that the tape, when applied to the cylinders and extending between them, falls in the line of stress otherwise occupied by the specimens when clamps are used. See Fig. 1.

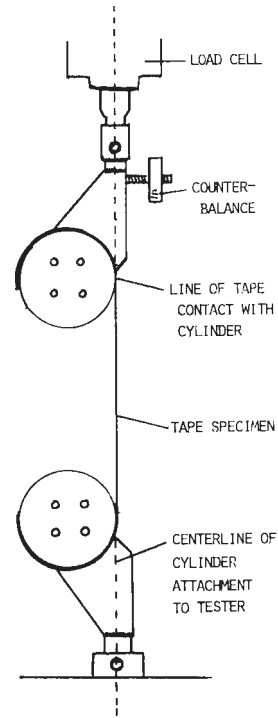


FIG. 1 Test Configuration for Reinforced Tapes

5.1.5 Scale, approximately 22 mm [1 in.] in length divided into 2-mm [0.1-in.] increments attached to each cylinder. The zero point or (origin) shall be at the point of tangency of the tape with the cylinder during the test and the scale shall increase upward on the lower cylinder and downward on the upper cylinder.

NOTE 5—These scales will be used to observe and measure the tape slippage during the tension test for reinforced tapes.

5.2 Cutter,⁵ holding two single-edged razor blades in parallel planes, a precise distance apart, to form a cutter of exact specimen width. Appropriate widths shall be available (refer to specimen width in Table 1) patterned after the 12 mm [½-in.] cutter in 5.2.1. The differences between cutters of various

⁵ Available from Chemsultants International, 9349 Hamilton Dr., Mentor, OH 44061-1118.

TABLE 1 Tester Preparation and Specimen Dimensions

	Gage Length, mm [in.]	Crosshead Velocity, mm [in.]/min	Chart Velocity, ^A mm [in.]/min	Specimen Width, ^B mm [in.]	Length, mm [in.]
Tapes with ultimate elongation of:					
Up to 200 %:					
Machine direction	125 [5]	125 [5]	125 [5]	12–24 [½-1]	230 [9]
Cross direction ^{CDE}	25 [1]	25 [1]	125 [5]	12 [¼-½]	125 [5]
200 % and up:					
Machine direction	50 [2]	50 [2]	125 [5]	12 [½]	150 [6]
Reinforced tapes	250 [10]	125 [5]	125 [5]	12–24 [½-1]	710 [28]

^AThe chart velocity may be set at other velocities. It should not be slower than the crosshead velocity.
^BThe specimen widths shown are for tests in which the specimen is cut from within the sample dimension. See 4.2.1.1.
^CCross-direction (C.D.) tests are limited to sample rolls of tape at least 2 in. in width.
^DIt is unusual to test C.D. tensile strength of tapes having ultimate elongations greater than 150 %. Therefore no reference to this is made in this table. However C.D. tests could be made under that category on the high-stretch materials.
^EIf the sample provides ample material, C.D. tests should preferably be made in the same way machine-direction (M.D.) tests are. This would occur with web material or sufficiently wide rolls.

widths is in the final width of the bar after removing the thickness of one razor blade.

5.2.1 The cutter shall consist of a 12 mm [$\frac{1}{2}$ in.] thick by approximately 200 mm [8-in.] length of aluminum bar stock $\frac{1}{2}$ in. wide. The edges, for about 125 mm [5 in.] from one end shall be slightly rounded to form a handle. The width of the bar, for approximately 75 mm [3 in.] from the opposite end, shall be narrowed to exactly 12 mm [0.500 in.] minus the thickness of a single razor blade (one of two used as cutting edges). The razor blades shall be held in position using side plates. The end of the cutter shall be cut away at a 0.75 rad [45°] angle to expose the cutting edges at one end of the blades.

6. Sampling

6.1 *Acceptance Sampling*—Acceptance sampling shall be in accordance with Practice D 3715/D 3715M.

6.2 *Sampling for Other Purposes*—The sampling and the number of test specimens depends on the purpose of the testing. Practice E 122 is recommended. It is common to test at least five specimens of a particular tape. Test specimens should be taken from several rolls of tape, and whenever possible, among several production runs of tape. Strong conclusions about a specific property of a tape cannot be based on tests of a single unit (roll) of a product.

7. Test Specimens

7.1 Specimens shall have the dimensions shown in Table 1.

7.2 Unwind and discard at least three, but no more than six, outer wraps of tape from the sample roll before taking specimens for testing.

7.3 Test one specimen per sample roll, unless otherwise specified.

7.4 The following applies to nonreinforced tapes:

7.4.1 Specimen ends that are clamped shall be prepared by covering the adhesive with paper, some other tape, or an extension of the specimen. In the latter case the specimen must be cut at least 100 mm [4 in.] longer than defined in Table 1.

7.4.2 The covering shall be free of wrinkles, leaving the gage-length area uncovered and completely cover the rest of the specimen so that the clamps will apply uniform pressure against the specimen.

7.4.3 A special specimen preparation is required for cross-direction (C.D.) specimens from rolls less than 100 mm [4 in.] in width. Lay two rectangular sample strips on a flat surface with the adhesive side facing up. See Fig. 2. Each strip shall be as wide as the sample roll and approximately 125 mm [5 in.] in length. Position these strips side by side with one long edge of one strip parallel to and 25 mm [1.0 in.] separated from one long edge of the second strip.

7.4.3.1 Cut a specimen from the sample roll to have the width specified in Table 1 and length equal to the width of the roll.

7.4.3.2 Lay this specimen adhesive side up across the 25-mm [1.0-in.] separation of the strips. Position it toward one end of the sample strips so that it rests equally on both strips and at a right angle to their parallel edges.

7.4.3.3 Cut two additional strips from the sample roll having the same width as the specimen. *Butt* the end of one of these at one end to form a continuation of the specimen across the remainder of the sample strip. Use the second strip to butt against the other end of the specimen in like manner.

7.4.3.4 Fold each of the original sample strips over onto itself to form a three-ply tab that will be gripped by the clamps during the test.

7.4.3.5 Trim off any excess (single ply of tape) of either the sample strips or the extension strips extending beyond the two- or three-ply parts of the assembly.

NOTE 6—The extension serves to keep the clamping pressure uniform over the whole area of the specimen. This is an imperative factor to a successful test.

7.5 For reinforced tapes the specimen requires no further preparation than to have the appropriate dimensions (Table 1) and ensure that the adhesive is not contaminated so it will adhere well to the cylinders.

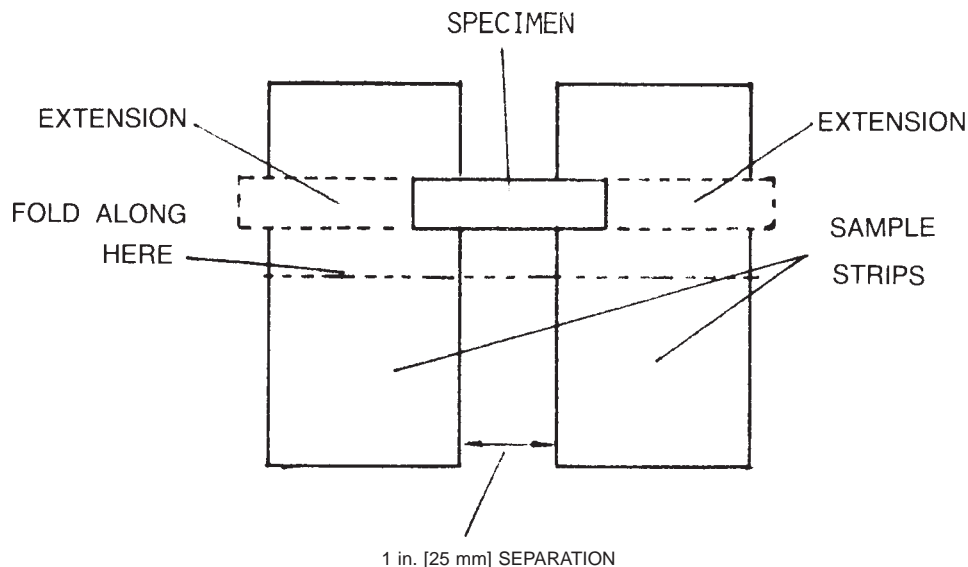


FIG. 2 Cross-Direction (C.D.) Specimen Preparation