



Standard Test Methods for Friction Tapes¹

This standard is issued under the fixed designation D69; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 These test methods cover the methods and procedures for testing friction tapes. Such tapes consist of a woven fabric sheeting that has been impregnated with an adhesive insulating compound and cut into rolls of narrow width. These tapes are commonly used for protecting and binding in place, insulation applied to joints of electrical wires and cables, and for other mechanical purposes.

NOTE 1—The material specifications formerly included in these test methods are now contained in Specification D4514.

1.2 The test methods included in this standard are as follows:

	Sections
Adhesion	6-11
Aged Adhesion	12-17
Breaking Strength	18-23
Dielectric Breakdown Voltage	24-29
Dimensions	30-35
Discoloration of Copper	36-40
Parallelism	41-45 Tackiness

1.3 The values stated in inch-pound units are the standard. The SI units in parentheses are for information only.

1.4 *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.*

NOTE 2—There is no equivalent IEC standard.

2. Referenced Documents

2.1 *ASTM Standards:*²

D149 [Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies](#)

D412 [Test Methods for Vulcanized Rubber and Thermoplastic Elastomers Tension](#)

D1711 [Terminology Relating to Electrical Insulation](#)

D4514 [Specification for Friction Tape](#)

D5423 [Specification for Forced-Convection Laboratory Ovens for Evaluation of Electrical Insulation](#)

D6054 [Practice for Conditioning Electrical Insulating Materials for Testing](#)

3. Terminology

3.1 *Definitions:*

3.1.1 For definitions of other terms used in this specification, refer to Terminology D1711.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *adhesion, n*—the resistance of the tape to unwind itself after being wound up under pressure, in accordance with this test method.

3.2.2 *breaking strength, n*—the force required, per unit width, to break the tape when tested in accordance with this test method.

¹ These test methods are under the jurisdiction of ASTM Committee D09 on Electrical and Electronic Insulating Materials and are the direct responsibility of Subcommittee D09.07 on Flexible and Rigid Insulating Materials.

Current edition approved October 2006; April 2012. Published October 2006. Originally approved in 1920. Last previous edition approved in 2006 as D69-01; D69-06. DOI: 10.1520/D0069-06.10.1520/D0069-12.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard.

3.2.3 *conditioning, n*—the exposure of the tape to the influence of a prescribed atmosphere for a stipulated period of time.

3.2.4 *length of tape in a roll, n*—the number of linear yards or metres of tape wound into a roll as measured in accordance with this test method.

3.2.5 *parallelism, n*—the difference in width between two mated ends of a tape that has been split in half, in accordance with this test method.

3.2.6 *tackiness, n*—the adherence of the friction tape surfaces to themselves after light contact has been made, in accordance with this test method.

4. Sampling

4.1 Select sample rolls at random from each shipment in accordance with the following table:

iTeh Standards
(<https://standards.iteh.ai>)
Document Preview

[ASTM D69-12](#)

<https://standards.iteh.ai/catalog/standards/sist/ba0f43a8-a5ef-48e2-8506-30ea4d6e146a/astm-d69-12>

Number of Rolls in Shipment	Number of Rolls in Sample
—50 to 200	2
—201 to 500	3
—501 to 1000	4
1001 to 5000	5

For shipments in excess of 5000 rolls, take one additional roll for each additional 1000 rolls or fraction thereof.

4.2A shipment shall consist of material shipped or intended for shipment to a customer and covered by one bill of lading.

4.1 The producer and consumer shall agree upon the number of rolls selected. Unless otherwise specified a minimum of three rolls per lot shall be tested.

4.2 For sampling purposes, a lot consists of identifiable materials of the same type manufactured in one production run and offered for delivery at the same time.

4.3 Test each sample roll for conformance to all the requirements of the specification.

4.4 Remove and discard at least 24 in. (610 mm) of the outer layer of each sample roll before taking test specimens.

4.5 Unwind the test specimen from the roll at a slow, uniform rate without jerking.

5. Conditioning

5.1 Unless otherwise specified, condition the rolls for 16 h in a standard laboratory atmosphere as specified in Practice D6054.

5.2 Unless otherwise specified, condition the test specimens for 1 h in a standard laboratory atmosphere as specified in Practice D6054.

ADHESION TEST

6. Significance and Use

6.1 In most applications, a friction tape must have adequate adhesion to remain in place and function properly.

7. Apparatus

7.1 *Adhesion Tester*—An assembly similar to that shown in Fig. 1, consisting of a mandrel mounted in a level position in ball bearings. The mandrel shall be 0.25 in. (6.4 mm) in diameter with a slot approximately 0.0625 in. (1.6 mm) in width and long enough to accommodate the full width of tape. The mandrel shall turn freely under a force of 0.25 ozf (0.07 N) suspended from a thread wound in a single layer on the center of the mandrel. This assembly is mounted on a wall or other vertical surface to which a vertical scale has been affixed. This scale shall begin 2 in. (51 mm) below the mandrel and extended downward for a distance of 36 in. (915 mm). The scale shall be readable to 1/8 in. (3.2 mm).

7.2 *Weights*—Two sets of weights and a device suitable for clamping the weights to the end of a tape sample, such that a total load of 4.0 lbf/in. (17.8 N/25 mm) and 10 lbf/in. (44.5 N/25 mm) can be achieved.

8. Test Specimen

8.1 Cut a test specimen 23 in. (580 mm) in length of tape removed from the sample roll, with care being taken not to touch the adhesive surfaces to be tested.

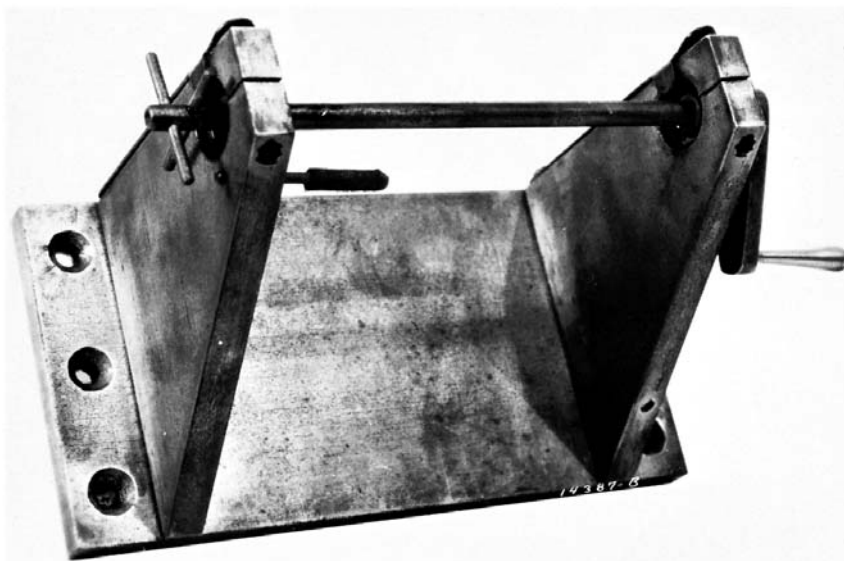


FIG. 1 Tester for Adhesion Test of Friction Tape

9. Procedure

- 9.1 Insert one end of the specimen into the slot of the mandrel and wind 2 in. (51 mm) onto the mandrel.
- 9.2 Attach a total weight of 10 lbf/in. (44.5 N/25 mm) to the end of the specimen and wind the remaining 19 in. (480 mm) of the specimen onto the mandrel at an approximate rate of 12 in./min (300 mm/min).
- 9.3 Allow the tape to remain for 3 min with the weight attached, after which substitute a weight of 4.0 lbf/in. (17.8 N/25 mm) and allow the tape to unwind.
- 9.4 After the first 2 in. (51 mm) have unwound, start a timer. Stop the unwinding process after 60 s have elapsed, and measure the length which has unwound in that time.

10. Report

- 10.1 For each sample roll, report the adhesion as the length unwound in one minute.

11. Precision and Bias

- 11.1 *Precision*—This test method has been in use for many years, but no information has been presented to ASTM upon which to base a statement of precision. No activity has been planned to develop such information.
- 11.2 *Bias*—This test method has no bias because the value for adhesion is determined solely in terms of this test method itself.

AGED ADHESION

12. Significance and Use

- 12.1 The adhesion of a friction tape must remain adequate after the tape has aged. Exposure in a dry oven is an attempt to simulate such shelf-storage aging.

13. Apparatus

- 13.1 *Oven*—An oven conforming to the requirements of Specification D5423.
- 13.2 *Adhesion Tester*, in accordance with 7.1.
- 13.3 *Weights*, in accordance with 7.2, except that a total load of 3 lbf/in. (13.3 N/25 mm) instead of 4 lbf/in. (17.8 N/25 mm) can be achieved.

14. Test Specimen

- 14.1 Prepare the test specimen as described in Section 8.

15. Procedure

- 15.1 Expose the specimen to dry air in an oven at a temperature of 212 ± 2 °F (100 ± 1 °C) for a period of 16 h. Support the specimen in the oven by clips or other suitable devices, in such a way that the adhesion test portion hangs free and out of contact with oven parts or other tape specimens.
- 15.2 After aging, allow the specimens to condition at a temperature of 73.4 ± 2 °F (23 ± 1 °C) and 50 ± 2 % relative humidity for a period of not less than 4 h nor more than 8 h, during which the adhesive surface shall be protected from contact with foreign material.
- 15.3 Test the specimen for adhesion following the procedure of Section 9, except that the load applied to unwind the tape shall be 3 lbf/in. (13.3 N/25 mm) and not 4 lbf/in. (17.8 N/25 mm).

16. Report

- 16.1 For each sample roll, report the aged adhesion as the length unwound in one minute.

17. Precision and Bias

- 17.1 *Precision*—This test method has been in use for many years, but no information has been presented to ASTM upon which to base a statement of precision. No activity has been planned to develop such information.
- 17.2 *Bias*—This test method has no bias because the value for aged adhesion is determined solely in terms of this test method itself.

BREAKING STRENGTH

18. Significance and Use

- 18.1 The breaking strength of the tape is an indicator of uniform quality and the ability to withstand mechanical load in service.

19. Apparatus

- 19.1 *Tensile Testing Machine*—A constant rate of elongation type tensile machine as described in Test Methods D412.