

[Metric]
A-A-180C
July 24, 1997
Superseding
A-A-180B
February 2, 1989

COMMERCIAL ITEM DESCRIPTION
TAPE, PRESSURE-SENSITIVE ADHESIVE
DOUBLE-COATED

The General Services Administration has authorized the use of this commercial item description by all Federal agencies.

1. **Scope:** This Commercial Item Description covers double-coated tapes used for mounting photos, drawings, mounting plates used for identification, decoration, holding heavier items, such as nameplates on doors or walls.

2. **Classification:**

Type - I. - Transparent film base

Class 1. - With liner

Class 2. - Without liner

Type - II. - Opaque paper base, with liner.

Grade A. - Regular holding power

Grade B. - High holding power

3. **Salient Characteristics:**

3.1 **Material.** The tape shall conform with the requirements specified in accordance with Table 1.

3.2 **Workmanship.** The tape shall be uniformly constructed and free from defects which may impair usefulness of the material for the intended use. The adhesive shall be coated in a smooth uniform layer over the entire surface of both sides of the tape backing. The tape shall be evenly and tightly wound with no voids. The edges of the roll shall be clean cut. When unwound, the tape shall not tear nor shall the adhesive separate from the backing.

Beneficial comments, recommendations, additions, deletions, clarifications, etc. and any data which may improve this document should be sent to General Services Administration, Federal Supply Service, Engineering Branch, 26 Federal Plaza, New York, NY 10278.

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Table 1.
Physical Properties

	Type I		Type II		Test Method
	Class 1	Class 2	Grade A	Grade B	
Tensile (lb/in) Width, minimum	280.2 N/100 mm (16 lb/in)	280.2 N/100 mm (16 lb/in)	262.6 N/100 mm (15 lb/in)	437.8 N/100 mm (25 lb/in)	ASTM D3759
Holding Power, minutes at 49 degrees Celsius, minimum	-	-	-	2.0	ASTM D3654 Procedure C see section 5.2.1
Adhesion (oz/in) width, minimum a) Initial	27.36 N/100 mm (25 oz/in)	27.36 N/100 mm (25 oz/in)	27.36 N/100 mm (25 oz/in)	54.72 N/100 mm (50 oz/in)	ASTM D3330 Method B;
b) After accelerated aging	21.89 N/100 mm (20 oz/in)	21.89 N/100 mm (20 oz/in)	27.36 N/100 mm (25 oz/in)	54.72 N/100 mm (50 oz/in)	Type I-1/; see section 5.2.2 Type II, see ASTM D3611
Adhesion to liner (oz/in) width, maximum a) Initial	27.36 N/100 mm (25 oz/in)	-	16.41 N/100 mm (15 oz/in)	16.41 N/100 mm (15 oz/in)	ASTM D3330, Method C;
b) After accelerated aging	21.89 N/100 mm (20 oz/in)	-	21.89 N/100 mm (20 oz/in)	21.89 N/100 mm (20 oz/in)	Type I-1/; see section 5.2.2 Type II, see ASTM D3611

4. Regulatory Requirements: The offerer/contractor is encouraged to use recovered materials to the maximum extent practicable, in accordance with paragraph 23.403 of the Federal Acquisition Regulation (FAR).

5. Quality Assurance Requirements:

5.1 Product Conformance. The product shall meet the salient characteristics of this commercial item description, conform to the producer's own drawings, specifications, standards and quality assurance practices and be the same product offered for sale in the commercial market. The government reserves the right to require proof of such conformance.

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5.2 Testing. Testing shall be in accordance with ASTM D 3715 Section 6 with an AQL of 4 percent defective. The sample unit shall be one roll of tape.

5.2.1 Holding Power Test: The holding power test specimen shall be (1/2 inch) 1.27 cm wide, and the area of test on the panel shall be a (1/2 in.) 1.27 cm by (1/2 in.) 1.27 cm square area. The test shall be performed at 49 degrees Celsius using a 500-g load. Both sides of the tape shall be tested. The specimen shall be prepared for the face side test by removing the liner and adhering the tape liner side to a 1-mil thick polyester film and then cutting a (1/2 inch) 1.27 cm wide specimen. The specimen for the liner side test shall be prepared by first adhering the tape face side to a 1-mil thick polyester film, The liner shall then be removed and a (1/2 inch) 1.27 cm wide specimen cut.

5.2.2 1/ Accelerated Aging: (Type I tape only) - Two specimens per test roll are required. Each specimen shall be at least (1/2 inch) 1.27 cm wide and (10 inches) 25.4 cm long. Place (4 inches) 10.16 cm of one specimen, adhesive side down, on a glass plate. Superimpose on each another specimen, adhesive side down, with the end projecting over the glass plate to serve as a starting tab. The starting tab is formed by doubling the adhesive side of the tape on itself. Arrange multiple specimens so that there is a free air space around them. Place a second glass plate over these strips. Add a 1,000 gram weight on the upper glass plate. Place in a container and environment described in ASTM D 3611, and place the assembly in a 49 (1 degree Celsius) oven. Remove assembly from the oven at the end of 30 hours, remove the weight and upper glass plate, and expose the remainder to a temperature of 23 (2 degree Celsius) and a relative humidity of 50 ± 2 percent until equilibrium is achieved. Remove the superimposed tape, and observe and report as a failure any adhesive stringiness or offsetting and any tearing or delamination of the backing. Perform the test for adhesion and adhesion to liner.

6. Packaging: Preservation, packing and marking shall be specified in the contract or order.

7. Notes:

7.1 Source of Documents. The following documents form a part of the Commercial Item Description to the extent specified herein. Unless otherwise indicated, the issue in effect on the date of invitation for bids or request for proposal shall apply:

7.1.2 American Society of Testing and Materials (ASTM) standard test methods can be obtained from, at 100 Barr Harbor Dr., West Conshohocken, PA 19428-2959.

7.1.3 Federal Acquisition Regulation (FAR) may be obtained from the Superintendent of Documents, Government Printing Office, Washington, DC 20402.

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7.2 Ordering Data: Purchasers should select the preferred options permitted herein, and include the following information in procurement documents:

A - Title, number and date of this specification.

B - Style and Size required.

7.3 National Stock Number Listing (NSN's). The following is a list of NSN's assigned which correspond to this CID. The list may not be indicative of all possible NSN's associated with the CID.

7510-00-904-2663

7510-00-935-5848

Civil Agency Coordinating Activities:

DOT
NASA

Preparing Activity:

GSA-FSS