

INCH-POUND

MIL-I-24391C  
AMENDMENT 1  
5 August 1991

**MILITARY SPECIFICATION**

**INSULATION TAPE, ELECTRICAL, PLASTIC PRESSURE-SENSITIVE**

This amendment forms a part of Military Specification MIL-I-24391C, dated 9 March 1990, and is approved for use by all Departments and Agencies of the Department of Defense.

**PAGE 5**

**3.4.1: Delete and substitute:**

"3.4.1 Marking of the rolls. Each roll of tape shall be marked with numerals or letters indicating the month and year of manufacture. Manufacturing date information shall appear in one of the following locations: (1) inside the core, (2) on core end surface, (3) on the side (edge) of the tape adjacent to the core."

**3.4.1.1: Add as new paragraph.**

"3.4.1.1 Marking of the cores. The manufacturer's name and designation of product shall be stamped or printed on the inside of the core. In addition when acquisition is from a distributor/rebrander, the distributor's name and designation of product shall be stamped or printed on the inside of the core. Alternatively (at the option of the distributor/rebrander) it shall be printed on a rectangular label which can be affixed to the inside of the core. Such label shall not exceed the width of the core or 1/2 the inside circumference of the core and shall not obscure the original manufacturer's name and product designation."

AMSC N/A

FSC 5970

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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TABLE II, Under "Property column" for "Shelf storage (2 years)", delete Units and Requirements entries and substitute the following:

"Shall conform to: Adhesion to backing, Unrolling at 23°C, and Breaking strength. No excessive adhesive flow on sides, no telescoping greater than 3/32 inch, no gapping greater than 3/64 inch."

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4.4.1: Delete and substitute:

"4.4.1 Lot. For the purposes of inspection sampling, a lot shall consist of all tape, of the same type, width and color produced in one facility using the same production processes, equipment, and materials, and being offered for delivery at one time."

4.4.1.1: Add as new paragraph.

"4.4.1.1 Quality conformance inspection sampling. As a minimum, the contractor shall randomly select sample quantities of rolls of tape from each lot in accordance with Tables III, IV, and V and inspect them in accordance with 4.4.2.1, 4.4.2.2, 4.4.2.3 and 4.4.3. If one or more defects are found in any sample, the entire lot shall be rejected. The contractor has the option of screening 100 percent of the lot for the defective characteristic(s) or providing a new lot which shall be inspected in accordance with the sampling plan contained herein."

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TABLE III: Delete and substitute:

"TABLE III. Sample size for appearance and construction examination

Lot size		Sample size
2	- 15	2
16	- 25	3
26	- 90	5
91	- 150	6
151	- 280	7
281	- 500	9
501	- 1200	11
1201	- 3200	13

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3201 - over

15"

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TABLE IV: Delete and substitute:

"TABLE IV. Sample size for examination of dimension, workmanship, and appearance.

Lot size	Sample size
1 - 25	3
26 - 50	5
51 - 90	6
91 - 150	7
151 - 280	10
281 - 500	11
501 - 1200	15
1201 - 3200	18
3201 - 10000	22
10001 - over	29"

4.4.2.3: Delete and substitute:

"4.4.2.3 Examination of the assembled rool tape for defect in workmanship and appearance. The assembled roll tape selected in accordance with table IV shall be examined for defects in workmanship and appearance as follows:

Examinations

Defects

Workmanship

Adhesive coating not evenly and smoothly applied over entire area of one side of backing; any bare spots or lumps.

Appearance

Roll telescoped, uneven, presence of liner, adhesive side exposed on roll. Roll not tightly wound, gaps in adjacent turns. Roll contains more than two splices."

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4.4.2.4, Add to the end of this paragraph the following:

"If one or more defects are found during examination of packaging, the entire lot of containers shall be rejected. The contractor has the option of screening 100 percent of the containers for the defective characteristic(s) or providing a new lot which shall be inspected in accordance with the sampling plan

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contained herein."

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TABLE V: Delete and substitute:

"TABLE V. Sample size for quality conformance tests.

Lot size		Sample size
2	- 50	5
51	- 500	16
501	- 35000	35
35001	- over	40"

PAGES 14 AND 15

TABLE VI: Delete and substitute:

"TABLE VI. Instructions for testing (sample unit).

Characteristic or Property	Specifications		Requirements applicable to individual unit	Results determined as	
	Requirement	Test methods		Pass or fail	Numerically to nearest
Breaking strength	Table II	4.6.2	X	-	.01 pound per inch width
Dielectric breakdown after 70°C exposure	Table II	4.6.3	X	-	25 volts
Adhesive	Table II	4.6.8	X	-	.01 pound per inch width
High humidity insulation resistance	Table II	4.6.8	X	-	Megohms
Flammability	Table	4.6.9	X	-	Seconds
Visual	-	-	-	1/	-

1/ Visual examination for excessive adhesive flow and telescoping of 3/32 inch maximum."

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6.6: Delete in its entirety.

6.6.1: Delete in its entirety.

TABLE VIII: Delete in its entirety.

6.6.2: Delete in its entirety.

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TABLE IX: Delete in its entirety.

6.6.3: Delete in its entirety.

TABLE X: Delete in its entirety.

Preparing activity:  
Navy - SH  
(Project 5970-1089)

Custodians:

Army - ER

Navy - SH

Air Force - 11

Review activities:

Army - EA

Navy - EC, OS

DLA - GS

NASA - DS

User activities:

Army - ME

Navy - MC, YD, CG