

MIL-T-23397B

11 December 1970

SUPERSEDING**MIL -T-23397A(ASG)**

23 August 1963

MILITARY SPECIFICATION**TAPES, PRESSURE SENSITIVE ADHESIVE, FOR MASKING
DURING PAINT STRIPPING OPERATIONS**

This specification is mandatory for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope - This specification covers tapes for masking during paint stripping operations (see 6.1).

1.2 Classification -

1.2.1 Types - The masking tapes shall be of the following types, as specified (see 6.2):

Type I - Three-hour protection

Type II - Seventy-two-hour protection

1.2.2 Sizes (widths) - The tapes shall be 1, 2, or 3 inches wide, as specified (see 6.2).

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on date of invitation for bids or request for proposal, form a part of the specification to the extent specified herein:

SPECIFICATIONS**Federal**

QQ-A-250/5	Aluminum Alloy Alclad 2024, Plate and Sheet
TT-R-248	Remover, Paint and Lacquer, Solvent Type
PPP-T-680	Tape, Pressure Sensitive Adhesive, Packaging and Packing of

FSC 8030

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SPECIFICATIONS (Continued)

Military

MIL-B-131	Barrier Material; Water Vaporproof, Flexible
MIL-P-5425	Plastic, Sheet, Acrylic, Heat Resistant
MIL-P-7962	Primer Coating, Cellulose-Nitrate Modified Alkyd Type, Corrosion Inhibiting, Fast Drying (For Spray Application Over Pretreatment Coating)
MIL-C-8514	Coating Compound, Metal Pretreatment, Resin-Acid
MIL-A-8625	Anodic Coatings, For Aluminum and Aluminum Alloys
MIL-L-19537	Lacquer; Acrylic-Nitrocellulose, Gloss (For Aircraft Use)
MIL-C-22750	Coating, Epoxy-polyamide
MIL-P-23377	Primer Coating, Epoxy-polyamide, Chemical and Solvent Resistant
MIL-R-81294	Remover, Paint, Epoxy System

STANDARDS

Federal

Fed. Test Method Std. No 147	Tapes, Pressure-Sensitive and Gummed; Methods of Inspection, Sampling and Testing
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Military

MIL-STD-105	Sampling Procedures and Tables for Inspection by Attributes
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(Copies of specifications, standards, drawings, and publications required by suppliers in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. REQUIREMENTS

3.1 Material - The tapes shall consist of backing coated on one side with a pressure-sensitive adhesive requiring no moisture, heat, or other special preparation prior to application.

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3.1.1 Backing - The backing shall be uniform in texture and shall perform satisfactorily as a masking tape when used with paint stripping compounds referenced herein (see 6.1.1 and 6.1.2).

3.1.2 Adhesive - The adhesive shall be pressure-sensitive, water insoluble, homogeneous, and coated in a smooth and evenly distributed layer on one side of the backing. The adhesive shall cause the tapes to adhere immediately and firmly to clean, dry surfaces to which the tape is generally applied for masking in paint stripping operations, without wrinkling, curling, breaking, or lifting. There shall be no separation of the adhesive from the backing upon unwinding the rolls or upon removal from surfaces after application of paint stripping materials. There shall be no liner over the adhesive.

3.2 Finished tape -

3.2.1 Rolls - The tapes shall be uniformly and smoothly wound in rolls, with the adhesive side in, on suitable cores having an inside diameter of 3 - 0, + 1/16 inches. The cores shall have sufficient rigidity to prevent distortion of the roll under normal conditions of use. The tapes shall be in one continuous strip, except that any single roll may contain three splices, provided the percentage of spliced rolls in any shipment does not exceed a reasonable proportion based upon standard manufacturing practice. The length of tape in the rolls shall be not less than 60 yards.

3.2.2 Width - The width shall be as specified in the contract or order. Tolerances of + 1/16 inch, - 1/32 inch will be allowed.

3.2.3 Marking of rolls - Each roll of tape furnished on Government order or contract shall be marked in or on the edge of the core with numerals or letters indicating the month and year of manufacture. In addition, the manufacturer's name and designation of the product shall be stamped in the core.

3.3 Performance - The tape shall conform to the requirements of Table I, when tested as specified in Section 4.

TABLE I

PHYSICAL PROPERTIES

Test	Type I requirement	Type II requirement	Test paragraph
Unwind (lbs/in. width), max.	2.0	3.0	4.4.1
Tensile strength (lbs/in. width), min.	20	22	4.4.1

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TABLE I (Continued)

Test	Type I requirement	Type II requirement	Test paragraph
Elongation, percent, max.	25	-	4.4.1
Water solubility	2.0 percent (max.)	2.0 percent (max.)	4.4.1
Adhesion:			
To 2024 (alclad) aluminum (oz./in. width), min.	16	50	4.4.2
To painted surface (acrylic) (oz./in. width), min.	15	50	4.4.2
To backing (oz./in. width), min.	8	25	4.4.2
Resistance to paint stripping compounds	No optical changes in the test panel due to softening or crazing attack by the stripper compound.		4.4.3
Resistance to paint stripping and cleaning	No optical changes in the test panel due to softening or crazing attack caused by ingress of the stripper compound. No adhesive mass transfer to the aluminum panel of the first layer of tape applied.		4.4.4

3.4 Workmanship - The adhesive shall be smooth, uniform coating covering the entire area of one side of the tape. Edges of the tape shall be straight, true, and unbroken. Tape shall adhere to the work snugly, without wrinkling, curling, lifting, or buckling.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection - Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved

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by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Inspection of components and materials - In accordance with 4.1 above, the supplier is responsible for insuring that materials and components used were manufactured, tested and inspected in accordance with the requirements of referenced subsidiary specifications and standards to the extent specified or, if none, in accordance with this specification. In the event of conflict, this specification shall govern.

4.2 Quality conformance inspection - Quality conformance inspection of the end item shall be conducted in accordance with Table II for the characteristics as indicated therein on each lot which is to be submitted for Government acceptance.

4.2.1 Lot for quality conformance inspection - The lot size, for the purpose of determining the number of sample units for testing, shall consist of all tape of the same type, manufactured by the same process, from the same components at one time at one plant by one manufacturer, under the same conditions within a weekly period.

4.2.2 Samples for quality conformance inspection - The sample unit as referenced herein is defined as the amount of tape required to perform all of the tests required. A sample unit shall consist of three two-inch rolls of tape of specified type randomly selected from each lot presented for examination. The lot size shall be expressed in units of rolls. The sampling shall be as follows:

<u>Lot size in rolls</u>	<u>Sample unit</u>
1000 or less	3
1001 to 10,000	5
10,001 or more	7

Failure of any sample unit to meet the requirements shall be cause for rejection of the lot. In the event that the lot does not contain rolls of tape of the width required for test samples, the manufacturer shall supply tape of the required width for use as test samples. The additional tape shall be made by the same process, from the same components, and by the same manufacturer as the tape of the lot being tested.

4.2.3 Shipment from a previously accepted inspection lot may be accepted without reinspection and may be released upon presentation of the test report for the lot.

4.2.4 Examination of the end item - Sampling for the end item examination shall be performed in accordance with the provisions set forth in MIL-STD-105. The end item shall be examined in accordance with the list of defects, inspection levels,

TABLE II
QUALITY CONFORMANCE INSPECTION INSTRUCTIONS

Test	Type		Specification reference		Requirements applicable to		Results reported as	
	I	II	Requirement	Test method	Individual sample unit	Lot average	Pass or fail	Numerically to nearest
Unwind	X	X	Table I	4.4.1	X	-		lbs./in. width
Tensile strength	X	X	Table I	4.4.1	X	-		lbs./in. width
Elongation	X		Table I	4.4.1	X	-		percent
Water solubility	X	X	Table I	4.4.1	X	-		percent
Adhesion:			Table I					oz./in. width
To 2024 (alclad) aluminum	X	X		4.4.2	X	-		
To painted surface	X	X		4.4.2	X	-		
To backing	X	X		4.4.2	X	-		
Resistance to paint stripping compounds	X	X	Table I	4.4.3	X	-	X	-
Resistance to paint stripping and cleaning	X	X	Table I	4.4.4	X	-	X	-

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and acceptable quality levels (AQL's) set forth below. No more than two rolls, randomly selected, shall be drawn from any one shipping container from each lot of material for each type of tape offered for acceptance for visual and dimensional characteristics. The lot size for purposes of determining the sample size in accordance with MIL-STD-105 shall be expressed in units of rolls for examinations under 4.2.4.1 through 4.2.4.3 inclusive and in units of shipping containers for examination under 4.2.4.4, of the specified type of tape.

4.2.4.1 Examination of the end item for defects in appearance and workmanship - The sample unit for this examination shall be one roll. One yard shall be taken from each roll for this examination.

<u>EXAMINE</u>	<u>DEFECT</u>
Appearance	Tape does not consist of a backing with a coating of adhesive on one side only.
	Dirty areas or spots.
	Holes, tear, cut, cracks, or sharp creases.
	Non-clean cut, broken, uneven or sticky edges.
Workmanship	Adhesive coating not evenly and smoothly applied over entire area of one side of backing; any bare spots or lumps

4.2.4.2 Examination of the end item for defects in construction - The sample unit for this examination shall be one roll.

<u>EXAMINE</u>	<u>DEFECT</u>
Tape on rolls	Rolls not uniformly and smoothly wound; not wound on suitable core; core not same width as tape.
	Adhesive side not wound on inside of roll.
	Core crushed, broken, mutilated, or collapsed.
	Markings omitted, incorrect, incomplete, illegible, or not as specified.
Unwinding of rolls (Three rolls maximum shall be used for the total unwind examination)	Does not unwind evenly and uniformly without ravelling.
	Backing breaks, delaminates, or splits during unwinding.
	Tape wound unevenly causing wrinkles or crease within the roll.

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<u>EXAMINE</u>	<u>DEFECT</u>
Unwinding of rolls (three rolls maximum shall be used for the total unwind examination)	When unwound, tape sticks together to the extent that un-rolling causes tearing or injury to surface; adhesive separates from backing; adhesive material removes color coating from back of adjacent layer.
(Continued)	Length less than 60 yards. Roll not continuous (3 splices permitted). (The length of the roll, in the relaxed state, shall be determined at this time.)

4.2.4.3 Examination of the end item for dimensional defects - The sample unit for this examination shall be one roll.

<u>EXAMINE</u>	<u>DEFECT</u>
Width of tape	Varies by more than +1/16 inch or -1/32 inch from width specified.
Cores	Inside diameter of core greater than 3-1/16 inches, or less than 3 inches.

4.2.4.4 Examination of the end product for defects in packaging, packing, and markings - An examination shall be made to determine that packaging, packing, and markings as required by Section 5 of this specification are complied with. The sample unit for this examination shall be one shipping container.

<u>EXAMINE</u>	<u>DEFECT</u>
Packaging (as applicable)	Not level specified; not in accordance with contract requirements.
Individual roll (when specified)	Not individual-roll packaged and adequately secured as specified; centering device omitted. Packaging material not as specified; closures not accomplished by specified or required methods or materials.
Packing (as applicable)	Not level specified; not in accordance with contract requirements.
Multiple roll (when specified)	Not packaged as specified; not adequately secured in position; centering device omitted if required; waxed paper (or equivalent) separators missing from between rolls.

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<u>EXAMINE</u>	<u>DEFECT</u>
Multiple roll (when specified) (Continued)	Packaging material not as specified; closures not accomplished by specified or required methods or materials. Container material damaged or not as specified. Closures not accomplished by specified or required methods or materials.
Count	Number of rolls per container less than indicated.
Weight (interior and exterior)	Gross or net weight exceeds specification requirements.
Markings (interior and exterior)	Markings not in accordance with 5.3.

4.2.4.5 Inspection levels and acceptable quality levels (AQL's) for examination of the end item - The inspection levels for determining the sample size and the acceptable quality levels (AQL's), expressed in defects per 100 units, shall be as specified in Table III.

TABLE III
INSPECTION LEVELS AND AQL'S

Examination paragraph	Inspection levels	AQL
4.2.4.1	S-3	2.5
4.2.4.2	S-2	4.0
4.2.4.3	S-2	4.0
4.2.4.4	S-2	4.0

NOTE: The same rolls of tape shall be used for examinations under 4.2.4.1 through 4.2.4.3, inclusive. The yardage used for examination under 4.2.4.1 and the rolls used for examination under 4.2.4.2 and 4.2.4.3 shall be within the rolls randomly selected under 4.2.4.1. The samples shall be selected initially for examination under 4.2.4.1 to provide sample rolls for examination under 4.2.4.2 and 4.2.4.4 inclusive. The containers, from which the sample rolls are selected, shall also be used for the packing and marking examination.

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4.3 Test conditions -

4.3.1 Sample rolls - The first three turns of tape shall be removed and discarded from each sample roll of tape prior to testing.

4.3.2 Conditioning - All tape selected for testing shall be conditioned for 24 hours at $73 \pm 3.5^\circ \text{F}$ and 50 ± 5 percent relative humidity and shall be tested under these conditions, unless otherwise specified in the method of test.

4.3.3 Device for application of tapes - The device for application of the tapes for test purposes shall consist of a horizontally mounted, free turning roller as specified below:

Type I

Total weight	4.50 \pm 0.1 pounds
Width	1.75 \pm 0.05 inches
Diameter	3.25 \pm 0.1 inches

The roller shall be faced with 1/4 inch of rubber with a Shore A durometer hardness of 75 to 85 giving a total roller diameter of approximately 3.75 inches.

Type II

Total weight	10 \pm 0.1 pounds
Width	1.875 \pm 0.1 inches
Total diameter	5 \pm 0.0312 inches

The rollers shall be propelled lengthwise back and forth over the tape at the rate of 12 inches per minute in such a manner that only the weight of the roller rests on the tape. The device may be either manually or mechanically operated. The adhesive side of the tape shall not be touched during application. For referee purposes the device shall be mechanically operated.

4.3.4 Test specimens - Three feet of tape shall be removed from the running end of each roll for the initial starting point. Five feet of tape shall then be removed and discarded. One specimen for each requirement shall then be taken. This procedure shall be continued, with 5-foot intervals between sample groups, until the required number of specimens is obtained.

4.3.5 Panel preparation - The test panels shall be fabricated from aluminum-clad aluminum alloy conforming to QQ-A-250/5 and anodized in accordance with MIL-A-8625. Spray one coat of wash primer, MIL-C-8514, to a dry film thickness of 0.2 to 0.3 mils, and air dry for 30 minutes. Then overspray with one coat of lacquer primer conforming to MIL-P-7962, to a dry film thickness of 0.2 to 0.3 mils and air dry for 30 minutes and not more than 5 hours. The final coating shall

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consist of 2 spray coats of acrylic nitrocellulose insignia white lacquer conforming to MIL-L-19537, with a 30-minute drying time between coats, and a 45-minute final drying time. The total film thickness, including primers, shall be 1.2 to 1.7 mils.

4.3.5.1 Panel preparation (Alternate epoxy coating) - When specified, aluminum test panels shall be coated with an epoxy system in lieu of the acrylic system as follows: Spray one coat of epoxy primer, MIL-P-23377, to a dry film thickness of 0.6-0.9 mils, and air dry for one hour. Then apply 2 spray coats of insignia white epoxy-polyamide coating, MIL-C-22750. Apply the first coat as a mist coat (not full hiding) and allow to dry for 30 minutes. Apply a second coat of insignia white epoxy-polyamide coating and allow to air dry for 48 hours. The total dry film thickness, including primer, shall be 2.2-2.6 mils.

4.4 Test methods -

4.4.1 The following tests shall be made in accordance with Fed. Test Method Std. No. 147:

<u>Test</u>	<u>Method No.</u>
Unwind	80.1
Tensile breaking and Elongation	30.1
Water Solubility	74.1

4.4.2 Adhesion -

4.4.2.1 Type I - The adhesion of Type I tape shall be determined as described in Method 10.1 of Fed. Test Method Std. No. 147, except that the test panel shall be aluminum-clad aluminum alloy conforming to QQ-A-250/5, and shall be painted as described in 4.3.5.

4.4.2.2 Type II - The adhesion of Type II tape shall be determined as described in 4.4.2.1, except that a 10-pound roller as described in 4.3.3 shall be used. The roller shall be passed five times each way over the test specimen.

4.4.2.3 Adhesion to backing - The adhesion to backing shall be determined as described in 4.4.2.1 and 4.4.2.2, except that the test panel shall first be covered with a strip of tape under test. The adhesion specimen shall then be applied to the strip of tape.

4.4.3 Resistance to paint stripping compounds -

4.4.3.1 Type I (Three-hour protection) - On a 4- by 4- by 1/8-inch flat acrylic plastic panel conforming to MIL-P-5425, center at least a 2- by 4- inch strip of Type I tape. Apply paint stripping compound conforming to TT-R-248 to the center

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of the tape's backing in approximately a 1-inch diameter circle. Allow the stripper to remain for 3 hours, and then remove the test tape from the plastic panel. Hold the acrylic panel (its test surface up) in a plane parallel to and in line with the eyes of the observer and a light source. Rotate the panel back and forth about an imaginary axis which is located along the panel edge closest to the observer. As the angle of incidence changes, carefully observe the area under where the paint stripping compound was applied to the tape backing. Look for any optical changes in the acrylic due to softening or crazing attack.

4.4.3.2 Type II (72-hour protection) - Apply Type II tape to two panels as described in 4.4.3.1. Apply MIL-R-81294 to one panel, and TT-R-248 to the second panel, as described in 4.4.3.1. Allow paint stripping compounds to remain for 72 hours before removing the tapes. Examine the test panels for effect of stripping compounds as described in 4.4.3.1.

4.4.4 Resistance to paint stripping and cleaning - Prepare 12-by 12-inch test panels as described in 4.3.5. Center a 2- by 2-inch piece of acrylic plastic panel conforming to MIL-P-5425 on the painted aluminum panel. Place a 5- by 5-inch mask of barrier material conforming to MIL-B-131, Type I, with its foil side up over the acrylic plastic. Employ a plastic squeegee and use the two-layer tape system to hold the barrier material in place. Apply either the Type I tape or the Type II tape in the following manner:

- (a) The first layer of tape consists of four 2- by 7-inch strips. Apply one strip of tape along the top edge of the barrier material, so that one inch of the tape's width adheres to the aluminum panel and the other inch adheres to the barrier material. In the same manner, apply a second strip of test tape along the bottom edge and then the other two test strips on the two remaining edges. The first layer of type must be completed before the second layer can be started.
- (b) The second layer of tape consists of four 2- by 9-inch strips. Apply one strip of tape along the top outside edge of the first tape layer so that one inch of the tape's width adheres to the aluminum panel and the other inch adheres to the first layer of tape. In the same manner, apply a second strip of test tape along the bottom edge and then the other two test strips on the two remaining edges.

After applying each strip of tape, firmly rub it down with the plastic squeegee. Allow the completed panel to dwell for 24 hours.

4.4.4.1 Type I (Three-hour protection) - Cover the entire surface area of the test panel prepared as described in 4.4.4 with paint stripping compound TT-R-248. Keeping the test panel horizontal, allow the paint stripping compound to remain for three

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hours. An apparatus consisting of a hose (I.D. = 1/2 inch) and a nozzle with an orifice (I.D. = 3/16 inch) shall be used to clean the test panel. Clean each panel by directing at a 45-degree angle a stream of water (160° F and 10 psi) at the edge where the tape overlaps the barrier material. Hold the nozzle 6 to 8 inches away from the panel. Starting in the lower left hand corner, direct the stream twice around the entire edge of the barrier material and tape. Repeat the procedure at the edge where the tape meets the painted aluminum surface. After thoroughly removing all stripping compounds, allow the panel to dry for 30 minutes. Remove the test tape and masking barrier and examine:

- (a) The acrylic plastic panel for attack caused by ingress of the stripper compounds using the method described in 4.4.3.1.
- (b) The aluminum panel for adhesive mass transfer.

4.4.4.2 Type II (72-hour protection) - Apply MIL-R-81294 to one panel, and TT-R-248 to a second panel as described in 4.4.4.1. Allow the paint stripping compounds to remain on the test panels for 72 hours. Clean and examine the panels as described in 4.4.4.1.

5. PREPARATION FOR DELIVERY

5.1 Packaging - Packaging shall be Level A or C as specified (see 6.2).

5.1.1 Levels A and C - Unless individual roll packaging is specified, tape, put-up as specified, shall be multiple roll packaged in accordance with the applicable requirements of PPP-T-680.

5.2 Packing - Packing shall be Level A, B, or C as specified (see 6.2).

5.2.1 Levels A, B, and C - Unless otherwise specified, tape shall be multiple roll packed in accordance with the applicable requirements of PPP-T-680.

5.3 Marking - In addition to the marking specified in PPP-T-680, the containers shall be marked with any special markings required by the contract or order.

6. NOTES

6.1 Intended use - The tapes are intended for masking purposes during paint stripping operations. They are designed to protect aircraft surfaces against the affects of both alkaline and acid type paint removers and must be capable of resisting the paint remover without any infiltration through the tape or seepage under it. The tape is designed to have no deleterious effect on materials used in aircraft construction.

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6.1.1 Type I - Type I tape is intended for use on applications where the paint stripping compound will be in contact with the tape for up to three hours. The only stripping compound that Type I is compatible with is TT-R-248. Do not use with other types of stripping compounds without prior testing as described in 4.4.3 and 4.4.4.

6.1.2 Type II - Type II tape is intended for use in masking operations where stripping compounds conforming to MIL-R-81294 and TT-R-248 are applied for periods up to 72 hours. To determine the tape's resistance to other stripping compounds, test as described in 4.4.3 and 4.4.4.

6.2 Ordering data - Procurement documents should specify:

- (a) Title, number, and date of this specification.
- (b) Type and size (see 1.2).
- (c) Levels of packaging and packing and whether single or bulk packaging is required (see 5.1 and 5.2).

6.3 Storage of tape - Masking tape should be stored in a cool location. It should not be stored close to steam pipes, radiators, or other sources of heat.

Custodians:

Army - MR
Navy - AS
Air Force - 84

Preparing activity:

Navy - AS
(Project No. 8030-0272)

Review:

Navy - AS
Air Force - 84
Other - NSA

SPECIFICATION ANALYSIS SHEET		Form Approved Budget Bureau No. 22-R255
INSTRUCTIONS: This sheet is to be filled out by personnel, either Government or contractor, involved in the use of the specification in procurement of products for ultimate use by the Department of Defense. This sheet is provided for obtaining information on the use of this specification which will insure that suitable products can be procured with a minimum amount of delay and at the least cost. Comments and the return of this form will be appreciated. Fold on lines on reverse side, staple in corner, and send to preparing activity. Comments and suggestions submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or serve to amend contractual requirements.		
SPECIFICATION MIL-T-23397B TAPES, PRESSURE SENSITIVE ADHESIVE, FOR MASKING <div style="text-align: center;">DURING PAINT STRIPPING OPERATIONS</div>		
ORGANIZATION		
CITY AND STATE	CONTRACT NUMBER	
MATERIAL PROCURED UNDER A <input type="checkbox"/> DIRECT GOVERNMENT CONTRACT <input type="checkbox"/> SUBCONTRACT		
1. HAS ANY PART OF THE SPECIFICATION CREATED PROBLEMS OR REQUIRED INTERPRETATION IN PROCUREMENT USE? A. GIVE PARAGRAPH NUMBER AND WORDING.		
B. RECOMMENDATIONS FOR CORRECTING THE DEFICIENCIES		
2. COMMENTS ON ANY SPECIFICATION REQUIREMENT CONSIDERED TOO RIGID		
3. IS THE SPECIFICATION RESTRICTIVE? <input type="checkbox"/> YES <input type="checkbox"/> NO (If "yes", in what way?)		
4. REMARKS (Attach any pertinent data which may be of use in improving this specification. If there are additional papers, attach to form and place both in an envelope addressed to preparing activity)		
SUBMITTED BY (Printed or typed name and activity - Optional)		DATE

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