

MIL-T-23397B
AMENDMENT 2
16 July 1980
SUPERSEDING
AMENDMENT 1
7 June 1974

MILITARY SPECIFICATION

TAPES, PRESSURE SENSITIVE ADHESIVE, FOR MASKING
DURING PAINT STRIPPING OPERATIONS

This amendment forms a part of Military Specification MIL-T-23397B, dated 11 Dec. 1970, and is approved for use by all Departments and Agencies of the Department of Defense.

PAGE 1

1.2.2 Delete in its entirety and substitute:

"Sizes - The tapes shall be 1, 2, or 3, inches wide, or as specified in the contract or order (see 6.2)."

PAGE 3

3.2.1 Line 5: Place a period after "splices" and delete the remainder of the sentence.

PAGE 4

Table I: Delete in its entirety "Resistance to paint stripping and cleaning."

* Table I: Delete in column: Type II requirement, the value of 25 oz/in min for the test adhesion to backing and replace with the value of 18 oz/in min.

Table II: Delete in its entirety "Resistance to paint stripping and cleaning."

PAGE 11

4.4.3.1 Delete in its entirety and substitute:

"Type I (3-hour protection) - Thoroughly clean three 1" x 6" x 1/4" flat acrylic plastic panels conforming to MIL-P-5425 with a mild soap and rinse with clear water. Place panels in the slots of

FSC 8030

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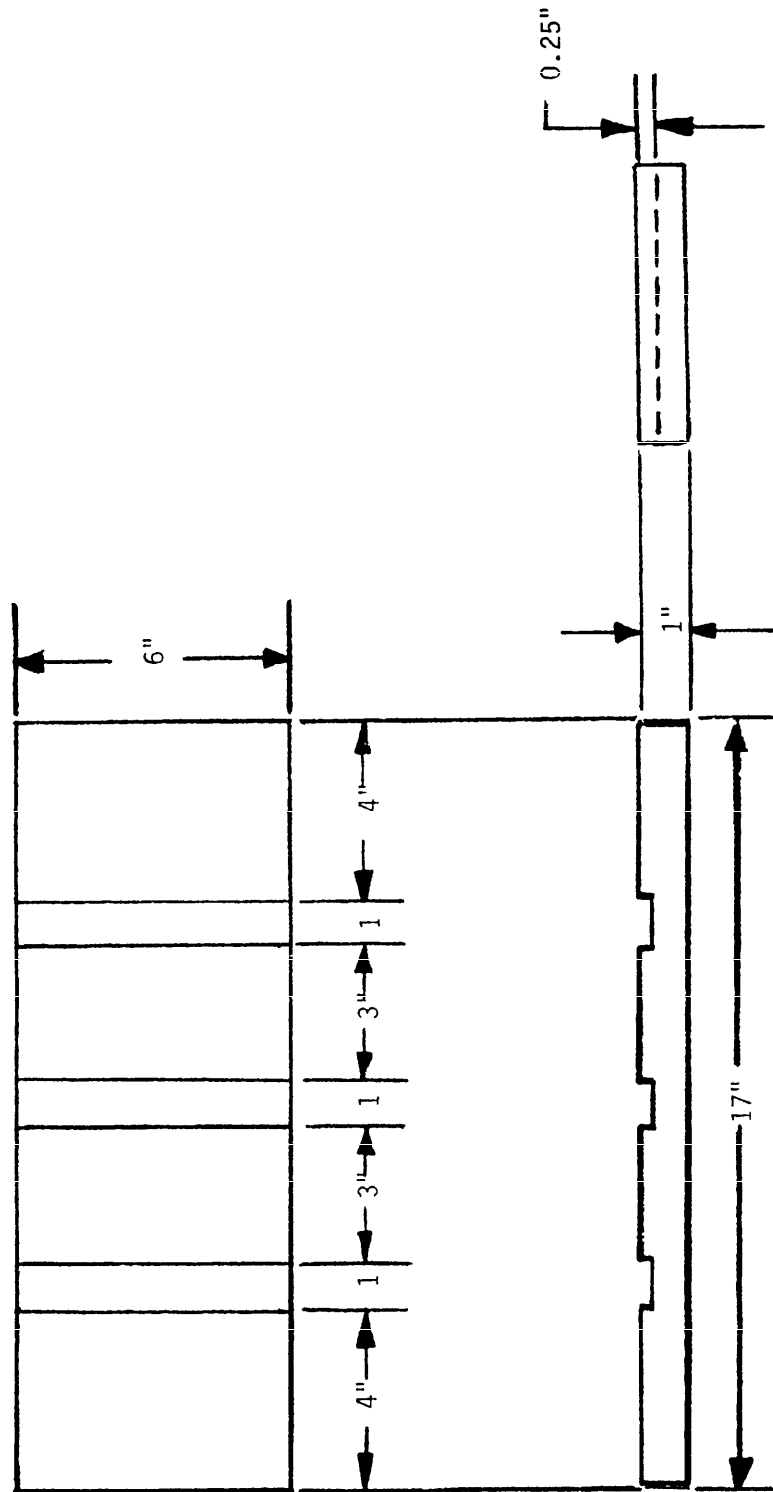


FIGURE 1. ALUMINUM TEST PANEL HOLDER

an aluminum plate, as shown in Figure 1. A single specimen panel holder can be used but the test must be run in triplicate. Remove approximately a nine inch strip of 2" wide Type I tape from the sample roll and center each strip onto the plastic test panels.

Rub tape down using firm hand pressure. Using the tape that is under test, build a wall around the 2" wide tape test strip. The tape wall shall be about 1/2 inch from the test tape so that the paint stripping compound will contact the bare metal plate and the test tape. Then apply paint stripping compound conforming to TT-R-248 over the tape strip backing to a depth of 1/4 inch. Allow the stripper to remain for 3 hours, and then remove the stripping compound with cool tap water (normal pressure) and remove the tape. Remove the acrylic panel and hold panel (test surface up) in a plane parallel to and in line with 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 all areas of the plastic panel. Look for any optical changes in the acrylic due to softening or crazing."

PAGE 12

4.4.3.2 Delete in its entirety and substitute:

"Type II (72-hour protection) - Apply Type II tape to the acrylic panels as described in 4.4.3.1. Apply paint stripping compound, conforming to MIL-R-81294, allow the stripper to remain for 72 hours, and remove stripper and examine test panels as described in 4.4.3.1."

4.4.4 Delete in its entirety.

4.4.4.1 Delete in its entirety.

PAGE 13

4.4.4.2 Delete in its entirety.

PAGE 14

6.1.1 Line 3: After "TT-R-248" add the following sentence. "For an anticipated exposure exceeding three hours use Type II tape."

6.1.1 Lines 4 and 5: Delete "and 4.4.4."

6.1.2 Delete in its entirety and substitute:

"Type II - Type II tape is intended for masking operations where stripping compounds conforming to MIL-R-81294 are used and where TT-R-248

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will be applied for periods exceeding 3 hours. To determine the tapes resistance to other stripping compound, test as described in 4.4.3."

6.4 Changes from previous issue. Asterisks are used in this amendment to identify changes with respect to the previous amendment.

Custodians:
Army - MR
Navy - AS
Air Force - 99

Preparing activity:
Navy - AS
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