



Standard Specification for Pressure-Sensitive Tape for Packaging, Box Closure, and Sealing^{1,2}

This standard is issued under the fixed designation D5486/D5486M; 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 This specification covers film, paper, and cloth pressure-sensitive tapes used for box closure and sealing.

1.2 The values stated in either inch-pound or SI units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system must be used independently, without combining values in any way.

1.3 The following safety hazards caveat pertains only to the test methods portion, Section 14, of this specification. *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.*

2. Referenced Documents

2.1 ASTM Standards:³

- D996 Terminology of Packaging and Distribution Environments
- D1974 Practice for Methods of Closing, Sealing, and Reinforcing Fiberboard Boxes
- D2860/D2860M Test Method for Adhesion of Pressure-Sensitive Tape to Fiberboard at 90° Angle and Constant Stress
- D3330/D3330M Test Method for Peel Adhesion of Pressure-Sensitive Tape
- D3611 Practice for Accelerated Aging of Pressure-Sensitive Tapes

¹ This specification is under the jurisdiction of ASTM Committee D10 on Packaging and is the direct responsibility of Subcommittee D10.14 on Tape and Labels.

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² This specification is intended to replace Federal Specifications PPP-T-60 and PPP-T-76.

³ 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.

D3652/D3652M Test Method for Thickness of Pressure-Sensitive Tapes

D3654/D3654M Test Methods for Shear Adhesion of Pressure-Sensitive Tapes

D3715/D3715M Practice for Quality Assurance of Pressure-Sensitive Tapes

D3759/D3759M Test Method for Breaking Strength and Elongation of Pressure-Sensitive Tape

D3811/D3811M Test Method for Unwind Force of Pressure-Sensitive Tapes

D3815/D3815M Practice for Accelerated Weathering of Pressure-Sensitive Tapes by Open-Flame Carbon-Arc Exposure Apparatus

D3816/D3816M Test Method for Water Penetration Rate of Pressure-Sensitive Tapes

D3833/D3833M Test Method for Water Vapor Transmission of Pressure-Sensitive Tapes

D3951 Practice for Commercial Packaging

D4727/D4727M Specification for Corrugated and Solid Fiberboard Sheet Stock (Container Grade) and Cut Shapes

D5570 Test Method for Water Resistance of Tape and Adhesives Used as Box Closure

2.2 TAPPI Standard:

T 414 Internal Tear Resistance of Paper (Elmendorf-Type Method)⁴

2.3 Federal Specifications:

PPP-T-60 Tape, Packaging, Waterproof⁵

PPP-T-76 Tape, Packaging, Paper (for Carton Sealing)⁵

PPP-T-680 Tape, Pressure-Sensitive Adhesion: Packaging and Packing of⁵

FED-STD-595 Colors⁵

2.4 ISO Standard:

ISO 9000:2000 Quality Management Systems—Fundamentals and Vocabulary⁶

⁴ Available from Technical Association of the Pulp and Paper Industry (TAPPI), 15 Technology Parkway South, Norcross, GA 30092, <http://www.tappi.org>.

⁵ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁶ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

ISO 9001:2000 Quality Management Systems—Requirements⁶

ISO 9004:2000 Quality Management Systems—Guidelines for Performance Improvements⁶

NOTE 1—The following is a comparison of types and classes of this specification compared with PPP-T-60 and PPP-T-76:

D5486/D5486M	PPP-T-60	PPP-T-76
Type I	Type III	N/A
Class 1	Class 1	
Class 2	Class 2	
Type II	N/A	N/A
Type III	N/A	N/A
Type IV	Type IV	N/A
Type V	N/A	Same

3. Terminology

3.1 Definitions:

3.1.1 General definitions for packaging and distribution environments are found in Terminology **D996**.

4. Significance and Use

4.1 Type I is a polyester film-backed pressure-sensitive tape intended for box closure and sealing applications where strength and resistance to sunlight, rain, and other deteriorating elements are required. It is usually used on weather-resistant fiberboard (Class WR or WWVR of Specification **D4727/D4727M**). The tape is intended for H-type closure or sealing of regular slotted boxes (Closure Method 2B3 and 2B4 of Practice **D1974**), and other applications where the tape will be overlapped onto itself. Type I, Class 2 transparent tape can also be used for label attachment and covering applications where weather resistance is needed.

4.2 Type II is a polyester film-backed pressure-sensitive tape intended for box closure applications where strength and water-resistance are required. It is usually used on domestic grade fiberboard (Class D of Specification **D4727/D4727M**). The tape is most suited for center seam closure of regular or regular slatted boxes (Closure Method 2B4 of Practice **D1974**) and other applications where the tape will not be overlapped onto itself. Type II, Class 2 tape is also used for label attachment and covering applications where water resistance is desired.

4.3 Type III is a polypropylene film-backed pressure-sensitive tape intended for box closure applications where a general purpose water-resistant tape is desired. It is used on domestic grade fiberboard (Class D of Specification **D4727/D4727M**). The tape is suited for center seam closure of regular slotted boxes (Closure Method 2B4 of Practice **D1974**).

4.4 Type IV is a woven cloth-backed pressure-sensitive tape for less critical packaging applications where a cloth-backed tape is desired.

4.5 Type V is a paper-backed weather-resistant, water-resistant pressure-sensitive tape for box closure and sealing applications where weather resistance and water resistance are required. It may be used on weather-resistant or domestic fiberboard (Classes WR, WWVR, and D of Specification **D4727/D4727M**). The tape is suited for center seam and H-type closures or sealing of regular slotted boxes (Closure

Methods 2B3, 2B4, and 2B7 of Practice **D1974**) and other applications where it may be overlapped onto itself.

5. Classification

5.1 Types and Classes:

5.1.1 *Type I*—Waterproof, weather-resistant, polyester-backed:

5.1.1.1 *Class 1*—Colored.

5.1.1.2 *Class 2*—Transparent.

5.1.2 *Type II*—Water-resistant polyester backed.

5.1.2.1 *Class 1*—Tan.

5.1.2.2 *Class 2*—Transparent.

5.1.3 *Type III*—Water-resistant polypropylene.

5.1.4 *Type IV*—Water-resistant woven cloth backed.

5.1.5 *Type V*—Weather-resistant paper backed.

6. Ordering Information

6.1 The inquiry or order shall include the following:

6.1.1 ASTM Designation and date of issue;

6.1.2 Type and Class required (see **5.1**);

6.1.3 Roll width and length (see **9.1**);

6.1.4 Color where applicable (see **10.1**);

6.1.5 When backing certification is required (see **17.1**);

6.1.6 When testing and inspection certification is required (see **17.2**);

6.1.7 Level of packaging and packing if other than commercial (see Section **18**);

6.1.8 For packaging and packing for shipments to the U.S. Government (see **18.2**); and

6.1.9 When core marking is required (see **18.3**).

7. Materials and Manufacture

7.1 The materials used in the construction of the tape shall be such as to assure performance of the tape over the temperature range from -65 to 160°F [-55 to 71°C] and shall conform to the requirements of this specification.

7.2 Backing:

7.2.1 Type I backing shall be polyester film.

7.2.2 Type II backing shall be a polyester film.

7.2.3 Type III backing shall be a polypropylene film.

7.2.4 Type IV backing shall be a woven cloth.

7.2.5 Type V backing shall be a treated paper.

7.3 *Adhesive*—The adhesive shall be pressure-sensitive water-insoluble and shall require no moisture heat or other preparation prior to or after application to clean, dry surfaces. The adhesive shall be coated in a smooth and evenly distributed layer on one side of the backing.

7.4 *Rolls*—The tape shall be evenly wound in rolls, adhesive side in, on cores made of paper-fiber or plastic. The core shall have sufficient rigidity to prevent distortion of the roll under normal conditions of transportation and use. The inside diameter of the core shall be $7.6, -0, +1.6$ mm [$3, -0, +\frac{1}{16}$ in.]. When the roll is unwound, the backing shall not tear, the adhesive shall not transfer nor split from the face of the tape backing to the adjacent layer before or after aging (see **Table 1**).