



CORPORATE PURCHASING SPECIFICATION

AA 514 18

Rev. No. 00

PAGE 1 OF 4

PRESSURE SENSITIVE ADHESIVE DIAXIALLY ORIENTED

POLY PROPYLENE (BOPP)TAPE

1.0 GENERAL:

This specification governs the quality requirements of Pressure sensitive adhesive BOPP tapes for packaging.

2.0 APPLICATION:

For sealing metallic components with polythene sheets where high degree of water vapour proof sealing is required.

3.0 CONDITION OF DELIVERY:

Tapes shall be supplied in the form of rolls wound on cores having internal diameter of 75+1.5mm or 50±0.5mm as specified in the order.

4.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply with the requirements of the following National standard and also meet the requirements of this specification

IS: 13262-1992 | Pressure sensitive adhesive tapes with

| plastic base

5.0 DIMENSIONS AND TOLERANCES:

1) Length:

The length of the roll shall be 50 metres and shall not vary by more than one percent.

5.1. Measurement:

The length of the tape on one roll shall be calculated from the total weight of the roll (without core) / and the mean weight of two specimens, each 2 m long, taken at random from the roll. Rest of the rolls shall be accepted by comparing the weight of each roll with that of the Sample roll.

5.2 Width:

Standard widths : 25, 37.5 and 50 mm.
Tolerance upto 25 mm : 1.0 mm
Above 25mm: :1.5 mm

5.3 Thickness:

Thickness of BOPP film shall not be less than 35 microns.

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**6.0 MANUFACTURE:**

The tape shall consist of a base film of Biaxially Oriented Poly Propylene (BOPP) Oriented Poly Propylene (BOPP) coated uniformly on the side with a suitable pressure sensitive adhesive composition, requiring no moisture heat or other special preparation prior to application.

Tapes shall have sufficient rigidity to prevent the distortion of the roll under normal conditions of transportation and use.

The rolls shall be wound uniformly and evenly so that each succeeding turn coincides with the one below it. The tape shall be free from materials which are known to be toxic.

Each rolls of tape shall be reasonably free from overlapping, depressions, distortion or telescoping and shall unroll without off – setting of the adhesive mass or tearing of the base.

A roll of tape shall not have more than one splice in a roll. The splices be so made as not to separate when unwound from the roll.

The emblem of BHEL of size A25 or A40 (Length 25 or 40 mm) depending upon width of tape shall be printed on the tape at intervals of 150mm along its length.

Printing shall be done on the underside of the tape. The colour of the emblem shall be Air craft Blue (Shade No. 108) as per IS:5. The emblem shall be as per AA 040 11 21.

7.0 COLUR:

Unless otherwise specified, the tape shall be supplied in Natural Colour.

8.0 TEST SAMPLES:

Sampling and criteria for conformity shall be as per IS: 8402.

9.0 PROPERTIES:

When tested in accordance with relevant clauses of IS: 8402, the test samples shall show the following properties.

9.1 Adhesion to metal and self : 2.0 N/10mm width, min.

9.2 adhesion to metal and self

After immersion in water : 160 g/10mm width, min.

9.3 Tensile strength : 25 N/10mm width, min

9.4 Minimum elongation : 10%

9.5 Anchorage : The adhesive mass shall not come off from the BOPP film.



CORPORATE PURCHASING SPECIFICATION

AA 514 18

Rev. No. 00

PAGE 3 OF 4

10.0 KEEPING PROPERTY:

The material shall the properties prescribed in this specification for a period of not less than 12 months when stored at $27 \pm 2^\circ \text{C}$ and $64 \pm 5\% \text{ R.H.}$ Under cover in a dry place in the original sealed container, from the date of manufacture which shall be after the date of placing our order.

11.0 INSPECTION AT SUPPLIERS' WORKS:

Whenever specified, tests and inspection are to be conducted in the presence of BHEL's representative.

BHEL's representative shall have free access at all times while the work on the contract is being performed, to all parts of the manufacturer's works. The manufacturer shall offer BHEL's representative all reasonable facilities without charge to satisfy the latter that the material is being furnished in accordance with this specification. The manufacturer shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities do not exit at his works, the manufacturer shall make necessary arrangements for carrying out the prescribed tests elsewhere. The manufacturer shall notify BHEL's representative in advance about the readiness of the material for inspection and testing.

BHEL reserves the right to test the material at BHEL's works and the final acceptance of the material shall be based on these test results.

12.0 TEST CERTIFICATES:

Three copies of test certificates shall be supplied unless otherwise stated on the order.

In addition, the supplier shall ensure to enclose one copy of the test certificate along with their dispatch Documents to facilitate quick clearance of the material.

The test certificate shall bear the following information:

AA 514 18: Pressure sensitive adhesive biaxially oriented poly propylene tape (BOPP).

BHEL Order No.

Batch / Lot No.

Results of dimensional inspection.

Test results of clause 10.

13.0 PACKING AND MARKING:

13.1 Packing:

The rolls shall be packed in suitable containers so that they are adequately protected from damage in transportation and from deterioration due to climatic conditions. The rolls shall not adhere to each other or to the container.

**13.2 Marking:**

Each container shall be marked with the following information:

AA 514 18

Length and width of the roll :

Weight of the roll :

BHEL Order No. :

Manufacturer's Name :

Batch No. :

Date of Manufacture :

Date of Expiry :

Directions for storage, if any :

14.0 REJECTION AND REPLACEMENT:

In the event of any tape proving defective during the course of preparation, testing, subsequent use, etc. Such material shall be rejected notwithstanding any previous certification of satisfactory testing and / or inspection. The supplier shall under take to replace the rejected film at his own cost and the rejected material shall be taken by the supplier after fulfilling the commercial terms and conditions.

15.0 REFERRED STANDARDS:

The following is the list of the latest standards, as published by the respective issuing bodies , referred to in this specification.

1) BHEL CS AA 040 11 21

2)IS:5

2) IS:8402

4)IS:13262