

		CORPORATE PURCHASING SPECIFICATION		AA 51412	
				REV. No. 01	
				PREFACE SHEET	

PRESSURE SENSITIVE ADHESIVE PVC TAPE

FOR INTERNAL USE ONLY
 REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS

Equivalent/Comparable Standards:

1. INDIAN : IS : 13262 - 1992

Acceptable Suppliers & Grades:

User Plants & Replaced Plant Specifications/References:

1. BHOPAL : -
 2. HYDERABAD : HY 78484

Revision: C1.5.6 of MOM of WG(T&PM)			Approved: INTERPLANT STANDARDIZATION COMMITTEE - WG (T&PM)		
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REV. No. 01

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PRESSURE SENSITIVE ADHESIVE PVC TAPE1. GENERAL:

This specification governs the quality requirements of pressure sensitive unplasticized adhesive PVC tapes for packaging.

2. APPLICATION:

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

3. CONDITION OF DELIVERY:

- 3.1 All tapes shall be wound on cores of internal diameters $75 \pm 1.5\text{mm}$ or $50 \pm 0.5\text{mm}$ and shall have sufficient rigidity to prevent the distortion of the roll under normal conditions of transportation and use.
- 3.2 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.
- 3.3. Each roll 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.
- 3.4 A roll of tape shall not have more than one splice for every 20 metres and not more than 3 in a roll. The splices shall be so made as not to separate when unwound from the roll.

4. COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply with 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. DIMENSIONS AND TOLERANCES:5.1 Length:

The length of the roll shall be 65 metres and shall not vary by more than one percent.

5.1.1 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.

Revision:

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5.2 Width:

Standard Width: 25 and 40 mm.

Tolerance:

Upto 25 mm: ± 1.0 mm.

Above 25 mm: ± 1.5 mm.

5.3 Thickness:

0.05 mm with tolerance of $\pm 10\%$.

6. GENERAL REQUIREMENTS:

6.1 The tape shall consist of a base film of unplasticized polyvinyl chloride or its copolymer whose major constituent is vinyl chloride, coated uniformly on one side with a suitable pressure sensitive adhesive composition, requiring no moisture, heat or other special preparation prior to application.

6.2 Colour:

The colour of the tape shall be CANARY YELLOW (Shade No.309 as per IS:5) unless otherwise specified.

6.3 Printing:

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

The colour of the emblem shall be Air craft Blue (Shade No.108 as per IS:5).

The emblem drawing shall be supplied at the time of placing order.

7. TEST SAMPLES:

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

8. PROPERTIES:

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

8.1 Adhesion to metal and self:

2.0 N/10mm width, Min.

8.2 Adhesion to Metal & Self After Immersion in Water:

160 g/10mm width. Min.

8.3 Tensile Strength:

25 N/10mm Width. Min.

**8.4 Elongation at Break:**

15% Min.

8.5 Anchorage:

The adhesive mass shall not come off from the PVC film.

9. KEEPING PROPERTY:

The material shall retain 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 $65 \pm 5\%$ R.H. under cover in a dry place in the original sealed container, after the date of manufacture which shall be subsequent to the date of placing order.

10. INSPECTION AT SUPPLIER'S 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 exist at his works, the manufacturer shall make necessary arrangements for carrying out the prescribed tests elsewhere. The manufacturer shall notify BHEL 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 is based on these results.

11. TEST CERTIFICATES:

11.1 The tenderers shall enclose a test certificate of the material with respect to the dimension & properties as per clauses 5 & 8 respectively obtaining from a national reputed, laboratory/institute along with the quotations.

11.2 Unless otherwise stated, three copies of test certificates giving the following information shall be supplied along with each consignment.

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

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BHEL Order No.

Manufacturer's Name.

Batch No.



Results of dimensional inspection and tests prescribed in clauses 3,5,6 & 8.

12. **PACKING AND MARKING:**

12.1 **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.

12.2 **Marking:**

Each container shall be marked with the following information.

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Length and width of the roll.

Weight of the roll.

BHEL Order No.

No. of rolls in the container.

Batch No.

Date of Manufacture/Expiry.

Manufacturer's Name.

Directions for storage, if any.

13. **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 undertake to replace the rejected tape at his own cost and the rejected shall be taken back by the supplier after fulfilling the commercial terms and conditions.

14. **REFERRED STANDARDS:**

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

1) IS: 5

2) IS: 8402