

Table 1

Grade of tape	Width of bobbin, mm	Lim. dev. %	Inside diameter of bobbin	Lim. dev. %	Outside diameter of bobbin	Lim. dev. %
A, A ₁	12, 15, 18, 20, 25	±8	50, 65, 70	±5	320, 250, 350	±4
B (B)	60, 80	±2	50, 65	±5	350	±4
	140	±1				
B (V)	17					
	25, 40, 50, 60	±5				
	70, 75, 100	±6	50, 65, 70	±5	250, 320, 350	±4
F (G)	125, 150, 180, 200	±5			320	±6
	17, 40	±5	50, 65, 70	±5	350	±6
A (D)	10	±1	50	±4	190	±3

Note: 1. Limit deviations in the bobbin width for grade B (V) gummed tape with state quality mark must not exceed ± 4%.

2. Inside diameter of the ring must be taken as inside diameter of a bobbin wound over a ring.

3. Bobbins with outside diameter not less than 140 mm may constitute not more than 5% of the bobbins in a batch of gummed tape grade A(D).

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2. TECHNICAL REQUIREMENTS

2.1. Gunned tape must meet the norms set out in Table 2 in respect of quality parameters.

Table 2 P-3

Parameter	Norm for paper of grades						Test methods	
	A	A ₁	B (B)	B (V)		Γ (G)		Δ (D)
				With State quality mark	First category			
1. Weight of gum layer per sq. metre of paper base, grams	28±2	30±5	50±5	40 ⁺⁵ ₋₃	40±5	26±5	23±3	As in para 4.3
2. Adhesive capacity and tearing force, N(kgf) not less than:								As per GOST 13525.1-79 and para 4.4 of the present standard
10	-	-	-	-	-	-	26(2.7)	
12	35 (3.6)	43 (4.4)	-	-	-	-	-	
15	44 (4.5)	54 (5.5)	73 (7.5)	93 (9.5)	78 (8.0)	34 (3.5)	39 (4.0)	
17	-	-	-	103 (10.5)	88 (9.0)	39 (4.0)	-	
18	53 (5.4)	65 (6.6)	-	-	-	-	-	
20	59 (6.0)	71 (7.3)	-	-	-	-	-	
25	73 (7.5)	90 (9.2)	-	-	-	-	-	
3. Moisture content, %	6±2	6±2	6±2	6±2	6±2	6±2	6±2	

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2.2. Paper base of the following grades must be used for making gummed tape:

Grade of gummed tape	Grade of paper base as per GOST 10459-72
A	A
A ₁	A ₁
Б (B)	Б (B)
В (V)	В (V)
Г (G)	Г (G)
Д (D)	Б (B) as in GOST 19625-74

2.3. Bone clay conforming to GOST 2067-80 of the highest and the first sorts and hide glue to GOST 3252-80 of the highest and the first grades must be used for this glue.

2.4. Glues other than those mentioned above may be used for preparing gummed tape of all grades, except grade D, provided the quality parameter of the gummed tape meet the requirements of the present standard.

If synthetic water-activated glue is used, the weight of the glue layer per sq.metre of paper must be as follows:

Paper grade	Weight of glue, grams
A	30 ± 5
A ₁	40 ± 5
Б (B)	65 ± 5
В (V)	60 ± 10
Г (G)	30 ± 5

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2.5. The glue layer must not have a strong unpleasant odour.

2.6. The glue layer on the paper linen must be uniform and uninterrupted.

2.7. The tape must be wound with the gummed layer inside. The gummed layer may be inside, if the manufacturer and the customer so require.

2.8. The ends of gummed tape must be pasted together wherever there is a cut, such pasting is not permitted in gummed tape of grades G and D.

2.8.1. Not more than two such pasted cuts are permitted in gummed tape B (V).

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2.9. Gummed tape must be wound tightly into bobbins. The end faces must be plane. The outer end of the bobbin must be pasted to the bobbin.

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2.10. When the bobbin is unwound, the tape must flow freely without damage and without giving off dust.

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3. ACCEPTANCE RULES

3.1. GOST 8047-78 defines batch and sampling scale for gummed tape.

3.2. If unsatisfactory test results are obtained in respect of even a single parameter, the particular test is repeated on twice the number of specimen drawn from the same roll.

The results of repeat tests are final and applicable to the whole batch.

4. TEST METHODS

4.1. Specimens must be selected and prepared for the tests as specified in GOST 8047-78 read with the following supplements:

4.2. Dimensions of bobbins are determined as described in GOST 21102-75.

4.3. The weight of the glue layer is determined as follows:

Five bobbins are selected from different places of each selected roll. Two strips are selected from different places of each selected bobbin at a distance of 3 metres from each other.

The specimen dried to a constant weight as described in GOST 13525.10-71, is placed in a bath large enough to permit processing of the tape with water at a temperature of 40 to 50°C.

After soaking in water for 15 minutes, the specimen is moistened with a sponge of glue layer. The tape is then washed with a jet of cold water till all the glue is completely removed (as checked by feeling with hand), after which the paper is dried till it attains a constant weight.

The weight of the glue layer (K) in grams, applied on one square metre of paper, is calculated from the formula

$$K = \frac{(m_0 - m_1) \cdot 1000}{B},$$

where m_0 is the weight of the specimen of gummed tape before processing with water, grams;

m_1 is the weight of the specimen of gummed tape after processing with water, grams and

B is the width of the gummed tape, mm.

The arithmetic mean of ten determinations is taken as the test result.

4.4. Adhesive property and tearing force of gummed tape are determined as follows:

Five bobbins are drawn from different places of each selected roll; Two strips each of length 280 mm are cut from each selected bobbin at a distance of not less than 2.5 metres from each other.

Strips of width 15 mm are cut from tape of width over 25 mm. Tape of width upto 25 mm is tested in the condition in which it is sold. Deviations in width of the strips must conform to para 1.2.

The strips are cut into two portions for testing. The roller used for applying the glue is fully moistened with water at a temperature of $20 \pm 2^{\circ}\text{C}$. The glue layer of one of the strips is moistened at a distance of not less than 10 mm from the end of the tape. The other strip of tape is then pasted to the first strip at a distance of 30 mm from the end under a pressure of 9.8 kPa (0.1 kgf/mm^2) on the reverse side (not covered with glue), forming an overlapping joint.

The specimen glued as above is dried in a drying cabinet at 70 to 75°C for 1 minute for tape of grades A, A₁, B (B) and D and for 2 minutes for tape of grade B (V) and Γ (G).

Tearing force is determined in accordance with GOST 13525.1-79 after drying. If the glueing strength is satisfactory, tearing must occur along the length.

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5. PACKING, MARKING, TRANSPORT AND STORAGE

5.1. Gummed tape is packed and marked in accordance with GOST 1641-75 read with the following supplements.

5.2. Bobbins may be fixed on a wooden rod with wooden planks before they are wrapped in paper. After wrapping in paper, the rolls may be securely tied up with paper twine twisted with several stands.

5.2.1. If the State Quality Mark has been awarded to the gummed tape, a facsimile of the SQM must be applied on the gummed tape in accordance with GOST 1.9-67.

(ADDED, REV. No. 2)

5.3. Bobbins of glued tape may, by mutual consent, be produced without the internal rings.

5.4. Cardboard grade Г (G) to GOST 7933-75 may be used instead of two sheets of paper for packing the end faces of rolls.

5.5. The roll must further be tightly wrapped in a single layer of film or in two layers of paper to GOST 2228-75, GOST 1341-74, GOST 9569-79 or GOST 8828-75.

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5.6. Weight of roll should not exceed 70 kg.

5.7. Gummed tape in the packed condition must be carried in closed and clean vehicles.

5.8. Rolls must not be thrown about while loading and unloading.

5.9. Gummed tape must be stored in enclosed premises where they are protected from the effect of atmospheric precipitations and subsoil moisture.

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5.10. Rolls of gummed tape in soft packing must be kept in the vertical position during transport and storage. Rolls may be stacked one over the other provided the possibility of mechanical damage to bobbins of tape and the packing of rolls is eliminated.

6. MANUFACTURER'S GUARANTEE

6.1. Gummed tape must pass acceptance by the quality control department of the manufacturing establishment. The manufacturer must guarantee conformity of the tape with the requirements of the present standard, provided the customer observes the storage conditions laid down by this standard.

6.2. Guaranteed shelf life is 1 year from the date of manufacture.