

4.2.6.1 (Continued)

The preform shall be placed on a 0.040 in. thick chromium plated metal plate and covered by a similar plate. Spacers 0.075 in. \pm 0.001 thick shall be placed between the plates at a distance such as not to interfere with the flow of material. The plates shall be placed between the platens of a press, the platens having a temperature of 500 F \pm 10. The platens shall be closed and loaded to follow the rate of melting. The plates shall reach the stops within 3 minutes. Full positive pressure sufficient to provide a sheet of the required thickness shall then be applied for 3 more minutes. Immediately upon completion of the press period, the load shall be removed and the plates and plastic sheet quenched in cold water (maximum 60 F). The 0.062 in. thick sheet shall then be stripped from the metal plates. Specimens shall be cut from this sheet in such a manner that the edge of the sheet is discarded.

Cut at least 2 test strips 2 in. long and 3/16 in. wide from the sheet and notch strips in center (1 in. from end) using a 3/64 in. notching tool. The cross section of the plastic at the notch shall be 0.047 in. \pm 0.001 wide by 0.062 in. \pm 0.003 thick.

Clip one end of the sample into a specimen holder at room temperature and to the other end clip a 7.5 g weight butting the ends of sample against the back of the clip.

The sample assembly shall be inserted into a furnace maintained at 482 F \pm 4 and the average time in seconds for the samples to break shall be recorded as the ZST (Zero Strength Time).

Note 1. The following formula shall be used to calculate the minimum dielectric strength requirement.

$$E = \frac{4500}{\sqrt{t}} \quad \text{Where } t = \text{nominal thickness in mils}$$

5. QUALITY: The product shall be uniform in quality and condition, clean, smooth, and free from foreign materials and from imperfections detrimental to fabrication, appearance, or performance of parts.
6. TOLERANCES: Unless otherwise specified, the following tolerances apply when measured at 75 - 85 F.

Nominal Thickness Inch	Tolerance, Inch Plus and Minus
0.002 to 0.005, incl	0.0005
Over 0.005 to 0.010, incl	0.001

7. REPORTS:

- 7.1 Unless otherwise specified, the vendor of the product shall furnish with each shipment three copies of a report stating that the product meets the requirements of this specification. This report shall include the purchase order number, material specification number, form or part number, and quantity.