

**METRIC**

A-A-52469

July 28, 1993

SUPERSEDING

MIL-C-62123A(AT)

22 June 1987

## COMMERCIAL ITEM DESCRIPTION

## CEMENT, TREAD, RUBBER (METRIC)

The U.S. Department of Defense has authorized the use of this commercial item description (CID) as a replacement for MIL-C-62123A(AT).

## ABSTRACT

This CID covers commercially manufactured cements containing resins which are used by the tire retreading industry for applying hot freshly extruded tread rubber compound to buffed tire casings upon which such resin base cements have been sprayed. The cement covered by this CID is intended for use in retreading tires used on military wheeled vehicles.

## SALIENT CHARACTERISTICS

a. Materials. The cement to be furnished shall be similar to resin based cements developed for, and used by, the tire retread industry for production of quality retread tires built with hot, extruded tread compound. The finished product shall conform to the requirements of ZZ-T-441 when standard shop practice is used for retreading.

1. Rubber content. The cement shall contain natural, synthetic natural (cis 1-4 polyisoprene), or styrene-butadiene rubbers in any combination, but shall not contain reclaimed rubber.

2. Resin content. The cement shall contain resins dissolved in organic solvents such that the hot extruded tread rubber, when applied at a temperature of 93 degrees Celsius (\*C), shall be held firmly to a buffed, cemented tire carcass without loosening, sagging, or drooping during and after the period in which the tread stock cools.

**Beneficial comments, recommendations, additions, deletions clarifications, etc. and any other data which may improve this document should be sent by letter to: U.S. Army Tank-Automotive Command, ATTN: AMSTA-GDS, Warren, MI 48397-5000.**

AMSC N/A

FSC 2640

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b. Adherence capability. The buffed cemented tire shall retain the capability of accepting and adhering to the hot extruded tread rubber for at least 5 hours after the cement has been applied.

c. Cement adhesion. The cement adhesion strength of 21.4 kilograms per centimeter (cm) of width shall be attained after curing. This shall be verified by preparing and testing two specimens in accordance with the cement adhesion test of ZZ-T-416 or other similar test which produces comparable results.

d. Solubility of resin cements. The addition of rubber solvent shall not cause galling of cement. Rubber solvent addition shall not cause precipitation or settling in the cement so that it cannot be re-dispersed by stirring. The rubber solvent shall consist of a high grade petroleum distillate that is water-clear, free from foreign material, acid, oil, water, or anti-knock materials. The solvent shall have a boiling range of 38 to 60°C initial, 93 to 138°C end point with no oil residue.

e. Viscosity. The viscosity of the resin cement shall be suitable for spray application as removed from the container. Viscosity shall range between 20 to 65 centipoises at 23°C. Viscosity shall be verified in accordance with method B of ASTM D1084.

f. Total solids. The total solids content of the cement shall not be less than 7% by weight.

g. Storage stability. The cement shall be usable for 1 year from date of manufacture when stored at temperatures not exceeding 24°C.

h. Material safety data sheet (MSDS). When applicable an MSDS shall be prepared in accordance with FED-STD-313 (see notes b and c).

#### QUALITY ASSURANCE PROVISIONS

a. Responsibility for inspection. The contractor is responsible for the performance of all inspections (examinations and tests).

b. Contractor certification. The contractor shall certify and maintain substantiating evidence that the product offered meets the salient characteristics of this commercial item description and that the product conforms to the producer's own drawings, specifications, workmanship standards, and quality assurance practices. Items with known defects shall not be submitted for Government acceptance. The Government reserves the right to require proof of such conformance prior to the first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

#### PRESERVATION, PACKAGING, PACKING, LABELING, AND MARKING

Preservation, packaging, packing, labeling, and marking for the desired level shall be as specified in the contract (see note b).

#### NOTES

(This section contains information of a general or explanatory nature that may be helpful, but is not mandatory.)

a. Addresses for obtaining copies of referenced documents.

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1. Government specifications and standards. Copies of FED-STD-313 "Material Safety Data, Transportation Data and Disposal Data for Hazardous Materials Furnished to Government Activities", ZZ-T-416 and ZZ-T-441 "Tire, Pneumatic: Retreated and Repair Materials" are available from the Navy Publications and Printing Service Office, Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

2. Non-Government Publications. ASTM D1084 "Standard Test Methods for Viscosity of Adhesives" is available from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

b. Ordering data. Acquisition documents must specify the following:

1. Title, number, and date of this CID.
2. Issue of the DODISS to be cited in the solicitation and, if not listed in the DODISS, the specific issue of the individual documents referenced.
3. Identify activities requiring copies of completed MSDS and specify when the MSDS will be inspected.
4. Selection of applicable level of packaging requirements.

c. MSDS. Contracting Officers should identify those activities that require copies of completed MSDS prepared in accordance with FED-STD-313. The pertinent Government mailing addresses for submission of data are listed in appendix B of FED-STD-313.

d. Cross reference data. Cement conforming to this CID is interchangeable with cement conforming to MIL-C-62123A(AT), dated 22 June 1987.

e. Regulatory requirements. The offeror/contractor is encouraged to use recovered materials in accordance with Public Law 94-580 to the maximum extent practicable.

MILITARY INTERESTS:

Custodian

Army - AT

CIVIL AGENCY COORDINATING ACTIVITY:

GSA - FSS

PREPARING ACTIVITY:

Army - AT

(Project 2640-0203)