

INCH-POUND

MIL-T-4K
8 August 1991
 SUPERSEDING
 MIL-T-004J
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MILITARY SPECIFICATION

TIRES AND INNER TUBES; PACKAGING OF

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope. This specification covers the preservation, packing, and marking for shipment and storage of: vehicle tires, pneumatic; inner tubes, pneumatic tires; and tires with flaps

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.1.1 Specifications, standards and handbooks. The following specifications, standards and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited in the solicitation (see 6.2).

SPECIFICATIONS

FEDERAL

L-P-378	- Plastic Sheet and Strip, Thin Gauge, Polyolefin.
T-T-871	- Twine, Cotton, Wrapping.
T-T-911	- Twine, Fibrous, Jute.
NN-P-71	- Pallets, Material Handling, Wood, Stringer Construction 2-Way and 4-Way (Partial).

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: U.S. Army Tank-Automotive Command, ATTN: AMSTA-GDS, Warren, MI 48397-5000, by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document, or by letter.

AMSC N/A

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DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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MMM-A-130	- Adhesive, Contact.
PPP-B-585	- Boxes, Wood, Wirebound.
PPP-B-601	- Boxes, Wood Cleated-Plywood.
PPP-B-621	- Boxes, Wood, Nailed and Lock-Corner.
PPP-B-636	- Boxes, Shipping Fiberboard.
PPP-B-640	- Boxes, Fiberboard, Corrugated, Triple-Wall.
PPP-F-320	- Fiberboard: Corrugated and Solid, Sheet Stock (container grade) and Cut Shapes.
PPP-T-60	- Tape, Packaging, Waterproof.

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MIL-P-116	- Preservation Packaging, Method of
MIL-P-11520	- Preservative, Coating, Rubber; for Rubber Surfaces.
MIL-L-61002	- Labels, Pressure - Sensitive Adhesive, for Bar Codes and Other Markings.

STANDARDS

MILITARY

MIL-STD-129	- Marking for Shipment and Storage.
MIL-STD-147	- Palletized Unit Loads.
MIL-STD-1190	- Minimum Guidelines for Level C Preservation, Packing and Marking.

(Unless otherwise indicated, copies of federal and military specifications, standards, and handbooks are available from the Naval Publications and Printing Services Office, Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.)

2.2 Non-Government publications. The following document(s) form a part of this document to the extent specified herein. Unless otherwise specified, the issues of the documents which are DOD adopted are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of the documents cited in the solicitation (see 6.2).

AMERICAN SOCIETY FOR TESTING AND MATERIALS

- D3950 - Standard Specification for Strapping, Nonmetallic (and Joining Methods)
- D3951 - Standard Practice for Commercial Packaging

(Application for copies should be addressed to American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

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Non-Government standards and other publications are normally available from the organizations that prepare or distribute the documents. These documents also may be available in or through libraries or other informational services.

2.3 Order of precedence. In the event of a conflict between the text of this specification and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 First article. When specified (see 6.2), a sample pack shall be subjected to first article inspection in accordance with 4.3.

3.2 Materials. Materials used for preservation and packing in accordance with this specification shall be as specified herein or in referenced specifications and shall be either new or reused. Reuse of serviceable packaging materials is permitted and shall be free from defects affecting serviceability. All materials required to preserve and pack items under this specification shall be of appropriate size and specified strength to contain the items and packages as applicable (see 4.6.1).

3.2.1 Recycled, virgin and reclaimed materials. There are no requirements for the exclusive use of virgin materials. The use of recycled or reclaimed (recovered) materials is acceptable provided that all other requirements of this specification are met (see 4.6.1 and 6.5.2).

3.3 Packaging.

3.3.1 Packaging requirements. Unless otherwise specified herein, the packaging and inspection of same shall be in accordance with MIL-P-116 (see 4.5).

3.3.2 Preservation. Preservation shall be level A or C, as specified (6.2).

3.3.2.1 Tires, Level A.

3.3.2.1.1 Cleaning. Tires shall be cleaned in accordance with MIL-P-116, process C-1, to ensure that all loose particles and mold release agents are removed.

3.3.2.1.2 Drying. Tires shall be dried in accordance with MIL-P-116, process D-1.

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3.3.2.1.3 Preservation. Tires shall be preserved in accordance with MIL-P-11520.

3.3.2.1.4 Tires with flap. Flaps shall be rolled and placed inside the tire. When the size of the rolled flap and normal distance between beads assure that flap will remain in place during normal handling and transportation, no tying is required. When the size of the rolled flap is such that it will not be securely held within the tire, it shall be secured within the tire using twine conforming to T-T-871 or T-T-911, or nonmetallic strapping conforming to ASTM D3950, or equal, in such a manner as to assure safe delivery. When it is too difficult to insert the rolled flap within the tire, it shall be secured within the tire in the normal installed position. Safe transportation shall be ensured by securing flaps within the tire using twine conforming to T-T-871 or T-T-911, or nonmetallic strapping conforming to ASTM D3950.

3.3.2.2 Tires, Level C. Tires shall be preserved in accordance with applicable commercial standards, but shall be no less than the requirements of ASTM D3951.

3.3.2.2.1 For Army use only. Preservation shall be accomplished in accordance with MIL-STD-1190.

3.3.2.3 Tubes, Level A.

3.3.2.3.1 Preservation. Tubes shall be rolled or folded and placed in a 2 mil thick poly bag and heat sealed (see 4.5). Bag material shall conform to the requirements of L-P-378. After bagging, tubes shall be placed in a fiberboard box conforming to PPP-B-636, style RSC, type CF, grade W5, class WR. Closure of the box shall be in accordance with PPP-B-636.

3.3.2.3.2 Tubes weighing more than 15 pounds. Tubes shall be rolled or folded and packed directly into a fiberboard box conforming to PPP-B-636, style RSC, type CF, grade W5, class WR. Closure shall be in accordance with PPP-B-636 requirements.

3.3.2.3.3 Intermediate container. Intermediate containers shall be used under the following conditions:

- a. When they are considered economical because of total quantity on order, production schedule, or when it facilitates handling, storage and reshipment.
- b. When the quantity to be shipped to a single destination permits the use of two or more intermediate containers in an exterior container.
- c. When the exterior surface of the unit pack is a bag or wrap of any kind.
- d. When the unit pack volume is less than 64 cubic inches and the exterior container is a rigid type.

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In the event that an intermediate container is required, the following limitations apply:

- a. Quantity shall be divisible by two.
- b. Maximum 100 unit packs per intermediate container.
- c. Maximum net load of 60 lbs.
- d. Maximum size of 2.0 cubic feet.

The container closure shall be in accordance with the requirements of PPP-B-636.

3.3.2.4 Tubes, Level C.

3.3.2.4.1 Preservation. Tubes shall be preserved in accordance with ASTM D3951.

3.3.2.4.2 For Army use only. Tubes shall be preserved in accordance with MIL-STD-1190.

3.4 Packing.

3.4.1 Tires, Level A.

3.4.1.1 Motorcycle, bicycle, and vehicle tires with outside diameter less than 14 inches. Tires shall be packed in wooden boxes conforming to PPP-B-585, class 2, style 1; or PPP-B-601, type overseas, style optional, grade B; or PPP-B-621, class 2, style optional, grade B. Top and bottom panels, side and end panels of boxes shall be lined with single wall corrugated fiberboard, grade W5 of PPP-F-320 and glued to the inside with adhesive conforming to MMM-A-130, Type 1 or equal.

3.4.1.2 Tires with an outside diameter of 14 inches and greater. Except for motorcycle and bicycle tires, tires with an outside diameter of 14 inches or greater shall be unitized in accordance with figure 1, 2 or 3 of this specification.

3.4.2 Tires, Level B.

3.4.2.1 Motorcycle, bicycle, and vehicle tires with an outside diameter less than 14 inches. Motorcycle, bicycle, and vehicle tires with an outside diameter less than 14 inches shall be packed in boxes conforming to PPP-B-640, style E, class 2 for loads up to 1000 lbs. Loads up to 2000 lbs shall be packed in boxes conforming to PPP-B-640, style B, class 2.

3.4.2.2 Tires with an outside diameter 14 inches and greater. Except for motorcycle and bicycle tires, tires with an outside diameter of 14 inches or greater shall be packed same as 3.4.1.2.

3.4.3 Tires, Level C. Tires shall be packed in accordance with the provisions of ASTM D3951.

3.4.3.1 For Army use only. Level C packing shall be in accordance with MIL-STD-1190.

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3.4.4 Tubes, Level A. Tubes shall be packed same as 3.4.1.1 except liner pads need not be used on the inside of containers.

3.4.5 Tubes, Level B. Tubes shall be packed in fiberboard exterior boxes conforming to PPP-B-636, style RSC, type CF, grade optional, class WR.

3.4.6 Tubes, Level C. Tubes shall be packed in accordance with ASTM D3951.

3.4.6.1 For Army use only. Tubes shall be packed in accordance with MIL-STD-1190.

3.5 Unitization.

3.5.1 Unitization of tires. Tubes and tubeless tires may be unitized into bundles not exceeding 43 inches in height. Means of unitizing may be by shrink wrapping with material conforming to L-P-378, type IV, class 3 or 4, grade A or B, finish 1 or 2; stretch wrapping with material conforming to L-P-378, type I, II, or III, class 3 or 4, grade A or B, finish 1 or 2; or strapping bundles with nonmetallic strapping conforming to ASTM D3950, type I, II, or III, grade A or B. When using strapping, a minimum of three vertical straps shall be used. Straps shall be evenly spaced, tensioned, and tires compressed approximately 15 percent of the bundle height (see figures 1 through 3).

3.5.2 Unitization of tubes. Boxed tire tubes shall be unitized in accordance with MIL-STD-147, method 1 or 1a, and stacked on wood pallets conforming to 4-way partial entry NN-P-71, type IV or V.

3.6 Marking. Tires and tubes shall be marked in accordance with MIL-STD-129. When tires are marked with labels, they shall comply with labels identified in MIL-L-61002, as type optional, grade A, style 3, rubber-composition b. Tires and tubes shall be bar coded.

3.6.1 Special marking. Tires shall be marked with cure date, and type II shelf life code 7, in accordance with MIL-STD-129. Tubes shall be marked with cure date, and type II shelf life code X, in accordance with MIL-STD-129.

3.7 Workmanship. Workmanship shall be in accordance with the manufacture of high quality packing and packaging of tires and tubes. This shall be evidenced by the absence of defects which are detrimental to the appearance, serviceability or durability of the packs and packages such as improper size, marking, unitization and boxing of tires and tubes; improper container, weight, stapling, taping and tying of packs and packages; unauthorized use of used or reworked materials (see 4.6.2).

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection. Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise

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specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in this specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Responsibility for compliance. All items shall meet all requirements of sections 3. The inspection set forth in this specification shall become a part of the contractor's overall inspection system or quality program. The absence of any inspection requirements in the specification shall not relieve the contractor of the responsibility of ensuring that all products or supplies submitted to the Government for acceptance shall comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the Government to accept defective material.

4.2 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. First article inspection (see 4.3).
- b. Quality conformance inspection (QCI) (see 4.4).
 1. Examination (see 4.4.2).
- c. Control tests (see 4.5).

4.3 First article inspection. First article inspection shall be performed on preproduction samples of one pack as specified in table I. Approval of the first article sample by the Government shall not relieve the contractor of the obligation to supply packs that are fully representative of those inspected as a first article sample. Any changes or deviations of the production units from the first article sample shall be subject to the approval of the contracting officer.

4.3.1 First article inspection failure. Deficiencies found during, or as a result of, the first article inspection shall be cause for rejection of the first article sample until evidence has been provided by the contractor that corrective action has been taken to eliminate the deficiency. Any deficiency found during, or as a result of the first article inspection shall be evidence that all items already produced prior to completion of the first article test are similarly deficient unless contrary evidence satisfactory to the contracting officer is furnished by the contractor. Such deficiencies on all items shall be corrected by the contractor. The Government will not accept products until first article inspection is completed to the satisfaction of the Government.

4.4 QCI. QCI shall include the examination of 4.4.2. Noncompliance with any of the specified requirements in section 3 shall be cause for rejection of the sample and the inspection lot (see 6.4).

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TABLE I. Classification of defects.

Major	Defects			Method of Inspection
	Packaging of tires	Packaging of tubes	Packing	
101	Improper preservation (see 3.3.2)	Tubes improperly folded (see 3.3.2.3.1)	Container closure improper (see 3.3.2.3.3)	Visual
102	Insecure tire flaps (see 3.5.1)	Bags not as specified (see 3.3.2.3.1)	Container size improper (see 3.3.2.3.3)	Visual
103	Incorrect marking (see 3.6 & 3.6.1)	Improper or inadequate bag closure (see 3.3.2.3.1)	Exterior shipping container not as specified (see 3.3.2.3.3)	Visual
104	Illegible marking (see 3.6 & 3.6.1)	Container not as specified (see 3.3.2.3.3)	Weight limitation of container exceeded (see 3.3.2.3.3)	Visual
105	Faulty workmanship (see 3.7)	Container closure improper (see 3.3.2.3.3)	Improper strapping (see 3.5.1)	Visual
106		Excessive looseness in package (see 3.5.1)	Improper marking (see 3.6 & 3.6.1)	Visual
107		Improper marking (see 3.6 & 3.6.1)	Illegible marking (see 3.6 & 3.6.1)	Visual
108		Illegible marking (see 3.6 & 3.6.1)		Visual
109		Faulty workmanship (see 3.7)	Faulty workmanship (see 3.7)	Visual

4.4.1 Sampling plan for examination. Unless otherwise specified (see 6.2), the sampling plan for examination as specified herein shall be used. See 6.4 for definitions of sampling inspection terms.

4.4.1.1 Lot formation. A lot shall consist of all packaging of items having the same stock number and from an identifiable package period.

4.4.1.2 Sampling for examination. The sample for QCI examination shall be randomly selected from the inspection lot in accordance with table II (see 4.5).

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TABLE II. Sampling plan for QCI.

QCI sampling plan		
Inspection lot size	Sample size for examination	
	Packaging of tires and tubes	Packing
2 to 8	*	5
9 to 15	13	5
16 to 25	13	5
26 to 50	13	5
51 to 90	13	7
91 to 150	13	11
151 to 280	20	13
281 to 500	29	16
501 to 1200	34	19
1201 to 3200	42	23
3,201 to 10,000	50	29
10,001 to 35,000	60	35
35,001 to 150,000	74	40
150,001 to 500,000	90	40
500,001 and over	102	40

* Indicates entire lot must be inspected (100% inspection).

4.4.2 Examination. The sample selected in accordance with 4.4.1.2 shall be examined and defects classified as specified in table I (see 4.7.2). The acceptance number in all cases is zero.

4.4.3 QCI failure. Any item that fails to conform to any specified requirement shall be rejected; any failure (one or more) of the selected sample in the Major categories for the appropriate inspection lot size shall constitute a failure of the entire lot. The rejected item(s) may be repaired or corrected and resubmitted for inspection. If the contractor utilizes sampling inspection as an element of his inspection system, rejected inspection lots may be resubmitted for acceptance if the contractor performs 100 percent inspection on the lot for those characteristics which were defective and resulted in rejection of the lot and removes all defective units or obtains procuring activity approval to resample the lot due to the insignificance of the defects. Resubmitted lots shall be kept separate from new lots and shall be clearly identified as resubmitted lots.

4.5 Control tests. From each lot of packaged tubes that has passed the inspection specified 4.4.1.2, a representative sample shall be subjected to the leakage test, and heat seal test specified in MIL-P-116 (see 3.3.1 and 3.3.2.3.1).

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4.5.1 Failure. Failure of any packaged tubes to pass any of the specified control tests shall be cause for the Government to refuse acceptance of the production quantity represented, until action taken by the contractor to correct defects and prevent recurrence has been approved by the Government.

4.6 Methods of inspection.

4.6.1 Materials, design and construction. Conformance to 3.2, 3.2.1 and 3.3 shall be determined by inspection of contractor records providing proof or certification that design, construction, processing, and materials conform to requirements. Applicable records shall include drawings, specifications, design data, receiving inspection records, processing and quality control standards, vendor catalogs and certifications, industry standards, test reports, and rating data.

4.6.2 Defects. Conformance to 3.3 thru 3.7, shall be determined by examination for defects listed in table I. Examination shall be visual, tactile, or by measurement with standard inspection equipment.

5. PACKAGING

This section is not applicable to this specification.

6. NOTES

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

6.1 Intended use. The preservation, packing, and marking requirements specified herein are intended to provide safe transportation and storage of tires, tubes, and tires with flaps.

6.2 Acquisition data. Acquisition documents must specify the following:

- (a) Title, number and date of this specification.
- (b) Issue of DODISS to be cited in the solicitation, and if required, the specific issue of individual documents referenced (see 2.1.1 and 2.2).
- (c) Whether first article is required (see 3.1).
- (d) If a preproduction sample pack is not required (see 4.3).
- (e) Selection of applicable level of packaging for tires and tubes (see 3.3 and 3.4).
- (f) Selection of unitization (see 3.5).
- (g) Whether contractor quality program or inspection system can be used (see 6.4).

6.3 First article. When first article inspection is required, the contracting officer should provide specific guidance to offerers whether the item(s) should be a first article sample, a first production item, or a standard production item from the contractor's current inventory and the number of items to be tested as specified in 4.3. The contracting officer

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should include specific instructions in acquisition documents regarding arrangements for examinations, approval of first article test results and disposition of first articles. Invitations for bids should provide that the Government reserves the right to waive the requirement for samples for first article inspection to those bidders offering a product which has been previously acquired or tested by the Government, and that bidders offering such products, who wish to rely on such production or test, must furnish evidence with the bid that prior Government approval is presently appropriate for the pending contract.

6.4 Quality control program or inspection system. When contracts include provisions for the establishment by the contractor or a quality control program or inspection system, and the approved program or system includes sampling and inspection requirements to insure that packages and packs meet the requirements of this specification, that program should be used in lieu of the sampling and inspection provisions of 4.4.3.

6.5 Definitions.

6.5.1 Definitions of terms used in sampling inspection.

a. Classification of defects. A classification of defects is the enumeration of possible defects of the unit of product classified according to their seriousness. A defect is any nonconformance of the unit of product with specified requirements. Defects will normally be grouped into one or more of the following classes: critical, major and minor defects. Also, defects may be grouped into other classes, or into subclasses within these classes.

b. Critical defects. A critical defect is a defect that judgement and experience indicate would result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product, or a defect that judgement and experience indicate is likely to prevent performance of the tactical function of a major end item such as a ship, aircraft, tank, missile, or space vehicle.

c. Critical defective. A critical defective is a unit of product which contains one or more critical defects and may also contain major and/or minor defects.

d. Defective. A defective is a unit of product which contains one or more defects.

e. Formation of lots or batches. The product shall be assembled into identifiable lots, sublots, batches, or in such other manner as may be prescribed (see 1). Each lot or batch shall, as far as is practicable, consist of units of product of a single type, grade, class, size, and composition, manufactured under essentially the same conditions, and at essentially the same time.

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f. Lot or batch. The term lot or batch shall mean "inspection lot" or "inspection batch", i.e., a collection of units or product from which a sample is to be drawn and inspected and may differ from a collection of units designated as a lot or batch for other purposes (e.g., production, shipment, etc.).

g. Lot or batch size. The lot or batch size is the number of units of product in a lot or batch.

h. Major defect. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

i. Major defective. A major defective is a unit of product which contains one or more major defects, and may also contain minor defects but contains no critical defect.

j. Minor defect. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

k. Minor defective. A minor defective is a unit of product which contains one or more minor defects but contains no critical or major defect.

l. Presentation of lots or batches. The formation of the lots or batches, lot or batch size, and the manner in which each lot or batch is to be presented and identified by the supplier shall be designated or approved by the responsible authority. As necessary, the supplier shall provide adequate and suitable storage space for each lot or batch, equipment needed for proper identification and presentation, and personnel for all handling of product required for drawing of samples.

m. Representative sampling. When appropriate, the number of units in the sample shall be selected in proportion to the size of sublots or subbatches, or parts of the lot or batch, identified by some rational criterion. When representative sampling is used, the units from each part of the lot or batch shall be selected at random.

n. Sample. A sample consists of one or more units of product drawn from a lot or batch, the units of the sample being selected at random without regard to their quality. The number of units or product in the sample is the sample size.

o. Sampling plan. A sampling plan indicates the number of units of product from each lot or batch which are to be inspected (sample size or series of sample sizes) and the criteria for determining the acceptability of the lot or batch (acceptance and rejection numbers).

p. Time of sampling. Samples may be drawn after all the units comprising the lot or batch have been assembled, or samples may be drawn during assembly of the lot or batch.

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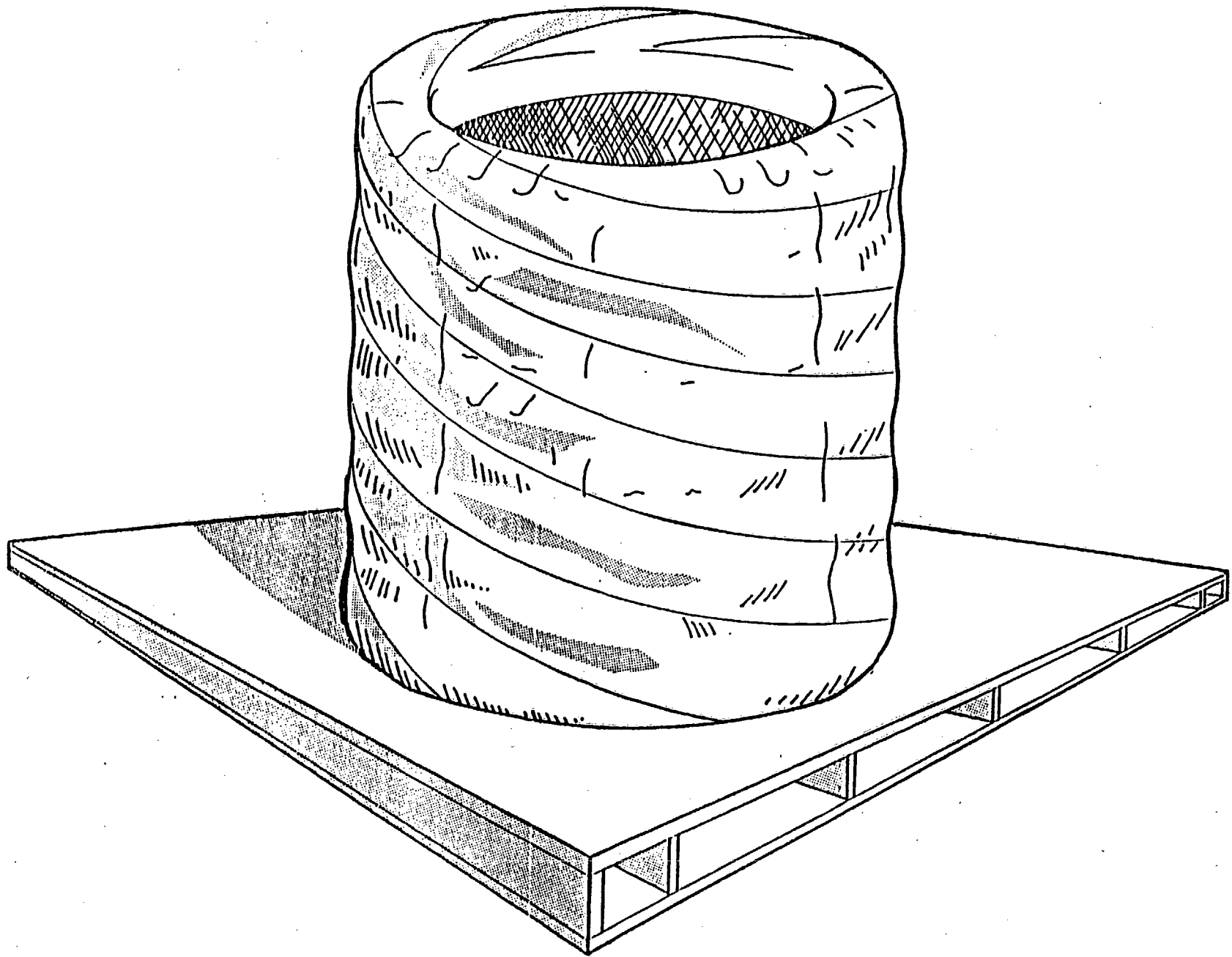
6.5.2 Recovered materials. "Recovered materials" means materials that have been collected or recovered from solid waste (see 6.5.3).

6.5.3 Solid waste. "Solid waste" means (a) any garbage, refuse, or sludge from a waste treatment plant, water supply treatment plant, or air pollution control facility; and (b) other discarded material, including solid, liquid, semisolid, or contained gaseous material resulting from industrial, commercial, mining and agricultural operations, and from community activities. It does not include solid or dissolved material in domestic sewage, or solid or dissolved material in irrigation return flows, or industrial discharges which are point sources subject to permits under section 402 of the Clean Water Act, (33 U.S.C. 1342 et seq.), or source, special nuclear, or byproduct material as defined by the Atomic Energy Act of 1954 (42 U.S.C. 2011 et seq.) (Source: Federal Acquisition Regulations, section 23.402).

6.6 Subject term (key word) listing.

- Heat seal test
- Intermediate container
- Inner tube
- Leakage test
- Preservation
- Recycled material
- Tire flap
- Unitization

6.7 AMC policy on AQLs/LTPDs. This specification is certified to be in compliance with current Army Materiel Command (AMC) policy for the elimination of AQLs/LTPDs (Acceptable Quality Levels/Lot Tolerance Percent Defectives) from military specifications.

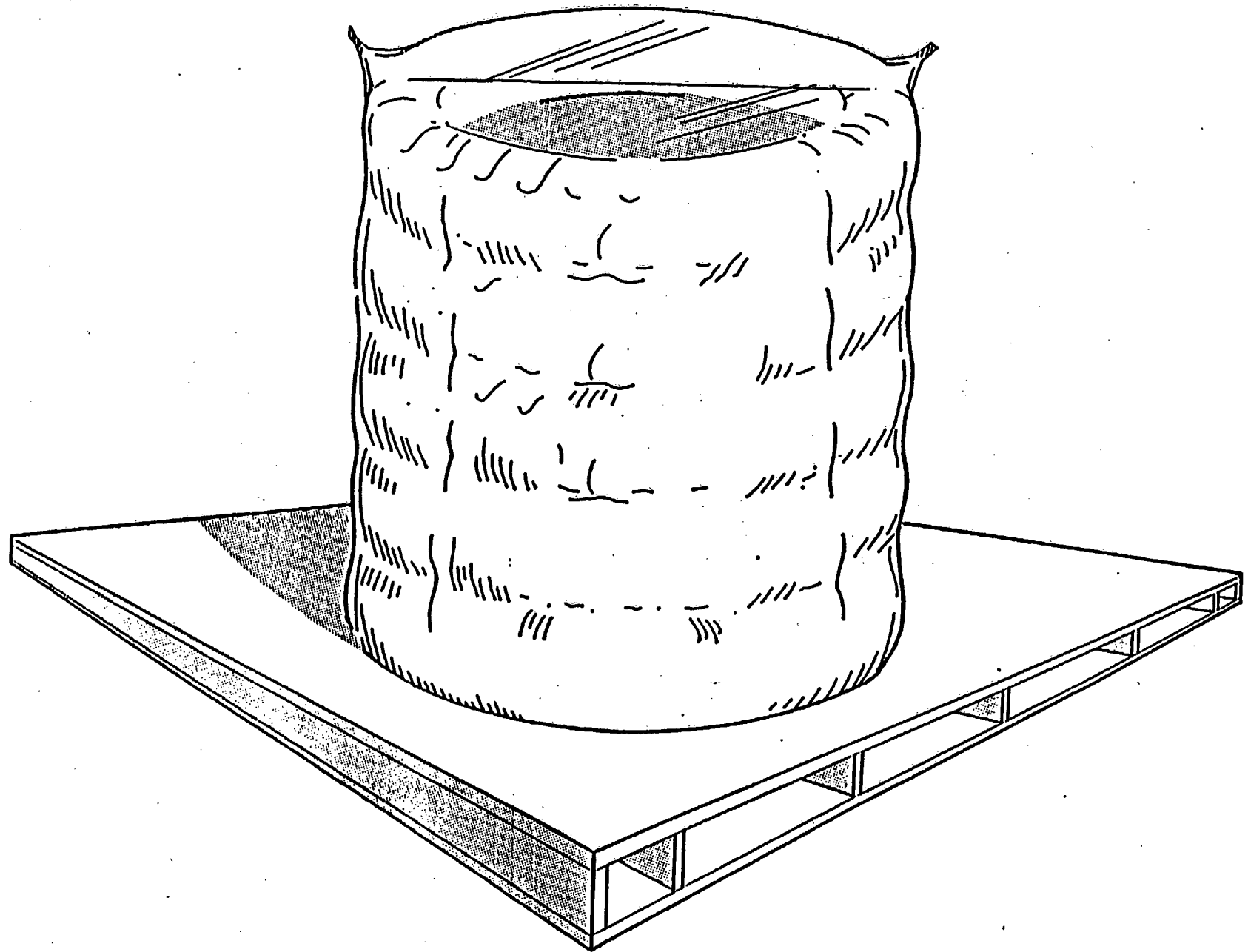


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FIGURE 1 - Stretch film pack.

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FIGURE 2 - Shrink film pack.

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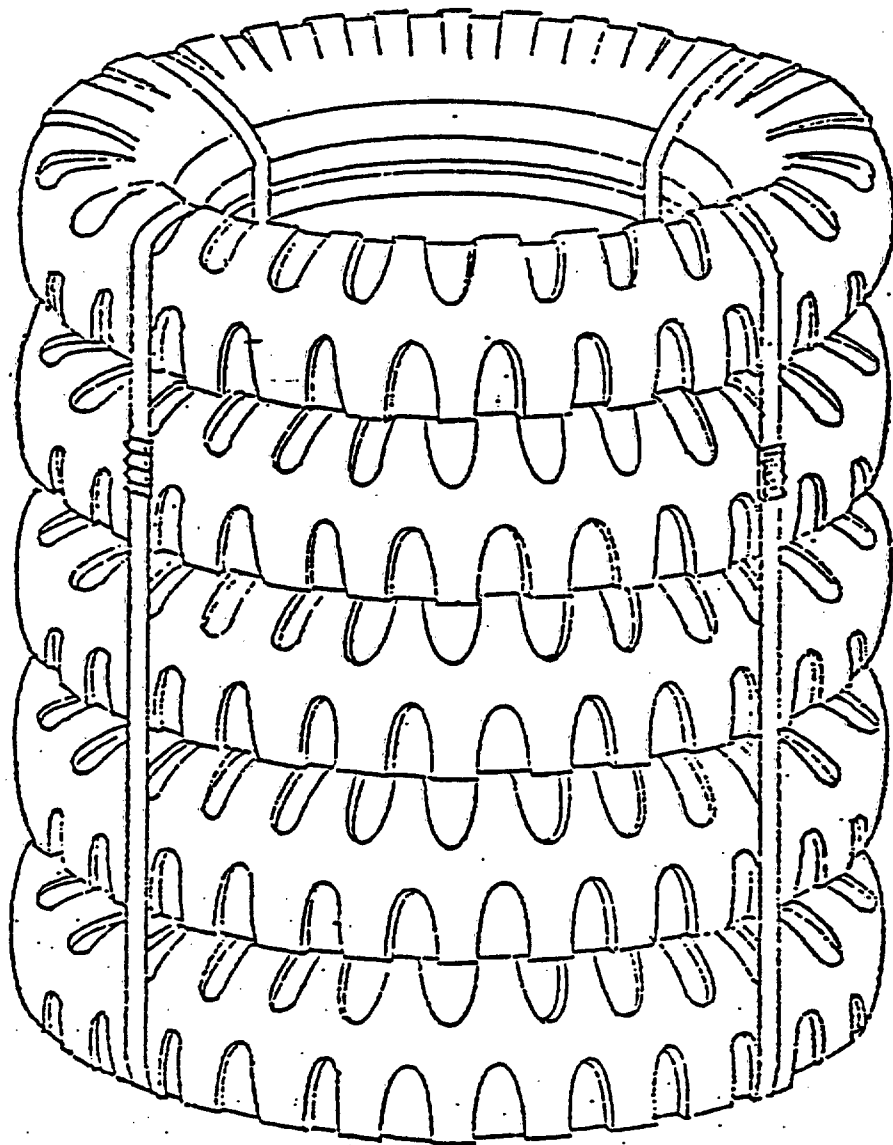


FIGURE 3 - Strapping.

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Custodians:

Army - AT
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Air Force - 84

Preparing activity:

Army - AT

(Project 2610-A152)

Review activities:

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Navy - BA

User activities:

Army - AV
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DEPARTMENT OF THE ARMY

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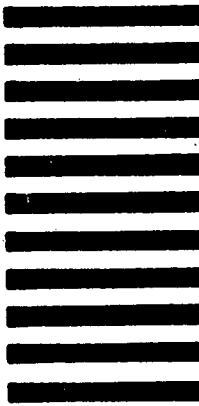


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