

USER SYMBOLS:

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*Review/new information is current as of the date of this document. For future coordination of changes to this document, draft circulation should be based on the information in the current 00D155.

This military standard is approved for use by all Departments & Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

APPLICATION - THIS STANDARD APPLIES TO QUALIFICATION, PRODUCTION SAMPLING, AND TESTING OF TRI-DEPARTMENT REBUILT AIRCRAFT TIRES. THESE TIRES ARE CLASSIFIED BY OTHER APPLICABLE MILITARY STANDARDS AS HIGH SPEED/HIGH PERFORMANCE (140 KNOTS AND ABOVE GROUND SPEED RATING AND/OR USED UNDER SEVERE SERVICE CONDITIONS).

REQUIREMENTS - HIGH SPEED/HIGH PERFORMANCE REBUILT AIRCRAFT TIRES SHALL CONFORM TO THE PROVISIONS OF MIL-R-7726, MIL-T-5041, AND THE APPLICABLE REBUILT TIRE MS DRAWINGS (SPECIFICATION SHEETS). THE PRODUCTION REBUILDING MATERIALS USED SHALL MEET THE FOLLOWING ADDITIONAL QUALIFICATION AND QUALITY ASSURANCE REQUIREMENTS:

QUALITY ASSURANCE REQUIREMENTS

PHYSICAL PROPERTY	REQUIREMENTS	TEST METHOD
TENSILE STRENGTH (PSI)	+15%	PARA. 4.6.4, MIL-R-7726
ULTIMATE ELONGATION (%)	±20%	PARA. 4.6.4, MIL-R-7726
DURUMETER A HARDNESS, (PTS)	±3	PARA. 4.6.14, MIL-R-7726
SPECIFIC GRAVITY	±0.02	PARA. 4.6.15, MIL-R-7726
COLD BEND TEST (-67°F)	NO CRACKING	PARA. 4.6.4, MIL-R-6855 4/
LOW TEMPERATURE TORSION RECOVERY (DEG.)	16.5" (MIN)	PARA. 4.5.9, MIL-T-5041 4/
RETREAD COMPONENT ADHESION (LBS)		PARA. 4.6.8, MIL-R-7726
a. TREAD TO BUFFED SURFACE	50.0 (MIN)	" "
b. TREAD TO REINFORCING PLY	AS DETERMINED (MIN)	" "
c. PLY TO PLY 2/	AS DETERMINED (MIN)	" "
CORD BODY PLY ADHESION (LBS) 3/	25 (MIN)	" "
BALANCE PAD ADHESION (LBS)	8.0 (MIN)	PARA. 4.6.10, MIL-R-7726

- 1/ PERMISSIBLE PRODUCTION VARIATION IN PHYSICAL PROPERTIES FROM ORIGINAL QUALIFICATION VALUES (AS ESTABLISHED BY THE COGNIZANT ENGINEERING ACTIVITY). "AS DETERMINED (MIN)" REQUIREMENTS SHALL MEET OR EXCEED THE VALUES ESTABLISHED IN THE QUALIFICATION TEST REPORT.
- 2/ VALUES SHALL BE OBTAINED FROM ADHESION AT THE INTERFACE OF THE FIRST AND SECOND REINFORCING PLYS.
- 3/ VALUES SHALL BE OBTAINED FROM ADHESION AT THE INTERFACE OF THE THIRD AND FOURTH PLY OF THE TIRE CARCASS MEASURED FROM THE TREAD. DISREGARD REINFORCING PLYS ADDED DURING REBUILDING.
- 4/ RESULTS FROM EITHER LOW TEMPERATURE TEST ARE ACCEPTABLE.

REBUILDING COMPOSITION - PRODUCTION REBUILDING MATERIAL SHALL HAVE AN INFRA-RED SPECTRUM IDENTICAL TO THAT OF THE ORIGINAL QUALIFICATION MATERIAL WHEN THE PYROLYZATE IS ANALYZED WITH A DOUBLE-BEAM INFRA-RED SPECTROPHOTOMETER.

COGNIZANT ENGINEERING ACTIVITY - THE DESIGNATED TRI-DEPARTMENT ENGINEERING ACTIVITIES ARE AS FOLLOWS:

ARMY - US ARMY AVIATION SYSTEMS COMMAND, ST. LOUIS, MO. 63166.
ATTN: AMSAV-QQC
AIR FORCE - SERVICES ENGINEERING AEROSPACE EQUIPMENT BRANCH, HILL AFB, UTAH 84406. ATTN: HEDS
NAVY - COMMANDING OFFICER, NAVAL AIR REWORK FACILITY, NORTH ISLAND, SAN DIEGO, CA. 92135. ATTN: CODE 34420

SAMPLES - QUALIFICATION TIRE - THE CONTRACTOR SHALL FORWARD ONE-HALF (1/2) OF THE DYNAMOMETER TESTED TIRE, ONE-HALF (1/2) OF THE UNTESTED REBUILT TIRE, AND THE REQUIRED QUALIFICATION TEST REPORTS (SEE MIL-R-7726) TO THE COGNIZANT ENGINEERING ACTIVITY. THE REMAINING TIRE HALVES SHALL BE KEPT ON FILE BY THE CONTRACTOR, PENDING FINAL QUALIFICATION APPROVAL.

PRODUCTION TIRE - SAMPLING PROCEDURES, FREQUENCY OF TESTING AND FORWARDING INSTRUCTIONS SHALL BE AS SPECIFIED IN THE CONTRACT AND AS DIRECTED BY THE COGNIZANT ENGINEERING ACTIVITY.

TESTING - QUALIFICATION TIRE - THE PHYSICAL PROPERTY REQUIREMENTS AS LISTED ABOVE SHALL BE DETERMINED BY THE COGNIZANT ENGINEERING ACTIVITY ON THE UNTESTED, REBUILT, QUALIFICATION TIRE FORWARDED BY THE CONTRACTOR.

PRODUCTION TIRE - THE PHYSICAL PROPERTY REQUIREMENTS LISTED ABOVE SHALL BE DETERMINED BY THE COGNIZANT ENGINEERING ACTIVITY OR ITS DESIGNATED GOVERNMENT LABORATORY.

REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.

(A) ENTIRE STANDARD REVISED

P.A. NAVY - AS Other Cust	TITLE	MILITARY STANDARD
Army - AV Air Force - 70	REBUILT TIRE-AIRCRAFT LABORATORY QUALITY ASSURANCE REQUIREMENTS	MS3377
PROCUREMENT SPECIFICATION MIL-R-7726	SUPERSEDES.	SHEET 1 OF 2

APPROVED 18 FEB 1969 REVISED (A) 9 JUN 75

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QUALITY ASSURANCE TEST REPORTS - QUALIFICATION TIRE - THE COGNIZANT ENGINEERING ACTIVITY SHALL FORWARD ONE (1) COPY OF THE TEST REPORT TO ITS DESIGNATED LABORATORY. THE DESIGNATED LABORATORY SHALL USE THE VALUES IN THE REPORT AS THE STANDARDS FOR PRODUCTION TESTING.

PRODUCTION TIRE - THE GOVERNMENT LABORATORY SHALL RETAIN ONE (1) COPY OF THE LABORATORY QUALITY ASSURANCE TEST REPORT AND FORWARD THREE (3) COPIES TO THE COGNIZANT ENGINEERING ACTIVITY.

- NOTE:**
- (A) ANY PRODUCTION TIRE TEST RESULT NOT MEETING THE REQUIREMENTS OF THE QTR RESULT SHALL BE REPORTED BY PRIORITY MESSAGE TO THE COGNIZANT ENGINEERING ACTIVITY.
 - (B) OTHER REQUIREMENTS FOR HIGH SPEED/HIGH PERFORMANCE REBUILT AIRCRAFT TIRES ARE COVERED BY INDIVIDUAL MILITARY STANDARDS OR DRAWINGS APPLICABLE TO EACH SIZE AND PLY RATED REBUILT TIRE.

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APPROVED 18 FEB 1969 REVISED (A) FOR CHGS SEE SHEET 1

P.A. NAVY - AS Other Cust Army - AV Air Force - 70	TITLE REBUILT TIRE-AIRCRAFT LABORATORY QUALITY ASSURANCE REQUIREMENTS	MILITARY STANDARD
		MS3377
PROCUREMENT SPECIFICATION MIL-R-7726	SUPERSEDES.	SHEET 2 OF 2