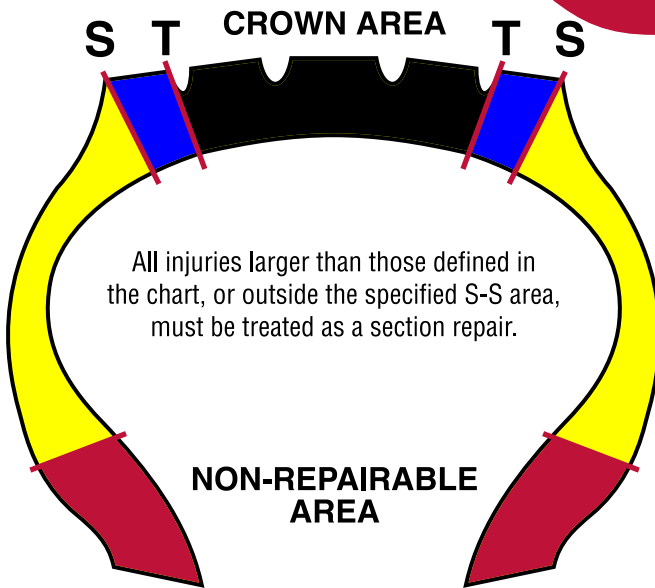


TECH Instructions for 2-Piece Nail Hole Repair Method

Refer to RM-5 Repair Manual for Additional Information



| RADIAL PASSENGER TIRE NAIL HOLE LIMITATIONS | | | | |
|---|----------------------|-------------|----------------|----------------|
| TIRE AREA | PREPARED INJURY SIZE | REPAIR UNIT | REPAIR STEM | CARBIDE CUTTER |
| T-T | 6mm (1/4") | CT-10 | ULS6 (250-1UL) | CC6 (270) |

| RADIAL MEDIUM TRUCK NAIL HOLE LIMITATIONS | | | | |
|---|----------------------|-------------|-----------------|----------------|
| TIRE AREA | PREPARED INJURY SIZE | REPAIR UNIT | REPAIR STEM | CARBIDE CUTTER |
| T-T | 6mm (1/4") | CT-10HD | ULS6 (250-1UL) | CC6 (270) |
| T-T | 8mm (5/16") | CT-12HD | ULS8 (251-1UL) | CC8 (271) |
| T-T | 10mm (3/8") | CT-20 | ULS10 (291-1UL) | CC10 (271/38) |
| S-T | 8mm (5/16") | CT-22 | ULS8 (251-1UL) | CC8 (271) |



1. Remove the tire from the wheel. Inspect tire for damages and defects. Do not repair tire if it shows any signs of: 1) underinflation; 2) run flat or overloading; 3) casing separation; 4) visible, bent or broken bead wires; 5) sidewall or tread cracking deeper than 3/32" (2mm); or 6) exposed cord from sidewall scuffing.



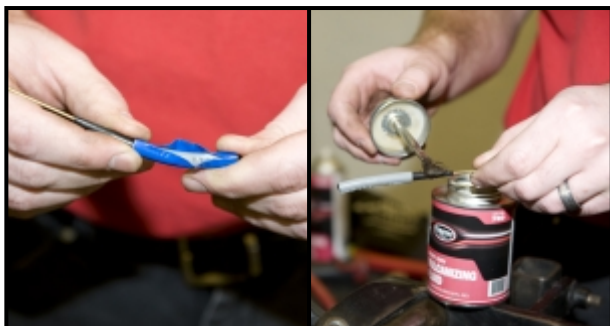
2. Pre-clean inner liner with Rub-O-Matic (#704A) rubber cleaner and a scraper. Repeat process 2 – 3 times to remove all contaminants.



3. Remove damaged rubber and steel from injury with a carbide cutter and low-speed drill (max. 1,200 RPM). Drill the injury from the inside of the tire 3 – 5 times and repeat this same process from the outside.



4. Apply Chemical Vulcanizing Fluid (#760) to the prepared injury using Spiral Cement Tool (#915) in a clockwise direction. Repeat 3 – 4 times.



5. Remove blue poly from the stem. Apply Vulcanizing Fluid (#760) to the tapered portion of the stem.



6. Pull the stem into place, leaving 1/8" (3mm) above the inner liner.



7. Outline the area to be buffed. Using a low-speed buffer (max. 5,000 RPM) and the appropriate inner liner wheel, buff the stem flush with the inner liner. Buff the inner liner to an RMA #1 or 2 texture.



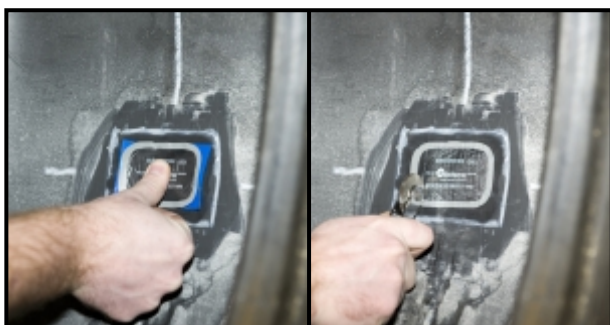
8. Use a soft wire brush to remove buffing dust and debris from the buffed area, followed by a vacuum to remove this material from the tire.



9. Apply a thin, even coat of Chemical Vulcanizing Fluid (#760) to the buffed surface. Allow to dry 3 – 5 minutes. Allow additional drying time in cold or humid conditions.



10. Partially remove the protective poly from the back of the repair, exposing only the middle portion of the repair. Center the repair over the injury.



11. Press down the center with your thumb. Stitch repair unit down from the center out. Remove the blue poly from the under cap and continue stitching toward the edges of the repair.



12. Remove clear poly from the repair. Seal the edges of the repair and the over buffed area with Security Coat Repair Sealer (#738).



13. With the stem relaxed, cut off the excess 1/8" (3mm) above the tread surface. The tire is ready to be returned to service.



WARNING

Failure to properly repair tire could cause **SUDDEN TIRE FAILURE, RESULTING IN SERIOUS INJURY OR DEATH.** Carefully read and follow these instructions.