



Technical Data Sheet for Permacure Repairs

Item Number(s): 220, 222, 224 and 226

Product Use: Permacure repairs are nylon reinforced tire repairs designed for all tubeless tires. They are primarily used for filling of injuries in tubeless tires. May also be used a filler material for use in two piece repairs with an inside repair.

Test Methods: Permacure repairs 220, 222, 224 and 226 are all tested in using a standardized test process. A random sample is taken from each line every 15 minutes. Each 15 minute lot is segregated and placed on hold until they are released. A flexible hose is run from a valve, this flexible hose is attached to one end of the Permacure and the flexible hose is then pressurized as the Permacure repair is submerged in water. The repair remains under water for 15 seconds, if no air bubbles are observed, this is recorded and the lot is released. If air bubbles are observed, five additional repairs from the lot are tested, if any air bubbles are observed on any of the additional samples, the lot is scrapped. This Test method could be also used by a customer to verify that the repairs are air tight.

The bonding gum applied to Permacure repairs is also fully tested and Tech always uses freshly produced cushion gum on the repairs. To verify that the gum is fresh in the field, a technician can use a knife to push the point into the gum. This will assure that the gum has good movement thus verifying freshness.

In addition to this testing, all repairs are inspected for length as random samples are inspected for gauge and weight. Tech International has established internal specifications for diameter and weight of all Permacure repairs to assure that they will properly fill the injury.

In addition, tire testing is also performed on a regular basis to assure that the product performs as well as it has for the last 25 years of reliable service.

Physical/Chemical Properties: Permacure repairs are made from 100% natural rubber. The body of the repair is nylon reinforced. The reinforcement is coated with a natural rubber material that is fully cured. The repairs are then wrapped with a layer of uncured gray bonding gum.

Strength of Repairs: 220 repair nominal strength is 180 psi to break, 222, 224 and 226 repairs nominal strength is 200 psi to break

Repair length: 220 and 222 = 95mm +/- 1.5mm, 224 = 130mm +/- 1.5mm, 226 = 190.5mm +/- 1.5mm

Repair Diameter: Diameter is in an oval shape. The 220 average width is 7mm +/- .5 mm and the height is 3.6mm +/- .4mm, the 222, 224 and 226 repairs are all the same shape and

dimensions. The average width of these repairs is 8mm \pm .6mm and the height is 3.8mm \pm .5mm.

Date coding on repairs: Tech International places a date code on every box of repairs. Example, 1214 would indicate that the repair was manufactured the 12th week of 2014.

Shelf life: The typical shelf life of Permacure repairs is three years from the date of manufacturing as long as the repairs have been stored out of direct sun light and in temperatures at or below 86°F (30°C). Higher temperatures will result in decreased shelf life.

Quality Assured by R&D Department

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10/23/14