



## The Patch Rubber Company

Patch Rubber Company, a Myers Industries company, is a complete rubber manufacturing facility providing efficient volume production of molded, calendered, extruded rubber products, and adhesives.

Located in Roanoke Rapids, North Carolina, our facilities are part of an industrial park setting on 20 acres of land with over 170,000 sq. feet of climate-controlled manufacturing, warehousing and distribution space.

### Manufacturing Capabilities:

- Compound Mixing
- Calendering
- Slitting and Re-rolling
- Extruding
- Compression, Transfer and Convection Curing
- Adhesive Mixing
- Adhesive Laminating
- Laboratory Testing and Formulating
- Climate Controlled Manufacturing and Storage



Certificate #008799



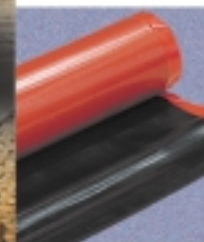
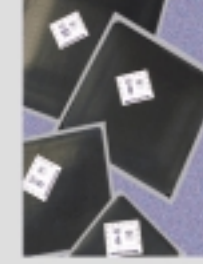
Committed To Being the Best at Meeting Customers' Needs.

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Form No. 400066 10/00 2M

## OTR REPAIR PRODUCT CATALOG

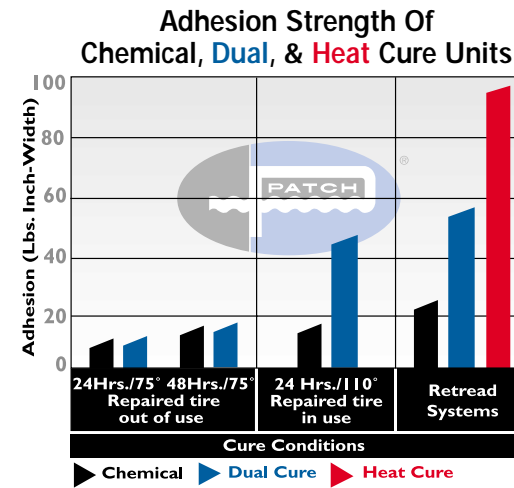
- Giant Tire Bias Ply Repairs
- Radial Repairs
- Implement Tires & Specialty Materials
- Tire Repair Materials
- Cements & Chemicals
- Repair Charts



Committed To Being the Best at Meeting Customers' Needs.

**Uncured, Dual Cure & Heat Cure Repair Units**

Patch Rubber Company offers the option of either **Heat Cure** or **Dual Cure** bonding gum as well as **Uncured** repair units so you can select a repair unit that fits your needs. All Heat Cure and Dual Cure repair units are cured at the factory under ideal pressure and temperature conditions assuring correct positioning of the ply package, rubber coverings and gum strips. No matter which type you choose, our tire repair units are designed to be user-friendly in less than ideal conditions.



► **Uncured Repair Units**    ► **Dual Cure Repair Units**    ► **Heat Cure Repair Units**

Uncured Repair Units must be applied with heat and pressure. **They will not chemically cure.** These repair units provide maximum adhesion and maximum flexibility during installation.

**Maximum Adhesion**

When cured by heat and pressure, these repair units provide the maximum adhesion available. Additional floater gum insures a proper bond even with slight imperfections at the buff.

**Maximum Flexibility**

Because of the uncured condition, the repair units have increased flexibility to make installation for the repairman easier.

**Cement Application Procedures**

Apply uncured repair units with Black Brush Type Cement (pg. 7) in curing systems that can vulcanize an uncured tire repair unit (section mold – Autoclave with temperatures 260°F and higher).

Dual Cure Repair Units chemically vulcanize at room temperature or when heat and pressure are applied. Dual Cure Repair Units provide many benefits to the tire repairman:

**User Friendly**

Our soft, high tack gum is less prone to problems associated with moisture, handling and cement drying time, allowing easy application.

**Superior Green Tack**

Soft and tacky Dual Cure Base Gum “locks” the repair unit in place until a full cure has occurred.

**Optimal Adhesion**

Dual Cure Bonding Gum has over twice the adhesive strength of chemical cure repair units.

**Flexibility In Use**

Depending on your need, Dual Cure Repair Units will fully cure during the retreading process, in a section mold, or with the heat and pressure created by a tire in service.

► **Cement Application Procedures**

Apply Dual Cure Repair Units with Fast-Dry Self-Vulcanizing Cement (see pg. 7).

Heat Cure Repair Units must be applied with direct heat and pressure. **They will not chemically cure.** Heat Cure Repair Units provide many benefits to the tire repairman:

**Maximum Adhesion**

When cured by heat and pressure, these repair units provide superior adhesion over chemically cured patches, and equivalent adhesion to uncured (green or raw) patches.

**A Permanent Repair**

During the curing process, the layer of Bonding Gum flows into imperfections in buffed surfaces acting as a “safety factor” for less-than-perfect application procedures. Because of increased adhesion to the tire casing, fewer units need to be removed prior to subsequent retreading cycles.

**Improved Appearance**

The heat cure repair units are cured at the factory which provides an improved appearance over uncured repairs. Repair Units feather into the tire innerliner, giving the repair an almost unnoticeable appearance.

► **Cement Application Procedures**

Apply Heat Cure Repair Units with Black Brush Type Cement (see pg. 7) in curing systems which typically can vulcanize a totally uncured tire repair unit. (Section Mold - Autoclave: Curing temperatures 260°F and higher.) Apply with Fast-Dry Cement (see pg. 7) in curing systems which provide marginal heat conditions. (Repairing while retreading in molds and chambers.) Chamber curing at 210°F may not provide sufficient temperature for proper vulcanization unless standard curing time is increased.

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**Statement of Warranties**

**(1) What Is Covered By This Warranty and Exclusive Remedies.** Patch Rubber Company (“PRC”) warrants that the product that is the subject of this sale (“product”) (a) conforms to PRC’s published specifications, and (b) is free from defects in material or workmanship. This warranty extends to the original purchaser only. The duration of this warranty is for one year. The warranty period begins on the date of delivery to the original purchaser. If the purchaser discovers within this period a failure of the product covered by this warranty, it must promptly notify PRC in writing. PRC must receive this notice during the warranty period or within thirty (30) days thereafter. Within a reasonable time after such notification, PRC will provide, at its sole option, either replacement product or refund of the purchase price. The remedies listed in this section are the purchaser’s EXCLUSIVE REMEDIES for breach of warranty. Any action for breach of warranty must be commenced within 15 months following delivery of the goods to the original purchaser.

**(2) What Is Not Covered By This Warranty.** PRC does not warrant (a) any product, component, or part not manufactured by PRC, (b) defects or damage caused by failure to provide a suitable environment for the product, (c) defect or damage caused by use of the product for purposes other than those for which it was designed, (d) defect or damage caused by natural or man-made disasters, including but not limited to fire, flood, wind, and lightning, (e) defect or damage caused by unauthorized attachments or modification, (f) damage during shipment, (g) failure to properly maintain product, or (h) any other abuse or misuse of the product.

**(3) Disclaimer of Warranty.** THE FOREGOING WARRANTIES ARE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

**(4) Limitation of Remedies.** In no case shall PRC be liable for any special, incidental, or consequential damages based upon breach of warranty, breach of contract, negligence, strict tort, or any other legal theory. Such damages include, but are not limited to, loss of profits, loss of savings or revenue, loss of use of the product or any associated equipment, cost of capital, cost of any substitute equipment, facilities or services, downtime, the claims of third parties including customers, and injury to property. This limitation does not apply to claims for personal injury. Where restricted by law, the warranty and remedy limitations in this Section and Section (3) will apply to the maximum extent allowed; any implied warranty of merchantability or fitness not disclaimed by operation of law is limited to the duration of the express warranty. This agreement allocates the risks of product failure between PRC and the purchaser. This allocation is recognized by both parties and is reflected in the product price.

**(5) No Other Warranties.** Unless modified in a writing signed by both parties, this agreement is understood to be the complete and exclusive agreement between the parties, superseding all prior agreements, oral or written, and all other communications between the parties or representations by PRC relating to the subject matter of this agreement. No employee or agent of PRC or any other party is authorized to make any warranty in addition to those made in this agreement.

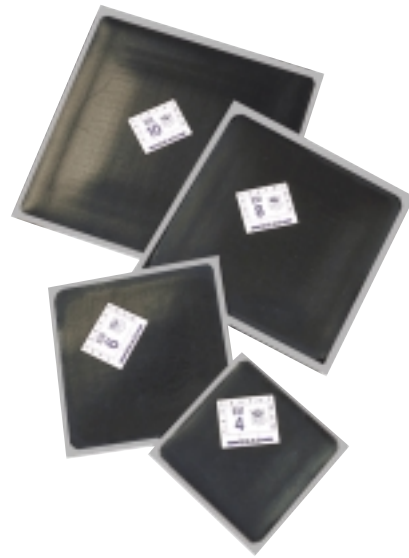
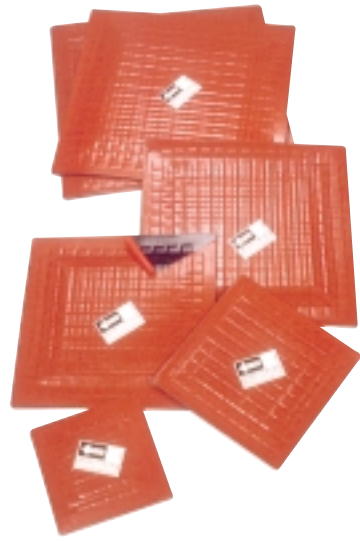
# GIANT TIRE BIAS REPAIRS



► **UNCURED**

► **DUAL CURE**

► **HEAT CURE**



## EM Repair Units

► **Uncured** ► **Dual Cure** ► **Heat Cure**

For reinforcement and section repairs in bias ply off-the-road tires. The EM Repair Units have plies made from strips of cord overlaid in an intricately-spaced design to form a "square lattice". This design allows the repair unit to flex with the tire.

Uncured		Dual Cure		Heat Cure		Size		Qty/
Order No.	Mfr. Code	Order No.	Mfr. Code	Order No.	Mfr. Code	In.	mm	Box
10-304	EM 4	12-304	EM DC 4	12-404	EM HC 4	6½	165	15
10-306	EM 6	12-306	EM DC 6	12-406	EM HC 6	8½	216	10
10-308	EM 8	12-308	EM DC 8	12-408	EM HC 8	10¼	260	8
10-310	EM 10	12-310	EM DC 10	12-410	EM HC 10	12¼	311	6
10-312	EM 12	12-312	EM DC 12	12-412	EM HC 12	14¼	362	5
10-314	EM 14	12-314	EM DC 14	12-414	EM HC 14	16¼	413	5
10-316	EM 16	12-316	EM DC 16	12-416	EM HC 16	18¼	464	2
10-318	EM 18	12-318	EM DC 18	12-418	EM HC 18	20¼	514	1
10-320	EM 20	12-320	EM DC 20	12-420	EM HC 20	24¼	616	1

For cement recommendations see pg. 3.

## OTR Repair Units

► **Uncured** ► **Dual Cure** ► **Heat Cure**

For reinforcement and section repairs in bias ply off-the-road tires, the OTR Repair Units have solid-ply construction, providing a large platform repair area in a smaller patch. Die-cut edges distribute the cord-end stresses across a radiused area, preventing lifting of the cord edges.

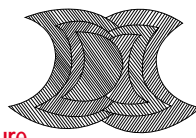
Uncured		Dual Cure		Heat Cure		Size		Qty/
Order No.	Mfr. Code	Order No.	Mfr. Code	Order No.	Mfr. Code	In.	mm	Box
10-340	OTR 4	12-380	OTR DC 4	12-580	OTR HC 4	6	152	10
10-342	OTR 6	12-382	OTR DC 6	12-582	OTR HC 6	8	203	10
10-344	OTR 8	12-384	OTR DC 8	12-584	OTR HC 8	10	254	10
10-346	OTR 10	12-386	OTR DC 10	12-586	OTR HC 10	12	305	5
10-348	OTR 12	12-388	OTR DC 12	12-588	OTR HC 12	14	356	5
10-350	OTR 14	12-390	OTR DC 14	12-590	OTR HC 14	16	406	5
10-352	OTR 16	12-392	OTR DC 16	12-592	OTR HC 16	18	457	2
10-354	OTR 18	12-394	OTR DC 18	12-594	OTR HC 18	20	508	1
10-356	OTR 20	12-396	OTR DC 20	12-596	OTR HC 20	24	610	1

For cement recommendations see pg. 3.

## Butterfly Sidewall EM Repair Units

► **Uncured** ► **Dual Cure** ► **Heat Cure**

For sidewall reinforcement or section repair in giant bias ply tires. The patented construction provides a strong and flexible unit that can be applied parallel or perpendicular to the bead as dictated by the injury location.



Uncured		Dual Cure		Heat Cure		Size		Qty/
Order No.	Mfr. Code	Order No.	Mfr. Code	Order No.	Mfr. Code	In.	mm	Box
10-370	BTFly 1	12-280	BTFly DC 1	12-480	BTFly HC 1	9 x 12	229 x 305	5
10-372	BTFly 2	12-282	BTFly DC 2	12-482	BTFly HC 2	11 x 15	279 x 381	5
10-374	BTFly 3	12-284	BTFly DC 3	12-484	BTFly HC 3	11 x 15	279 x 381	5
10-376	BTFly 4	12-286	BTFly DC 4	12-486	BTFly HC 4	12 x 17	305 x 432	5
10-378	BTFly 5	12-288	BTFly DC 5	12-488	BTFly HC 5	13 x 19	330 x 483	5

For cement recommendations see pg. 3.

# GIANT TIRE RADIAL REPAIRS



► **DUAL CURE**

► **HEAT CURE**



## Bullseye Radial OTR Repair Units

► **Dual Cure** ► **Heat Cure**

For section repairs in radial-ply off-the-road tires. These Bullseye Units feature an elongated stepdown between plies, together with additional top cover stock. These features allow the repair unit to be centered over the injury and anchored in any flex area of the tire.

### Bullseye Radial Repairs

Dual Cure		Heat Cure		Size		Qty/
Order No.	Mfr. Code	Order No.	Mfr. Code	In.	mm	Box
12-070	BUL DC 46	12-270	BUL HC 46	5 x 16	127 x 406	5
12-071	BUL DC 50	12-271	BUL HC 50	7 x 21	178 x 533	5
12-072	BUL DC 52	12-272	BUL HC 52	9 x 21	229 x 533	5
12-073	BUL DC 56	12-273	BUL HC 56	9 x 28	229 x 711	2
12-074	BUL DC 60	12-274	BUL HC 60	10 x 38	254 x 965	2

For cement recommendations see pg. 3.

### Bullseye Radial Crown Repairs

Dual Cure		Heat Cure		Size		Qty/
Order No.	Mfr. Code	Order No.	Mfr. Code	In.	mm	Box
12-069	BUL DC 45	12-269	BUL HC 45	9 x 7½	229 x 190	5
12-075	BUL DC 55	12-275	BUL HC 55	13 x 10	330 x 254	5
12-076	BUL DC 65	12-276	BUL HC 65	17 x 13½	432 x 343	3
12-077	BUL DC 75	12-277	BUL HC 75	21 x 17	533 x 432	3

For cement recommendations see pg. 3.

## EMR Radial Repair Units

► **Uncured** ► **Dual Cure** ► **Heat Cure**

For section repairs in radial ply off-the-road tires. A combination of EM and radial tire construction techniques have created a specially-reinforced radial, off-the-road tire repair, which is extremely flexible and is equally suited for larger sidewall and shoulder injuries.

Uncured		Dual Cure		Heat Cure		Size		Qty/
Order No.	Mfr. Code	Order No.	Mfr. Code	Order No.	Mfr. Code	In.	mm	Box
10-295	EMR 15	12-220	EMR 15	12-520	EMR HC 15	5 x 16	127 x 406	5
10-296	EMR 20	12-221	EMR 20	12-521	EMR HC 20	9 x 20	229 x 508	5
10-297	EMR 27	12-222	EMR 27	12-522	EMR HC 27	10 x 27	254 x 685	5
10-298	EMR 38	12-223	EMR 38	12-523	EMR HC 38	10 x 38	254 x 965	5

(For non-flex to non-flex application.) For cement recommendations see pg. 3.

## Wide-Base EMR Repair Units

► **Uncured**

A larger version of the EMR Radial Repair units. These Wide-Base EMR repair units have more surface area for increased adhesion. A strong repair for severe repair service on haulage tire or other off-road tires.

Uncured		Size		Qty/
Order No.	Mfr. Code	In.	mm	Box
10-300	EMR 40 WB	17½ x 40	444 x 1016	3
10-301	EMR 20 WB	11 x 20	279 x 508	5
10-302	EMR 27 WB	13½ x 27	343 x 686	5

For cement recommendations see pg. 3.

### HEAT SHIELD

All Heat Cure Giant Tire Repair Units are covered with a special heat-resistant layer and marked by a Heat Shield Protected decal. This Heat Shield protects the entire repair unit from oxidation and heat degradation caused by the extreme operating temperatures common in giant tires.

- Protective Heat Shield
- Flex Resistant Top Cover Rubber
- Giant Tire Ply Construction
- Base Compound Floater Gum
- HC Bonding Gum



### Skidder/Tractor

#### Bias Repairs

##### ► Dual Cure

These repair units feature a large ply platform to accommodate the large injuries commonly found in skidder and tractor section repairs, yet are lightweight and flexible in light ply tires. The multi-directional repair units may be applied parallel or perpendicular to the beads to properly repair any type of injury.

Dual Cure						
Order No.	Mfr. Code	Size		Ply	Qty/Box	
		Inches	mm			
12-431	SKD DC 1	9 x 12	229 x 305	4	5	
12-432	SKD DC 2	11 x 15	279 x 381	4	5	
12-433	SKD DC 3	12 x 17	305 x 432	4	5	
12-434	SKD DC 4	13 x 19	330 x 483	4	5	
12-435	SKD DC 5	9 x 12	228 x 305	6	5	
12-436	SKD DC 6	11 x 15	279 x 381	6	5	
12-437	SKD DC 7	12 x 17	305 x 432	6	5	
12-438	SKD DC 8	13 x 19	330 x 483	6	5	
12-451	HDSKD DC 6	11 x 15	279 x 381	8	5	
12-452	HDSKD DC 7	11 x 15	279 x 381	10	5	
12-453	HDSKD DC 8	12 x 17	305 x 432	10	5	
12-454	HDSKD DC 9	13 x 19	330 x 483	10	5	



### Under Tread Repairs

#### Bias Repairs

##### ► Uncured

Compact repair units for reinforced and section repairs in truck and off-the-road tires. Constructed of specially-cut and fabricated plies, these units can be counter-sunk into the buffed casing in the crown area and cured during the retread process. Use in conjunction with bias ply repair units to make a sandwich repair. Apply with Black Brush-Type cement (see pg. 7).

Uncured					
Order No.	Mfr. Code	Size		Qty/Box	
		Inches	mm		
10-102	UT 4-3	4 x 3	102 x 76	25	
10-105	UT 6-4	6 x 4	152 x 102	25	
10-108	UT 8-4	8 x 4	203 x 102	20	
10-110	UT 10-6	10 x 6	254 x 152	10	
10-111	UT 12-8	12 x 8	305 x 203	5	
10-112	UT 14-10	14 x 10	356 x 254	5	
10-114	UT 8-6	8 x 6	203 x 152	10	

Dual Cure					
Order No.	Mfr. Code	Size		Qty/Box	
		Inches	mm		
12-060	BUL DC 80	6 x 7 3/4	152 x 197	5	
12-061	BUL DC 82	7 1/2 x 10	191 x 254	5	
12-062	BUL DC 84	8 1/2 x 11 1/2	216 x 292	5	
12-063	BUL DC 86	9 3/4 x 13 1/2	248 x 343	5	

### Radial Tractor

#### Bullseye Radial Tractor Repairs

##### ► Dual Cure

For tread and sidewall section repairs in radial off-the-road tires. Bullseye Radial Tractor Repairs are constructed of one-directional fabric for reinforcement of the radial ply package. Special rubber compound gives maximum adhesion and resists over cures and the effects of radial tire flexing. Apply with Black Brush-Type Cement (see pg. 7).



### Fiber Bond Cement

A high solid content cement for hot and cold tread rubber application. Available in spray or brush type for retreading and repairing. Excellent adhesion and tack in all humidity conditions. Flammable. Flash point below 0°F. Shelf life 1 year.

Order No.	Size	liters	Ship Wt./Case	
			Lbs.	kg
16-354	5 Gal. - Spray Type	18.9	35	16
16-355	54 Gal. - Spray Type	205	385	173
16-349	1 Gal. - Brush Type	3.8	8	3.5
16-350	5 Gal. - Brush Type	18.9	35	16
16-351	54 Gal. - Brush Type	205	418	188

### Fast-Dry Cement

Fast-Dry Self-Vulcanizing Cement eliminates the most common cause of failed repairs — lack of proper drying time. Fast-Dry Cement activates the chemical vulcanization process to bond repair units to the tire casing. Flammable. Flash point -4°F. Shelf life 1 year.

Order No.	Size	liters	Ship Wt./Case		Case Qty.
			Lbs.	kg	
16-450	1 Qt.	.94	11	5	6
16-451	8 Oz.	.25	7	3	12
16-452	1 Gal.	3.8	32	15	4

### Repair Sealer

Restores the air retention qualities to the overbuff area or a damaged innerliner. Can be used in a service application or prior to the repair/ retreading cycle. Flammable. Flash point 14°F. Shelf life 1 year.

Order No.	Size	liters	Ship Wt./Case		Case Qty.
			Lbs.	kg	
16-170	1 Pt.	.47	11	5	12
16-171	1 Gal.	3.8	32	15	4

### Chemical Vulcanizing Fluid

All purpose chemical cement. Use with Chemical Cure materials. Non-Flammable. Shelf life 1 year.

Order No.	Size	liters	Weight		Case Qty.
			Lbs.	kg	
16-430	8 Oz.	.25	13	6	12
16-431	1 Qt.	.94	23	10	6
16-432	1 Gal.	3.8	50	23	4

### Black Repair Cement

Use for buzz-outs, exposed fabric and with uncured gums. A fast-drying, penetrating, heat-curing cement. Use with repairs which are vulcanized with heat and pressure. (Section, reinforced and spot repairs.) Flammable. Flash point below 0°F. Shelf life 1 year.

Order No.	Size	liters	Ship Wt./Case		Case Qty.
			Lbs.	kg	
16-325	1 Qt.	1.0	12	5	6
16-326	1 Gal.	3.8	32	15	4
16-327	5 Gal.	18.9	39	18	1

### HV Chemical Cement

Recommended adhesive for tube-type tires. Specially formulated, high-viscosity adhesive for applications where a tackier cemented surface is required. Blue color identifies where the cement has been applied during application and after cement has dried. Fast-drying solvent reduces waiting and repair failures due to wet cement. Compatible with Heat Cure or Dual Cure repairs. Flammable. Flash point -4°F. Shelf life 1 year.

Order No.	Size	liters	Ship Wt./Case		Case Qty.
			Lbs.	kg	
16-460	8 Oz.	.25	7	3	12
16-461	1 Qt.	.94	11	5	6

### Butyl Innerliner Sealer

This two-part mixture, when brushed onto damaged innerliners, will cure at room temperature and renew the air retention properties of the innerliner. Heavy, viscous butyl cement to be mixed with activator. Once ingredients are mixed, sealer is usable for up to 3 hours. Flammable. Flash point below 0°F. Shelf life 1 year.

Order No.	Item	Size	liters	Weight	
				Lbs.	kg
16-290	Sealant	1 Gal.	3.8	9	4
16-239	Activator	50cc Tube	-	1	.5
16-291	Sealer	5 Gal.	18.9	40	18
16-240	Activator	250cc Can	-	2	1

### Chem Seal Tubeless Tire Sealant

Use to protect against slow leaks caused by porous innerliners, pinhole leaks and normal wheel porosity. Improved rust inhibitors reduce damaging rust build-up on the rim. Extend the useful life of any OTR, heavy-duty or light-truck tire with a simple application of Chem Seal to the innerliner.

Order No.	Gal.	Size	liters	Weight	
				Lbs.	kg
16-120	1 Gal.		3.8	8	4
16-121	5 Gal.		18.9	38	17
16-122	54 Gal.		205	485	220

**Extruder Rope**

**RMA Cure Class 10A/15C**

All-Purpose Extruder Rope. A soft, extrudable compound that eliminates air pockets, flows easily into contours and crevices of buzz-outs. Made with Fast Cure material. Consistent quality reduces gun maintenance problems. Cure rate: 8 min/280°F, 15 min/260°F. Shelf life: 3 months. Use with Black Brush Type Cement.

Order No.	Width		Wt/Box	
	Inches	mm	Lbs.	kg
18-122	3/8	10.0	25	12



**Tread Rope**

**RMA Cure Class 20A/35C**

Formulated to provide a finished repair with tread rubber qualities yet easily processed through the extruder gun. Cure rate: 20 min/280°F, 35 min/260°F. Shelf life 1 year. Use with Black Brush Type Cement.

Order No.	Width		Wt/Box	
	Inches	mm	Lbs.	kg
18-118	3/8	10.0	25	12

**Black & Tan Rope Rubber**

**Chemical Cure**

Feed Black and Tan Rope Rubber through an extruder gun to form a repair putty. Once properly mixed, putty compound chemically cures at room temperature.

Order No.	Description	Width x Gauge		Wt/Box	
		Inches	mm	Lbs.	kg
18-120	Tan Chem Ext. Rope	3/4 x .125	9 x 3.2	5	2
16-501	Black Chem Ext. Rope	3/4 x .125	19 x 3.2	5	2



**Cushion Gum**

**RMA Cure Class 20A/35C**

Fill buzz-outs over exposed cords, spot repairs, reinforce repairs and section repairs. Natural rubber compound with excellent tack and workability. Cure rate: 20 min/280°F, 35 min/260°F. Shelf life: 1 year.

Order No.	Width x Gauge		Wt/Box	
	Inches	mm	Lbs.	kg
18-191	4 x 1/32	102 x .8	25	12
18-193	6 x 1/32	152 x .8	25	12
18-196	4 x 1/16	102 x 1.6	25	12
18-197	6 x 1/16	152 x 1.6	25	12
18-198	2 x 1/32	51 x .8	30	14
18-199	3 x 1/32	76 x .8	30	14
18-200	18 x 1/16	457 x 1.6	10	5
18-201	18 x 1/32	457 x .8	10	5
18-202	18 x 1/64	457 x .4	10	5



**Floater Gum**

All-natural gum specially compounded to use with EM patches. High flex-resistant quality floater gum acts as a shock absorber between the tire and EM patch. Shelf life 1 year. Use with Black Brush Type Cement.

Order No.	Width x Gauge		Wt/Box	
	Inches	mm	Lbs.	kg
18-150	18 x 1/8	457 x 3.2	10	4.5



**Tread Gum**

**RMA Cure Class 20A/35C**

Use to make repairs exposed to wear and/or weather conditions. Tough, abrasion-resistant compound with excellent finishing and wearing qualities. Cure rate: 20 min/280°F, 35 min/260°F. Shelf life: 1 year.

Order No.	Width x Gauge		Wt/Box	
	Inches	mm	Lbs.	kg
18-207	18 x 1/16	457 x 1.6	10	5

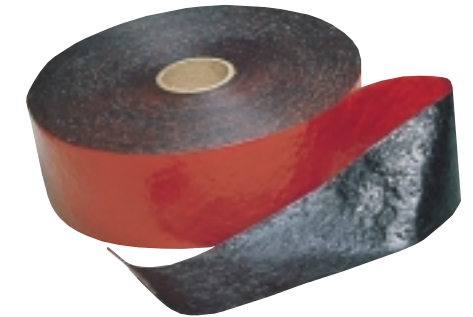


**Fiber Gum**

**RMA Cure Class 20A/35C**

Natural rubber cushion gum reinforces injured areas through the directional strength of impregnated nylon fibers. For light reinforcement, Fiber Gum can be custom cut and plied up. Cure rate: 20 min/280°F, 35 min/260°F. Shelf life: 1 year.

Order No.	Width x Gauge		Wt/Box	
	Inches	mm	Lbs.	kg
18-283	3 x 1/16	76 x 1.6	15	7
18-284	18 x 1/16	457 x 1.6	25	12



**Repair Cord**

Use to build reinforced repairs to tires, conveyor belting and other types of fabric-reinforced rubber goods. High tensile-strength tire cord calendered with high-quality skim compound to a uniform gauge. Cure rate: 30 min/280°F, 50 min/260°F. Shelf life: 1 year. Apply with Black Brush Type Cement

Order No.	Item	Width x Gauge		Wt/Box	
		Inches	mm	Lbs.	kg
15-007	Nylon	29 x 3/64	736 x 1.200	19	9
15-009	Polyester	29 x 3/64	736 x 1.200	19	9
98-006	Nylon Sq. Woven	28 x 3/64	711 x 1.200	15	7
98-001	Nylon H.D. Sq. Woven	28 x 1/16	711 x 1.600	15	7

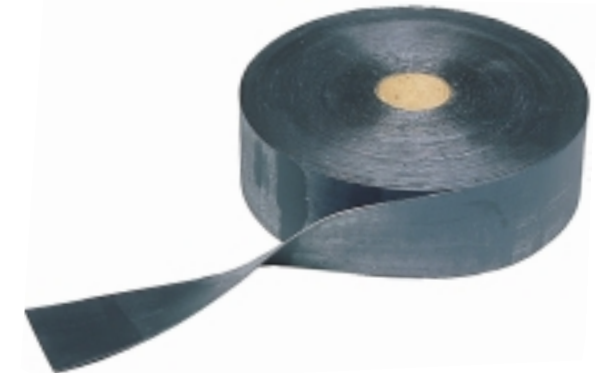


**Chem-Gum**

**Chemical Cure**

Use for field service repairs such as tread and shoulder snags, cuts in sidewalls and bead repairs. Compounded to cure chemically. Shelf life: 6 months. Apply with Fast Dry Self-Vulcanizing Cement to both sides of gum for proper vulcanization.

Order No.	Width x Gauge		Wt/Box	
	Inches	mm	Lbs.	kg
18-320	3 x .045	76 x 1.100	10	5
18-317	9 x .045	229 x 1.100	10	5



**Stripping Stock**

**RMA Cure Class 20A/35C**

Free-flowing stock for stripping edges of tread rubber to cover overbuff and improve sidewall appearance. Cure rate: 20 min/280°F, 35 min/260°F. Shelf life: 1 year.

Order No.	Width x Gauge		Wt/Box	
	Inches	mm	Lbs.	kg
18-222	1 x 1/16	25 x 1.6	25	12
18-223	2 x 1/16	51 x 1.6	25	12
18-225	3 x 1/16	76 x 1.6	25	12



# TIRE REPAIR CHARTS

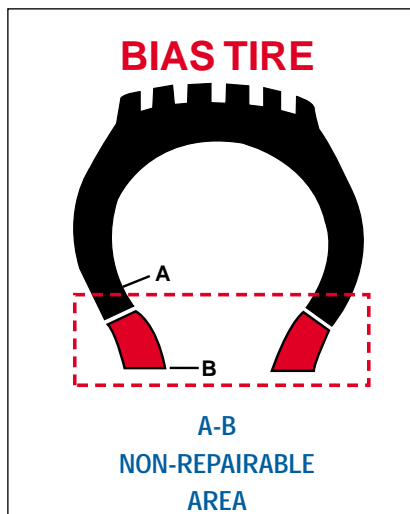
## Passenger, Truck & Off-The-Road

### CX Passenger, Truck & OTR Bias Tire Repair Application



INJURY SIZE*		TIRE PLY RATING							
Inches	mm	4 Ply	6 Ply	8 Ply	10 Ply	12 Ply	14 Ply	16 Ply	18 Ply
1/4	6	CX 2	CX 2	CX 2	CX 2	CX 2	CX 2	CX 3	CX 3
3/8	10	CX 2	CX 2	CX 2	CX 2	CX 2	CX 3	CX 4-2	CX 5-3
1/2	13	CX 3-2	CX 3-2	CX 3-2	CX 4-2	CX 4-2	CX 4-2	CX 5-3	CX 7-3
3/4	19	CX 4-2	CX 4-2	CX 4-2	CX 5-3	CX 5-3	CX 5-3	CX 6-4	CX 6-4
1	25	CX 5-3	CX 5-3	CX 5-3	CX 5-3	CX 6-4	CX 6-4	CX 8-4	CX 9-6
1 1/2	38	CX 5-3	CX 5-3	CX 7-3	CX 7-3	CX 6-4	CX 6-4	CX 9-6	CX 9-6
2	51	CX 7-3	CX 7-3	CX 6-4	CX 8-4	CX 9-6	CX 9-6	CX 12-6	CX 12-6
2 1/2	64	CX 8-4	CX 8-4	CX 8-4	CX 8-4	CX 9-6	CX 12-6	CX 15-6	CX 15-6
3	76			CX 9-6	CX 9-6	CX 12-6	CX 12-6	CX 16-8	CX 16-8
4	102				CX 15-6	CX 15-6	CX 15-6	CX 16-8	CX 16-8
5	127							CX 18-8	CX 18-8

\*Reinforced repairs-down size one patch, i.e. 1 1/2" injury on 12 ply-rating tire. Section repair; 6-4, reinforced repair; 5-3.



TIRE SIZE	
Passenger	2" (51mm)
Light-Truck (7.00 - 8.75)	3 1/4" (80mm)
Heavy-Duty (9.00 - 14.00)	4" (100mm)
16.00 - 18.00 (20.5 - 22.5)	5" (125mm)
21.00 - 29.5 (26.5 - 33.8)	6" (150mm)
30.00 - 33.00 (37.25 - 37.5)	7" (195mm)
36.00 - up	8" (200mm)

## Skidder/Tractor & Farm Implement

### CX/SKD Bias Tire Repair Application



INJURY SIZE*		TIRE PLY RATING							
Inches	mm	4 Ply	6 Ply	8 Ply	10 Ply	12 Ply	14 Ply	16 Ply	
1/8	3	CX 1	CX 1	CX 1	CX 1	CX 2	CX 2	CX 3	
1/4	6	CX 1	CX 1	CX 1	CX 1	CX 2	CX 2	CX 3	
3/8	10	CX 3-2	CX 3-2	CX 3-2	CX 3-2	CX 3-2	CX 4-2	CX 4-2	
1/2	13	CX 4-2	CX 4-2	CX 4-2	CX 4-2	CX 4-2	CX 4-2	CX 5-3	
3/4	19	CX 4-2	CX 4-2	CX 6-2	CX 6-2	CX 7-3	CX 7-3	CX 6-4	
1	25	CX 6-2	CX 6-2	CX 7-3	CX 7-3	CX 7-3	CX 7-3	CX 8-4	
1 1/2	38	CX 7-3	CX 7-3	CX 8-4	CX 8-4	CX 8-4	CX 8-4	SKD 5	
2	51	CX 7-3	CX 7-3	CX 8-4	CX 8-4	CX 9-6	CX 9-6	SKD 6	
2 1/2	64	CX 8-4	CX 8-4	CX 9-6	CX 9-6	CX 9-6	CX 9-6	SKD 7	
3	76	CX 8-4	CX 9-6	SKD 1	SKD 1	SKD 5	SKD 5	SKD 8	
4	102	CX 8-4	SKD 1	SKD 1	SKD 2	SKD 5	SKD 5	SKD 8	
5	127	CX 10-4	SKD 1	SKD 1	SKD 2	SKD 6	SKD 7	HDSKD 6	
6	152	SKD 2	SKD 2	SKD 2	SKD 3	SKD 6	SKD 7	HDSKD 6	
7	178	SKD 2	SKD 2	SKD 2	SKD 3	SKD 7	SKD 8	HDSKD 7	
8	203	SKD 3	SKD 3	SKD 3	SKD 3	SKD 7	SKD 8	HDSKD 8	
9	229		SKD 4	SKD 4	SKD 4	SKD 8	HDSKD 9	HDSKD 9	
10	254		SKD 4	SKD 4	SKD 4			HDSKD 9	

\*Reinforced repairs - downsize one patch i.e. 1 1/2" injury on 12 ply-rating tire. Section repair; 8-4, reinforced repair; 7-3.

## Earthmover/Off-The-Road

### EM/OTR Bias Tire Repair Application



INJURY SIZE*†		TIRE PLY RATING									
Inches	mm	2-4	6-8	10-12	14-16	18-20	22-24	26-28	30-36	38-44	46 & Over
1/2	13	4	4	4	4	4	6	6	6	6	6
1	25	4	6	6	6	6	6	6	6	6	8
1 1/2	38	4	6	6	6	6	6	8	8	8	8
2	51	4	6	6	8	8	8	8	8	8	10
2 1/2	64		6	6	8	8	8	10	10	10	12
3	76		6	8	10	10	10	10	10	12	14
4	102			8	10	10	10	12	12	12	14
5	127				10	10	12	12	12	14	16
6	152				12	12	12	14	14	16	16
7	178					12	14	14	16	16	18
8	203						14	16	18	18	18
9	229						16	16	18	18	20
10	254							18	18	20	20
11	279								20	20	20
12	305									20	20

\*For high speed, severe service, add length plus width of injury to determine "injury size".

†Reinforced repairs - downsize one patch i.e. 2" injury on 18 ply rating tire. Section repair; 8, reinforced repair; 6.

## Butterfly Sidewall

### Bias Tire Repair Application

INJURY SIZE*†		TIRE PLY RATING		
Inches	mm	12-16	18-22	24-30
1-3	25-76	1	2	2
4	102	1	2	2
5	127	2	2	3
6	152	2	3	3
7	178		3	4
8	203		4	4
9	229		4	5
10	254		5	5
11	279			5
12	305			5

**ATTENTION:**  
Tire repair unit selection charts are a guideline based on available industry information. O.E. Tire Manufacturers should be consulted for detailed repair limitations and information.

## Off-The-Road

### Tire Cross Section



Group I	Group II	Group III	IV	V
14.00-16.00, 15.5, 17.5, 20, 20.5	18.00, 21.00, 23.5, 26.5, 35/65, 40/65	24.00, 27.00, 29.5, 30.00, 33.25, 33.5, 37.25, 37.5, 45	36.00, 40.00	50.5

Bullseye Radial OTR Shoulder/Sidewall/Crown Tire Repair Application										
Shoulder Injury "S"	Crown Injury "C"	Sidewall Injury			TIRE SIZE GROUP					
		W	x	L	I	II	III	IV	V	
Inches	mm	Inches	mm	Inches	mm	Inches	mm	Use	Repair	Unit No.
Up to 3/8 10	Up to 3/8 10					24	24	24	40	40
		3/8 10	2 1/2 64			24	24	24	24	24
		1/2 13	4 102			44	44	44	44	44
		3/4 19	3 76			44	44	44	44	44
1 25	1 25	1 1/4 32	2 51			44	44	44	46	46
		Crown Repair Only			45	45	45	55	55	55
3/4 19					46	46	46	50	50	50
		3/4 19	6 152			46	46	46	46	46
		1 25	4 1/2 114			46	46	46	46	46
1 1/2 38	1 1/2 38	1 1/2 38	3 76			46	46	46	50	50
		Crown Repair Only			45	45	55	55	55	55
1 1/2 38		1 1/4 32	10 254			50	50	50	50	50
1 25					50	50	50	52	52	52
		2 51	8 203			50	50	50	52	52
		Crown Repair Only			55	55	55	65	65	65
1 1/2 38		2 3/8 60	6 1/2 165			50	50	50	50	50
					52	52	52	56	56	56
		2 1/2 64	10 254			52	52	52	56	56
		Crown Repair Only			55	55	65	65	75	75
2 51					52	52	52	56	60	60
		3 76	7 178			52	52	52	52	52
		4 102	5 127			52	52	52	52	52
		4 1/2 114	4 102			52	52	52	52	52
		2 51	14 356			56	56	56	56	56
		3 76	9 229			56	56	56	56	56
3 76					56	56	56	60	60	60
		3 76			65	65	65	75	75	75
		Crown Repair Only			56	56	56	60	60	60
2 1/2 64					56	56	56	56	56	56
		4 102	7 178			56	56	56	56	56
		4 1/2 114	6 152			56	56	56	56	56
		2 51	17 432			60	60	60	60	60
		3 76	11 279			60	60	60	60	60
		3 1/2 89				60	60	60	60	60
		3 1/2 89				65	75	75	75	75
		Crown Repair Only			60	60	60	60	60	60
2 3/4 70					60	60	60	60	60	60
		4 102	8 203			60	60	60	60	60
		4 1/2 114	7 178			60	60	60	60	60
		4 100				85	85			
		Crown Repair Only								

## Earthmover/Off-The-Road

### EMR Radial Shoulder/Sidewall Tire Repair Application (Non-flex to non-flex application)

TIRE SIZE	PATCH* EMR-15				PATCH* EMR-20				PATCH* EMR-27				PATCH* EMR-38				
	W	PATCH* x	EMR-15	L	W	PATCH* x	EMR-20	L	W	PATCH* x	EMR-27	L	W	PATCH* x	EMR-38	L	
Inches	mm	x	Inches	mm	Inches	mm	x	Inches	mm	Inches	mm	x	Inches	mm	x	Inches	mm
14.00, 15.5	3/4 19	x	6 152	2 1/4 57	x	8 3/4 222											
17.5, 20.5	1 25	x	5 127	3 1/4 82	x	6 1/2 165											
16.00	1 1/4 32	x	4 102	3 3/4 95	x	4 3/4 121											
	1 3/4 44	x	3 76	4 3/4 121	x	3 1/2 89											
18.00	3/4 19	x	6 152	2 1/4 57	x	8 3/4 222	2 1/4 57	x	11 3/4 298								
21.00	1 25	x	5 127	3 1/4 82	x	6 1/2 165	3 1/4 82	x	8 3/4 222								
23.5	1 1/4 32	x	4 102	3 3/4 95	x	4 3/4 121	3 3/4 95	x	6 3/4 171								
26.5	1 3/4 44	x	3 76	4 3/4 121	x	3 1/2 89	4 3/4 121	x	5 1/4 133								
24.00, 27.00	3/4 19	x	6 152	2 1/4 57	x	8 3/4 222	2 1/4 57	x	11 3/4 298	2 1/4 57	x	15 381					
29.5, 33.25	1 25	x	5 127	3 1/4 82	x	6 1/2 165	3 1/4 82	x	8 3/4 222	3 1/4 82	x	11 279					