Technical Bulletin
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Topic: Tube and Flap Selection and Repair Requirements

Recent CCM audits of tires to be installed have revealed that the quality control on used tube and flap inspections are below expectations. In consideration of the conditions observed we have updated the CCM tube and flap specifications.

Please advise all M&R repair vendors, and all parties performing tire mounting and dismounting that the following specifications on tube and flap repairs are to take effect immediately.

Tube Information
1. Tubes are to be inspected and if in good condition and clean of debris are to be patched and reused wherever possible.
2. No more than 2 patches allowed per tube.
3. Valve stems should be straightened to as close to original angle as possible.
4. No kinked, oblong or stripped stems are allowed.
5. Tube protectors are to be salvaged and reused wherever possible.
6. All replacement tubes are to be of 100% Butyl rubber only. All natural rubber tubes are not allowed.
7. All tubes purchased or returned to CCM MUST be accompanied by a sealing metal valve cap.

NOTE: repair vendors are not allowed to repair tubes for reuse. Only recappers are allowed to test and repair tubes. Any damaged tube identified by the repair vendor is to be replaced – not repaired.

Flap Information
1. Flaps may be reused provided they are not cut, torn, doubled or otherwise present a hazard to the tube and stem. NOTE: particular attention is to be paid to the condition of the valve stem reinforcement area. Any flap exhibiting abrasion and cracking in the stem reinforcement area or signs of stress are to be replaced.
2. All flaps must be checked for reinforcement in the stem area. Flaps that do not have a sufficient stem reinforcement area such as illustrated below.

OR are not accompanied by an approved metal stem protector plate in good condition are to be replaced. Plates such as the following are to be removed from service and if necessary the flap is to be replaced with a reinforced flap.
Following is an example of an unacceptable flap installation
3. All replacement flaps must have a 4 inch reinforcement in the stem area as illustrated above to properly protect the tube and flap in the rim area

Mounting Tires

1. Care must be taken to ensure that the tube is properly positioned in the valve stem slot.
   a. Stems that come out of the slot at an angle such are not acceptable
   b. Stems should not be in contact with the rim. Following are examples of unacceptable mounting
If equipped with a protector plate, bent or damaged flap protection plates are to be removed from service and are not to reused. Note examples of damaged improperly mounted protectors above and following
If protector plates are installed, the protector MUST be properly aligned with the rim and care must be given to ensure the tube is pulled all the way through the flap and protector.

Example of properly installed protector plate

NOTE: CCM Technical Services will be issuing these same instructions to all retreaders under separate cover. Please advise The Technical Services Manager if a retreader claims to not have received a copy of the revised tube and flap specifications