



ContiLifeCycle Technical Service Bulletin

Tech Tip Adhesion

Adhesion to the tread can be impacted by several factors. Please ensure you are following the existing process controls:

- › If you used cement on the tread or cushion, ensure proper dry times were maintained. Contact your cement provider for exact times. For Tech International brand, it is 8 – 10 minutes.
- › If you notice the tread has detached from the cushion before enveloping, re-stitch the tread.
- › Ensure the built tire is enveloped as soon as possible. It is advisable to envelope a tire within two hours or sooner of being built.
- › Ensure your envelopes are not baggy and are the proper size. If excessive stretch is noticed, replace the envelope.
- › Ensure the envelope is vacuum tested and capped off after the test.
- › All tires need to be cured within 72 hours of being built.
- › Maintain proper time, temperature, and pressures during the cure.

Recently, treads manufactured in our Mount Vernon, Illinois facility were observed to have an extremely low occurrence of no buff texture, which has led to a low occurrence of tread detachment issues. The issue was corrected in our manufacturing facility on January 29th, 2021 however, for any tread manufactured prior to that date, the following actions must be taken:

- › Prior to building, check the buff texture of the tread that will be applied.
 - › If you do not see a buff texture, set **entire tread roll** aside for warranty processing.
- › After tread application, check the trailing edge of the tread for buff texture.
 - › If you do not see a buff texture, set **entire tread roll** aside for warranty processing.

Finally, before shipment to the fleet:

- › If Shearography is available, after curing, and after the tire has cooled, run the tire through Shearography and look for any signs of a lack of adhesion, such as the example shown here.
- › If there is a question regarding the Shearography findings, **hold tire** for warranty processing.



If you have questions, these are your contacts: CLC Tech Service Rep for your region

Example of “No Buff Texture” Shearography Finding:

