
TWO PIECE REPAIR

Application Guidelines



TWO PIECE REPAIR APPLICATION GUIDELINES



**Do a through Internal and External Inspection of Tire.
This is to ensure the size of the injury and see if the tire can be repaired.**

Use proper lighting for inspection.



TWO PIECE REPAIR APPLICATION GUIDELINES



Remove the foreign material from the injury and using a probe or an inspection tool, determine the size and angle of the injury.

The size and the angle of the injury is very important to select and do the appropriate repair.

If the angle of injury is more than 25°, then ONLY a '2 piece repair' is to be done.



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To clean, use Kwik Klean or any tire pre-buff cleaner or rubber solvents. While the area is still moist, use a tire scraper to remove all traces of dirt and silicone mold lubricant from the inner-liner area.

This is to be repeated 2 or 3 times to completely remove all traces of mold lubricant from the inner surface of the tire.

If traces of silicone tire mold lubricant is not completely removed, then repair may fail.



TWO PIECE REPAIR APPLICATION GUIDELINES



Use a Low Speed Drill (max 1200 rpm) and an appropriate size carbide cutter to prepare the injury.

Drill the injury both from inside and outside.

Repeat this for about 3 or 4 times to remove all the dirt from inside the Injury.



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Apply the Kwik Fast Dry Cement into the injury channel using a Spiral Cementing Tool



TWO PIECE REPAIR APPLICATION GUIDELINES



Remove the Poly film from the Stem Plug patch. without touching the cushioned surface



TWO PIECE REPAIR APPLICATION GUIDELINES



Apply one coat of Fast Dry Cement or CVF on the stem of the Stem Plug patch.



TWO PIECE REPAIR APPLICATION GUIDELINES



Guide the Plug into the injury using the guide wire. Once it is positioned in the injury remove the poly film



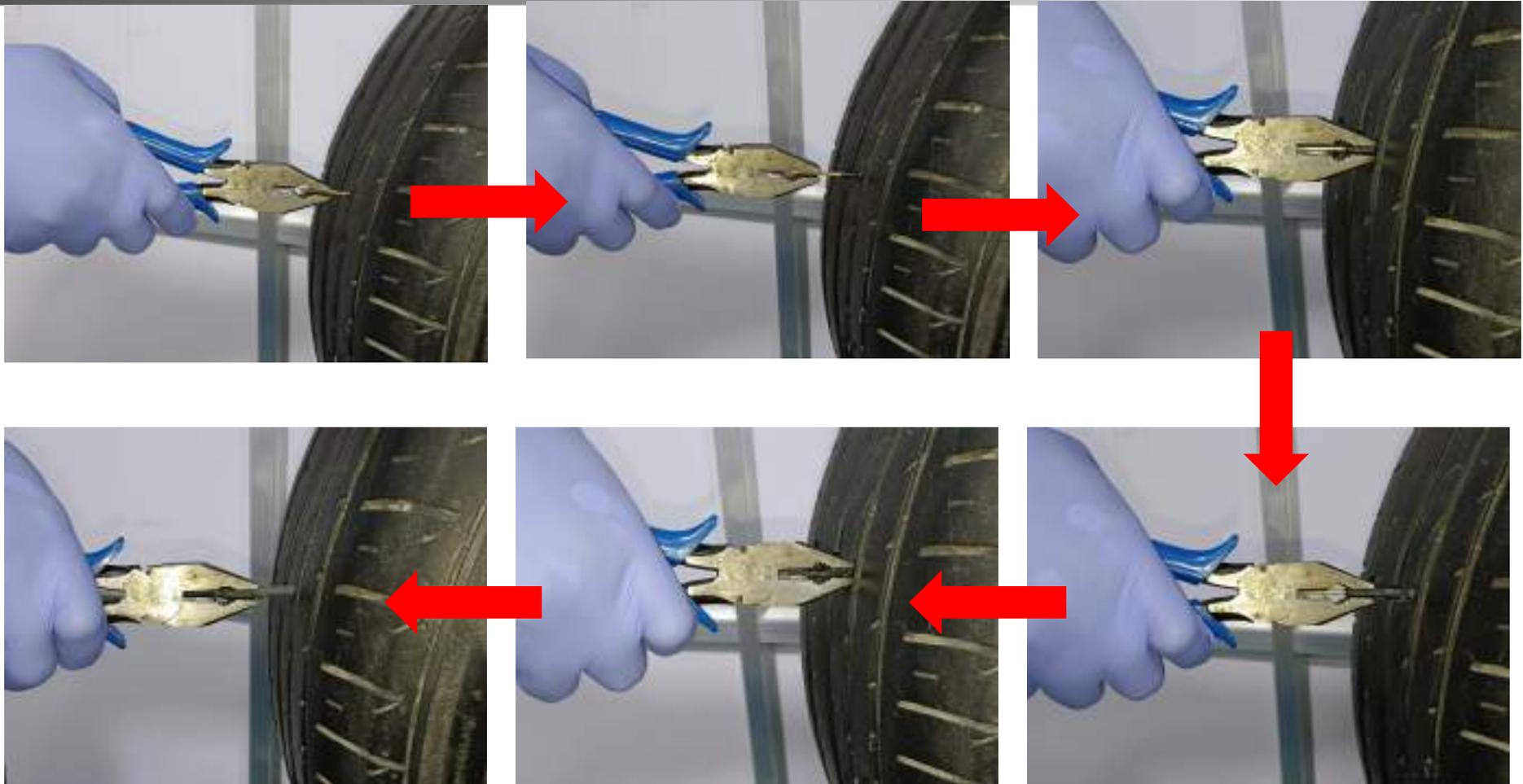
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Hold and pull out the protruded guide wire as shown in the image



TWO PIECE REPAIR APPLICATION GUIDELINES



Pull the Stem Plug slowly outward as per the steps shown in the above image. Always hold the rubber part of the stem while pulling.



TWO PIECE REPAIR APPLICATION GUIDELINES

- Ensure that the Plug Stem Patch is gripped firmly **ONLY** on the rubber part of the stem.
- Always grip the stem of Plug Stem Patch close to the Tire surface when pulling outwards.
- Pull the Plug Stem Patch step by step outward (as shown in the previous slide).
- DO NOT PULL THE STEM OF THE PLUG STEM PATCH OUTWARD IN ONE FULL MOTION.(This may result in the breakage of the stem)**



TWO PIECE REPAIR APPLICATION GUIDELINES

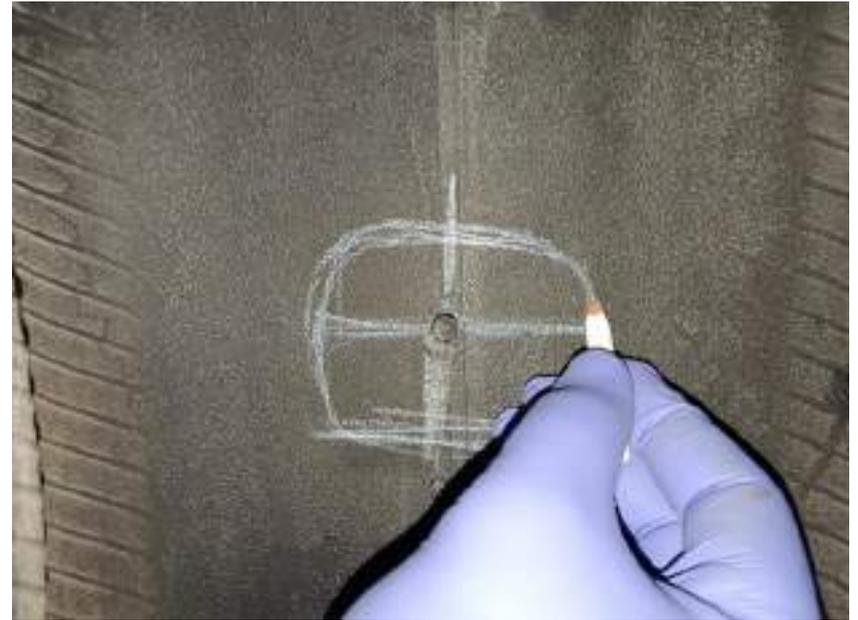


Fig: 1



- Pull the Stem Plug slowly outward – leaving about 2mm of the stem protruding inside as shown in the Fig: 1.**
- Cut the excess Stem Plug protruding outside tire leaving 3mm above the tire surface.**

TWO PIECE REPAIR APPLICATION GUIDELINES

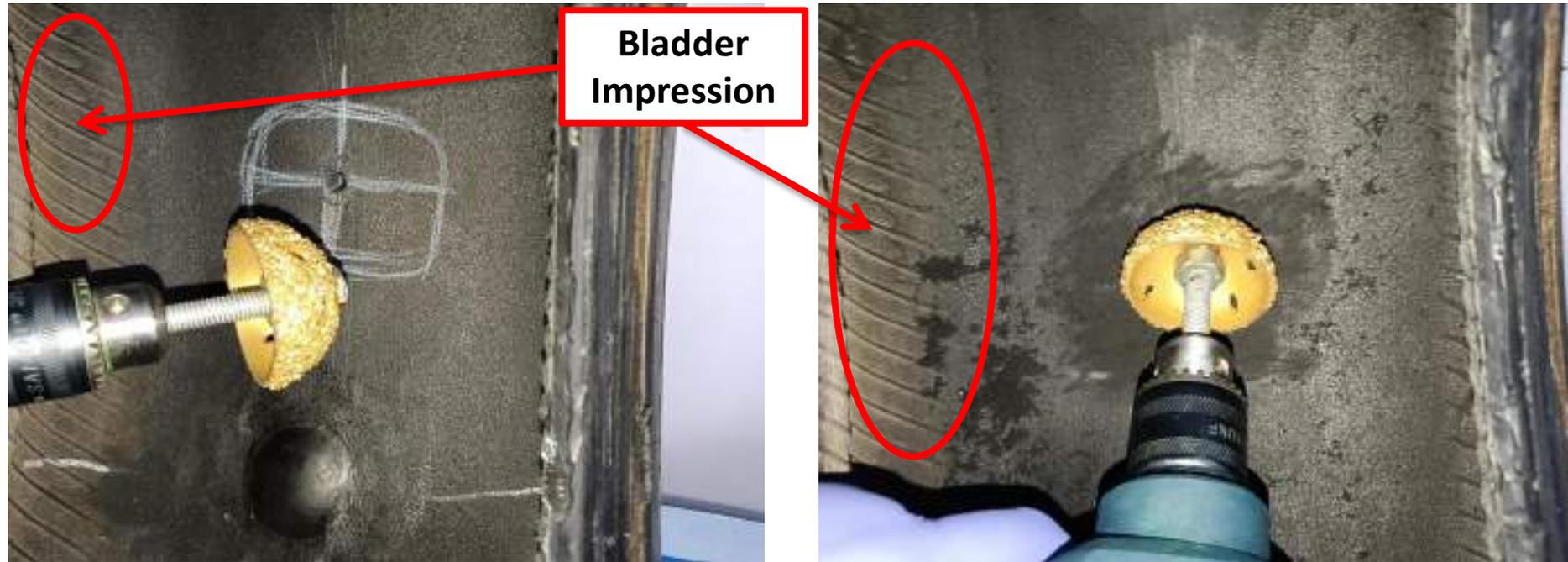


Using a relevant template or the patch as reference, outline the area to be buffed with a marker.

The marked area should be $\frac{1}{4}$ " or 6 mm larger than the actual patch size all around.



TWO PIECE REPAIR APPLICATION GUIDELINES



Buff the inner liner with white Corundum Grinding Wheel or a Cup Rasp of 36 Grit.

Ensure that the bladder impressions are totally buffed off.

The projected plug should be evenly buffed to the level with the buffed inner tire surface.

The buffed texture should be of RMA1 / BT1 (see reference)



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RMA 1/BT 1



RMA 2/ BT 2

RMA1/BT1 : Smooth, velvet- like texture appropriate for inside tire surfaces repairs.

RMA2/BT2 : Smooth, velvet- like texture appropriate for inside tire heat cure repairs and retreading.



TWO PIECE REPAIR APPLICATION GUIDELINES



After rasping the area, clean the buffed dust with a nylon brush or vacuum the dust thoroughly.

Do not use compressed air to clean the buffing dust as this may contaminate the rasped area.



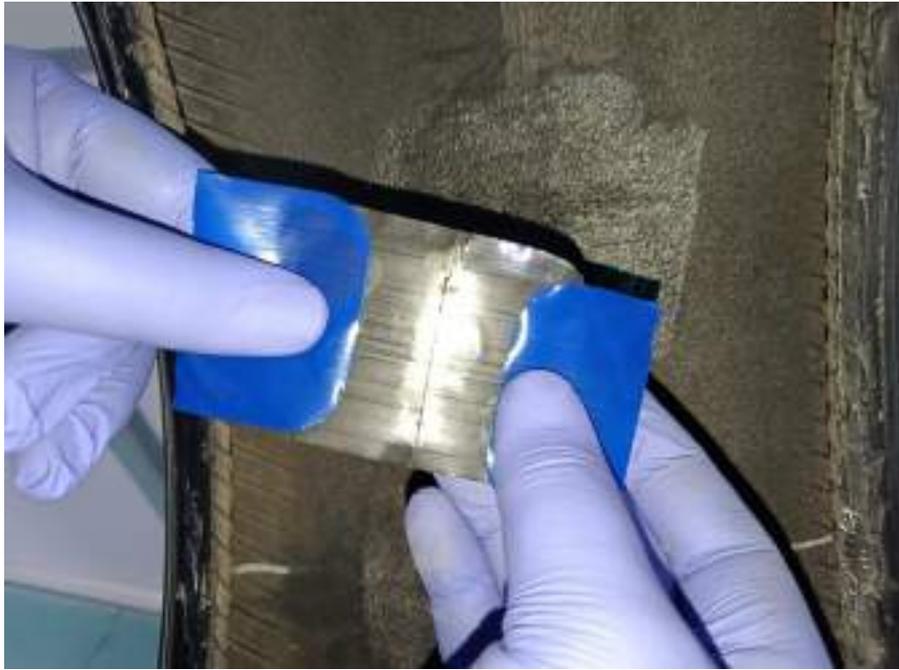
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Apply a Single Coat of Fast Dry Cement in a stippling motion and allow it to dry (Normal drying time is 3 to 5 min. or as per the ambient temperature and humidity).



TWO PIECE REPAIR APPLICATION GUIDELINES



**Remove the Poly film without touching the cushioned surface.
Place the Patch on the injury centering it to the injury.
Once the patch is positioned on the injury, press the center of the patch to the injury and then remove the poly film.**



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Stitch the patch from the center to either sides vigorously using a serrated hand Sticher.

This is to ensure that there are no air trapped in between the patch and Tire.

Repeat this again in the opposite direction from the top.



TWO PIECE REPAIR APPLICATION GUIDELINES



Apply a coat of Kwik Repair Sealer around the patch and entire exposed buffed area.

This is to improve the integrity to the inner liner of the tire.



Important Points to be Observed while Repairing Tire :

1. It is important to inspect the tire, both internal and external to determine if the tire can be repaired.
2. Check for run flat or weathering cracks of the Tire.
3. See that the repairable injury is only on the tread area.
4. Avoid inverting and excessive spreading of the beads in Radial Tires while inspecting.
5. **If the angle of injury is more than 25°, only a 2 piece repair procedure to be done.**
6. Use only the proper size of carbide cutter to prepare the injuries.
7. While rasping the injury be careful not to buff too deep and expose the tire cords.
8. Do not use compressed air to clean the buffed area. Preferably use a vacuum cleaner to clean the buffed area.



Important Points to be Observed while Repairing Tire : continued...

9. **Do not use compressed air to clean the buffed area.** Preferably use a vacuum cleaner to clean the buffed area
10. Use a stippling motion to coat the cement. Do not use compressed air or hair dryer to dry the cement.
11. While drying keep the injury of the tire at 12 o'clock position, to avoid any contamination to the repair area.
12. When the patch is applied ensure that the bead is in the normal position (not spread).
13. **Ensure that only the rubber part of the stem is gripped close to the Tire surface when the Plug Stem Patch is pulled outward.**
14. Remount the tire and check for leaks before the Tire is put into use.



THANK YOU

