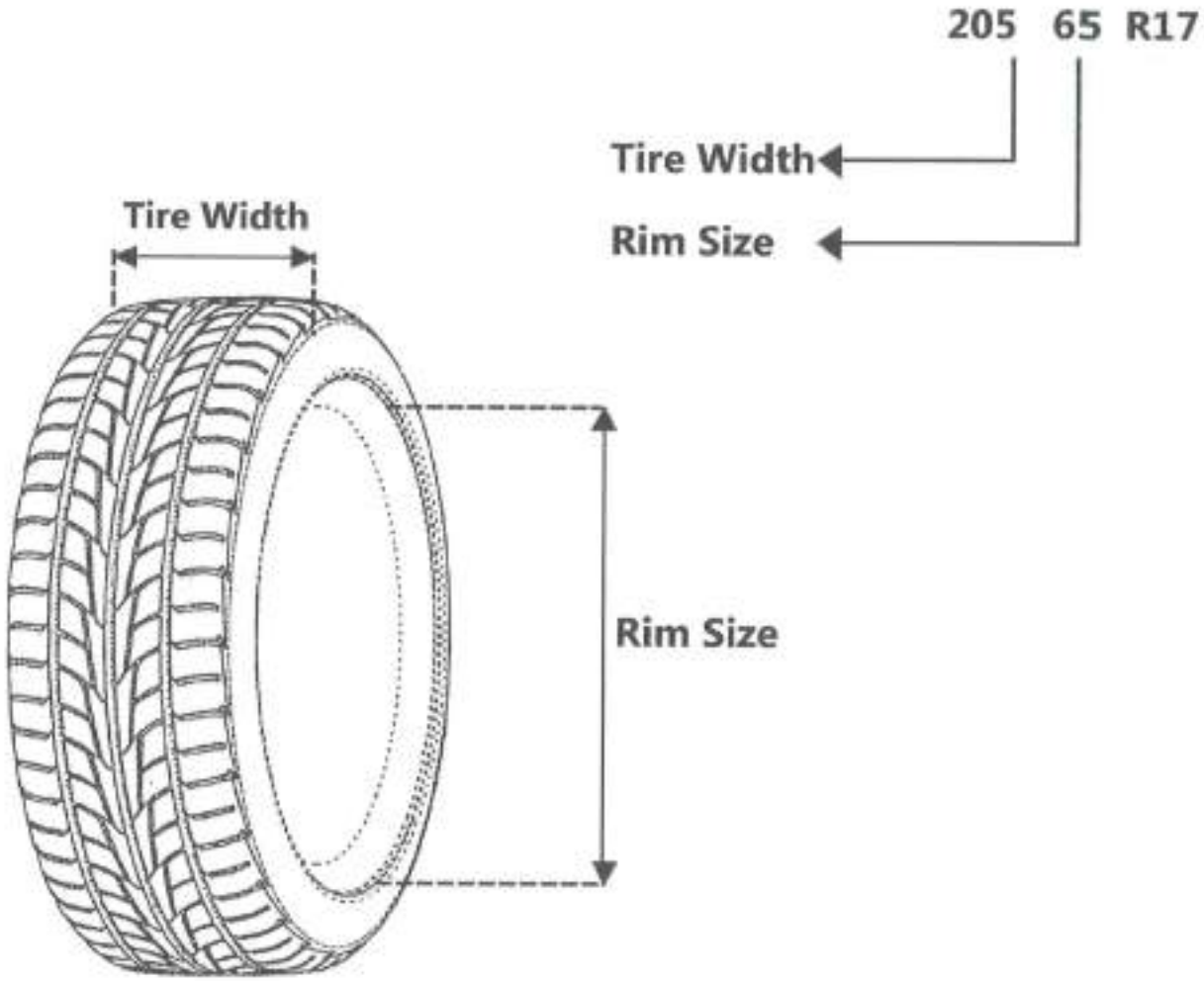
HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

PA SPECIFICATION

SPEC NR OE-23T205x65 R17
11 OCT 2019
(Interim)



Directional Type

FIGURE 1

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

PA SPECIFICATION

SPEC NR OE-23T205x65 R17
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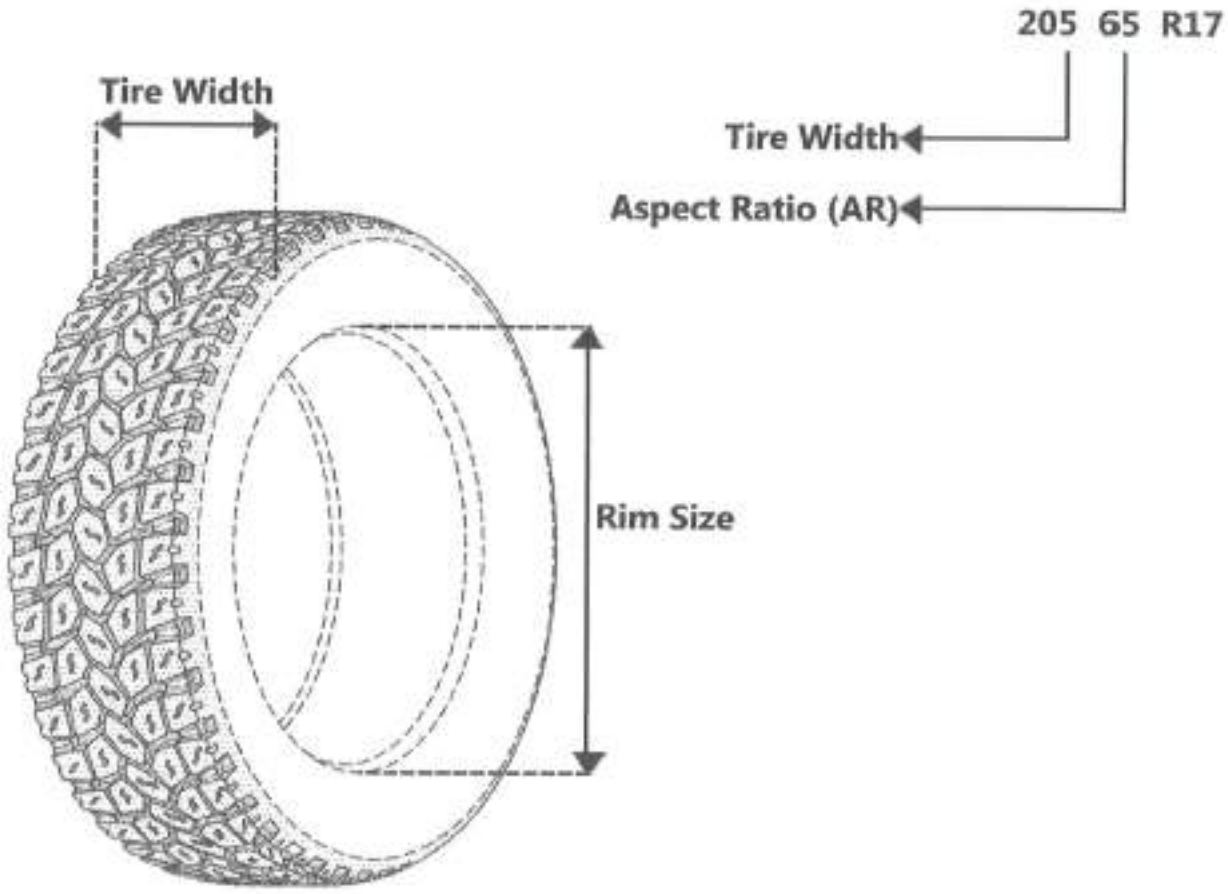


FIGURE 2

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

TEST AND ACCEPTANCE PROCEDURE
TIRE, 205x65 R17

1. GENERAL

1.1. Scope: This Test and Acceptance Procedure shall apply to 205x65R17 Tires intended for the following vehicles: SUV and MPV.

1.2. Objective: To ascertain compliance of tires with standards and specifications in consonance with the need of the end user.

1.3. References:

a. Philippine National Standard for Pneumatic Tires, PNS 25: 1994.

b. ISO 4209-1:2001 International Standard – Truck and Bus Tires and Rims (Metric Series)

2. PROCEDURES

2.1. The Technical Inspection and Acceptance Committee (TIAC) for Quartermaster Items or its representatives shall ensure that the complete quantity stated in the contract is packed/palletized prior to inspection.

2.2. The TIAC shall conduct random sampling from the lot or lots. The samples shall be properly segregated, packed, marked and secured by the members/representatives of the committee.

2.3. Technical inspection and test shall be conducted on the representative samples of the lot by visual, dimensional and functional test to determine the over-all workmanship, markings, size and appropriate packaging of the items.

2.4. Functional Test will be done to determine the functional performance of the tire.

2.5. Results obtained shall be recorded and evaluated to determine the compliance of the items to Technical Specifications and as basis for acceptance or rejection of the lot or lots.

3. PHYSICAL INSPECTION

3.3. Visual Inspection

3.3.1. Purpose: To determine the completeness, overall external workmanship, symbols, codes and markings of the tire set sample/s.

3.3.2. Procedure: Visually inspect the completeness, overall appearance and presence of required symbols or markings of the tire set.

3.3.3. Standard:

3.3.3.1. With the Tires required appropriate size of Flap and Tube.

3.3.3.2. With the required Traction Design (Rib Type as appropriate)

3.3.3.3. With PS or ICC Quality Mark or Certificate of Exemption from DTI in case the product offered are beyond the minimum standard of DTI.

3.3.3.4. With Brand Name or Trade Name.

3.3.3.5. Tire Designation Markings: Manufacturer's Standard for Tire, 425x65 R22.5 (Tire Size, Minimum Ply Rating/Load Range and Type/Construction).

3.3.3.6. With Maximum Air Pressure Markings.

3.3.3.7. With the words "Made in the Philippines" or country of origin if imported.

3.3.3.8. With Manufacturing Date Markings.

3.3.3.9. With Maximum Load Capacity Markings.

3.3.3.10. No evident damage on tread, sidewall, ply, cord, inner liner and including damage on flap and tube/tube valve. No bead separation, chunking, broken cords, cracking or open splices.

3.4. Dimensional Test

3.4.1. Purpose: To determine the actual dimensions of the tire sample/s.

3.4.2. Procedure:

3.4.2.1. The tire set sample/s shall be mounted on its corresponding rim and inflated to the indicated maximum permissible inflation pressure (450kPa) at maximum load as labeled on the tire sidewall. The tire shall be allowed to stand for a minimum of 24 hours at room temperature. The pressure thereafter should be measured and adjusted to within 10kPa of the pressure specified for the tire type, being the ideal condition for measurement of the tire. Measure the Tire Diameter, Tire Width, Sidewall Height and Circumference by hanging the tire to avoid any obstruction from any external factor which may affect the dimensional test.

3.4.2.2. Overall Diameter shall be determined to the nearest millimeter by measuring the outside circumference by a tape and then divide the value by constant 3.1416 (π). or by means of a measuring device calibrated to show directly the diameter of the tire. Figure 1, 2 and 3.

3.4.2.3. Overall Width is the average of maximum widths including the sidewalls, side ribs, bars decorations, letters or numerals. The width shall be measured by nearest millimeters at four different points equally distributed around the tire and the result averaged.

3.4.2.4. Size Factor shall be the sum of overall diameter and overall width.

3.4.3. Standard:

Parameters	Traction Design
Tire Diameter (mm)	702.3 (maximum)
Tire Width (mm)	209 (maximum)
Sidewall Height (mm)	137.25 (maximum)
Circumference (mm)	2197.77 (maximum)

3.5. Tire Strength Test

3.3.1 Purpose: To determine the strength of the tire.

3.3.2 Allocation of samples

3.3.2.1 Post Qualification: One (1) sample shall be submitted to undergo the plunger test. Previous test result of plunger test that is within the period of one (1) year and evaluated as passed can be used in lieu of submission of required samples.

3.3.2.2 Pre Delivery/Final Acceptance: One (1) sample shall be subjected to plunger test that will be taken at random from the delivery which had already undergone the physical inspection and dimensional test. Additional sample for plunger test will be provided when prescribed in the contract which will be determined by procuring entity's representative.

3.3.3 Procedure:

3.3.3.2 To be conducted by Philippine GeoAnalytics Inc (PGAI) if done in-Country or equivalent government recognized testing center at the country of origin.

3.3.3.3 Force a 38mm diameter cylindrical steel plunger rod with a hemispherical end at 5 equally distributed points perpendicularly into the tread rib as near to the centerline as possible, avoiding penetration into the groove, at the rate of 50 mm/min±10 mm/min.

3.3.3.4 The plunger is stopped before reaching the rim or the required tire strength value of 271J is reached without the tire breaking.

3.3.3.5 Should there be a Pre Delivery Inspection at the country of origin, all the required Functional Tests and Inspections shall be conducted through a capable independent third party entity or that host country/government accredited test facility or in the absence thereof, at the manufacturer's test facilities. The Manufacturer shall issue a document certifying that the tested tire came from the lots delivered and have passed the Tire Strength Test.

3.3.4 Standard: Tire Strength requirement based on PNS 25:1994 standards if done in-Country or its equivalent standard used at the country of origin if conducted thereat.

3.3.4.1 All tire samples must pass the test. Any samples that fail the tire strength test shall cause the rejection of the lot.

4. ACCEPTABILITY

4.1 The result of the test based on the above criteria shall be the basis for evaluation of the Acceptance Committee in the acceptance/rejection of the above item for use of the PA.

EDMUNDO S SUFICIENCIA
Colonel, QMS (GSC) PA
Chief

NOTED

CG, PA
DATE: OCT 11 2019

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

TABLE OF CLASSIFICATION OF DEFECTS

TIRE, 205x65 R17

DEFECTS	CLASSIFICATION OF DEFECTS	
	Major	Minor
Visual		
1. Each Tires required appropriate size Flap and Tube	x	
2. Required Traction Design (Rib Type as appropriate)	x	
3. With PS or ICC Quality Mark or Certificate of Exemption from DTI in case the product offered are beyond the minimum standard of DTI.	x	
4. Shall have Brand Name or Trade Name markings	x	
5. Manufacturer's Tire Designation Markings is 205x65 R17	x	
6. Not within the Minimum Load Range and/or Ply Rating and Type/Construction requirements	x	
7. Shall have Maximum Air Pressure Markings	x	
8. Shall have the words "Made in the Philippines" or country of origin if imported.	x	
9. Shall have Manufacturing Date Markings/Symbol	x	
10. Not within the Manufacturing Period requirement	x	
11. Each Tires shall have Maximum Load Capacity Markings	x	
12. Not within the Maximum Load Capacity Requirement	x	
13. Evident damage on Tread or Sidewall or Ply or Cord or Inner liner	x	
14. Evident damage on Flap or Tube/Tube valve	x	
15. Bead Separation	x	
16. Chunking, Broken Cords, Cracking or Open Splices on tire surface	x	
Dimensional Test		
17. Dimensions (Diameter or Width or Tread Depth) is not within the standard requirement		x
18. Size Factor is not within the standard requirement	x	
Workmanship		
19. Presence of dirt, stains and other defects:		
a. Does not affect appearance		x
b. Affect appearance	x	
Tire Strength		
20. Each Tire shall meet the required tire strength	x	
Packing and Packaging:		
21. Each Tire shall be packed in plastic transparent or manufacturer's standard	x	
Total test point	**20**	**2**

EDMUNDO S SUFICIENCIA
Colonel, GSC (QMS) PA
Chief

HEADQUARTERS
PHILIPPINE ARMY
PA TECHNICAL WORKING GROUP FOR ORDNANCE ITEMS – MOBILITY
Fort Andres Bonifacio, Metro Manila

PA PQT NR: *MT-14-06-16* 05 JUL 2016
Rescinds PQ Test Nr MT-14-11-15-A for Tire, 205/70 R15

POST QUALIFICATION TEST PROCEDURE FOR TIRE, 205/70 R15

1. GENERAL

1.1. Scope: This Post Qualification Test Procedure shall apply to 205/70 R15 radial type tires intended for Light Passenger Cars and Utility Vehicles.
1.2. Objective: To ascertain compliance of tires with standards and specifications in consonance with the need of the end user.
1.3. References: a. Philippine National Standard for Pneumatic Tires, PNS 25: 1994.
b. ISO 4209-1:2001 International Standard – Truck and Bus Tires and Rims (Metric Series)

2. SAMPLE ALLOCATION

Test sample shall consist of One (1) *serviceable* Tire based on the technical specifications on the submitted product offered by the proponent during the bidding.

3. TEST PARAMETERS

3.1. Visual Inspection

3.1.1. Purpose: To determine the completeness, overall external workmanship, symbols, codes and markings of the tire set sample/s.
3.1.2. Procedure: Visually inspect the completeness, overall appearance and presence of required symbols or markings of the tire set.
3.1.3. Standard:
3.1.3.1. With the Tire's required Flap and Tube.
3.1.3.2. With the required Traction Design (Directional/Rib or Lug Type as appropriate)
3.1.3.3. With PS or ICC Quality Mark.
3.1.3.4. With Brand Name or Trade Name.
3.1.3.5. Tire Designation Markings: Manufacturer's Standard for Tire, **205/70 R15**. (Tire Size, Minimum Ply Rating/Load Range and Type/Construction)
3.1.3.6. With Maximum Air Pressure Markings.
3.1.3.7. With the words "Made in the Philippines" or country of origin if imported.
3.1.3.8. With Manufacturing Date Markings.
3.1.3.9. With Maximum Load Capacity Markings.

3.1.3.10. No evident damage on tread, sidewall, ply, cord, inner liner and including damage on flap and tube/tube valve. No bead separation, chunking, broken cords, cracking or open splices.

3.2. Dimensional Test

3.2.1. Purpose: To determine the actual dimensions of the tire sample/s.

3.2.2. Procedure:

3.2.2.1. The tire set sample/s shall be mounted on its corresponding rim and inflate to the indicated maximum permissible inflation pressure (220kPa) at maximum load as labeled on the tire sidewall. The tire shall be allowed to stand for a minimum of 24 hours at room temperature. The pressure thereafter should be measured and adjusted to within 10kPa of the pressure specified for the tire type, being the ideal condition for measurement of the tire. Measure the Overall Diameter, Overall Width, Size Factor and Tread Depth.

3.2.2.2. Overall Diameter shall be determined to the nearest millimeter by measuring the outside circumference by a tape and then divide the value by constant 3.1416 (π). Or by means of a measuring device calibrated to show directly the diameter of the tire.

3.2.2.3. Overall Width is the average of maximum width including the sidewalls, side ribs, bars, decorations, letters or numerals. The width shall be measured by nearest millimeters at four different points equally distributed around the tire and the result averaged.

3.2.2.4. Size Factor is the sum of the Overall Diameter and Overall Width when mounted on its rim and inflated to the specified inflation pressure.

3.2.2.5. Tread Depth shall be measured at the first major groove nearest the tread centerline, avoiding any wear indication.

3.2.3. Standard:

Parameters	Requirement
Overall Diameter (mm)	Not more than 687
Overall Width (mm)	Not more than 211
Tread Depth (mm)	Minimum of 4.9
Size Factor (mm)	Minimum of 847
Air Pressure Loss during 24h conditioning period	Not more than 13.8 kPa or 2PSI

3.3. Tire Strength

3.3.1 Purpose: To determine that the type of tire offered conforms to the tire strength requirement specified.

3.3.2 Procedure: Manufacturer's tire strength test result for same type of tire shall be submitted for evaluation.

3.3.3 Standard: The tire strength test values shall be compliant or higher with the PNS 25:1994 standard.

05 JUL 2016

4. TABLE OF CLASSIFICATION OF DEFECTS

DEFECTS	CLASSIFICATION	
	MAJOR	MINOR
Visual Inspection		
1. Not the required Traction Design (Directional/Rib or Lug Type as appropriate)	X	
2. Without PS or ICC Quality Mark	X	
3. Without Brand Name or Trade Name	X	
4. Without Manufacturer's Tire Designation Markings for **205/70 R15**	X	
5. Not within the Minimum Load Range and/or Ply Rating and Type/Construction (Tubeless/Radial) requirements	X	
6. Without Maximum Air Pressure Markings	X	
7. Without the words "Made in the Philippines" or country of origin if imported.	X	
8. Without Manufacturing Date Mark/Symbol	X	
9. Not within the Manufacturing Period requirement	X	
10. Without Maximum Load Capacity Markings	X	
11. Not within the Maximum Load Capacity Requirements	X	
12. Evident damage on Tread or Sidewall or Ply or Cord or Inner liner	X	
13. Bead Separation	X	
14. Chunking or Cracking or Open Splices on tire surface	X	
Dimensional Test		
15. Dimensions (Diameter or Width or Tread Depth) is not within the standard requirement		X
16. Size Factor is not within the standard requirement	X	
17. Air Pressure lost after 24 hours at room temperature exceeded 13.8kPa or 2PSI	X	
Tire Strength		
18. The tire strength of the offered tire is below the requirement stated in PNS 25:1994 for the same type of tire.	X	

5. POST QUALIFICATION CRITERIA: No Defects Allowed.

Prepared by:

RAMON A TORRES
MAJ (OS) PA
Alternate Member

Approved by:

QUIRINO F LABORTE
Colonel, GSC (OS) PA
Chairman

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF ORDNANCE AND CHEMICAL SERVICE
Fort Andres Bonifacio, Metro Manila

TAP NR: *MT-14-02-16*
Rescinds TAP Nr MT-14-11-15-A for Tire, 205/70 R15 10 MAY 2016

TEST AND ACCEPTANCE PROCEDURE FOR TIRE, 205/70 R15

1. GENERAL

1.1. Scope: This Test and Acceptance Procedure shall apply to 205/70 R15 radial type tires intended for Light Passenger Cars and Utility Vehicles.
1.2. Objective: To ascertain compliance of tires with standards and specifications in consonance with the need of the end user.
1.3. References:
   a. Philippine National Standard for Pneumatic Tires, PNS 25: 1994.
   b. ISO 4209-1:2001 International Standard – Truck and Bus Tires and Rims (Metric Series)

2. PROCEDURES

2.1. The Technical Inspection and Acceptance Committee (TIAC) for Ordnance-Mobility or its representatives shall ensure that the complete quantity stated in the contract is packed/palletized prior to inspection.
2.2. The TIAC shall conduct random sampling from the lot or lots. The samples shall be properly segregated, packed, marked and secured by the members/representatives of the committee.
2.3. Technical inspection and test shall be conducted on the representative samples of the lot by visual, dimensional and functional test to determine the over-all workmanship, markings, size and appropriate packaging of the items.
2.4. Functional Test will be done to determine the functional performance of the tire.
2.5. Results obtained shall be recorded and evaluated to determine the compliance of the items to Technical Specifications and as basis for acceptance or rejection of the lot or lots.

3. TEST PARAMETERS

3.1. Visual Inspection

3.1.1. To determine the completeness, overall external workmanship, symbols, codes and markings of the tire set sample/s.
3.1.2. Procedure: Visually inspect the completeness, overall appearance and presence of required symbols or markings of the tire set.
3.1.3. Standard:
   3.1.3.1. With the Tire's required Flap and Tube.
   3.1.3.2. With the required Traction Design (Directional/Rib or Lug Type as appropriate)
   3.1.3.3. With PS or ICC Quality Mark.
   3.1.3.4. With Brand Name or Trade Name.

3.1.3.5. Tire Designation Markings: Manufacturer's Standard for Tire, **205/70 R15**. (Tire Size, Minimum Ply Rating/Load Range and Type/Construction)

3.1.3.6. With Maximum Air Pressure Markings.

3.1.3.7. With the words "Made in the Philippines" or country of origin if imported.

3.1.3.8. With Manufacturing Date Markings.

3.1.3.9. With Maximum Load Capacity Markings.

3.1.3.10. No evident damage on tread, sidewall, ply, cord, inner liner and including damage on flap and tube/tube valve. No bead separation, chunking, broken cords, cracking or open splices.

3.2. Dimensional Test

3.2.1. Purpose: To determine the actual dimensions of the tire sample/s.

3.2.2. Procedure:

3.2.2.1. The tire set sample/s shall be mounted on its corresponding rim and inflate to the indicated maximum permissible inflation pressure (220kPa) at maximum load as labeled on the tire sidewall. The tire shall be allowed to stand for a minimum of 24 hours at room temperature. The pressure thereafter should be measured and adjusted to within 10kPa of the pressure specified for the tire type, being the ideal condition for measurement of the tire. Measure the Overall Diameter, Overall Width, Size Factor and Tread Depth.

3.2.2.2. Overall Diameter shall be determined to the nearest millimeter by measuring the outside circumference by a tape and then divide the value by constant 3.1416 (π). Or by means of a measuring device calibrated to show directly the diameter of the tire.

3.2.2.3. Overall Width is the average of maximum width including the sidewalls, side ribs, bars, decorations, letters or numerals. The width shall be measured by nearest millimeters at four different points equally distributed around the tire and the result averaged.

3.2.2.4. Size Factor is the sum of the Overall Diameter and Overall Width when mounted on its rim and inflated to the specified inflation pressure.

3.2.2.5. Tread Depth shall be measured at the first major groove nearest the tread centerline, avoiding any wear indication.

3.2.3. Standard:

Parameters	Requirement
Overall Diameter (mm)	Not more than 687
Overall Width (mm)	Not more than 211
Tread Depth (mm)	Minimum of 4.9
Size Factor (mm)	Minimum of 847
Air Pressure Loss during 24h conditioning period	Not more than 13.8 kPa or 2PSI

3.3. Tire Strength Test

3.3.1 Purpose: To determine the strength of the tire.

3.3.2 Number of Samples: One (1) sample shall be subjected to plunger test for each quantity of delivery from **151** up to **1,200** pieces. Additional sample shall be randomly selected from the quantity in-excess of 1,200 pcs but within the lot of 151- 1,200 to be subjected to the test.

3.3.3 Procedure:

3.3.3.1 To be conducted by Philippine GeoAnalytics Inc (PGAI) if done in-Country or equivalent government recognized testing center at the country of origin.

3.3.3.2 Force a **19mm** diameter cylindrical steel plunger rod with a hemispherical end at **5** equally distributed points perpendicularly into the tread rib as near to the centerline as possible, avoiding penetration into the groove, at the rate of **50 mm/min±10 mm/min**.

3.3.3.3 The plunger is stopped before reaching the rim or the required tire strength value of **294J** is reached without the tire breaking.

3.3.3.4 Should there be a Pre Delivery Inspection at the country of origin, all the required Functional Tests and Inspections shall be conducted through a capable independent third party entity or that host country/government accredited test facility or in the absence thereof, at the manufacturer's test facilities. The Manufacturer shall issue a document certifying that the tested tire came from the lots delivered and have passed the Tire Strength Test.

3.4.1. Standard: The tire should not break before reaching the Tire Strength requirement based on PNS 25:1994 standards, or its equivalent standard at the country of origin if conducted thereat. All tire sample/s should pass the test.

4. TABLE OF CLASSIFICATION OF DEFECTS

DEFECTS	CLASSIFICATION	
	MAJOR	MINOR
Visual Inspection		
1. Not the required Traction Design (Directional/Rib or Lug Type as appropriate)	X	
2. Without PS or ICC Quality Mark	X	
3. Without Brand Name or Trade Name	X	
4. Without Manufacturer's Tire Designation Markings for **205/70 R15**	X	
5. Not within the Minimum Load Range and/or Ply Rating and Type/Construction (Tubeless/Radial) requirements	X	
6. Without Maximum Air Pressure Markings	X	
7. Without the words "Made in the Philippines" or country of origin if imported.	X	
8. Without Manufacturing Date Mark/Symbol	X	
9. Not within the Manufacturing Period requirement	X	
10. Without Maximum Load Capacity Markings	X	
11. Not within the Maximum Load Capacity Requirements	X	
12. Evident damage on Tread or Sidewall or Ply or Cord or Inner liner	X	
13. Bead Separation	X	
14. Chunking or Cracking or Open Splices on tire surface	X	
Dimensional Test		
15. Dimensions (Diameter or Width or Tread Depth) is not within the		X

standard requirement		
16. Size Factor is not within the standard requirement	X	
17. Air Pressure lost after 24 hours at room temperature exceeded 13.8kPa or 2PSI	X	

5. ACCEPTANCE CRITERIA:

5.1. Visual Inspection

Acceptability of lots shall be determined by using the following Sampling Plans for visual inspection based on MIL STD 105E dated 10 May 1989 using the Acceptable Quality Level as shown in the sampling plan table.

To use the Sampling Plan, a number of sample units based on General Inspection Level I (GIL-I) shall be inspected. If the number of defective/s found is equal to or less than the Acceptance Number (AC) based on GIL I (Reduced), the lot or batch shall be considered acceptable. If the number of defective/s found is equal to or greater than the Rejection Number (RE) based on GIL I (Reduced), the lot or batch shall be rejected.

If the number of defective/s found in the inspection is between the first Acceptance (AC) and Rejection Number (RE); sampling plan for Normal Inspection (GIL-II) shall be applied. The number of samples shall be increased corresponding to the required samples for General Inspection Level II (Normal). The number of defective/s found in the first and second samples shall be accumulated. If the cumulative number of defective/s is equal to or less than the Acceptance Number (AC) for GIL-II (Normal), the lot or batch shall be considered acceptable. If the cumulative number of defective/s is equal to or greater than the Rejection Number (RE) for GIL-II (Normal), the lot or batch shall be rejected.

TABLE- I

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 91 - 150 SAMPLE SIZE: 3	
		AC	RE
Major	6.5	0	2
Minor	10	1	3

TABLE- I-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 91 - 150 SAMPLE SIZE: 20	
		AC	RE
Major	6.5	3	4
Minor	10	5	6

TABLE- II

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 151 - 280 SAMPLE SIZE: 5	
		AC	RE
Major	6.5	1	3
Minor	10	1	4

TABLE- II-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 151 - 280 SAMPLE SIZE: 32	
		AC	RE
Major	6.5	5	6
Minor	10	7	8

TABLE- III

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 281 – 500 SAMPLE SIZE: 8	
		AC	RE
Major	6.5	1	4
Minor	10	2	5

TABLE- III-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 281 – 500 SAMPLE SIZE: 50	
		AC	RE
Major	6.5	7	8
Minor	10	10	11

TABLE- IV

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 501 – 1,200 SAMPLE SIZE: 13	
		AC	RE
Major	6.5	2	5
Minor	10	3	6

TABLE- IV-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 501 – 1,200 SAMPLE SIZE: 80	
		AC	RE
Major	6.5	10	11
Minor	10	14	15

TABLE- V

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 1,201 – 3,200 SAMPLE SIZE: 20	
		AC	RE
Major	6.5	3	6
Minor	10	5	8

TABLE- V-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 1,201 – 3,200 SAMPLE SIZE: 125	
		AC	RE
Major	6.5	14	15
Minor	10	21	22

AC- acceptance number RE- rejection number

For quantities exceeding the lot size provided in the above sampling plan, additional samples shall be randomly selected from the quantity in-excess based on the applicable sampling table and subjected for dimensional test. All sample/s or groups of samples tested shall pass the requirement all the same as one homogeneous quantity.

5.2. Dimensional Test

Acceptability of lots shall be determined by using the following Sampling Plans for dimensional test based on MIL STD 105E dated 10 May 1989 using the Acceptance Limits as shown in the sampling plan table.

Determination of sample/s to be subjected to dimensional test is based on Special Inspection Level S-2 (SIL-S2) due to the strenuous requirement on tools and equipment, personnel and time. Acceptable Quality Limits shall be based on the values indicated in General Inspection Level II (GIL-II) corresponding to the quantity inspected based on SIL-S2. If the number of defective/s found is equal to or less than the Acceptance Number (AC) based on GIL-II, the lot or batch shall be considered acceptable. If the number of defective/s found is equal to or greater than the Rejection Number (RE) based on GIL-II, the lot or batch shall be rejected.

TABLE- I

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR SPECIAL INSPECTION LEVEL – S-2			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 26 – 150 SAMPLE SIZE: 3	
		AC	RE
Major	4.0	0	1
Minor	6.5	0	1

TABLE- II

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR SPECIAL INSPECTION LEVEL – S-1			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 151 – 1,200 SAMPLE SIZE: 5	
		AC	RE
Major	4.0	0	1
Minor	6.5	1	2

TABLE- III

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR SPECIAL INSPECTION LEVEL – S-2			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 1,201 – 3,200 SAMPLE SIZE: 8	
		AC	RE
Major	4.0	1	2
Minor	6.5	1	2

AC- acceptance number RE- rejection number

For quantities exceeding the lot size provided in the above sampling plan, additional samples shall be randomly selected from the quantity in-excess based on the applicable sampling table and subjected for dimensional test. All sample/s or groups of samples tested shall pass the requirement all the same as one homogeneous quantity.

5.3. Tire Strength Test

All tire samples must pass the test. Any sample that fail the tire strength test cause the rejection of the lot.

6. ACCEPTABILITY

The result of the test based on the above criteria shall be the basis for evaluation of the Acceptance Committee in the acceptance/rejection of the above item for use of the PA.

Prepared by:

MARCEL DS FIGURACION
LTC (OS) PA
Acting Chief, Mobility Branch

Approved by:

ERNESTO T LOPENA
Colonel, GSC (OS) PA
Chief

24 DEC 2015

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF ORDNANCE AND CHEMICAL SERVICE
Fort Andres Bonifacio, Metro Manila

PA SPECS NR: MT-14-11-15-A
Rescinds PA SPECS NR: MT-14-09-15 for Tire, 205/70 R15

TECHNICAL SPECIFICATIONS FOR TIRE, 205/70 R15

Application: Intended for use of Light Passenger Cars and Utility Vehicles.	
Technical Data	**Requirements**
Visual	
1. Nominal size including Ply Rating/Load Range	Identifiable
Tire size	205/70 R15
Ply Rating/Load Range	Minimum of 4/B
Type/Construction	Tubeless/Radial
2. Philippine Standard (PS) or Import Commodity Clearance (ICC) Quality Mark	Identifiable
3. Brand Name or Trade Name	Identifiable
4. Maximum Air Pressure Markings	Identifiable
5. The words "Made in the Philippines" or country of origin if imported.	Identifiable
6. Maximum Load Capacity (at 220 kPa)	Identifiable Not less than 636 kgs
7. Manufacturing Date	Identifiable
Dimensional	
8. Overall Diameter (mm)	Not more than 687
9. Overall Tire Width (mm)	Not more than 211
10. Tread Depth (mm)	Minimum of 4.9
11. Size Factor (mm)	Minimum of 847
Tire Strength	Must pass the plunger rod test

Prepared by:

JAY CHRISTIAN M DE GUIA
Major, (OS) PA
Chief, Mobility Branch

Recommended by:

ERNESTO T LOPENA
Colonel, GSC (OS) PA
Chief

Approved by:

EDUARDO M AÑO
Lieutenant General, AFP
Commanding General, PA

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

PA SPECIFICATION **SPEC NR OE-23T265x65 R16**

01 OCT 2019
(Interim)

TIRE, 265x65 R16

Application: Intended for use in Light Trucks and SUV	
Technical Data	**Requirements**
Design:	
1. Traction Design	All Terrain
2. Type/ Construction	Tubeless/Radial
Construction:	Bead, Inner Liner, 1st Ply, 2nd Ply, Tread, 1st Belt, 2nd Belt and Side Wall
Composition:	Natural Rubber
	Synthetic Rubber
	Carbon Black
	Steel
	Fibre, Fillers, Accelerators, antiozonants, etc
Markings:	
1. Manufacturer's Tire Designation Markings	265x65 R16
2. Minimum ply rating/Load range	10 ply/Load Range E
3. Country of origin if imported	Philippines/Country of origin
4. Manufacturing date/Symbol	Coded by Week/Year
5. Manufacturing Period requirement	Date covered is within one (1) year prior to delivery period
Maximum load capacity (at 550 kPa):	
Maximum load single (kgs)	At least 1,120
Dimensional Test:	
1. Tire Diameter (mm)	754.9 (maximum)
2. Tire With (mm)	269 (maximum)
3. Circumference (mm)	2363.02 (maximum)
4. Sidewall Height (mm)	176.25 (maximum)
Tire strength:	Min 576J @ 50mm/min ± 10mm/min
Workmanship manufacturing standard:	Tech Specs Compliant
Packaging:	Each tire shall be packed in transparent plastic or manufacturer standard.

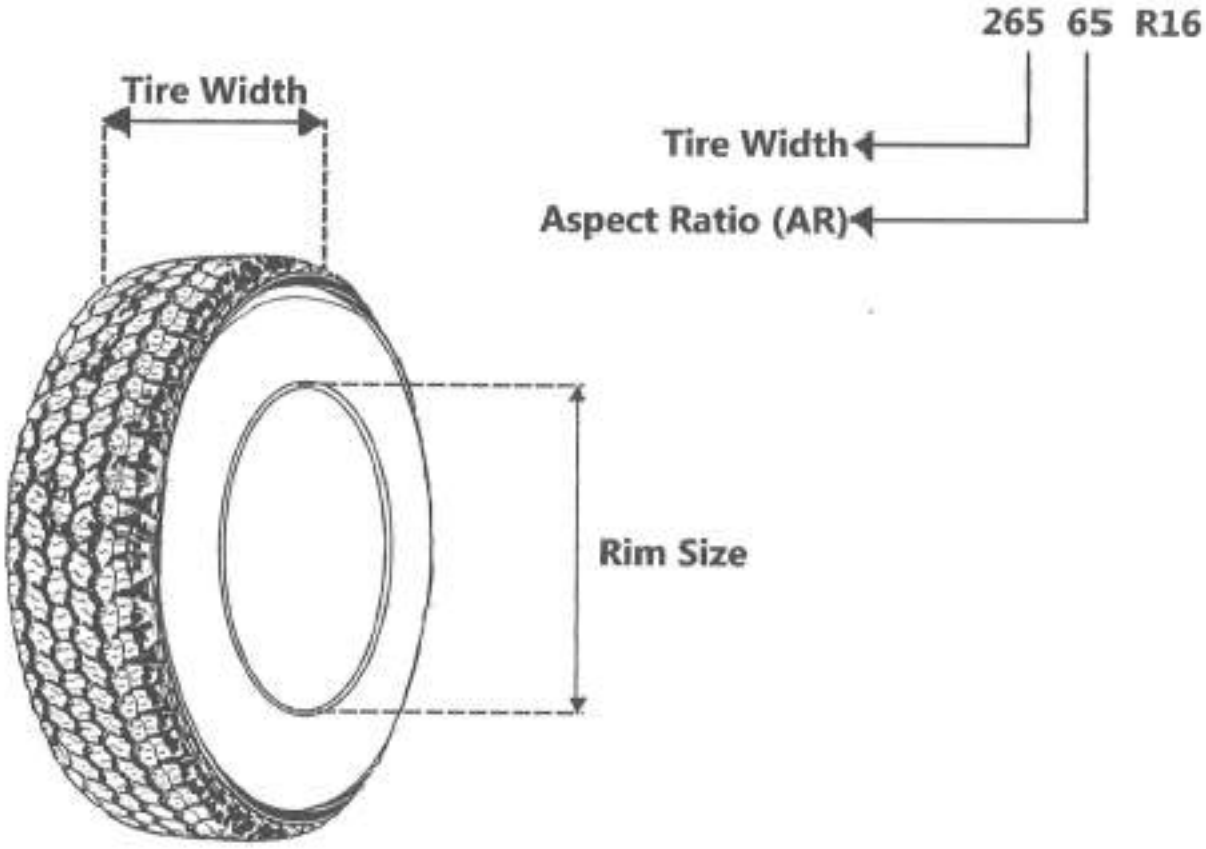
EDMUNDO S SUFICIENCIA
Colonel, GSC (QMS) PA
Chief

NOTED
CG, PA
DATE: OCT 11 2019

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

PA SPECIFICATION

SPEC NR QE-23T265x65 R16
11 OCT 2019
(Interim)



All Terrain Type

FIGURE 1

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

TEST AND ACCEPTANCE PROCEDURE
TIRE, 265x65 R16

1. GENERAL

1.1. Scope: This Test and Acceptance Procedure shall apply to 265x65 R16 Tires intended for Light Trucks and Sports Utility Vehicles (SUV).

1.2. Objective: To ascertain compliance of tires with standards and specifications in consonance with the need of the end user.

1.3. References:

a. Philippine National Standard for Pneumatic Tires, PNS 25: 1994.

b. ISO 4209-1:2001 International Standard – Truck and Bus Tires and Rims (Metric Series)

2. PROCEDURES

2.1. The Technical Inspection and Acceptance Committee (TIAC) for Quartermaster Items or its representatives shall ensure that the complete quantity stated in the contract is packed/palletized prior to inspection.

2.2. The TIAC shall conduct random sampling from the lot or lots. The samples shall be properly segregated, packed, marked and secured by the members/representatives of the committee.

2.3. Technical inspection and test shall be conducted on the representative samples of the lot by visual, dimensional and functional test to determine the over-all workmanship, markings, size and appropriate packaging of the items.

2.4. Functional Test will be done to determine the functional performance of the tire.

2.5. Results obtained shall be recorded and evaluated to determine the compliance of the items to Technical Specifications and as basis for acceptance or rejection of the lot or lots.

3. PHYSICAL INSPECTION

3.3. Visual Inspection

3.3.1. Purpose: To determine the completeness, overall external workmanship, symbols, codes and markings of the tire set sample/s.

3.3.2. Procedure: Visually inspect the completeness, overall appearance and presence of required symbols or markings of the tire set.

3.3.3. Standard:

3.3.3.1. With the Tires required appropriate size of Flap and Tube.

3.3.3.2. With the required Traction Design (Rib Type as appropriate)

3.3.3.3. With PS or ICC Quality Mark or Certificate of Exemption from DTI in case the product offered are beyond the minimum standard of DTI.

3.3.3.4. With Brand Name or Trade Name.

3.3.3.5. Tire Designation Markings: Manufacturer's Standard for Tire, 265x65 R16 (Tire Size, Minimum Ply Rating/Load Range and Type/Construction).

3.3.3.6. With Maximum Air Pressure Markings.

3.3.3.7. With the words "Made in the Philippines" or country of origin if imported.

3.3.3.8. With Manufacturing Date Markings.

3.3.3.9. With Maximum Load Capacity Markings.

3.3.3.10. No evident damage on tread, sidewall, ply, cord, inner liner and including damage on flap and tube/tube valve. No bead separation, chunking, broken cords, cracking or open splices.

3.4. Dimensional Test

3.4.1. Purpose: To determine the actual dimensions of the tire sample/s.

3.4.2. Procedure:

3.4.2.1. The tire set sample/s shall be mounted on its corresponding rim and inflated to the indicated maximum permissible inflation pressure (550kPa) at maximum load as labeled on the tire sidewall. The tire shall be allowed to stand for a minimum of 24 hours at room temperature. The pressure thereafter should be measured and adjusted to within 10kPa of the pressure specified for the tire type, being the ideal condition for measurement of the tire. Measure the Tire Diameter, Tire Width, Circumference and Sidewall Height by hanging the tire to avoid any obstruction from any external factor which may affect the dimensional test.

3.4.2.2. Overall Diameter shall be determined to the nearest millimeter by measuring the outside circumference by a tape and then divide the value by constant 3.1416 (π). or by means of a measuring device calibrated to show directly the diameter of the tire. Figure 1, 2 and 3.

3.4.2.3. Overall Width is the average of maximum widths including the sidewalls, side ribs, bars decorations, letters or numerals. The width shall be measured by nearest millimeters at four different points equally distributed around the tire and the result averaged.

3.4.2.4. Size Factor shall be the sum of overall diameter and overall width.

3.4.3. Standard:

Parameters	Traction Design
Tire Diameter (mm)	754.9 (minimum)
Tire Width (mm)	269 (maximum)
Circumference (mm)	2363.02 (maximum)
Sidewall Height (mm)	176.25 (maximum)

3.5. Tire Strength Test

3.3.1 Purpose: To determine the strength of the tire.

3.3.2 Allocation of samples

3.3.2.1 Post Qualification: One (1) sample shall be submitted to undergo the plunger test. Previous test result of plunger test that is within the period of one (1) year and evaluated as passed can be used in lieu of submission of required samples.

3.3.2.2 Pre Delivery/Final Acceptance: One (1) sample shall be subjected to plunger test that will be taken at random from the delivery which had already undergone the physical inspection and dimensional test. Additional sample for plunger test will be provided when prescribed in the contract which will be determined by procuring entity's representative.

3.3.3 Procedure:

3.3.3.2 To be conducted by Philippine GeoAnalytics Inc (PGAI) if done in-Country or equivalent government recognized testing center at the country of origin.

3.3.3.3 Force a 38mm diameter cylindrical steel plunger rod with a hemispherical end at 5 equally distributed points perpendicularly into the tread rib as near to the centerline as possible, avoiding penetration into the groove, at the rate of 50 mm/min±10 mm/min.

3.3.3.4 The plunger is stopped before reaching the rim or the required tire strength value of 576J is reached without the tire breaking.

3.3.3.5 Should there be a Pre Delivery Inspection at the country of origin, all the required Functional Tests and Inspections shall be conducted through a capable independent third party entity or that host country/government accredited test facility or in the absence thereof, at the manufacturer's test facilities. The Manufacturer shall issue a document certifying that the tested tire came from the lots delivered and have passed the Tire Strength Test.

3.3.4 Standard: Tire Strength requirement based on PNS 25:1994 standards if done in-Country or its equivalent standard used at the country of origin if conducted thereat.

3.3.4.1 All tire samples must pass the test. Any samples that fail the tire strength test shall cause the rejection of the lot.

4. ACCEPTABILITY

4.1 The result of the test based on the above criteria shall be the basis for evaluation of the Acceptance Committee in the acceptance/rejection of the above item for use of the PA.

EDMUNDO S SUFICIENCIA
Colonel, QMS (GSC) PA
Chief

NOTED

CG, PA

DATE OCT 11 2019

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY QUARTERMASTER
Fort Andres Bonifacio, Metro Manila

TABLE OF CLASSIFICATION OF DEFECTS

TIRE, 265x65 R16

DEFECTS	CLASSIFICATION OF DEFECTS	
	Major	Minor
Visual		
1. Each Tires required appropriate size Flap and Tube	x	
2. Required Traction Design (Rib Type as appropriate)	x	
3. With PS or ICC Quality Mark or Certificate of Exemption from DTI in case the product offered are beyond the minimum standard of DTI.	x	
4. Shall have Brand Name or Trade Name markings	x	
5. Manufacturer's Tire Designation Markings is 265x65 R16	x	
6. Not within the Minimum Load Range and/or Ply Rating and Type/Construction requirements	x	
7. Shall have Maximum Air Pressure Markings	x	
8. Shall have the words "Made in the Philippines" or country of origin if imported.	x	
9. Shall have Manufacturing Date Markings/Symbol	x	
10. Not within the Manufacturing Period requirement	x	
11. Each Tires shall have Maximum Load Capacity Markings	x	
12. Not within the Maximum Load Capacity Requirement	x	
13. Evident damage on Tread or Sidewall or Ply or Cord or Inner liner	x	
14. Evident damage on Flap or Tube/Tube valve	x	
15. Bead Separation	x	
16. Chunking, Broken Cords, Cracking or Open Splices on tire surface	x	
Dimensional Test		
17. Dimensions (Diameter or Width or Tread Depth) is not within the standard requirement		x
18. Size Factor is not within the standard requirement	x	
Workmanship		
19. Presence of dirt, stains and other defects:		
a. Does not affect appearance		x
b. Affect appearance	x	
Tire Strength		
20. Each Tire shall meet the required tire strength	x	
Packing and Packaging:		
21. Each Tire shall be packed in plastic transparent or manufacturer's standard	x	
Total test point	**20**	**2**

EDMUNDO S SUFICIENCIA
Colonel, GSC (QMS) PA
Chief

HEADQUARTERS
PHILIPPINE ARMY
PA TECHNICAL WORKING GROUP FOR ORDNANCE ITEMS – MOBILITY
Fort Andres Bonifacio, Metro Manila

PA PQT NR: *MT-15-06-16* 05 JUL 2016
Rescinds PQT Nr MT-15-11-15 for Tire, 265/65 R17

POST QUALIFICATION TEST PROCEDURE FOR TIRE, 265/65 R17

1. GENERAL

1.1. Scope: This Post Qualification Test Procedure shall apply to **265/65 R17** tires intended for use in SUVs and Pick Up Trucks.
1.2. Objective: To ascertain compliance of tires with standards and specifications in consonance with the need of the end user.
1.3. References: a. Philippine National Standard for Pneumatic Tires, PNS 25: 1994.
b. ISO 4209-1:2001 International Standard – Truck and Bus Tires and Rims (Metric Series)

2. SAMPLE ALLOCATION

Test sample shall consist of One (1) *serviceable* Tire based on the technical specifications on the submitted product offered by the proponent during the bidding.

3. TEST PARAMETERS

3.1. Visual Inspection

3.1.1. Purpose: To determine the completeness, overall external workmanship, symbols, codes and markings of the tire set sample/s.
3.1.2. Procedure: Visually inspect the completeness, overall external appearance and presence of required symbols or markings of the tire set.
3.1.3. Standard:
3.1.3.1. With the required Traction Design (Directional/Rib or Lug Type as appropriate).
3.1.3.2. With PS or ICC Quality Mark.
3.1.3.3. With Brand Name or Trade Name.
3.1.3.4. Tire Designation Markings: Manufacturer's Standard for Tire, **265/65 R17**. (Tire Size, Minimum Ply Rating/Load Range and Type/Construction)
3.1.3.5. With Maximum Air Pressure Markings.
3.1.3.6. With the words "Made in the Philippines" or country of origin if imported.
3.1.3.7. With Manufacturing Date Markings.
3.1.3.8. With Maximum Load Capacity Markings.

3.1.3.9. No evident damage on tread, sidewall, ply, cord and inner liner. No bead separation, chunking, broken cords, cracking or open splices.

3.2. Dimensional Test

3.2.1. Purpose: To determine the actual dimensions of the tire sample/s.

3.2.2. Procedure:

3.2.2.1. The tire set sample/s shall be mounted on its corresponding rim and inflate to the indicated maximum permissible inflation pressure (300kPa) at maximum load as labeled on the tire sidewall. The tire shall be allowed to stand for a minimum of 24 hours at room temperature. The pressure thereafter should be measured and adjusted to within 10kPa of the pressure specified for the tire type, being the ideal condition for measurement of the tire. Measure the Overall Diameter, Overall Width and Tread Depth.

3.2.2.2. Overall Diameter shall be determined to the nearest millimeter by measuring the outside circumference by a tape and then divide the value by constant 3.1416 (π). Or by means of a measuring device calibrated to show directly the diameter of the tire.

3.2.2.3. Overall Width is the average maximum width including the sidewalls, side ribs, bars decorations, letters or numerals. The width shall be measured by nearest millimeters at four different points equally distributed around the tire and the result averaged.

3.2.2.4. Size Factor is the sum of the Overall Diameter and Overall Width when mounted on its rim and inflated to the specified inflation pressure.

3.2.2.5. Tread Depth shall be measured at the first major groove nearest the tread centerline, avoiding any wear indication.

3.2.3 Standard:

Parameters	Requirement
Maximum Overall Diameter (mm)	Not more than **780**
Maximum Overall Tire Width (mm)	Not more than **290**
Tread Depth (mm)	Minimum of **9**
Air Pressure Loss during 24h conditioning period	Not more than 13.8 kPa or 2PSI

3.3. Tire Strength

3.3.1 Purpose: To determine that the type of tire offered conforms to the tire strength requirement specified.

3.3.2 Procedure: Manufacturer's tire strength test result for same type of tire shall be submitted for evaluation.

3.3.3 Standard: The tire strength test values shall be compliant or higher with the PNS 25:1994 standard.

4. TABLE OF CLASSIFICATION OF DEFECTS

DEFECTS	CLASSIFICATION	
	MAJOR	MINOR
Visual Inspection		
1. Not the required Traction Design (Directional/Rib or Lug Type as appropriate)	X	
2. Without PS or ICC Quality Mark	X	
3. Without Brand Name or Trade Name	X	
4. Without Manufacturer's Tire Designation Markings for **265/65 R17**	X	
5. Not within the Minimum Load Range and/or Ply Rating and Type/Construction (Tubeless/Radial) requirements	X	
6. Without Maximum Air Pressure Markings	X	
7. Without the words "Made in the Philippines" or country of origin if imported	X	
8. Without Manufacturing Date Mark/Symbol	X	
9. Not within the Manufacturing Period requirement	X	
10. Without Maximum Load Capacity Markings	X	
11. Not within the Maximum Load Capacity requirements	X	
12. Evident damage on Tread or Sidewall or Ply or Cord or Inner liner	X	
13. Bead Separation	X	
14. Chunking or Cracking or Open Splices on tire surface	X	
Dimensional Test		
15. Dimensions (Diameter or Width or Tread Depth) is not within the standard requirement		X
16. Size Factor is not within the standard requirement	X	
17. Air Pressure lost after 24 hours at room temperature exceeded 13.8kPa or 2PSI.	X	
Tire Strength		
18. The tire strength of the offered tire is below the requirement stated in PNS 25:1994 for the same type of tire.	X	

5. POST QUALIFICATION CRITERIA: No Defects Allowed.

Prepared by:

RAMON A TORRES
MAJ (OS) PA
Alternate Member

Approved by:

QUIRINO F LABORTE
Colonel, GSC (OS) PA
Chairman

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF ORDNANCE AND CHEMICAL SERVICE
Fort Andres Bonifacio, Metro Manila

TAP NR: *MT-15-06-16-A*
Rescinds TAP Nr MT-15-03-16 for Tire, 265/65 R17

28 JUN 2016

TEST AND ACCEPTANCE PROCEDURE FOR TIRE, 265/65 R17

1. GENERAL

1.1. Scope: This Test and Acceptance Procedure shall apply to 265/65 R17 tires intended for use in SUVs and Pick Up Trucks.
1.2. Objective: To ascertain compliance of tires with standards and specifications in consonance with the need of the end user.
1.3. References: a. Philippine National Standard for Pneumatic Tires, PNS 25: 1994.
b. ISO 4209-1:2001 International Standard – Truck and Bus Tires and Rims (Metric Series)

2. PROCEDURES

2.1. The Technical Inspection and Acceptance Committee (TIAC) for Ordnance-Mobility or its representatives shall ensure that the complete quantity stated in the contract is packed/palletized prior to inspection.
2.2. The TIAC shall conduct random sampling from the lot or lots. The samples shall be properly segregated, packed, marked and secured by the members/representatives of the committee.
2.3. Technical inspection and test shall be conducted on the representative samples of the lot by visual, dimensional and functional test to determine the over-all workmanship, markings, size and appropriate packaging of the items.
2.4. Functional Test will be done to determine the functional performance of the tire.
2.5. Results obtained shall be recorded and evaluated to determine the compliance of the items to Technical Specifications and as basis for acceptance or rejection of the lot or lots.

3. TEST PARAMETERS

3.1. Visual Inspection

3.1.1. Purpose: To determine the completeness, overall external workmanship, symbols, codes and markings of the tire set sample/s.
3.1.2. Procedure: Visually inspect the completeness, overall external appearance and presence of required symbols or markings of the tire set.
3.1.3. Standard:
3.1.3.1. With the required Traction Design (Directional/Rib or Lug Type as appropriate).

3.1.3.2. With PS or ICC Quality Mark.
3.1.3.3. With Brand Name or Trade Name.
3.1.3.4. Tire Designation Markings: Manufacturer's Standard for Tire, **265/65 R17**. (Tire Size, Minimum Ply Rating/Load Range and Type/Construction)
3.1.3.5. With Maximum Air Pressure Markings.
3.1.3.6. With the words "Made in the Philippines" or country of origin if imported.
3.1.3.7. With Manufacturing Date Markings.
3.1.3.8. With Maximum Load Capacity Markings.
3.1.3.9. No evident damage on tread, sidewall, ply, cord and inner liner. No bead separation, chunking, broken cords, cracking or open splices.

3.2. Dimensional Test

3.2.1. Purpose: To determine the actual dimensions of the tire sample/s.
3.2.2. Procedure:
3.2.2.1. The tire set sample/s shall be mounted on its corresponding rim and inflate to the indicated maximum permissible inflation pressure (300kPa) at maximum load as labeled on the tire sidewall. The tire shall be allowed to stand for a minimum of 24 hours at room temperature. The pressure thereafter should be measured and adjusted to within 10kPa of the pressure specified for the tire type, being the ideal condition for measurement of the tire. Measure the Overall Diameter, Overall Width and Tread Depth.
3.2.2.2. Overall Diameter shall be determined to the nearest millimeter by measuring the outside circumference by a tape and then divide the value by constant 3.1416 (π). Or by means of a measuring device calibrated to show directly the diameter of the tire.
3.2.2.3. Overall Width is the average maximum width including the sidewalls, side ribs, bars decorations, letters or numerals. The width shall be measured by nearest millimeters at four different points equally distributed around the tire and the result averaged.
3.2.2.4. Size Factor is the sum of the Overall Diameter and Overall Width when mounted on its rim and inflated to the specified inflation pressure.
3.2.2.5. Tread Depth shall be measured at the first major groove nearest the tread centerline, avoiding any wear indication.

3.2.3 Standard:

Parameters	Requirement
Maximum Overall Diameter (mm)	Not more than **780**
Maximum Overall Tire Width (mm)	Not more than **290**
Tread Depth (mm)	Minimum of **9**
Air Pressure Loss during 24h conditioning period	Not more than 13.8 kPa or 2PSI

3.3. Tire Strength Test

3.3.1 Purpose: To determine the strength of the tire.

3.3.2 Number of Samples: One (1) sample shall be subjected to plunger test for each quantity of delivery from **151** up to **1,200** pieces. Additional sample shall be randomly selected from the quantity in-excess of 1,200 pcs but within the lot of 151- 1,200 to be subjected to the test.

3.3.3 Procedure:

3.3.3.1 To be conducted by Philippine GeoAnalytics Inc (PGAI) if done in-Country or equivalent government recognized testing center at the country of origin.

3.3.3.2 Force a **19mm** diameter cylindrical steel plunger rod with a hemispherical end at **5** equally distributed points perpendicularly into the tread rib as near to the centerline as possible, avoiding penetration into the groove, at the rate of **50 mm/min±10 mm/min**.

3.3.3.3 The plunger is stopped before reaching the rim or the required tire strength value of **576J** is reached without the tire breaking.

3.3.3.4 Should there be a Pre Delivery Inspection at the country of origin, all the required Functional Tests and Inspections shall be conducted through a capable independent third party entity or that host country/government accredited test facility or in the absence thereof, at the manufacturer's test facilities. The Manufacturer shall issue a document certifying that the tested tire came from the lots delivered and have passed the Tire Strength Test.

3.3.4 Standard: Tire Strength requirement based on PNS 25:1994 standards if done in-Country or its equivalent standard used at the country of origin if conducted thereat.

4. TABLE OF CLASSIFICATION OF DEFECTS

DEFECTS	CLASSIFICATION	
	MAJOR	MINOR
Visual Inspection		
1. Not the required Traction Design (Directional/Rib or Lug Type as appropriate)	X	
2. Without PS or ICC Quality Mark	X	
3. Without Brand Name or Trade Name	X	
4. Without Manufacturer's Tire Designation Markings for **265/65 R17**	X	
5. Not within the Minimum Load Range and/or Ply Rating and Type/Construction (Tubeless/Radial) requirements	X	
6. Without Maximum Air Pressure Markings	X	
7. Without the words "Made in the Philippines" or country of origin if imported	X	
8. Without Manufacturing Date Mark/Symbol	X	
9. Not within the Manufacturing Period requirement	X	
10. Without Maximum Load Capacity Markings	X	
11. Not within the Maximum Load Capacity requirements	X	
12. Evident damage on Tread or Sidewall or Ply or Cord or Inner liner	X	

13. Bead Separation	X	
14. Chunking or Cracking or Open Splices on tire surface	X	
Dimensional Test		
15. Dimensions (Diameter or Width or Tread Depth) is not within the standard requirement		X
16. Air Pressure lost after 24 hours at room temperature exceeded 13.8kPa or 2PSI.	X	

5. ACCEPTANCE CRITERIA:

5.1. Visual Inspection

Acceptability of lots shall be determined by using the following Sampling Plans for visual inspection based on MIL STD 105E dated 10 May 1989 using the Acceptable Quality Level as shown in the sampling plan table.

To use the Sampling Plan, a number of sample units based on General Inspection Level I (GIL-I) shall be inspected. If the number of defective/s found is equal to or less than the Acceptance Number (AC) based on GIL I (Reduced), the lot or batch shall be considered acceptable. If the number of defective/s found is equal to or greater than the Rejection Number (RE) based on GIL I (Reduced), the lot or batch shall be rejected.

If the number of defective/s found in the inspection is between the first Acceptance (AC) and Rejection Number (RE); sampling plan for Normal Inspection (GIL-II) shall be applied. The number of samples shall be increased corresponding to the required samples for General Inspection Level II (Normal). The number of defective/s found in the first and second samples shall be accumulated. If the cumulative number of defective/s is equal to or less than the Acceptance Number (AC) for GIL-II (Normal), the lot or batch shall be considered acceptable. If the cumulative number of defective/s is equal to or greater than the Rejection Number (RE) for GIL-II (Normal), the lot or batch shall be rejected.

TABLE- I

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 91 – 150 SAMPLE SIZE: 3	
		AC	RE
Major	6.5	0	2
Minor	10	1	3

TABLE- I-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 91 – 150 SAMPLE SIZE: 20	
		AC	RE
Major	6.5	3	4
Minor	10	5	6

TABLE- II

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 151 – 280 SAMPLE SIZE: 5	
		AC	RE
Major	6.5	1	3
Minor	10	1	4

TABLE- II-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 151 – 280 SAMPLE SIZE: 32	
		AC	RE
Major	6.5	5	6
Minor	10	7	8

TABLE- III

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 281 – 500 SAMPLE SIZE: 8	
		AC	RE
Major	6.5	1	4
Minor	10	2	5

TABLE- III-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 281 – 500 SAMPLE SIZE: 50	
		AC	RE
Major	6.5	7	8
Minor	10	10	11

TABLE- IV

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 501 – 1,200 SAMPLE SIZE: 13	
		AC	RE
Major	6.5	2	5
Minor	10	3	6

TABLE- IV-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 501 – 1,200 SAMPLE SIZE: 80	
		AC	RE
Major	6.5	10	11
Minor	10	14	15

TABLE- V

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL-I			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 1,201 – 3,200 SAMPLE SIZE: 20	
		AC	RE
Major	6.5	3	6
Minor	10	5	8

TABLE- V-A

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR GENERAL INSPECTION LEVEL – II (NORMAL)			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 1,201 – 3,200 SAMPLE SIZE: 125	
		AC	RE
Major	6.5	14	15
Minor	10	21	22

AC- acceptance number RE- rejection number

For quantities exceeding the lot size provided in the above sampling plan, additional samples shall be randomly selected from the quantity in-excess based on the applicable sampling table and subjected for dimensional test. All sample/s or groups of samples tested shall pass the requirement all the same as one homogeneous quantity.

5.2. Dimensional Test

Acceptability of lots shall be determined by using the following Sampling Plans for dimensional test based on MIL STD 105E dated 10 May 1989 using the Acceptance Limits as shown in the sampling plan table.

Determination of sample/s to be subjected to dimensional test is based on Special Inspection Level S-2 (SIL-S2) due to the strenuous requirement on tools and equipment, personnel and time. Acceptable Quality Limits shall be based on the values indicated in General Inspection Level II (GIL-II) corresponding to the quantity inspected based on SIL-S2. If the number of defective/s found is equal to or less than the Acceptance Number (AC) based on GIL-II, the lot or batch shall be considered acceptable. If the number of defective/s found is equal to or greater than the Rejection Number (RE) based on GIL-II, the lot or batch shall be rejected.

TABLE- I

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR SPECIAL INSPECTION LEVEL – S-2			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 26 – 150 SAMPLE SIZE: 3	
		AC	RE
Major	4.0	0	1
Minor	6.5	0	1

TABLE- II

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR SPECIAL INSPECTION LEVEL – S-1			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 151 – 1,200 SAMPLE SIZE: 5	
		AC	RE
Major	4.0	0	1
Minor	6.5	1	2

TABLE- III

SAMPLING PLAN: SINGLE SAMPLING PLAN FOR SPECIAL INSPECTION LEVEL – S-2			
CLASSIFICATION OF DEFECT	AQL	LOT SIZE: 1,201 – 3,200 SAMPLE SIZE: 8	
		AC	RE
Major	4.0	1	2
Minor	6.5	1	2

AC- acceptance number RE- rejection number

For quantities exceeding the lot size provided in the above sampling plan, additional samples shall be randomly selected from the quantity in-excess based on the applicable sampling table and subjected for dimensional test. All sample/s or groups of samples tested shall pass the requirement all the same as one homogeneous quantity.

5.3. Tire Strength Test

All tire samples must pass the test. Any sample that fail the tire sample test shall cause the rejection of the lot.

6. ACCEPTABILITY

The result of the test based on the above criteria shall be the basis for evaluation of the Acceptance Committee in the acceptance/rejection of the above item for use of the PA.

Prepared by:

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Acting Chief, Mobility Branch

Approved by:

ERNESTO T LOPENA
Colonel, GSC (OS) PA
Chief

HEADQUARTERS
PHILIPPINE ARMY
OFFICE OF THE ARMY CHIEF ORDNANCE AND CHEMICAL SERVICE
Fort Andres Bonifacio, Metro Manila

14 OCT 2015

PA SPECS NR: MT-15-09-15

TECHNICAL SPECIFICATIONS FOR TIRE, 265/65 R17

Application: Intended for use in SUVs and Pick Up Vans.	
Technical Data	**Requirements**
Visual	
1. Nominal size including Ply Rating/Load Range	Identifiable
Tire size	265/65 R17
Ply Rating/Load Range	Minimum of 10/E
Type/Construction	Tubeless/ Radial
2. Philippine Standard (PS) or Import Commodity Clearance (ICC) Quality Mark	Identifiable
3. Brand Name or Trade Name	Identifiable
4. Maximum Air Pressure Markings	Identifiable
5. The words "Made in the Philippines" or country of origin if imported.	Identifiable
6. Maximum Load Capacity (at 300 kPa)	Identifiable
Single (kgs)	Not less than 1,000
7. Manufacturing Date	Identifiable
Dimensional	
8. Maximum Overall Diameter (mm)	780
9. Maximum Overall Tire Width (mm)	290
10. Tread Depth (mm)	Minimum of 9
Tire Strength	Must pass the plunger rod test

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