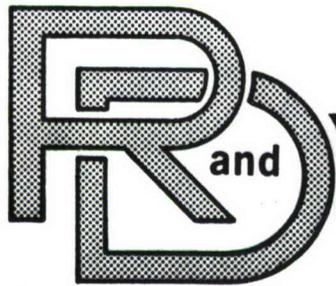


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TECHNICAL REPORT

No. 12653



FABRICATION OF T-156 TRACK BUSHING ASSEMBLIES

FINAL REPORT

JULY, 1982

U. S. ARMY

TANK - AUTOMOTIVE COMMAND

CONTRACT NO. DAAE07-81-C-4095

by C. E. LYNN

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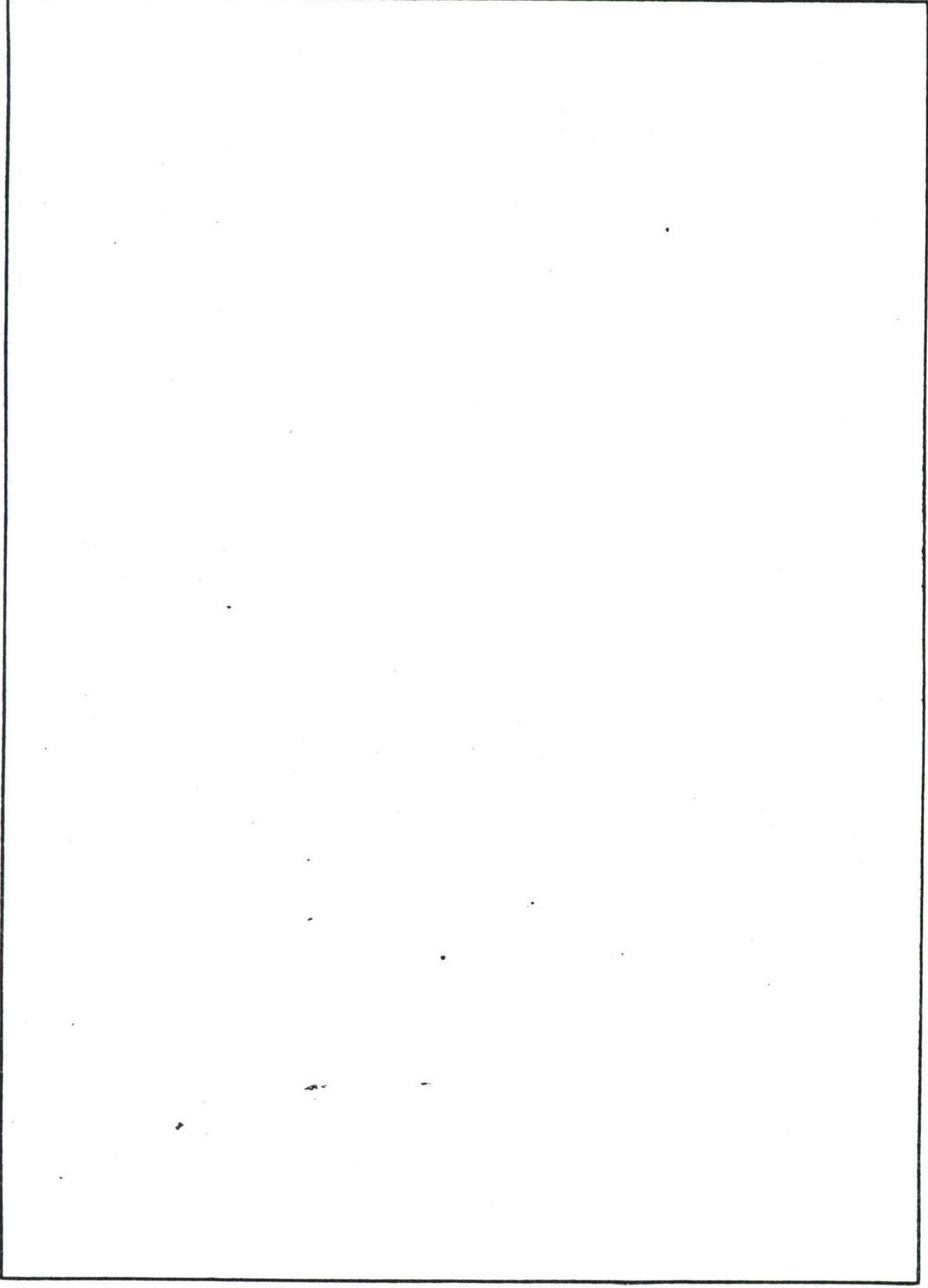
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REPORT DOCUMENTATION PAGE		READ INSTRUCTIONS BEFORE COMPLETING FORM
1. REPORT NUMBER 12653	2. GOVT ACCESSION NO.	3. RECIPIENT'S CATALOG NUMBER
4. TITLE (and Subtitle) Fabrication of T-156 Track Bushing Assemblies		5. TYPE OF REPORT & PERIOD COVERED Final
		6. PERFORMING ORG. REPORT NUMBER
7. AUTHOR(s) Charles E Lynn		8. CONTRACT OR GRANT NUMBER(s) DAAE07-81-C-4095
9. PERFORMING ORGANIZATION NAME AND ADDRESS The Goodyear Tire & Rubber Company P. O. Box 288 St Marys, Ohio 45885		10. PROGRAM ELEMENT, PROJECT, TASK AREA & WORK UNIT NUMBERS DD Form 1423
11. CONTROLLING OFFICE NAME AND ADDRESS U. S. Army Tank - Automotive Command DRSTA-RCKT 6501 East Eleven Mile Road, Warren, Michigan		12. REPORT DATE July 1982
		13. NUMBER OF PAGES 9
14. MONITORING AGENCY NAME & ADDRESS (if different from Controlling Office)		15. SECURITY CLASS. (of this report) Unclassified
		15a. DECLASSIFICATION/DOWNGRADING SCHEDULE
16. DISTRIBUTION STATEMENT (of this Report) Distribution Unlimited.		
17. DISTRIBUTION STATEMENT (of the abstract entered in Block 20, if different from Report)		
18. SUPPLEMENTARY NOTES		
19. KEY WORDS (Continue on reverse side if necessary and identify by block number) Components Process Rubberizing		
20. ABSTRACT (Continue on reverse side if necessary and identify by block number) This report gives a brief description of the manufacturing process for rubberizing 1500 T-156 pins according to drawing P3-18483		



SUMMARY

The Goodyear Tire & Rubber Company, a manufacturer of component products for military tracked vehicles, rubberized 1500 T-156 track shoe pins (Ref Dwg 12274418) to a given configuration as shown on Dwg P3-18483.

Material used in the rubberization process was Goodyear's QPL rubber - SM7541 as specified on Dwg P3-18483.

Materials and processing were monitored according to Military Specification Mil-T-11891 and Goodyear's QCI - No. 25.

Manufacturing technology applicable to this part is similar to that used in the fabrication of other military track-shoe-pin bushing assemblies.

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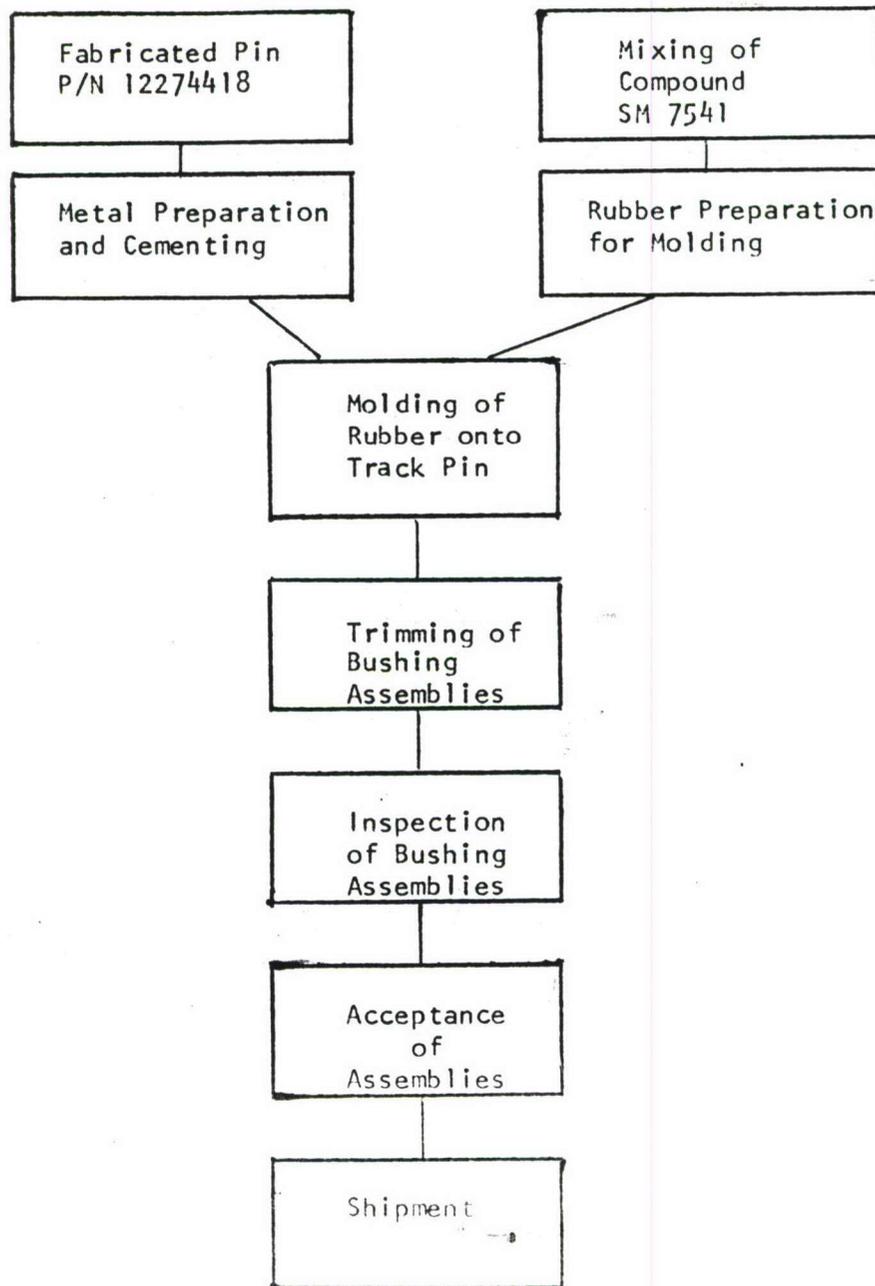
OBJECTIVE

The purpose is to identify the manufacturing processes of a T-156 track shoe bushing assembly and denote problem areas within that procedure.

An independent contractor, not an agent of the Government, shall provide the personnel, materials and manufacturing facilities to fabricate 1,500 T-156 track pins and rubberize them per drawing P3-18483.

DESCRIPTION OF ASSEMBLY PROCEDURE

The description of assembly procedures is presented in the following flow chart.



CONCLUSION

The assembly and molding process for the 1,500 T-156 track-shoe-pin bushing assemblies was accomplished at the manufacturing facilities of The Goodyear Tire and Rubber Co., St Marys Plant, St Marys, Ohio.

No particular problems were encountered in any of the various production processes.

All phases were monitored under Mil-T-11891 and Goodyear's QCI 25.

PHYSICAL TESTING RESULTS

Shot Peening Intensity Values

(Checks per MIL-S-13165 to 0.010 A to 0.020# A)

Results: 0.012 - 0.013 Range
Average Value - 0.0125

Bushing Adhesion Pull Values

(Checks per MIL-T-11891 - Outer Bushings - 33 lb/min)
- Inner Bushings - 37 lb/min)

Results: 40 - 65 Range - Inner
Average Value - 52 lb

Results: 34 - 62 Range - Outer
Average Value 50 lb

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DRAWINGS

Attachment I - Dwg No. P3-18483, Rev 3, Dated 1-20-81

Attachment II - Dwg No. 12274418, Rev C, Dated 5-12-80

