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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 13652-2023

Replacing GB/T 13652-2004

Surface quality of aircraft tires

航空轮胎表面质量

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Foreword

This document complies with the provisions of GB/T 1:1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents" Drafting: This document replaces GB/T 13652-2004 "Surface Quality of Aeronautical Tires": Compared with GB/T 13652-2004, except for structural adjustments and In addition to editorial changes, the main technical changes are as follows:

- a) The requirements for qualified products for tire crown rubber edges have been changed (see item 1 of Table 1, item 1 of Table 1 of the:2004 edition);
- b) The requirements for qualified products with die gap misalignment have been changed (see item 2 of Table 1, item 2 of Table 1 in the:2004 edition);
- c) Added requirements for repairing missing glue in the pattern (see item 3 of Table 1, item 3 of Table 1 in the:2004 edition);
- d) Changed the requirements for qualified products with side skin or cracks in the tire (see item 4 of Table 1, item 4 of Table 1 in the:2004 edition);
- e) Changed the requirements for qualified products of bead fitting surface (see item 8 of Table 1, item 8 of Table 1 in the:2004 edition);
- f) The requirements for qualified products with tire toe fillets have been changed (see item 10 of Table 1, item 10 of Table 1 of the:2004 edition);
- g) Delete the dents or cracks in the lining (see item 14 of Table 1 of the:2004 edition);
- h) The requirements for qualified products of fully reinforced tire treads have been changed (see item 17 of Table 1, item 18 of Table 1 in the:2004 edition);
- i) The requirements for product marking of qualified products have been changed (see item 19 of Table 1, item 20 of Table 1 of the:2004 version);
- j) The cord break defect has been deleted (see item 23 of Table 1 of the:2004 edition);
- k) The traveler breakage defect has been deleted (see item 25 of Table 1 of the:2004

edition): Please note that some content in this document may be subject to patents: The publisher of this document assumes no responsibility for identifying patents: This document is proposed by China Petroleum and Chemical Industry Federation: This document is under the jurisdiction of the National Tire and Rim Standardization Technical Committee (SAC/TC19): This document was drafted by: China National Chemical Corporation Shuguang Rubber Industry Research and Design Institute Co., Ltd.; Guilin Lanyu Aviation Tire Development Co., Ltd: Company, Sanyak Co., Ltd.; and Tsinghua University: The main drafters of this document: Gao Jing, Li Yuting, Lu Hengyu, Fu Yuncui, Huang Zhiyi, Zhang Juyin, Qi Yuemeng, Ma Chao, Zhang Lanyi, Liu Dameng: This document was first published in:1992, revised for the first time in:2004, and this is the second revision: Aerospace tire surface quality

1 Scope

GB/T 13652-2023 is the Chinese national standard on surface quality of aircraft tires, in the field of rubber and plastic industries. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 28 December 2023 by the State Administration for Market Regulation; Standardization Administration of China, and has been in force since 1 July 2024.

Classification: ICS 83.160.20, CCS G41. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This document specifies the surface quality requirements for aircraft tires: This document applies to the production and inspection of various types of aviation tires (hereinafter referred to as tires):

2 Normative reference documents

The contents of the following documents constitute essential provisions of this document through normative references in the text: Among them, the dated quotations For undated referenced documents, only the version corresponding to that date applies to this document; for undated referenced documents, the latest version (including all amendments) applies to this document:

GB/T 6326 Tire terminology

3 Terms and definitions

The terms and definitions defined in GB/T 6326 apply to this document:

4 Technical requirements

1 The tire surface quality should comply with the requirements in Table 1: Table

1 Surface quality Serial number Surface quality problem Qualified product standard
Repairable standard

1 tire crown rubber edge

Tire nominal section width mm Glue edge base thickness mm ≤ 200 > 200 $\leq 1:0$ $\leq 2:0$ 2:
Die gap misalignment Nominal outer diameter of tire mm offset value mm ≤ 600 > 600
 $\leq 0:5$ $\leq 1:0$ 3: The pattern lacks glue or is round: Tire nominal section width mm Depth of
glue shortage mm ≤ 200 > 200 $\leq 1:0$ $\leq 1:$

5 The pattern lacks rubber or is round and the cumulative length does not exceed the
outside of the tire: 1/5 of the circumference Nonconforming items may be repaired or
repaired: repair After repair or repair, the overall appearance of the tire should not be
affected: Observe that there should be no obvious unevenness in the tread: