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**Ton-Mile Per Hour
Test Procedure**

SAE Recommended Practice
Revised December 1983

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TON-MILE PER HOUR TEST PROCEDURE

1. PURPOSE:

This procedure provides a uniform method for determining the work capability or ton-mile per hour (TMPH) rating of an off-the-road tire as limited by its operating temperature. This practice is applicable to tires used on earthmoving machines as defined in SAE J1057a (June, 1975). It is also applicable to certain of the machines referenced in SAE J1116 (July, 1975).

2. SCOPE:

The TMPH rating defines another factor for evaluating the performance capability of off-the-road tires. The TMPH rating is a measure of work per unit time and as such is intended to supplement information published by tire industry standards associations and by tire manufacturers.

- 2.1 The TMPH test was developed using Tire and Rim Association standards (Section 3, Off-the-Road, TRA Yearbook) and reference is made to these specifications throughout the procedure.
- 2.2 The test procedure is also applicable to tire and rim developments approved by the tire and rim manufacturers, although not published in the TRA Yearbook. (See paragraph 7.)
- 2.3 This test procedure does not define how the TMPH rating is applied in evaluating specific applications to machines or their performance.

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3. FACILITIES:

- 3.1 Test Machine: The tires are to be mounted on a suitable machine with a rim as specified in the TRA Yearbook. The test tires should be singles located on a drive (nonsteered) or trail axle. Care must be exercised to eliminate any camber or toe-in of the wheels to prevent nonuniform loading (or see 2.2).
- 3.2 Test Course: The test course shall be any dry, flat, highly compacted material or paved road, laid out in a closed loop configuration. The course length and arrangement should be such that tire loading will not be significantly affected by weight transfer due to turns and super-elevations. The intent is to operate the tire with a known constant load. Provision for a turnaround should be made to reverse the direction of travel. MPH measurements must be run only on a dry test course, as moisture will influence tire temperatures.
- 3.3 Instrumentation:
- 3.3.1 Temperature Measurement System: The system shall be capable of measuring tire test temperatures with an accuracy of $\pm 1.8^{\circ}\text{F}$ ($\pm 1^{\circ}\text{C}$).
- 3.3.2 Thermocouple Probe Assembly: An instrument as described in Fig. 1 is required to provide the functions of holding, guiding, and inserting the thermocouple, and a handle with connection to the reading or recording device.

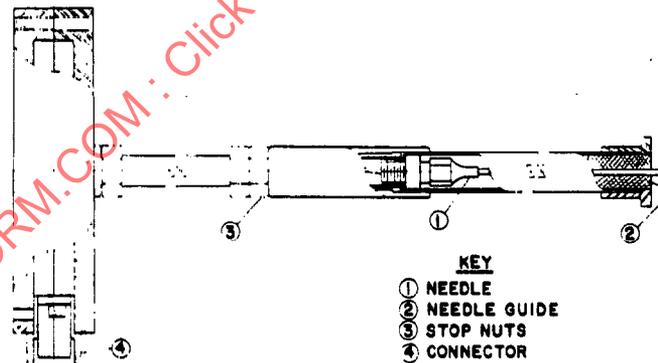


FIGURE 1 - Thermocouple Needle and Holder

- 3.3.3 Pressure Instrument: An instrument capable of measuring tire pressure to an accuracy of ± 1 psi (± 6.9 kPa).
- 3.3.4 Weight Scale: A weight scale with an accuracy of 2%.
- 3.3.5 Timing Device: A standard stopwatch or stopclock capable of measuring 60 min or more, with graduations of 0.01 min.

4. PREPARATION FOR TESTS:

4.1 Tires: Tires must be prepared for thermocouple probes by drilling 0.125 in (3 mm) diameter holes from the tread surface to the top of the topmost reinforcement, i.e., breaker cord, belt cord, or carcass ply. These holes, drilled normal or perpendicular to the tread surface, must be located across the tread in such a pattern that one or more will be within 1.0 in (25 mm) or less of the hottest point in the tire. To insure this, the following procedure is recommended.

4.1.1 Drill Hole Location:

4.1.1.1 With the caliper, measure the total tire thickness of each tread element around the tire at the centerline and shoulder. Determine the area around the circumference with the greatest total thickness.

4.1.1.2 Select a tread bar or contiguous tread element in this heavy gage area as the probe location.

4.1.1.3 For tires of 16.00 cross section and smaller, locate holes in the center of the cross lug or contiguous tread element and at maximum increments of 1.0 in (25 mm) from the tire centerline to each shoulder. For larger tires, locate holes at 2.0 in (50 mm) maximum increments.

4.1.1.4 Continuous rib design tires will require holes in the center of each rib. Ribs wider than 3.0 in (76 mm) will require additional holes 1.0 in (25 mm) either side of the center, but not closer than 0.5 in (12.5 mm) from the rib edge.

4.1.1.5 Mark off increments as described in 4.1.1.3 and/or 4.1.1.4 across the crown of the tire.

4.1.2 Drill Hole Depth Determination:

4.1.2.1 Depth of the drilled holes should be such that the bottom of the hole is within 0.1 in (2.5 mm) of the top of the highest reinforcement cord, but not into or through this cord.

4.1.2.2 If the carcass thickness is known, measure the total tire thickness at the location determined in 4.1.1.3 and subtract the known carcass thickness from this measurement; the remainder (less 0.1 in (2.5 mm)) is the drill depth at that location.

4.1.2.3 If the total carcass thickness is not known, then the drill depth can be determined by drilling test core holes.

4.1.2.3.1 Make core drillings not to exceed 0.250 in (6 mm) diameter at the prescribed intervals (see 4.1.1.3 and 4.1.1.4) from the centerline to both shoulders on a tread element immediately adjacent to the intended probe location. On rib design tires, the cored hole must not be within 2 in (50 mm) of the drill location. Cores should be drilled normal or perpendicular to the tread surface. Avoid excessive core depths and cord breakage.

4.1.2.3.2 Measure the reinforcement (carcass material) thickness on the plugs removed from the cored holes and subtract from the depth of the cored hole. This measurement (less 0.1 in (2.5 mm)) determines the probe depth for that location.

4.2 Inflation: New tires are to be inflated for 24 h prior to the first test. Test tires should be inflated to the TRA Yearbook pressure for the subject ply rating or load range (or see 2.2).

4.3 Break-In: New test tires are to be run for between 80 and 100 miles (130 and 160 km) at a load and speed combination estimated to produce an actual stable temperature within the limits listed below:

4.3.1 Textile Tires, 190-225°F (87-107°C).

4.3.2 Wire Tires, 160-200°F (71-93°C).

5. TEST PROCEDURES:

5.1 Test Conditions:

5.1.1 Selecting Test Load: The test load is determined by selecting a load between 80 and 90% of the TRA Yearbook (30 mph (48 km/h) capacity table for both test tires. The load must be measured for each tire within 2% of the selected test load. This load will be used throughout the test (or see 2.2).

5.1.2 Setting of Test Inflation Pressures: Immediately prior to the test, inflation pressures are to be adjusted with the tires at ambient conditions and the pressure corrected to a 60°F (15.6°C) standard (see 4.2).

5.1.3 Selection of Test Speeds: Three speeds are selected. These three speeds when multiplied by the test load (5.1.1) will generate three corresponding TMPH values to be used in TMPH determination (6.3).

5.1.3.1 Definition of Speed: Speed is an average speed calculated by using the total distance traveled divided by the total time from the initial machine start to the final stop.

5.1.3.2 Method of Speed Selection: Three average speeds are selected which will each produce level off tire temperatures in the approximate ranges shown in Table 1.

5.2 Test Cycle: The test cycle consists of running at a constant speed for approximately 60 min or 15 miles (24.1 km) and a fixed stop-period of minimum duration (not to exceed 10 min). The travel times or distances may be varied slightly to permit even laps around the course between stops. Once the speed or travel time of the cycle has been established, it must be accurately controlled within $\pm 1\%$.

TABLE 1 - Level-Off Tire Temperatures

Tire Type	Approximate Temperature Normalized for Ambient (6.2)	
	°F	°C
Textile	200	93
	225	107
	250	121
Wire	175	79
	200	93
	225	107

5.3 Measurement and Recording of Data:

5.3.1 Recommended Data Form: See Fig. 2.

5.3.2 Tire temperatures are measured in the predrilled probe holes with instrumentation per 3.3.1 and 3.3.2. Temperatures should be taken as quickly as possible at the beginning of the stop-period. A specific measurement sequence should be maintained throughout the test. Measurements should be taken with the thermocouple probe within 0.050 in (1.3 mm) of the probe hole depth. With each temperature recorded, record the elapsed time from the beginning of the stop-period.

5.3.2.1 Hot Area Measurement: It will not be necessary to probe each drilled hole after a sufficient number of readings have been obtained to determine the area of the hot spot or spots on either side of the centerline. After this area has been established, continue to record the hot point in each area and each point adjacent to make certain that the hottest points are being measured.

5.3.2.2 Cooling Rate Measurement: At the completion of the last probe measurement (hottest test condition, 5.1.3), when the level-off condition (5.4) has been reached, each probe hole should again be measured in the same sequence as followed in the test (5.3.2), recording the continuing time lapse from stop for each probe measurement, in the same manner as has been done throughout the test. With the timing device continuing to record the time after the final stop, a third set of probe hole temperature data should be taken with its appropriate stop times, approximately 15 min after the previous readings. This procedure should continue for several more 15 min intervals until sufficient data are obtained to plot a uniform descending rate temperature versus time curve.

5.3.3 Ambient temperature should be recorded at the beginning of the timed test and 30 min before each stop-period. These data are to be used for normalizing the tire temperatures to 100°F (38°C).

TMPH DATA FORM

TEST No. _____ PAGE _____ of _____ DATA BY _____ DATE _____
 TIRE BRAND _____ SIZE _____ TYPE _____ PR _____
 POSITION: (DRIVE OR TRAIL)
 LEFT () LOAD _____ Lb (kP) SERIAL _____
 RIGHT () LOAD _____ Lb (kg) SERIAL _____
 TEST PLAN: GEAR _____ CYCLE TIME _____ Min TRAVEL SPEED _____ MPH (km/h)

PROBE LOCATION		Meas. Temp.	Time After Stop	REMARKS						
LEFT	OUTSIDE									
		TIRE C/L								
	TEMP. °F(°C)	INSIDE	C/L							
RIGHT	OUTSIDE									
		TIRE C/L								
	TEMP. °F(°C)	INSIDE	C/L							
START TIME _____										
STOP TIME _____										
TRIP DIST. _____										
TOTAL MILES _____										
AMBIENT START °F(°C) _____										
30 Min. PRIOR STOP °F(°C) _____										
TIRE HOT SPOT ACT.:										
(L) START _____										
(R) START _____										
TIRE TEMPERATURE:										
(L) HOT SPOT ACT. _____										
(R) HOT SPOT ACT. _____										
ACT. AMB. CORR. ± _____										
(L) CORRECTED _____										
(R) CORRECTED _____										

SUMMARY:
 TOTAL DIST. _____ Miles TOTAL TIME _____ AVERAGE SPEED _____ MPH _____
 LEVEL-OFF TEMPERATURES:
 LEFT: ACTUAL _____ °F(°C) AMB. CORR. _____ °F(°C)
 RIGHT: ACTUAL _____ °F(°C) AMB. CORR. _____ °F(°C)

FIGURE 2 - TMPH Data Form

5.3.3.1 Minimum Ambient Limit for Valid Test: If the ambient is less than 50°F (10°C) during the last 3 h of test, the data are not valid.

5.4 Test Duration: Temperature data are to be recorded at each stop-period until the level-off condition for each tire has been reached. The level-off condition is defined as when the variation in hot spot (paragraph 6) temperature corrected to 100°F (38°C) does not increase more than 5°F (2.8°C) total for three successive stop-periods.

6. DATA REDUCTION AND ANALYSIS:

6.1 Temperature Correction for Time Lapse During Probe Measurements: See 5.3.2.2. An additive correction shall be applied to each probe measurement based on the time lapse after stop. The amount of the correction is determined at the completion of the test, using the cooling curve established at that time.

6.1.1 Cool Curve: The cooling curve is plotted from data obtained as described in 5.3.2.2. The curve is not normalized for the ambient because the cooling rate correction is applied directly to the recorded data.

6.2 Ambient Temperature Normalization: The highest temperature recorded (hot spot) at each tire during each stop is to be normalized to 100°F (38°C) by the following procedure:

(a) If the ambient temperature recorded 30 min prior to tire temperature is less than 100°F (38°C), add 60% (80% for steel cord tires) of the difference to this highest temperature reading. That is,

$$0.60(100^{\circ}\text{F} - \text{amb})$$

(b) If the ambient temperature is greater than 100°F (38°C), subtract 60% (80% for steel cord tires) of the difference. That is,

$$0.60(\text{amb} - 100^{\circ}\text{F})$$

These normalized values are used to determine TPH.

6.3 TPH Determination: The normalized level-off temperatures for the three conditions (5.1.3.2) are plotted on coordinate paper against the appropriate TPH level at which they were generated. (See 5.1.3). Data from both test tires are to be plotted for averaging purposes. (See Fig. 3.)

The rating temperature (T°) is the temperature (given the state of technological development) which the tire can sustain with reliability. This temperature (T°) is separately determined by criteria not given in this test procedure. The TPH value for each of the test tires is read at the T° as established and published by the testing agency. The average of the test sample (minimum of two tires) is to be used as the rating. If temperature difference between test sample tires at the rating temperature exceeds 10°F (5.6°C), the test is not considered valid and the sample size should be increased.