



Designation: D4776 – 04<sup>e1</sup>

# Standard Test Method for Adhesion of Tire Cords and Other Reinforcing Cords to Rubber Compounds by H-Test Procedure<sup>1</sup>

This standard is issued under the fixed designation D4776; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

<sup>e1</sup> NOTE—Editorial corrections were made in 6.3 and in Fig. 1(a) in January 2009.

## 1. Scope

1.1 This test method covers the measurement of adhesion of reinforcing cords that are bonded to rubber compounds. This test method is applicable to textile cord structures from both natural and manmade fibers, other than steel. For adhesion testing of steel tire cords, refer to Test Method [D2229](#).

1.2 This test method is primarily used to evaluate tire cords, using a suitable tire cord adhesive and a suitable rubber compound. This test method is also used to evaluate (1) tire cord adhesives, and (2) the process of adhesive reaction on the cord using one consistent form of tire cord and one consistent rubber compound. This test method may be used to evaluate cords in industrial hose and belting products and other cord reinforced rubber products.

1.3 This test method is written in SI units. The inch-pound units which are provided in this test method are not necessarily exact equivalents of the SI units. Either system may be used in this test method.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

## 2. Referenced Documents

2.1 *ASTM Standards:*<sup>2</sup>

- [D76](#) Specification for Tensile Testing Machines for Textiles
- [D123](#) Terminology Relating to Textiles
- [D1566](#) Terminology Relating to Rubber
- [D2229](#) Test Method for Adhesion Between Steel Tire Cords and Rubber

- [D4393](#) Test Method for Strap Peel Adhesion of Reinforcing Cords or Fabrics to Rubber Compounds
- [D6477](#) Terminology Relating to Tire Cord, Bead Wire, Hose Reinforcing Wire, and Fabrics

## 3. Terminology

3.1 *Definitions:*

3.1.1 For definitions of terms relating to tire cord, bead wire, hose wire, and tire cord fabrics, refer to Terminology [D6477](#).

3.1.1.1 The following terms are relevant to this standard: adhesion, adhesion, in tire fabrics, cord, curing, H-test adhesion, industrial yarn, reinforcing cord, rubber, rubber compound, as used in the manufacture of rubber articles, vulcanization.

3.1.2 For definitions of other terms relating to rubber, refer to Terminology [D1566](#).

3.1.3 For definitions of other textile terms related to textiles, refer to Terminology [D123](#).

## 4. Summary of Test Method

4.1 A cord specimen is sandwiched between two layers of rubber compound test stock in a form resembling an “H,” placed in a heated mold, and cured at a specified temperature and pressure. The test specimen sandwich is then cut to create an H-test specimen consisting of a single cord with each end embedded in the center of a tab end of the rubber test block ([Fig. 2](#)). The test specimen is placed in the grips of the tensile tester, and then the grips are separated. The maximum force obtained is the H-test adhesion force.

## 5. Significance and Use

5.1 Test Method D4776 for the determination of the H-test adhesion of reinforcing cords to rubber compounds may be used for the acceptance testing of commercial shipments of reinforcing cords but caution is advised since information about between-laboratory precision is incomplete. Comparative tests as directed in [5.1.1](#) may be advisable.

5.1.1 In cases of dispute arising from the differences in reported test results when using Test Method D4776 for acceptance testing of commercial shipments, the purchaser and the supplier should conduct comparative tests to determine if

<sup>1</sup> This test method is under the jurisdiction of ASTM Committee [D13](#) on Textiles and is the direct responsibility of Subcommittee [D13.19](#) on Tire Cord and Fabrics. Current edition approved Oct. 1, 2004. Published October 2004. Originally approved in 1988. Last previous edition approved in 2002 as D4776 – 02. DOI: 10.1520/D4776-04E01.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard’s Document Summary page on the ASTM website.

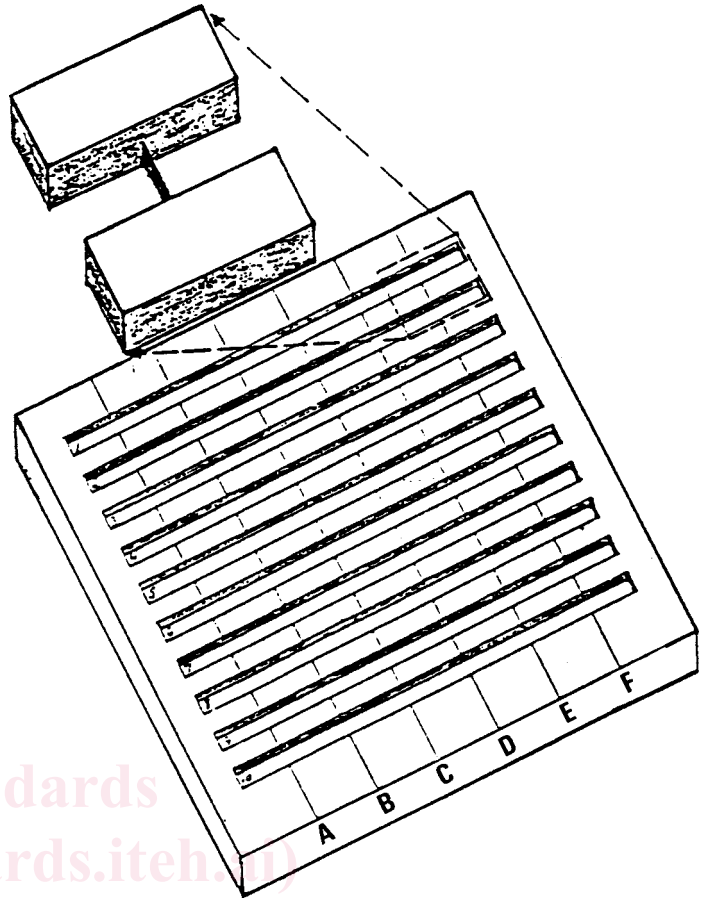
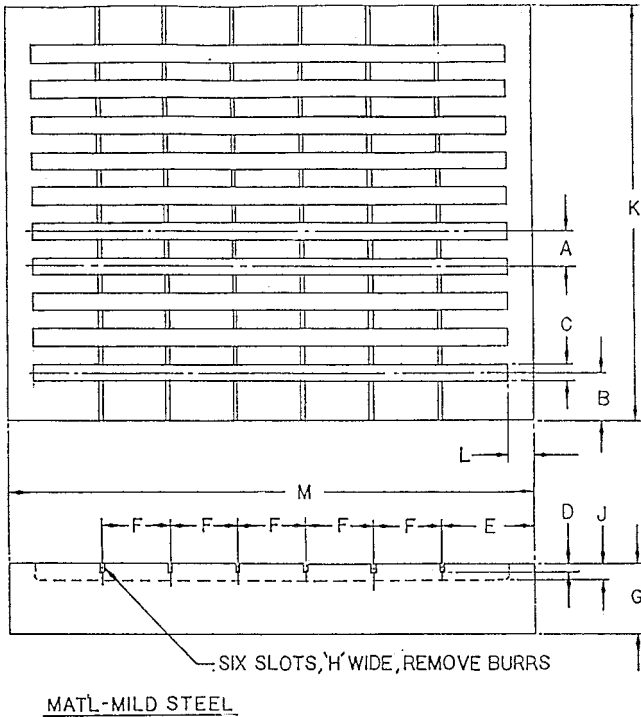


FIG. 2 H-Test Specimen

NOTE 1—The mold as shown will produce 30 specimens. It may be fabricated to produce a larger or smaller number, but the dimensions that govern the specimen size shall not be altered.

NOTE 2—A mold cover plate must be provided. It should be 9.5 mm (.38 in.) thick and the same outside dimensions (“K” and “L”) as the mold.

NOTE 3—Mold dimension tolerances are XX.X mm ± .3 mm (XX.XX in. ± .01 in.) or XX.XX mm ± .13 mm (XX.XXX in. ± .005 in.).

Dimension	2a		2b	
	mm	in.	mm	in.
A	12.70	.500	15.88	.625
B	17.5	.69	17.5	.69
C	6.35	.250	9.52	.375
D	3.17	.125	3.17	.125
E	34.9	1.38	34.9	1.38
F	25.40	1.000	25.40	1.000
G	25.4	1.00	25.4	1.00
H	1.17	0.046	1.17	0.046
J	6.40	.250	6.40	.250
K	149.2	5.88	177.8	7.00
L	9.5	.38	9.5	.38
M	196.8	7.75	196.8	7.75

FIG. 1 Mold for H-Test

there is statistical bias between their laboratories. Competent statistical assistance is recommended for the investigation of bias. As a minimum, the two parties should take a group of test specimens which are as homogeneous as possible and which are from a lot of material of the type in question. The test specimens should then be randomly assigned in equal numbers to each laboratory for testing. The average results from the two laboratories should be compared using Student's *t*-test for unpaired data and an acceptable probability level chosen by the two parties before testing begins. If a bias is found, either its cause must be found and corrected or the purchaser and the supplier must agree to interpret future test results in light of the known bias.

5.2 This test method is used to measure the force required to extract the cord from a rubber compound test block.

5.3 This test method is designed to test the adhesion of textiles that are bonded to rubber compounds. Variables that may contribute to differences in results of this test method include adhesive type, adhesive application procedure, adhesive cure, fiber type, construction of cords, rubber type, rubber cure, and rubber thickness.

5.3.1 The deleterious effect of ozone in combination with atmospheric moisture on the ability of adhesives to bond with rubber requires assiduous protection of cords prior to embedment.

5.4 The expected range of values which characterize acceptable adhesion can be determined in any cord-rubber combination with experience. For this reason, the purchaser normally establishes a minimum level of adhesion to be obtained by the supplier in either the supplier's laboratory or the purchaser's laboratory using either the supplier's standard rubber compound or the purchaser's rubber compound.

5.5 Another procedure for testing adhesion of cords to rubber compounds is Test Methods D4393. This procedure has been used extensively in the trade for acceptance testing. Results obtained by this method cannot be used interchangeably since there is no overall correlation between them.

## 6. Apparatus and Materials

6.1 *Tensile Testing Machine*—Although a constant-rate-of-extension (CRE) tensile testing machine is preferred, a constant-rate-of-traverse (CRT type, pendulum type) may be