

DEPARTMENT OF COMMERCE
BUREAU OF STANDARDS
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UNITED STATES GOVERNMENT MASTER SPECIFICATION FOR
CLOTH-INSERTED RING CUSHIONS

FEDERAL SPECIFICATIONS BOARD SPECIFICATION No. 226a

[Revised June 1, 1925]

This specification was officially promulgated by the Federal Specifications Board on November 5, 1924, for the use of the Departments and Independent Establishments of the Government in the purchase of cloth-inserted ring cushions.

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I. TYPE

Cloth-inserted ring cushions shall be of a single type as described below. Rubber ring cushions are considered in Federal Specifications Board Specification No. 227a.

II. MATERIAL AND WORKMANSHIP

The cushion shall be made of single-coated rubber sheeting. It shall have a smooth, uniform, soft finished, and shall be free from pits and other imperfections.

III. GENERAL REQUIREMENTS

The cushion shall be round with an open center. All seams shall be reinforced, and there shall be an additional reinforcement around the air valve. The cushion shall be accurately fitted with a nickel-plated, screw-tightening air valve. The diameter of the cushion shall be taken as the outside diameter of the air pocket when the cushion is deflated. The width of the outer border, which is formed by the seams and reinforcements, shall not be included as a part of the diameter. The cushion when measured as described shall conform to the following requirements:

Dimensions

Nominal size	Diameter deflated, minimum	Width of air pocket deflated, minimum
8	<i>Inches</i> 16	<i>Inches</i> 5
10	18	5½

IV. DETAIL REQUIREMENTS

1. **THICKNESS OF WALL.**—The wall shall be 0.035 inch thick, with a tolerance of +0.005 inch.

2. **RUBBER CONTENT.**—The rubber compound shall contain not less than 38 per cent, by weight, of best quality new wild or plantation rubber.

3. **FABRIC.**—The sheeting shall be a plain weave, evenly woven, and free from imperfections and makeweight. It shall have a thread count of not less than 68 threads to the inch in warp and 70 in filling, and shall weigh not less than 4.3 ounces per square yard. It shall have a tensile strength of not less than 60 pounds, warp and filling, determined by the strip method.

4. **FINISHED SHEETING.**—The tensile strength of the coated sheeting shall be not less than 65 pounds, warp and filling. Tests shall be made within 30 days from date of delivery, by the strip method on specimens 2 inches wide.

5. **INFLATION.**—Each cushion when inflated with air at a pressure of 3 lbs./in.² shall show no leakage nor any indication of weakness.

V. SAMPLING

One cushion shall be selected from each 100 or less delivered, for test and analysis.

VI. PACKING AND MARKING

Each cushion shall have the size and manufacturer's name or trade name vulcanized in raised letters. Packing shall be as called for in the proposal.

VII. ADDITIONAL INFORMATION

No details specified.

VIII. GENERAL SPECIFICATIONS

General Specifications for Rubber Goods, F. S. B. Specification No. 59a, and for Textiles, in effect on date of issuance of proposal, shall form part of this specification.

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