

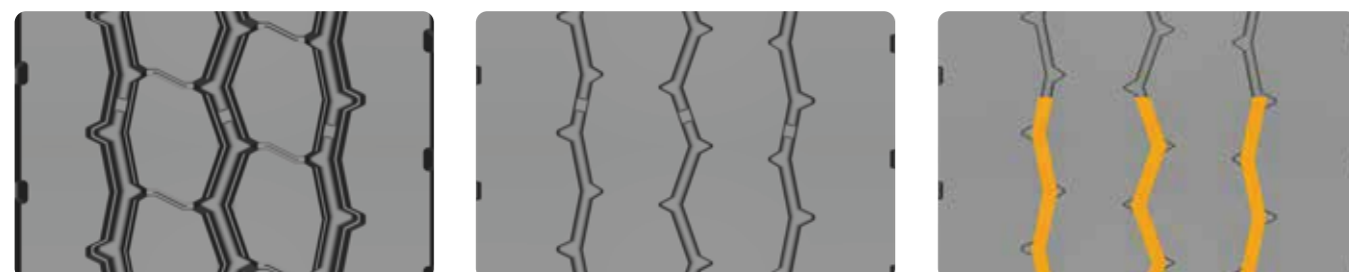
ATH135



NEW TIRE PART WORN REGROOVED

Size	Regrooving depth (mm)	Regrooving width (mm)	Regrooving radius (mm)
215/75R17.5	2.5	6	3
385/65R22.5	3	10	4

AAM210



NEW TIRE PART WORN REGROOVED

Size	Regrooving depth (mm)	Regrooving width (mm)	Regrooving radius (mm)
13R22.5	3	8	4
295/80R22.5	3	8	4
315/80R22.5	3	8	4

ADM215



NEW TIRE PART WORN REGROOVED

Size	Regrooving depth (mm)	Regrooving width (mm)	Regrooving radius (mm)
13R22.5	3	10	4
295/80R22.5	3	10	4
315/80R22.5	3	10	4



TRUCK AND BUS TIRES

REGROOVING RECOMMENDATIONS

PRINX CHENGSHAN TIRE EUROPE GmbH
Berliner Allee 47, 64295 Darmstadt, Germany
E-mail: info@prinx.eu | www.austonetire.com

REGROOVING GUIDELINES

Depending on conditions of use and maintenance new tire casings can offer multiple tire lives (new, regrooved, retread) and minimise tire costs while ensuring safety, performance and fuel economy at the same time.

REGROOVING BASICS

1. A regrooved tire, either new or retreaded, is a tire on a new tread pattern produced by cutting into the tread deeper than the original moulded groove depth.
2. The regrooving operation of truck tires should be entrusted solely to fully trained operators.
3. Only proven regrooving tools with electrically heated blades should be used.
4. A minimum of remaining under the tread rubber is essential to avoid damage to the belt package, groove cracking and/or stone damage.
5. If regrooved according to the recommendations outlined in this manual, the tires can, in principle, be mounted on all wheel positions. However, since it has become standard practice for users to normally fit new tires on front axles, the regrooved tires will usually be mounted on the rear axles or trailer positions.
6. Tires which are heavily damaged in the tread area (e.g. rib tearing, multiple cutting and chipping) should not be regrooved but retreaded.

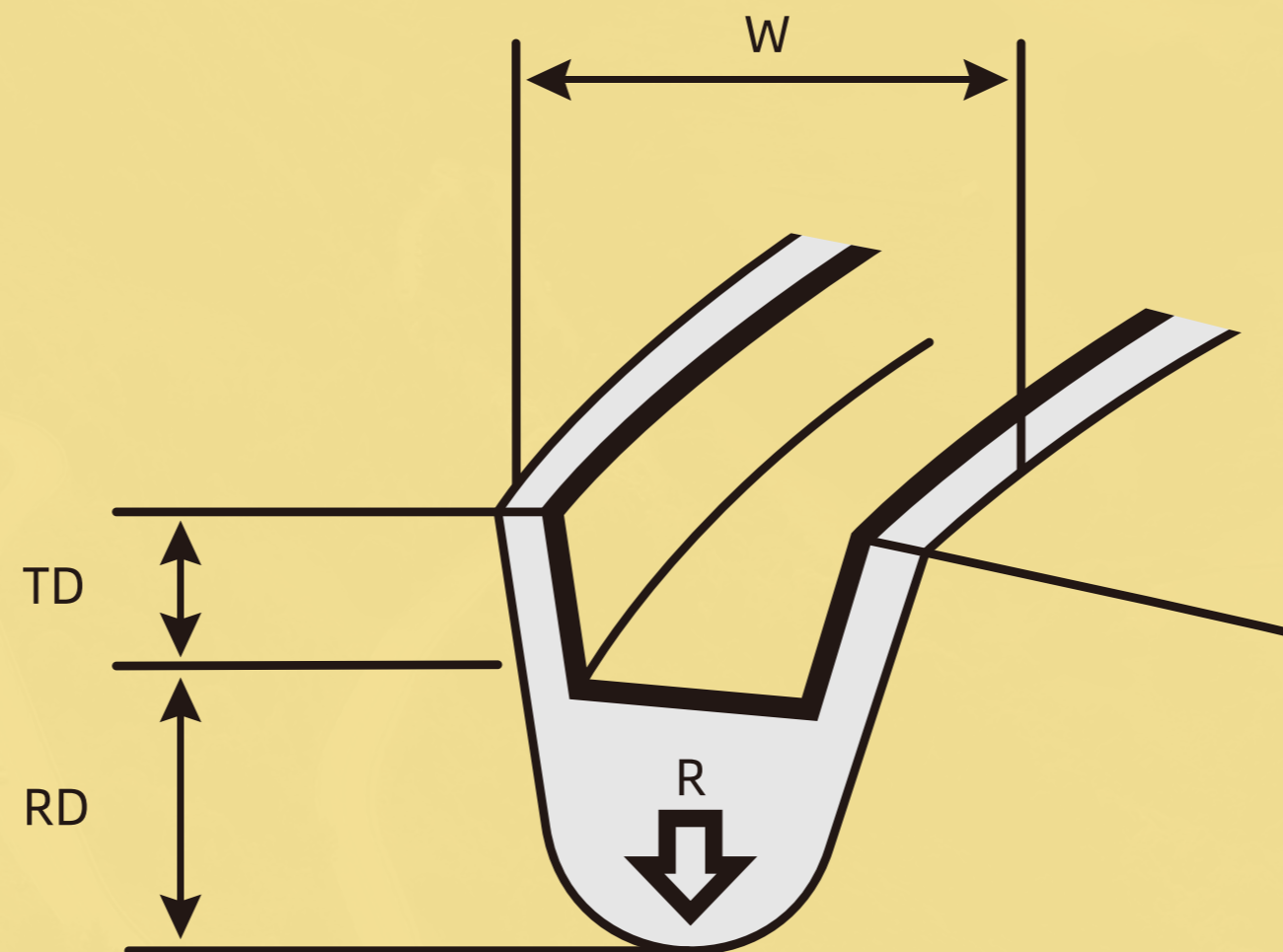
REGROOVING PARAMETERS

Regroove our truck tires only when there is still sufficient tread depth. Suggested remaining tread depths are 3-4 mm for regular highway use; 5-6 mm in operating conditions where penetration damage is likely.

PLEASE CLOSELY FOLLOW THE BELOW RECOMMENDATIONS:

1. Always regroove tires after dismounting from the rim.
2. Carefully inspect the tire before regrooving, check to see that there is no damage on any part of the tire.
3. Remove any stones or foreign objects trapped in the grooves or other areas. Perform repairs when needed.
4. If a tire has irregular wear, it may be possible to regroove the most worn part if enough original groove is visible before regrooving.
5. It is recommended that the minimum remaining tread depth be 3mm before regrooving (measured in 4 places across tire circumference to determine minimum depth).
6. After regrooving, check that the tire is free from defects. It is essential to ensure that the steel belts are not damaged or exposed.

EXAMPLE:



W — regrooving width
(ex. 6 mm)

RD — regrooving depth
(ex. 4 mm)

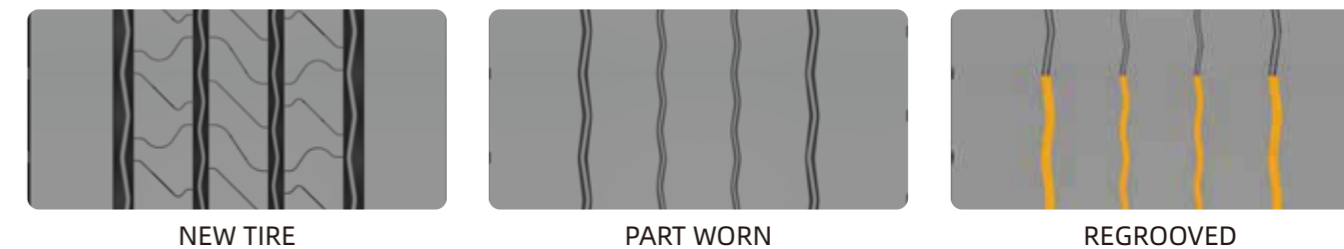
R — regrooving radius
(ex. 3 mm)

TD — remaining tread depth
(ex. 3 mm)

TD + RD — Depth to which cutter blade is set
(ex. 3+4 = 7 mm)

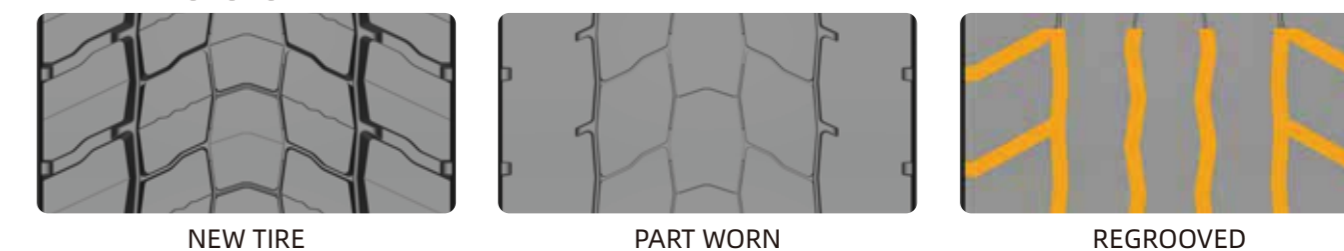
REGROOVING INSTRUCTIONS BY PATTERN

AAR603



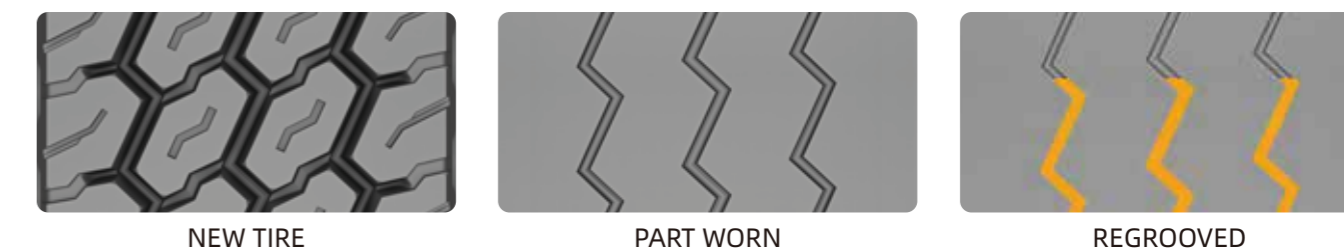
Size	Regrooving depth (mm)	Regrooving width (mm)	Regrooving radius (mm)
205/75R17.5	2.5	6	3
215/75R17.5	2.5	6	3
225/75R17.5	2.5	6	3
235/75R17.5	2.5	6	3
265/70R19.5	2.5	6	3
285/70R19.5	2.5	6	4
295/80R22.5	3	8	4
315/60R22.5	3	8	4
315/70R22.5	3	8	4
315/80R22.5	3	8	4
385/55R22.5	3	10	4
385/65R22.5	3	10	4

ADR606



Size	Regrooving depth (mm)	Regrooving width (mm)	Regrooving radius (mm)
215/75R17.5	2.5	6	3
225/75R17.5	2.5	6	3
235/75R17.5	2.5	6	3
265/70R19.5	2.5	6	3
285/70R19.5	2.5	6	3
295/60R22.5	3	8	4
295/80R22.5	3	8	4
315/60R22.5	3	8	4
315/70R22.5	3	8	4
315/80R22.5	3	8	4

AAM211



Size	Regrooving depth (mm)	Regrooving width (mm)	Regrooving radius (mm)
385/65R22.5	3	10	4