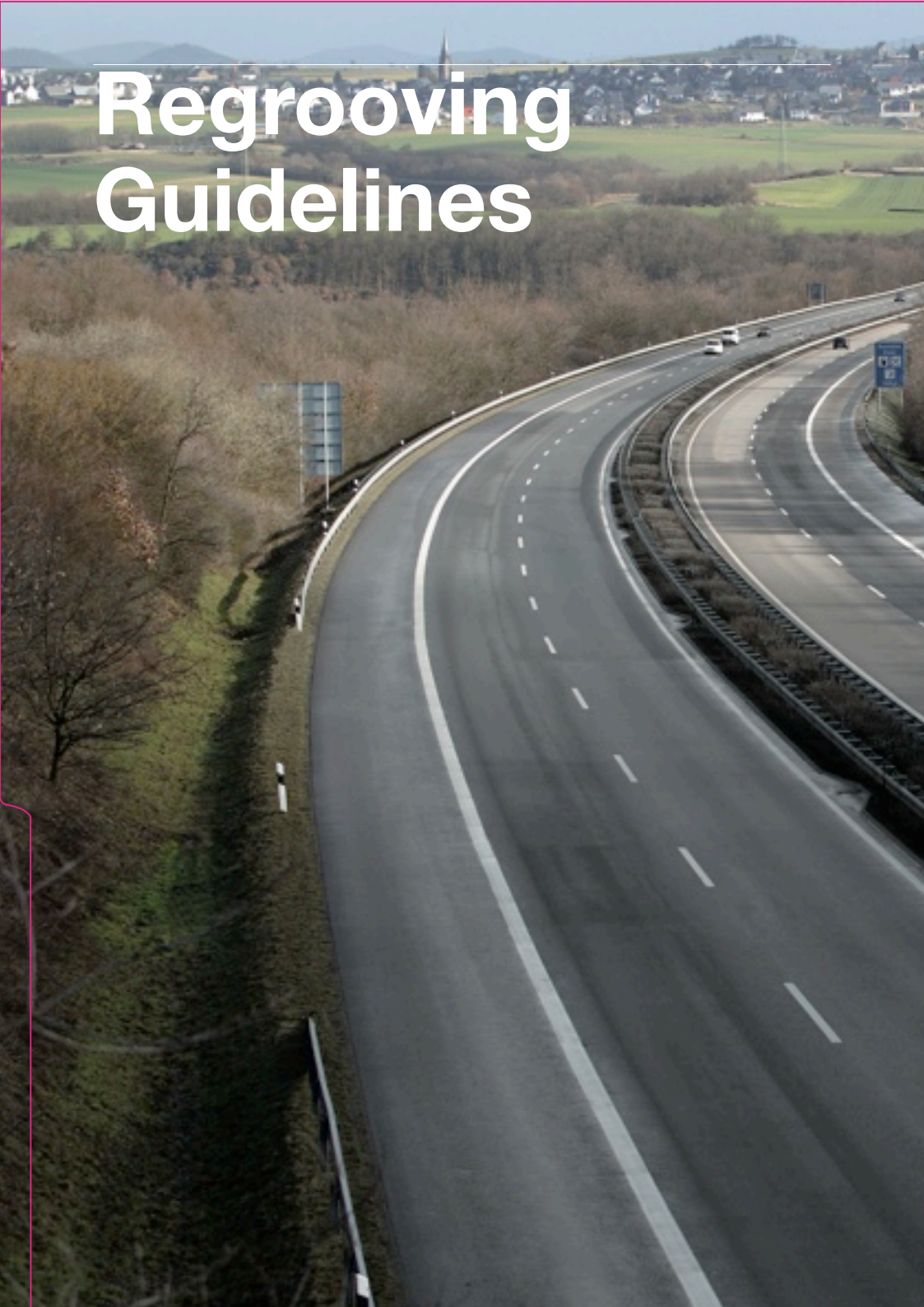


Regrooving Guidelines





Regrooving Guidelines

Depending on conditions of use and maintenance, Goodyear's high-quality tyre casings can give each tyre a minimum of four lives (new, regrooved, retread, regrooved retread) while ensuring safety, performance and minimising operating costs.

Regrooving basics

1. A regrooved tyre is a tyre, either new or retreaded tyre, on which the tread pattern has been renewed or a new tread pattern has been produced by cutting into the tread deeper than the original moulded groove depth.
2. The regrooving of truck tyres 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 undertread rubber is essential to avoid damage at the top breaker belt, groove cracking and/or stone damage.
5. If regrooved according to the recommendations outlined in this manual, Goodyear tyres can, in principle, be mounted on all wheel positions. However, since it has become standard practice for users to normally fit new tyres on front axles, the regrooved tyres will usually be mounted on the rear axles or trailer positions.
6. Tyres which are heavily damaged in the tread area (e.g. rib tearing, multiple cutting and chipping) should not be regrooved but retreaded.

All tyres that are marked 'Regroovable' in the sidewall areas have extra undertread thickness for regrooving purposes.

Regrooving recommendations

1. Under NO circumstances should the tyre be completely worn before regrooving. It is strongly recommended to regroove when 3 to 6 mm of the original design is still left.
2. Determine the blade setting depth for each individual tyre as follows:
 - a) Measure the remaining groove depth AT THE POINT OF LOWEST TREAD DEPTH;
 - b) Set the blade in the cutter head to the 'minimum remaining groove depth' + 3 mm maximum regrooving depth.
This will maintain a 3 mm gauge under the regrooved tread.
3. While regrooving, hold the cutter so that the underside of the cutting head is flush against the tread surface.
4. The maximum regrooving depth for all Goodyear tyres is 3 mm.
5. If the wear is irregular, probing of the remaining undertread gauge is necessary to ensure that 3 mm of undertread will remain after regrooving.

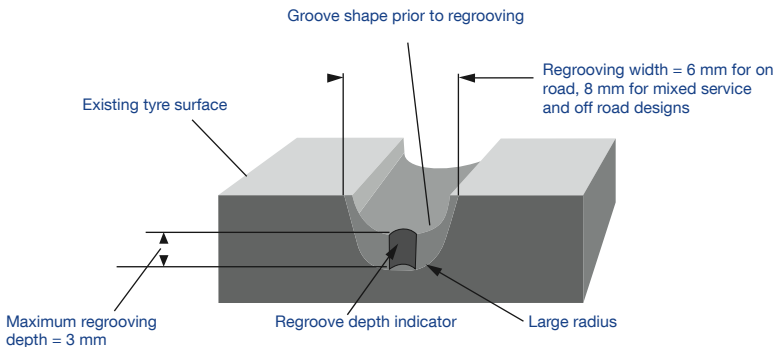
Regrooving Goodyear remould tyres

Provided that the retreading process is on Goodyear casings carried out by Goodyear Authorised Retreader, Goodyear remould tyres may be regrooved to the same pattern as the new tyre, with a maximum regrooving depth of 3 mm.

Regrooving parameters

Regroove Goodyear truck tyres 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.

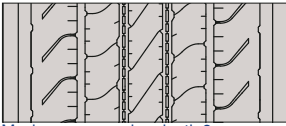
Regrooving depth indicators are moulded into the tyre design. They allow regrooving tools to be set to the optimum depth.



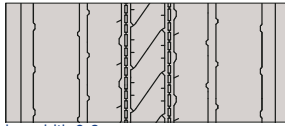
Marathon

Marathon LHS II 22.5

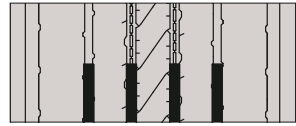
New tyre tread



80% worn



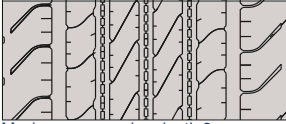
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

Marathon LHS II 65, 55 and 50 series

New tyre tread



80% worn



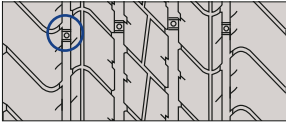
Regrooved tyre



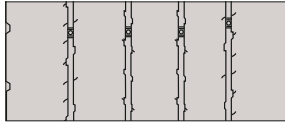
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

Marathon LHS LR8

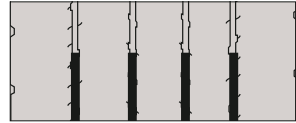
New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6 mm.

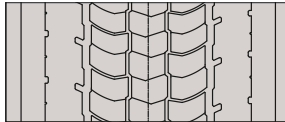
O = Regrooving depth indicators

Marathon LHD II 22.5

New tyre tread



80% worn



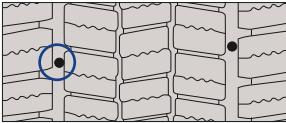
Regrooved tyre



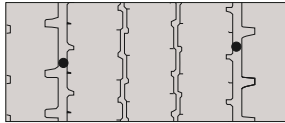
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

Marathon LHD II 265/55R19.5

New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6 mm.

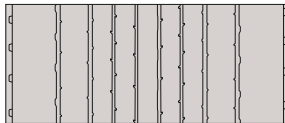
O = Regrooving depth indicators

Marathon LHD Super Single 495/45R22.5

New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6 mm.

Marathon LHT+ 435/50R19.5

New tyre tread



80% worn



Regrooved tyre

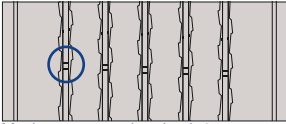


Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

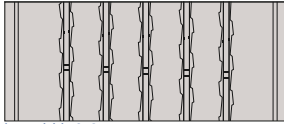
O = Regrooving depth indicators

Marathon LHT 65 and 55-SERIES

New tyre tread



80% worn



Regrooved tyre

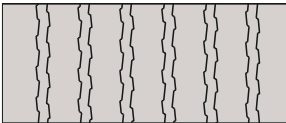


Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

O = Regrooving depth indicators

Marathon LHT+ 455/40R22.5

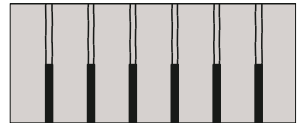
New tyre tread



80% worn



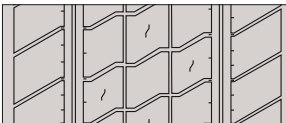
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

Marathon LHT LPT

New tyre tread



80% worn



Regrooved tyre



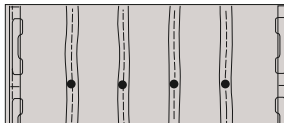
Maximum regrooving depth 3 mm, regrooving width 6 mm.

Marathon LHT 265/55R19.5

New tyre tread



80% worn



Regrooved tyre



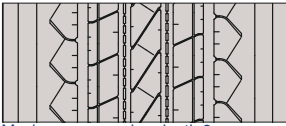
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

O = Regrooving depth indicators

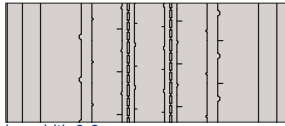
Regional

Regional RHS II 22.5

New tyre tread



80% worn



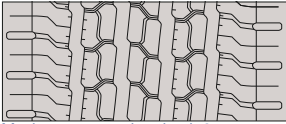
Regrooved tyre



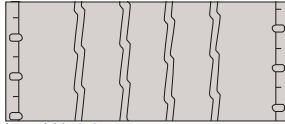
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

Regional RHS II 17.5 and 19.5

New tyre tread



80% worn



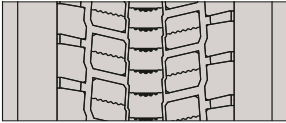
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

Regional RHD II 22.5

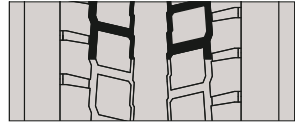
New tyre tread



80% worn



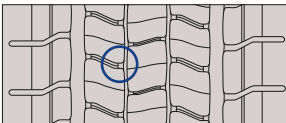
Regrooved tyre



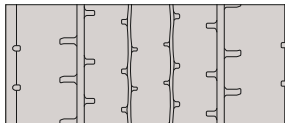
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

Regional RHD II 17.5 and 19.5

New tyre tread



80% worn



Regrooved tyre

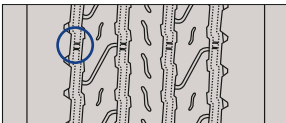


Maximum regrooving depth 3 mm, regrooving width 6 mm.

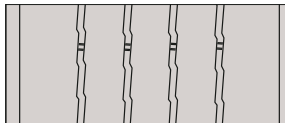
O = Regrooving depth indicators

Regional RHT

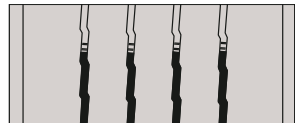
New tyre tread



80% worn



Regrooved tyre

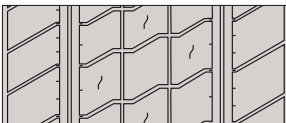


Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

O = Regrooving depth indicators

Regional RHT LPT

New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6 mm.



Omnitrac

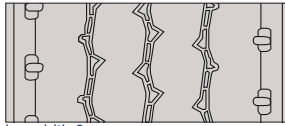
Omnitrac MSS 4-rib

New tyre tread

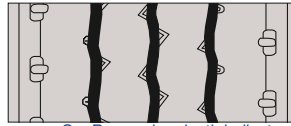


Maximum regrooving depth 3 mm, regrooving width 6 mm.

80% worn



Regrooved tyre



O = Regrooving depth indicators

Omnitrac MSS 5-rib

New tyre tread



Maximum regrooving depth 3 mm, regrooving width 6 mm.

80% worn



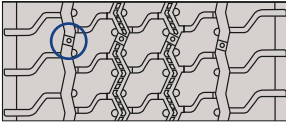
Regrooved tyre



O = Regrooving depth indicators

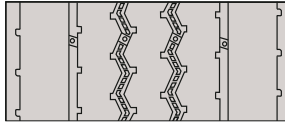
Omnitrac MSS 75 and 90 series

New tyre tread

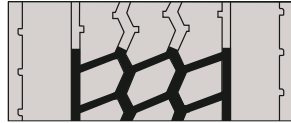


Maximum regrooving depth 3 mm, regrooving width 8 mm.

80% worn



Regrooved tyre



O = Regrooving depth indicators

Omnitrac MSD

New tyre tread



Maximum regrooving depth 3 mm, regrooving width 6-8 mm longitudinal, 8-10 mm radial.

80% worn

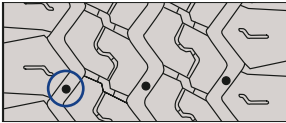


Regrooved tyre



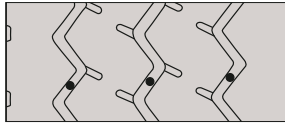
Omnitrac MST

New tyre tread

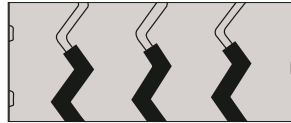


Maximum regrooving depth 3 mm, regrooving width 8 mm.

80% worn



Regrooved tyre



O = Regrooving depth indicators

Offroad

Offroad ORD

New tyre tread



80% worn



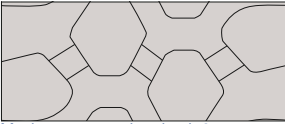
Regrooved tyre



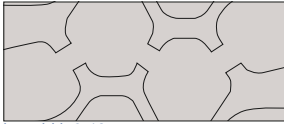
Maximum regrooving depth 3 mm, regrooving width 8-10 mm.

Offroad ORD 90 and 85 series

New tyre tread



80% worn



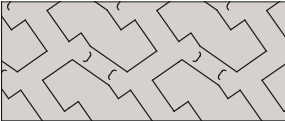
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 8-10 mm.

Offroad ORD 14.00R20

New tyre tread



80% worn



Regrooved tyre



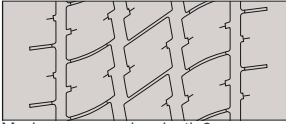
Maximum regrooving depth 3 mm, regrooving width 8-10 mm.



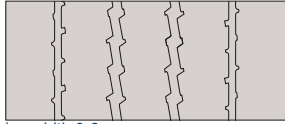
Urban

UrbanMax MCA

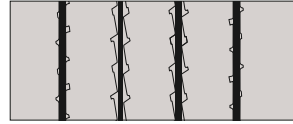
New tyre tread



80% worn



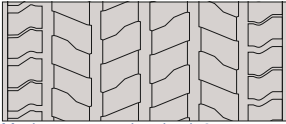
Regrooved tyre



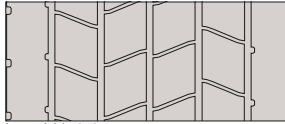
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

UrbanMax MCD Traction

New tyre tread



80% worn



Regrooved tyre



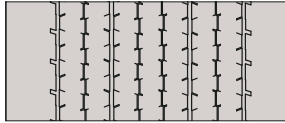
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

MCD Super Single

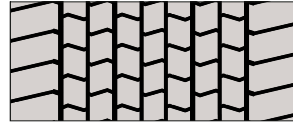
New tyre tread



80% worn



Regrooved tyre



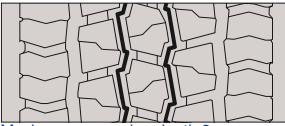
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.



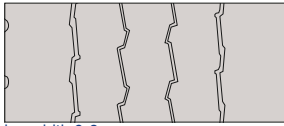
UltraGrip

UltraGrip WTS

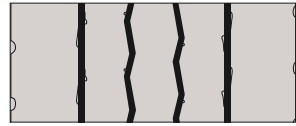
New tyre tread



80% worn



Regrooved tyre



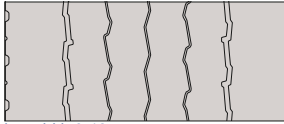
Maximum regrooving depth 3 mm, regrooving width 6-8 mm.

UltraGrip WTS 6-rib

New tyre tread



80% worn



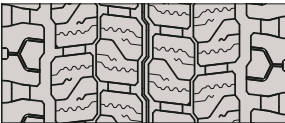
Regrooved tyre



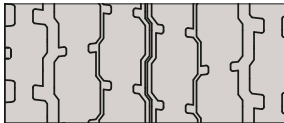
Maximum regrooving depth 3 mm, regrooving width 6-10 mm.

UltraGrip WTD

New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-10 mm.

