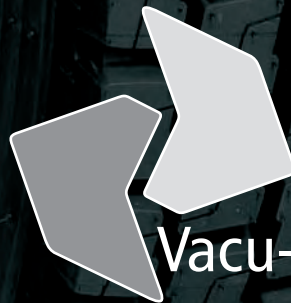


Regrooving manual Vacu-Lug Duramold tyres



TYRE SOLUTION PARTNERS

Vacu-Lug

Regrooving Vacu-Lug Duramold retread tyres

Vacu-Lug Duramold retread tyres are produced by taking worn tyre casings of good structural quality and completely renewing the tread and sidewall rubber.

The finished product provides a reliable, cost-effective and safe alternative to new tyres.

Once used, the Vacu-Lug Duramold retread tyres contained within this publication can be regrooved in exactly the same way as new tyres.



Retread tyres are:

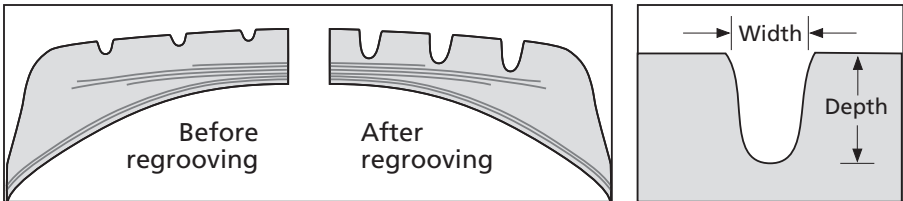
- ♦ **SAFE:** manufactured and tested to the same performance criteria as new tyres (ECE Regs 109).
- ♦ **DURABLE:** can last as long as new tyres and often longer due to their unique design.
- ♦ **FLEXIBLE:** bespoke tread compound and patterns for specific vehicles or road conditions. Thicker sidewalls for reduced wear due to kerb contact are also an option.
- ♦ **ECONOMIC:** retread tyres typically cost 25-30 percent less than new tyres. Add on the cost-per-mile benefits and the savings are even more significant.
- ♦ **ENVIRONMENTALLY ACCEPTABLE:** retreading uses less natural resources – a typical Vacu-Lug tyre uses 75-litres less oil and raw materials than an equivalent new tyre as well as reducing the demand for energy and other petrochemicals during the production process

Regrooving and safety requirements

- ◆ Tyres must always be demounted from the wheel rim prior to regrooving.
- ◆ Check to ensure there is no damage to any part of the tyre before regrooving. In particular, take great care when inspecting the tread area.
- ◆ Remove any stones, nails etc embedded in the grooves and repair if necessary before regrooving.
- ◆ In cases of abnormal tyre wear, regrooving may be possible provided there is still sufficient original groove visible to act as a guide.

Recommendations

- ◆ There should be a minimum of 2–3mm of tread remaining before regrooving.
- ◆ Check this depth at four points around the circumference of the tyre to find the minimum depth of tread remaining.
- ◆ Always set the cutter blade to the exact depth listed for each tyre in this manual.
- ◆ Ensure the patterns, depths and widths specified in this manual are always followed exactly.
- ◆ After regrooving, always thoroughly inspect the tyre for any defects. In particular, ensure the steel belts under the tread have not been exposed.



Regrooving procedure

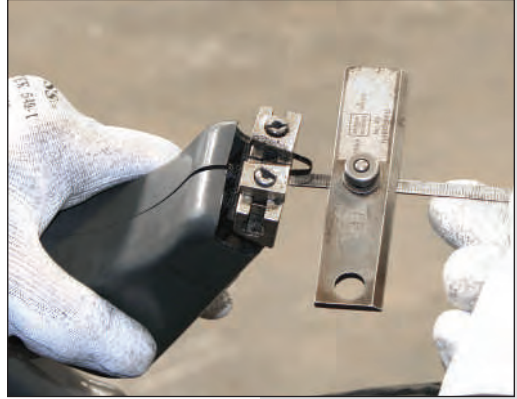
Check that the tyre is marked REGROOVABLE. Inspect for any damage, remove stones, nails etc from the tread and repair if necessary. Look for tread wear indicators the bottom of the grooves.



Measure the remaining tread depth at four points around the tyre to determine the minimum amount of remaining tread – there should always be 2–3mm left before regrooving.



Adjust the depth of cut as specified in this manual. Ensure the width of the blade is set correctly depending upon the tread pattern being cut.



Begin regrooving with the circumferential grooves.



Measure the depth of the first groove cut to confirm the blade is adjusted correctly. After regrooving thoroughly inspect the tyre once again, ensuring in particular that the steel belts have not been exposed.



Duramold tyres regrooving data

MTE2



265/70 R19.5

Depth (mm) 2

Width (mm) 8

T100



11 R22.5

12 R22.5

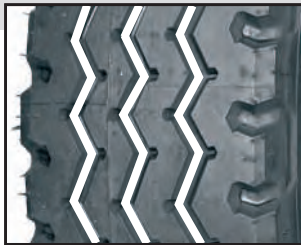
295/80 R22.5

315/80 R22.5

Depth (mm) 2

Width (mm) 10

TZY



11 R22.5

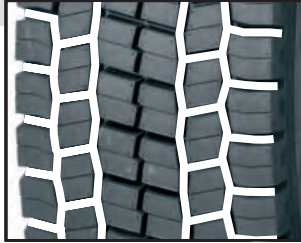
295/80 R22.5

Depth (mm) 2

Width (mm) 10

Duramold tyres regrooving data

W729



295/80 R22.5

Depth (mm) 3

Width (mm) 8

WDE2+



295/80 R22.5

Depth (mm) 3

Width (mm) 8

315/70 R22.5

Depth (mm) 2

Width (mm) 8

WDU/WDU2



265/70 R19.5

285/70 R19.5

Depth (mm) 2

Width (mm) 10

Duramold tyres regrooving data

WDY



11 R22.5

Depth (mm)	2
Width (mm)	10

WDY3



11 R22.5

Depth (mm)	2
Width (mm)	10

295/80 R22.5

Depth (mm)	3
Width (mm)	10

WRE2

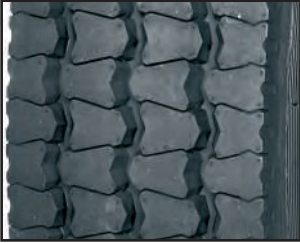


385/65 R22.5

Depth (mm)	4
Width (mm)	8

Duramold tyres regrooving data

WZE



11 R22.5

Depth (mm)	2
Width (mm)	10

WZE2



205/75 R17.5

215/75 R17.5

Depth (mm)	2
Width (mm)	8

WZY2



11 R22.5 & 12 R22.5

Depth (mm)	2
Width (mm)	8

295/80 R22.5

315/80 R22.5

Depth (mm)	3
Width (mm)	8

VACU-LUG DURAMOLD TYRE REGROOVING MANUAL

All specifications correct at time of going to press.

Check www.vaculug.com regularly for updates and further information concerning the regrooving of Vacu-Lug Duramold tyres.

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