



Depending on conditions of use and maintenance, Sailun's high-quality tyre casings can give each tyre three lives (new, 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, Sailun 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 4 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 regrooving depth for all Sailun tyres is 4 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 Sailun remould tyres

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

Regrooving parameters

Regroove Sailun 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

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

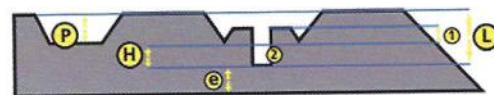
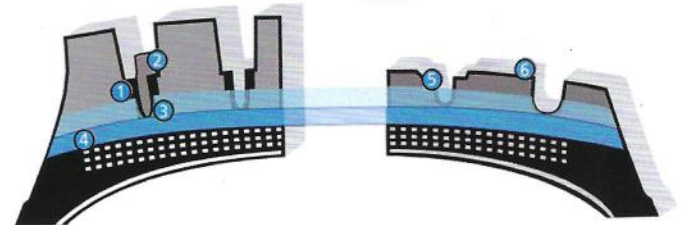
Original profile

- ① Bottom of tread pattern
- ② Tread wear indicator
- ③ Regroove depth indicator
- ④ Layer of under tread rubber

⑤ Profile before regrooving

⑥ Regrooved profile

- Thickness of rubber to be regrooved
- Thickness of rubber to be retained 2mm



⑤ Depth remaining before regroove

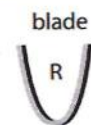
⑥ Theoretical height of regrooving

⑦ Blade setting: $L = P + H$
We recommend that you measure L with a depth gauge

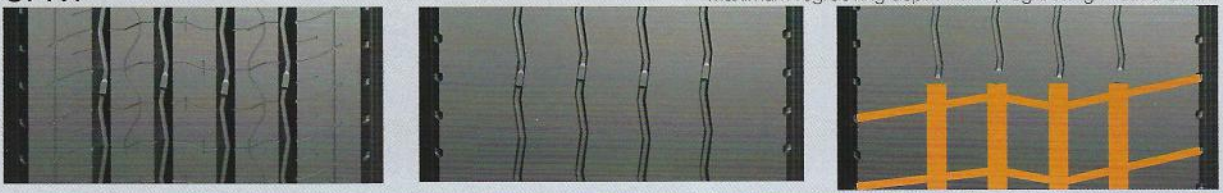
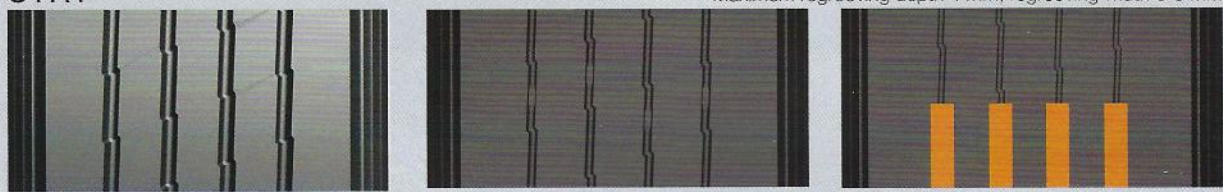
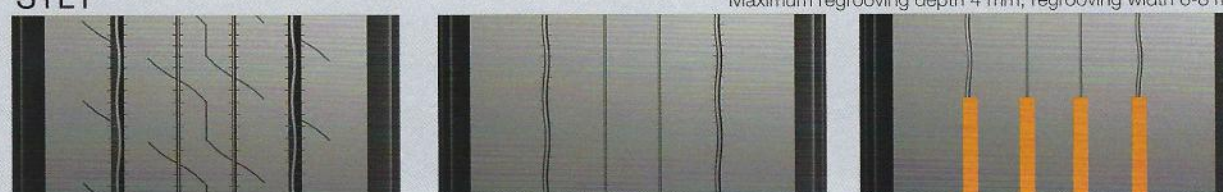
⑧ Thickness of rubber to be kept after regrooving: 2mm

⑨ Height of the wear indicator

⑩ Recess indicating the regrooving depth



RADIAL TRUCK TYRES REGROOVING GUIDELINES

NEW TYRE TREAD	75%WORN	REGROOVED TREAD		
<p>SFR1 Maximum regrooving depth 4 mm, regrooving width 6-8 mm</p> 				
PATTERN	SIZE	H	W	R
SFR1	285/70R19.5	2-2.5	6-8	3
	295/60R22.5	3	6-8	3
	295/80R22.5	3	6-8	3
	315/60R22.5	3	6-8	3
	315/70R22.5	3	6-8	3
	315/80R22.5	3	6-8	3
<p>STR1 Maximum regrooving depth 4 mm, regrooving width 6-8 mm</p> 				
PATTERN	SIZE	H	W	R
STR1	385/65R22.5	3	6-8	3
	385/55R22.5	3	6-8	3
<p>STL1 Maximum regrooving depth 4 mm, regrooving width 6-8 mm</p> 				
PATTERN	SIZE	H	W	R
STL1	385/55R22.5	3	6-8	3
	385/65R22.5	3	6-8	3
	435/50R19.5	3	6-8	3
	445/45R19.5	3	6-8	3

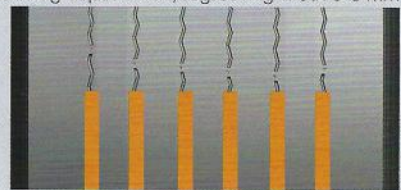
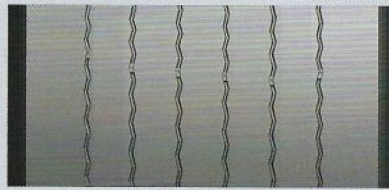
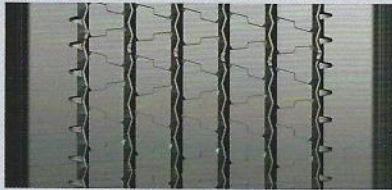
NEW TYRE TREAD

75%WORN

REGROOVED TREAD

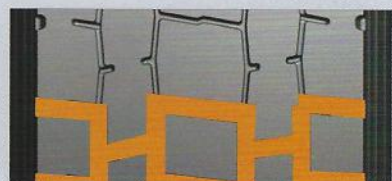
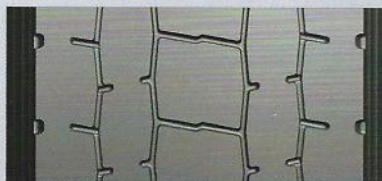
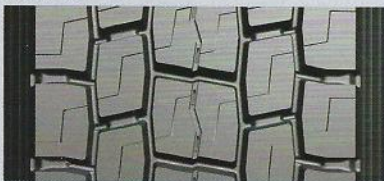
S696

Maximum regrooving depth 4 mm, regrooving width 6-8 mm



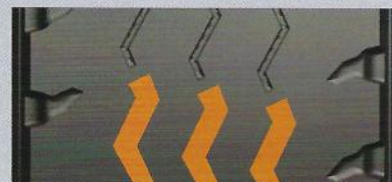
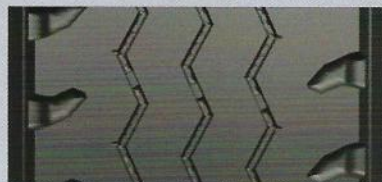
PATTERN	SIZE	H	W	R
S696	435/50R19.5	3	6-8	3
	445/45R19.5	3	6-8	3

SDR1




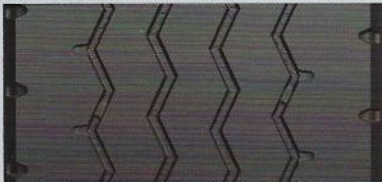

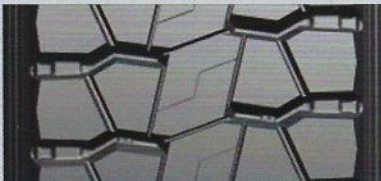
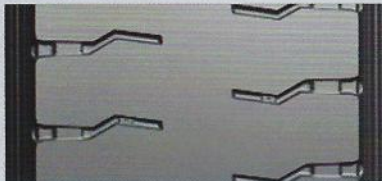

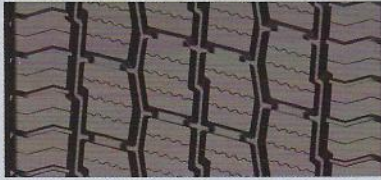
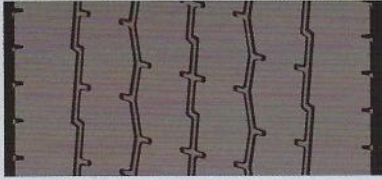

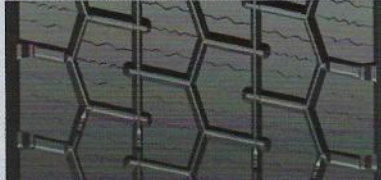
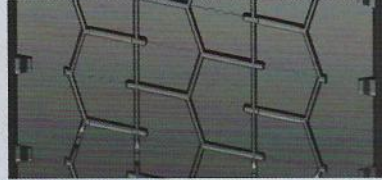
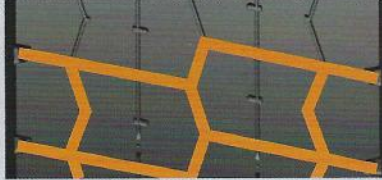
PATTERN	SIZE	H	W	R
SDR1	205/75R17.5	2.5	6	3
	215/75R17.5	2.5	6	3
	235/75R17.5	2.5	6	3
	245/70R17.5	2.5	6	3
	225/70R19.5	2.5	6	3
	245/70R19.5	2.5	6	3
	265/70R19.5	2.5	6	3
	285/70R19.5	2.5	6-8	3-4
	295/60R22.5	3	6-8	3-4
	295/80R22.5	3	6-8	3-4
	315/60R22.5	3	6-8	3-4
	315/70R22.5	3	6-8	3-4
	315/80R22.5	3	6-8	3-4

S815




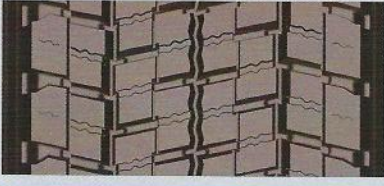
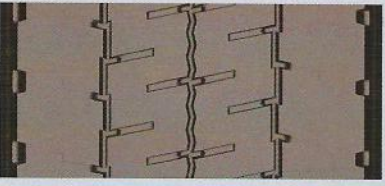
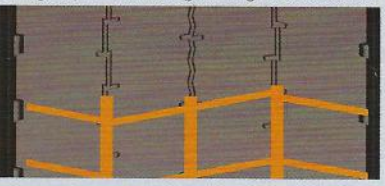


PATTERN	SIZE	H	W	R
S815	295/80R22.5	3	8	4
	315/80R22.5	3	8	4
	11R22.5	3	8	4
	13R22.5	3	8	4

RADIAL TRUCK TYRES REGROOVING GUIDELINES

	NEW TYRE TREAD	75%WORN	REGROOVED TREAD	
S825				
				
PATTERN	SIZE	H	W	R
S825	385/65R22.5	3	8	4
	425/65R22.5	3	8	4
	445/65R22.5	3	8	4
S711				
				
PATTERN	SIZE	H	W	R
S711	315/80R22.5	3	10	4
	13R22.5	3	10	4
SW06				
				
Maximum regrooving depth 4 mm, regrooving width 6-8 mm				
PATTERN	SIZE	H	W	R
SW06	295/80R22.5	3	6-8	4
	315/70R22.5	3	6-8	4
	315/80R22.5	3	6-8	4
	385/55R22.5	3	6-8	4
	385/65R22.5	3	6-8	4
SW02				
				
Maximum regrooving depth 4 mm, regrooving width 6-8 mm				
PATTERN	SIZE	H	W	R
SW02	295/80R22.5	3	6-8	4
	315/70R22.5	3	6-8	4
	315/80R22.5	3	6-8	4

H: Regrooving Depth W: Regrooving Width R: Blade radius

NEW TYRE TREAD	75%WORN	REGROOVED TREAD		
CITY CONVOY				
				
Maximum regrooving depth 4 mm, regrooving width 6-8 mm				
PATTERN	SIZE	H	W	R
Cityconvoy	275/70R22.5	2.5	6-8	3
SW05				
				
Maximum regrooving depth 4 mm, regrooving width 6-8 mm				
PATTERN	SIZE	H	W	R
SW05	315/80R22.5	3	6-8	4