

Regrooving Introduction

INTRODUCTION

A regrooved tyre means a tyre, either new or retreaded, on which a tread pattern has been produced by cutting into the tread in accordance with the tyre manufacturer's recut tread pattern. Recut tread patterns for Hankook tyres are contained in this manual.

Regrooving of truck tyres requires fully trained operators :

- Use only regrooving tools with electrically heated blades.
- Determine the blade setting depth for each individual tyre.
- Set the blade in the cutter head to the specified depth.
- While regrooving, hold the cutter so that the underside of the cutting head is flat against the tread surface. Heating of the blade starts automatically as the blade penetrates the rubber.

A minimum depth of remaining undertread rubber is required to avoid :

- Damage of the top steel belt
- Rib tearing caused by groove cracking
- Stone damage

After regrooving, the tyre should be free of any defects (cracks, separations, exposed ply or cord) visible on either the mounted or demounted tyre.

TECHNICAL REQUIREMENTS

The tyre must be demounted from the rim before regrooving.

Inspection :

- Before regrooving check there is no damage on any part of the tyre.
- Remove stones and any other foreign objects such as nails from the tread which may have embedded in to the grooves. Repair if necessary.
- Particular care should be exercised in selecting a tyre for regrooving where the tread area is damaged in any way (eg : chipping, tearing, and cutting due to abnormal operating conditions)
- Where a tyre has worn abnormally it may be possible to regroove that part of the worn tyre, provided that a sufficient amount of the original groove is visible before regrooving.

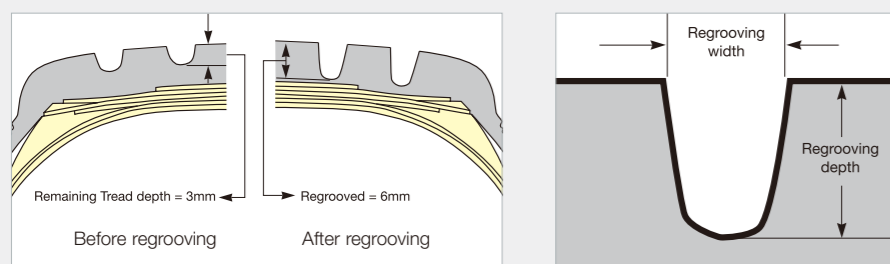
It is recommended that the minimum remaining tread depth be between 2mm and 3mm before regrooving. The tread depth should be measured around the circumference at 4 places to find the minimum remaining depth. Set the cutter blade for the recommendations as shown in this publication.

Please make sure that you regroove Hankook Steel Radials to the patterns, depths and widths recommended in this manual to ensure good service from your tyres.

After regrooving, your tyre should be free from defects.

It is most important to ensure that the belts under the tread have not been exposed.

REGROOVING RECOMMENDATIONS



AM06 SMART WORK AM15 SMART WORK DM09

Mixed Service



Regrooving technical data

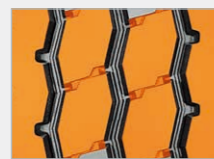


AM06

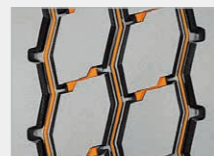
All-position tyre for on and off-road use



Optimised design



Extra deep tread with exclusive compound featuring maximised resistance against cutting and chipping enhances extra long tread life.

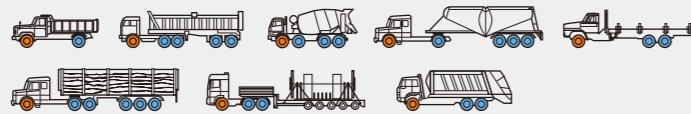


Lateral surface groove between blocks provides good water drainage.



Solid shoulder with innovative 2-step lug shape promotes excellent grip performance and traction.

Recommended / available vehicles and positions



● Recommended position ● Available position

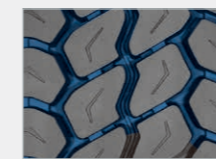
M + S

SMART^{WORK} AM15

On and off-road all-position tyre maximised for longer mileage



Optimised design



Expanded groove width compared to previous pattern for enhanced traction performance.



Stone ejector rib in the middle of the grooves prevents stone drilling.



Tie bars between each block prevents irregular wear.

Recommended / available vehicles and positions



● Recommended position ● Available position

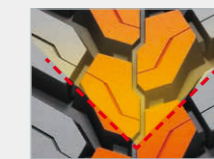
M + S

SMART^{WORK} DM09

Drive axle tyre for on and off-road use



Optimised design



The directional pattern is adopted for excellent handling. The best traction performance is provided even in wet and muddy conditions.



The interblock tie-bar at the centre guarantees outstanding straight driving performance and impact dispersion for blocks, thereby improving durability.



The tapered block design ensures a flexible response to lateral impact.

Recommended vehicles and positions



● Recommended position