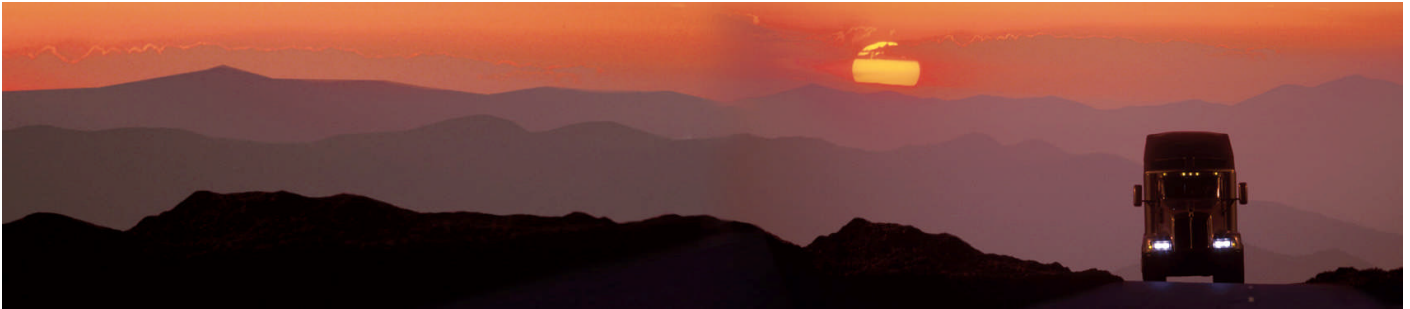


TECHNICAL BULLETIN

TB12002



SUBJECT: REGROOVING

BACKGROUND

The service life all GT Radial radial truck tires marked in the sidewall as REGROOVABLE, can be extended by regrooving even after they have become partially worn or unserviceable due to uneven wear, provided that such regrooving is not legally prohibited.

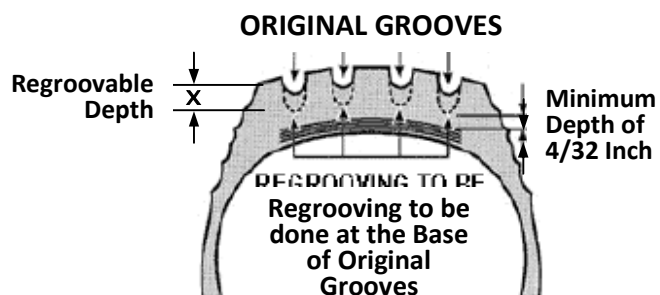
REGROOVING GUIDELINES

1. Regroove only those tires marked "REGROOVABLE" on the sidewall (Photo 1) because they have extra undertread thickness for regrooving purposes.
2. Tires with a remaining tread depth of less than $2/32''$ (1.59 mm) should not be regrooved.
3. A minimum rubber depth of $4/32''$ must be maintained between the tire's top belt and the regrooved grooves (Graphic 1).
4. Such minimum remaining undertread rubber is essential to avoid damage at the top belt, groove cracking and/or stone damage.

Photo 1



Graphic 1



If you have any questions please contact us at techservice@us.giti.com
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5. It is recommended that tires exhibiting severe irregular wear **not be** regrooved.
6. Tires that are heavily damaged in the tread area (e.g. rib tearing, multiple cutting and chipping) **should not** be regrooved.
7. Regrooving should be restricted to the tire's original tread grooves (Graphic 1) and must be done according to Regroovable Depths as provided in Charts 1 and 2.

REGROOVING RECOMMENDATIONS

- It is strongly recommended to **regroove when 3 to 6 mm (3.5 to 7.5/32") of the original tread depth is still remaining.**
- The regrooving of truck tires should be entrusted solely to **fully trained** operators.
- Only **proven regrooving tools** with electrically heated blades should be used.
- Select a grooving blade of proper size according to the width and depth of the groove to be made.
- Determine the blade setting depth for each individual tire as follows:
 - Measure the remaining groove depth at the point of lowest tread depth.
 - Set the blade in the cutter head to the 'minimum remaining groove depth' plus "x" maximum regrooving depth).
 - Note: For "x" please refer to "Regroovable Depth". See Charts 1 and 2.
- Exercise care not to damage the belt edge with the blade, nor cause the belt to be exposed.
- Exert force uniformity while grooving to ensure that the bottom of the groove will be as smooth as possible.
- If the wear is irregular, probing of the remaining undertread gauge is necessary to ensure that 3.2 mm (4/32") of undertread will remain after regrooving.
- It is recommended that regrooved tires are to be mounted on rear axles or trailer positions **not** on the front axle.

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GT RADIAL TIRES REGROOVABLE DEPTHS

Chart 1

SIZE	PR	Load Index & Speed Symbol	PATTERN	Regroovable Depth X	
				(mm)	32nds of Inch
225/70R19.5	14	128/126J	GT279	3	3.8
245/70R19.5	16	136/134J	GT279	3	3.8
11R22.5	14	146/142M	GT279	3	3.8
11R22.5	16	148/145M	GT279	3	3.8
11R22.5	14	146/142M	GT288	3	3.8
11R22.5	16	148/144M	GT288	3	3.8
295/75R22.5	14	144/141M	GT288	3	3.8
11R24.5	14	146/143M	GT288	3	3.8
11R24.5	16	149/146M	GT288	3	3.8
285/75R24.5	14	144/141M	GT288	3	3.8
11R22.5	14	146/142L	GT669	3	3.8
11R22.5	16	148/145L	GT669	3	3.8
295/75R22.5	14	144/141L	GT669	3	3.8
11R24.5	14	146/143L	GT669	3	3.8
11R24.5	16	149/146L	GT669	3	3.8
285/75R24.5	14	144/141L	GT669	3	3.8
11R22.5	14	146/142L	GT679	3	3.8
11R22.5	16	148/144L	GT679	3	3.8
11R24.5	14	146/143L	GT679	3	3.8
11R22.5	14	146/142M	GT688	3	3.8
11R22.5	16	148/144M	GT688	3	3.8
295/75R22.5	14	144/141M	GT688	3	3.8
11R24.5	14	146/143M	GT688	3	3.8
11R24.5	16	149/146M	GT688	3	3.8
285/75R24.5	14	144/141M	GT688	3	3.8
265/70R19.5	14	137/134M	GT879	3	3.8
11R22.5	14	146/142M	GT879	3	3.8
11R22.5	16	148/145M	GT879	3	3.8
11R22.5	16	148/144M	GT01	3	3.8
315/80R22.5	18	154/151L	GT01	3	3.8
12.00R24	18	156/153K	GT01	3	3.8
215/75R17.5	16	135/133J	GT979	2.5	3.1
11R22.5	14	146/142L	GT979	2.5	3.1
255/70R22.5	16	140/137L	GT979	2.5	3.1
295/75R22.5	14	144/141L	GT979	2.5	3.1
11R24.5	14	146/143L	GT979	2.5	3.1
285/75R24.5	14	144/141L	GT979	2.5	3.1

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