



REGROOVING DATA

RECOMMENDATIONS

RECOMMENDATIONS FOR REGROOVING FIRESTONE STEEL RADIAL TYRES FOR TRUCKS AND BUSES

INTRODUCTION

Regrooving Firestone steel radial tyres for trucks and buses will ensure longer serviceability of your tyres. Check that the word "REGROOVABLE" is molded on the tyre sidewall. If it is not, under no circumstances should regrooving be attempted.

GUIDELINES

1. Tyre must be demounted from the rim before regrooving.
2. Inspection:
 - a) Before regrooving, check to see that there is no damage on any part of the tyre i.e. tread, shoulders, sidewalls, beads and inner liner.
 - b) Remove stones which may have become embedded in the grooves, and other foreign objects such as nails from the tread. Repair if necessary.
 - c) Particular care should be exercised when selecting a tyre for regrooving if the tread area is in any way damaged, e.g. by chipping, tearing and cutting due to abnormal operating conditions.
 - d) Where a tyre has worn abnormally, it may be possible to regroove just that part of the worn tyre provided a sufficient portion of the original groove is visible before regrooving.
3. It is recommended that the minimum remaining tread depth be 3mm before regrooving. The tread depth should be measured around the circumference at four places to find the minimum remaining depth. Set the cutter blade according to the recommendations shown in this publication.
4. Please ensure that you regroove your Firestone steel radials to the patterns, depths and widths recommended in this publication to ensure the good service of your tyres.

5. After regrooving, check that your tyre is free from defects. It is most important to ensure that the belts under the tread have not been exposed.
6. As the number of profile grooves and tread design may vary depending on the dimensions, please contact your local Bridgestone customer services representative for further regrooving information.

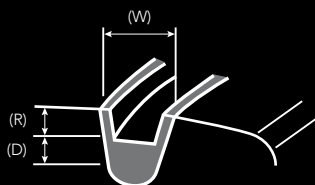
LEGISLATION

Construction and Use Regulations prohibit the use of regrooved tyres on cars, motorcycles, dual purpose vehicles or goods vehicles weighing less than 2,540 kg (2½ tons) ULW, or electric goods vehicles, which are motor cars over 2,540 kg (2½ tons), which have wheels with a rim diameter less than 405mm (16 inches). Electric vehicles are exempt. Regrooved tyres are also prohibited on trailers less than 1,020 kg (1 ton) ULW, (2,040 kg (2 tons) on caravans) and trailers carrying plant and equipment, which do not exceed the total weight of 2,290 kg (2½ tons).

Generally, with most trucks and buses over 2,540 kg (2½ tons) ULW, and electric goods vehicles and trailers weighing more than 1,020 kg (1 ton), the ULW can be fitted with regrooved tyres provided they are designed for regrooving.

Example:

Minimum remaining tread depth = 3 mm (R)
Recommended regrooving depth = 3 mm (D)
Depth to which cutter blade is set = 6 mm (R+D)
Recommended regrooving width = W





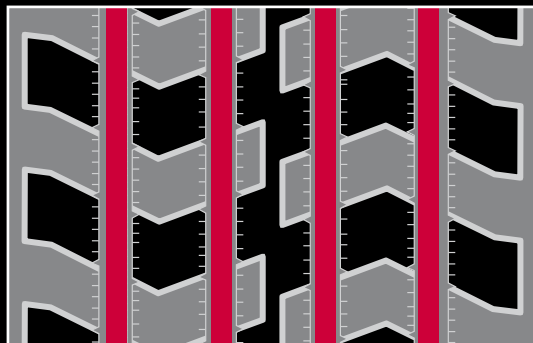
Regrooving Data **49**

ON ROAD

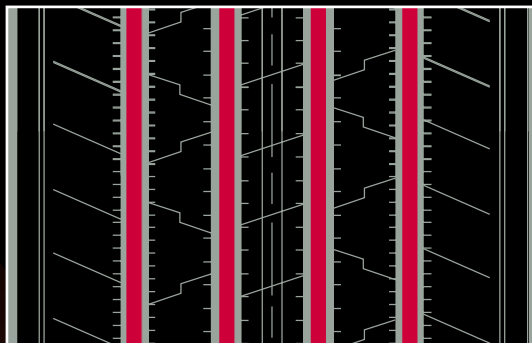
| | |
|---------------|----|
| FS422 | 52 |
| FS400 | 53 |
| PSD3000 | 54 |
| FD622 | 55 |
| FD600 | 56 |
| FT522 | 57 |
| TSP3000 | 58 |

ON/OFF ROAD

| | |
|-------------------|----|
| FS833 | 59 |
| UT3000 Plus | 60 |
| FD833 | 61 |
| FT833 | 62 |
| TMP3000 | 63 |



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 295/80 R 22.5 | 2.0 | 7.0 - 8.0 |
| 315/80 R 22.5 | 2.0 | 7.0 - 8.0 |
| 315/70 R 22.5 | 2.0 | 7.0 - 8.0 |



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 8.5 R 17.5 | 2.0 | 5.0 - 6.0 |
| 9.5 R 17.5 | 3.0 | 6.0 - 7.0 |
| 205/75 R 17.5 | 2.5 | 5.0 - 6.0 |
| 215/75 R 17.5 | 2.0 | 5.0 - 6.0 |
| 225/75 R 17.5 | 2.0 | 5.0 - 6.0 |
| 235/75 R 17.5 | 2.0 | 5.0 - 6.0 |
| 245/70 R 19.5 | 2.5 | 6.0 - 7.0 |
| 265/70 R 19.5 | 2.0 | 6.0 - 7.0 |
| 285/70 R 19.5 | 2.5 | 7.0 - 8.0 |
| 12 R 22.5 | 2.0 | 7.0 - 8.0 |
| 295/80 R 22.5 | 3.0 | 7.0 - 8.0 |
| 275/70 R 22.5 | 2.0 | 7.0 - 8.0 |
| 315/70 R 22.5 | 2.0 | 7.0 - 8.0 |



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) | |
|------------|--------------------------------|--------------------------------|-----|
| | | A | B |
| 12.00 R 20 | 4.0 | 4.0 | 8.0 |



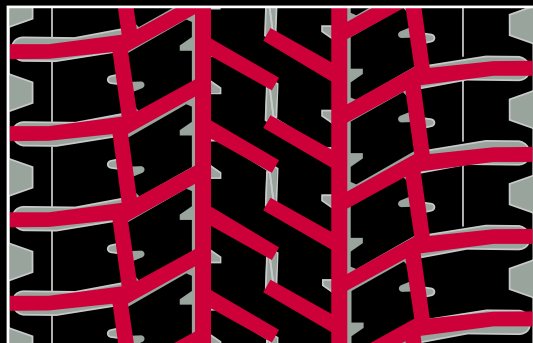
PREFERRED



OPTIONAL



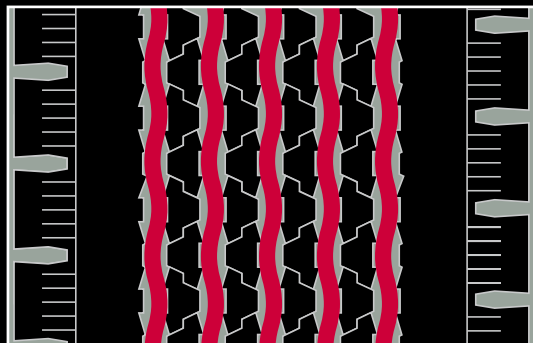
| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 295/80 R 22.5 | 2.0 | 7.0 - 8.0 |
| 315/80 R 22.5 | 2.0 | 7.0 - 8.0 |
| 315/70 R 22.5 | 2.0 | 7.0 - 8.0 |



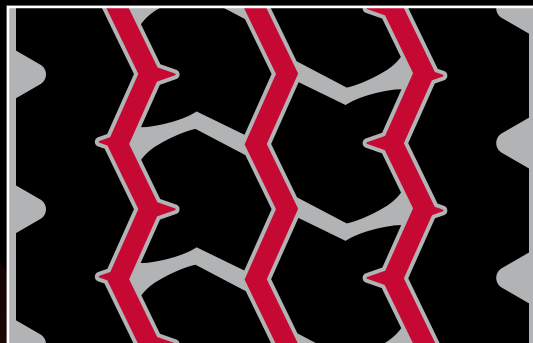
| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 8.5 R 17.5 | 2.0 | 5.0 - 6.0 |
| 9.5 R 17.5 | 2.0 | 6.0 - 7.0 |
| 205/75 R 17.5 | 2.5 | 5.0 - 6.0 |
| 215/75 R 17.5 | 2.5 | 5.0 - 6.0 |
| 225/75 R 17.5 | 2.5 | 5.0 - 6.0 |
| 235/75 R 17.5 | 2.5 | 5.0 - 6.0 |
| 245/70 R 19.5 | 3.0 | 6.0 - 7.0 |
| 265/70 R 19.5 | 3.0 | 6.0 - 7.0 |
| 285/70 R 19.5 | 2.5 | 7.0 - 8.0 |
| 12 R 22.5 | 3.0 | 7.0 - 8.0 |
| 295/80 R 22.5 | 3.0 | 7.0 - 8.0 |
| 275/70 R 22.5 | 2.5 | 7.0 - 8.0 |
| 315/70 R 22.5 | 3.0 | 7.0 - 8.0 |



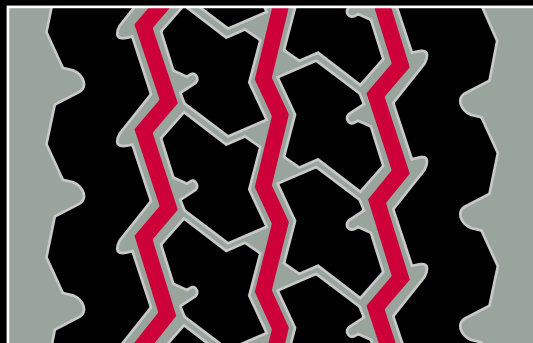
| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 385/65 R 22.5 | 2.0 | 7.0 - 8.0 |



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 9.5 R 17.5 | 2.5 | 7.0 - 8.0 |
| 215/75 R 17.5 | 2.5 | 7.0 - 8.0 |
| 235/75 R 17.5 | 2.5 | 7.0 - 8.0 |
| 245/70 R 17.5 | 2.0 | 7.0 - 8.0 |
| 265/70 R 19.5 | 2.5 | 7.0 - 8.0 |
| 285/70 R 19.5 | 3.0 | 7.0 - 8.0 |
| 11 R 22.5 | 3.0 | 8.0 MAX |
| 315/80 R 22.5 | 3.0 | 7.0 - 8.0 |
| 425/65 R 22.5 | 3.0 | 8.0 MAX |

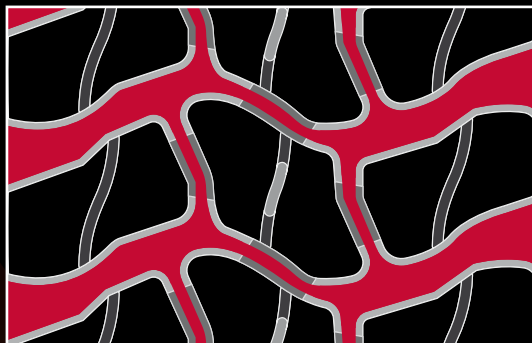


| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 13 R 22.5 | 3.5 | 8.0 MAX |
| 315/80 R 22.5 | 3.5 | 8.0 MAX |



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 9.00 R 20* | 3.0 | 9.0 |
| 11 R 22.5 | 4.0 | 9.0 |
| 12 R 22.5 | 2.5 | 8.0 MAX |
| 295/80 R 22.5 | 3.0 | 8.0 MAX |

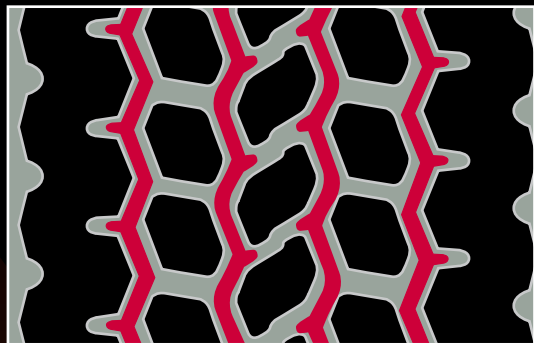
* 20 inch sizes ON/OFF still available in non Plus specification



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 13 R 22.5 | 2.5 | 8.0 MAX |
| 315/80 R 22.5 | 2.5 | 8.0 MAX |



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 385/65 R 22.5 | 3.0 | 8.0 MAX |



| Size | D: Regrooving depth (mm) | W: Regrooving width (mm) |
|---------------|--------------------------------|--------------------------------|
| 265/70 R 19.5 | 2.5 | 8.0 MAX |
| 275/70 R 22.5 | 3.0 | 8.0 MAX |
| 445/65 R 22.5 | 3.0 | 8.0 MAX |