
Regrooving Guidelines

Depending on conditions of use and maintenance, Goodyear's high-quality tyre casings can give each tyre multiple lives (new, regrooved, retread, regrooved retread) lowering operating costs.

Regrooving basics

1. A regrooved tyre is a tyre, either new or retreaded, 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, Goodyear 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 3 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 maximum regrooving depth for all Goodyear tyres is 3 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.

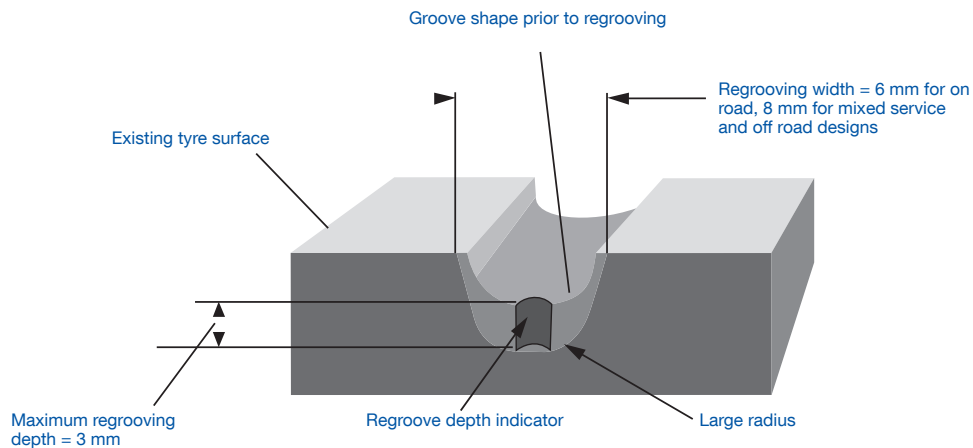
Regrooving Goodyear remould tyres

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

Regrooving parametres

Regroove Goodyear 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.

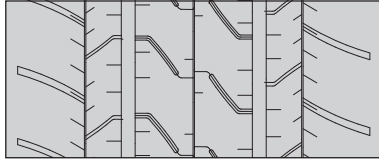
Regrooving depth indicators are moulded into the tyre design. They allow regrooving tools to be set to the optimum depth.



On Road Fuel Efficient

FUELMAX S 22.5"

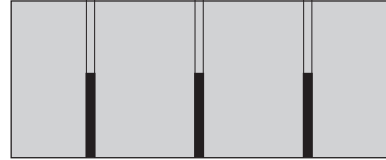
New tyre tread



80% worn



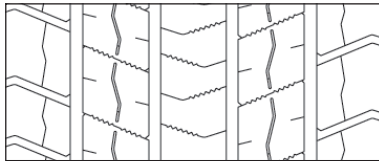
Regrooved tyre



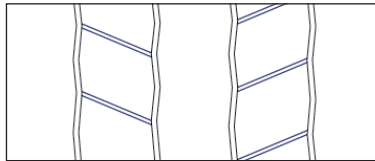
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

FUELMAX D 22.5"

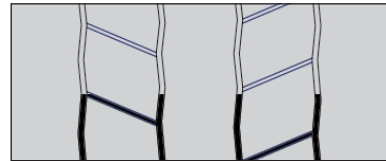
New tyre tread



80% worn



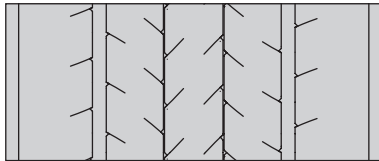
Regrooved tyre



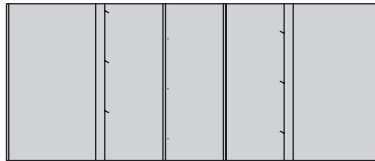
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

FUELMAX T 19.5" and 22.5"

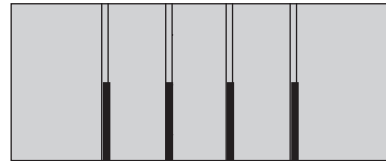
New tyre tread



80% worn



Regrooved tyre

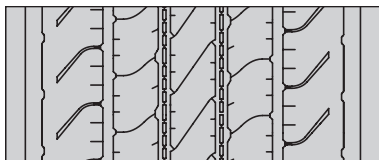


Maximum regrooving depth 3 mm, regrooving width 6 mm. Retreadable by Goodyear TreadMax.

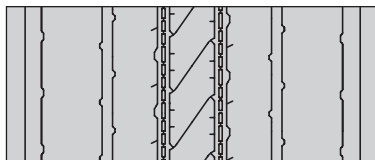
O = Regrooving depth indicators

Marathon LHS II+ 22.5

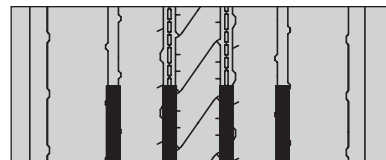
New tyre tread



80% worn



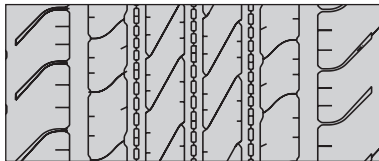
Regrooved tyre



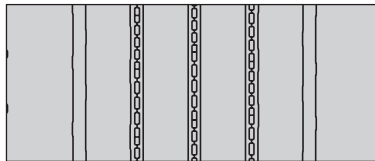
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Marathon LHS II+ 65, 55 and 50 series

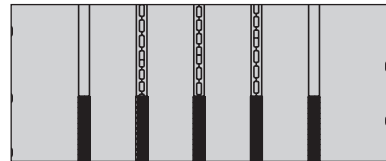
New tyre tread



80% worn



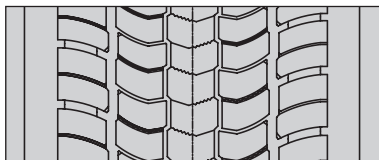
Regrooved tyre



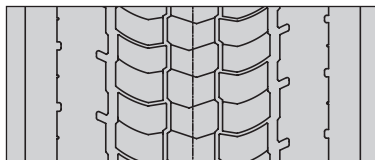
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Marathon LHD II+ 22.5

New tyre tread



80% worn



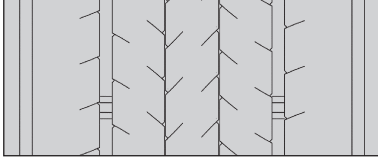
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Marathon LHT II 22.5

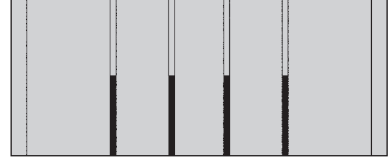
New tyre tread



80% worn



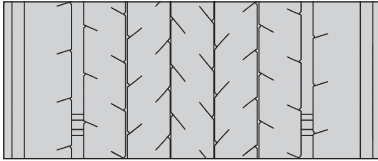
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Marathon LHT II 435/50R19.5

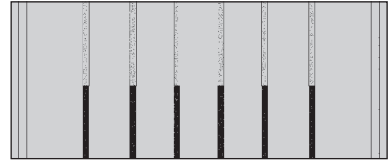
New tyre tread



80% worn



Regrooved tyre

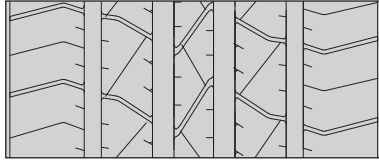


Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

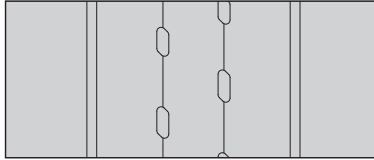
On Road Mileage

KMAX S 22.5"

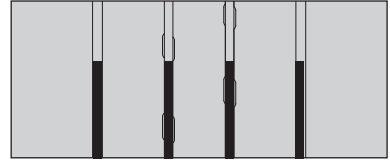
New tyre tread



80% worn



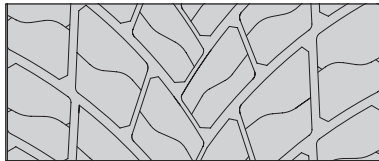
Regrooved tyre



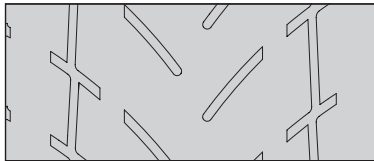
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

KMAX D 22.5"

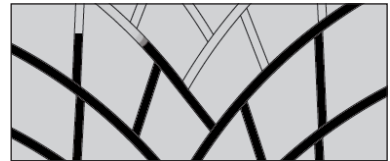
New tyre tread



80% worn



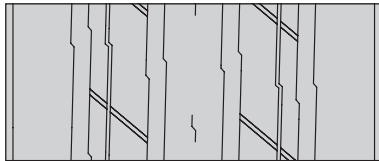
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

KMAX T 19.5" and 22.5"

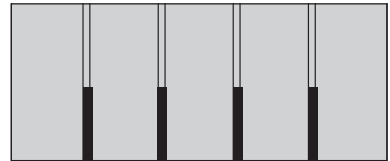
New tyre tread



80% worn



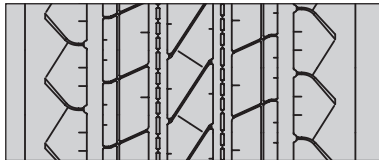
Regrooved tyre



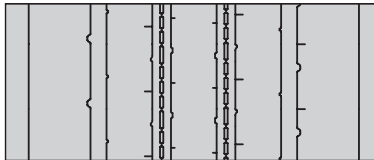
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Regional RHS II 22.5

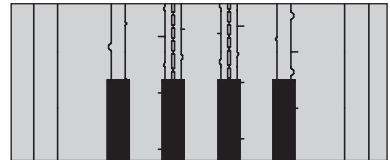
New tyre tread



80% worn



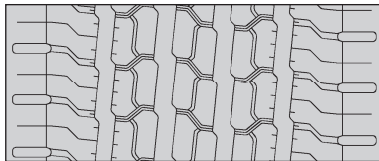
Regrooved tyre



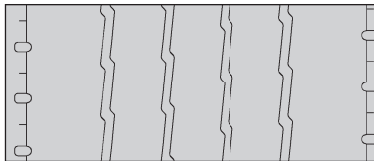
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Regional RHS II 17.5 and 19.5

New tyre tread



80% worn



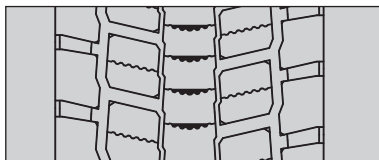
Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Regional RHD II 22.5

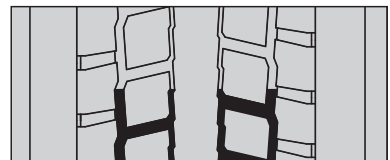
New tyre tread



80% worn



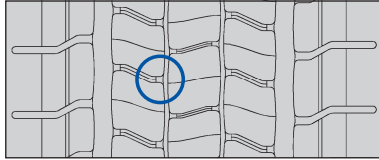
Regrooved tyre



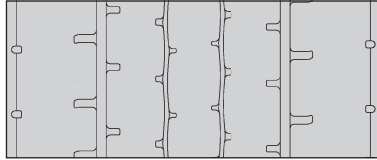
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Regional RHD II 17.5 and 19.5

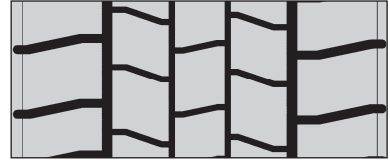
New tyre tread



80% worn



Regrooved tyre

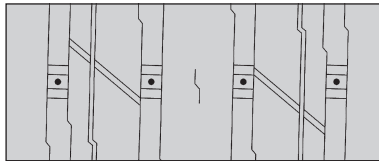


Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

O = Regrooving depth indicators

Regional RHT II 22.5"

New tyre tread



80% worn



Regrooved tyre

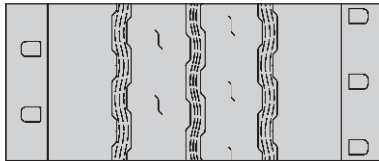


Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

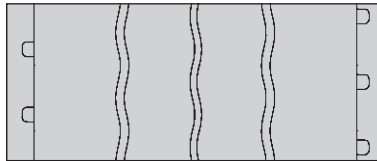
O = Regrooving depth indicators

Regional RHT II 17.5" and 19.5"

New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 2.5 mm, regrooving width 8-10 mm. Retreadable by Goodyear TreadMax.

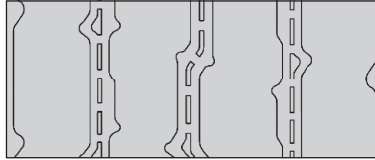
Mixed Services

Omnitrac MSS II 4 ribs

New tyre tread



80% worn



Regrooved tyre

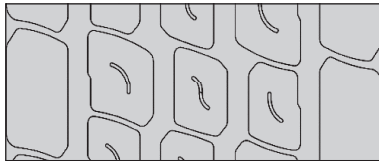


Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

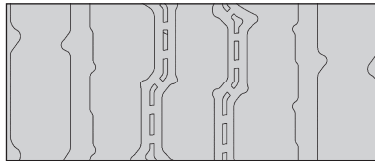
O = Regrooving depth indicators

Omnitrac MSS II 5 ribs

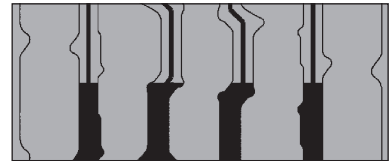
New tyre tread



80% worn



Regrooved tyre

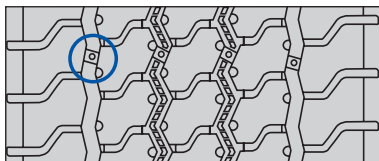


Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

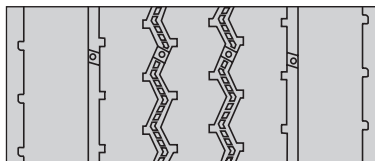
O = Regrooving depth indicators

Omnitrac MSS 375/90R22.5 and 445/75R22.5

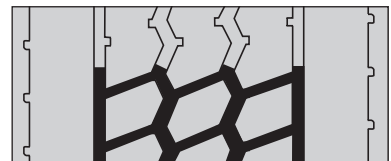
New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

O = Regrooving depth indicators

Omnitrac MSD II 20", 22.5" and 24"

New tyre tread



80% worn



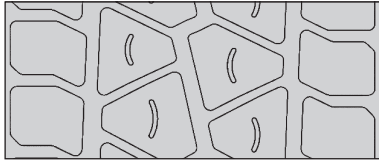
Regrooved tyre



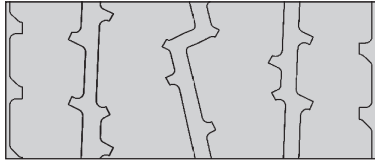
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Omnitrac MSD II 385/55R22.5

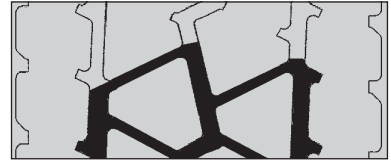
New tyre tread



80% worn



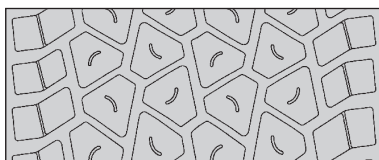
Regrooved tyre



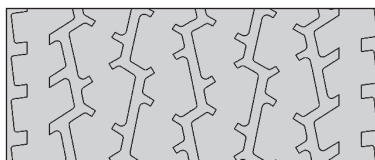
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Omnitrac MSD II 495/45R22.5

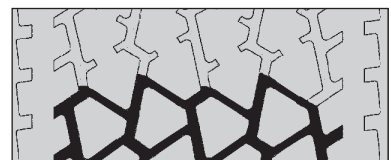
New tyre tread



80% worn



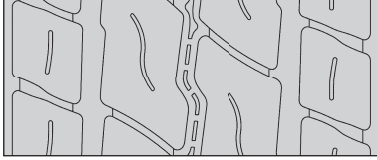
Regrooved tyre



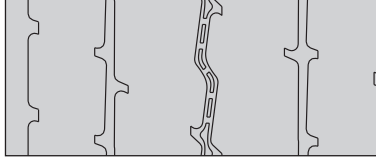
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Omnitrac MST II 22.5"

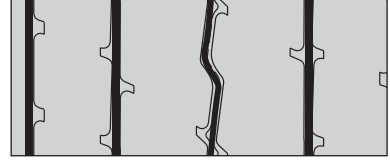
New tyre tread



80% worn



Regrooved tyre



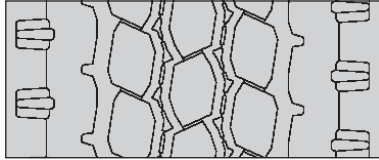
Maximum regrooving depth 3 mm, regrooving width 8 mm. Retreadable by Goodyear TreadMax.

O = Regrooving depth indicators

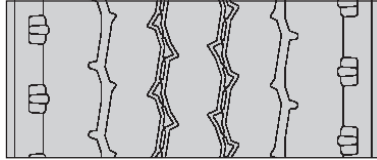
Offroad

Offroad ORS 22.5"

New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

Offroad ORD 22.5" and 24"

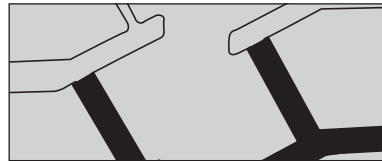
New tyre tread



80% worn



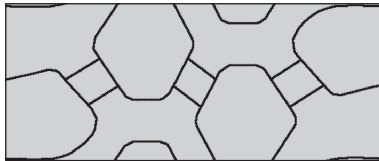
Regrooved tyre



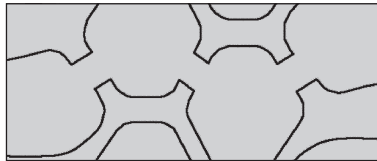
Maximum regrooving depth 3 mm, regrooving width 8-10 mm. Retreadable by Goodyear TreadMax.

Offroad ORD 365/85R20 and 375/90R22.5

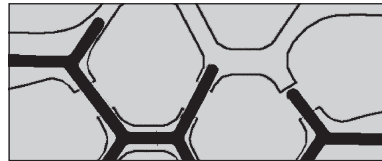
New tyre tread



80% worn



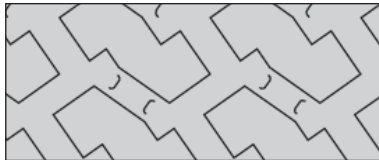
Regrooved tyre



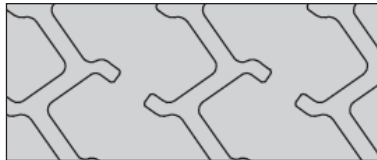
Maximum regrooving depth 3 mm, regrooving width 8-10 mm. Retreadable by Goodyear TreadMax.

Offroad ORD 14.00R20

New tyre tread



80% worn



Regrooved tyre

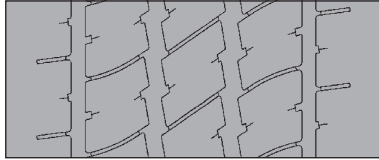


Maximum regrooving depth 3 mm, regrooving width 8-10 mm. Retreadable by Goodyear TreadMax.

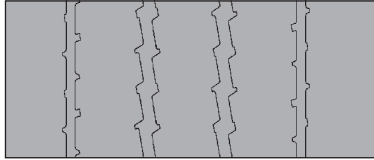
Urban

UrbanMax MCA 19.5" and 22.5"

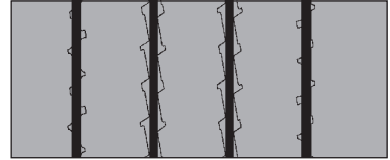
New tyre tread



80% worn



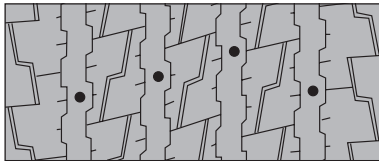
Regrooved tyre



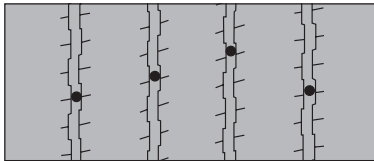
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

UrbanMax MCS 22.5"

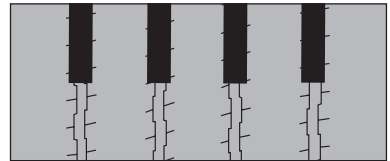
New tyre tread



80% worn



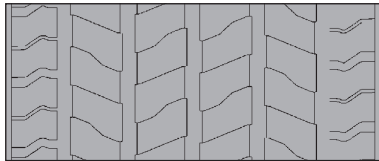
Regrooved tyre



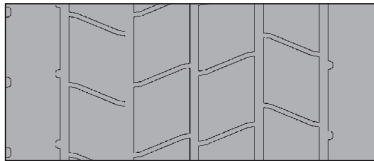
Maximum regrooving depth 3 mm, regrooving width 8-10 mm. Retreadable by Goodyear TreadMax.

UrbanMax MCD Traction 22.5"

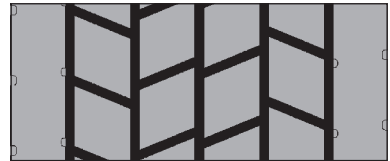
New tyre tread



80% worn



Regrooved tyre



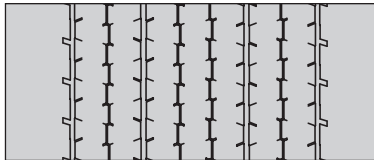
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

UrbanMax MCD Super Single 22.5"

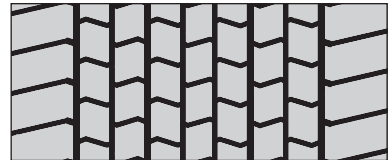
New tyre tread



80% worn



Regrooved tyre

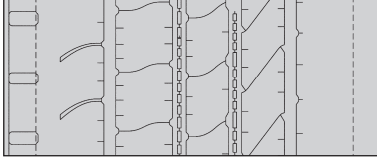


Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

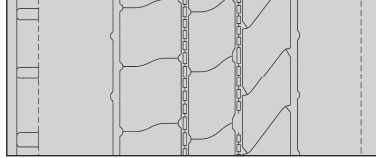
Coach

Marathon Coach 22.5"

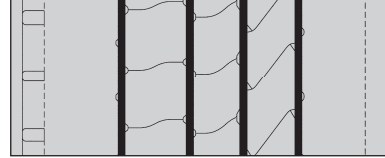
New tyre tread



80% worn



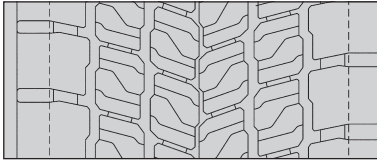
Regrooved tyre



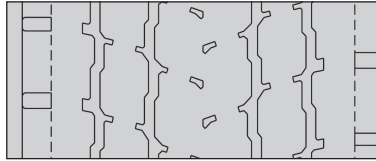
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

ULTRA GRIP Coach 22.5"

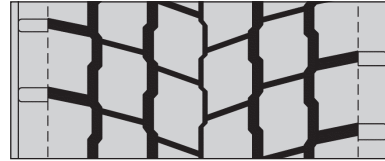
New tyre tread



80% worn



Regrooved tyre

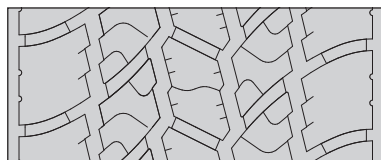


Maximum regrooving depth 3 mm, regrooving width 6-10 mm. Retreadable by Goodyear TreadMax.

Winter

ULTRA GRIP MAX S 22.5"

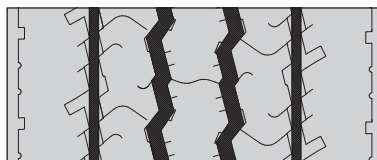
New tyre tread



80% worn



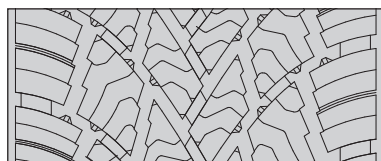
Regrooved tyre



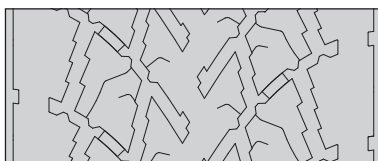
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

ULTRA GRIP MAX D 22.5"

New tyre tread



80% worn



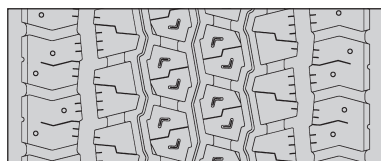
Regrooved tyre



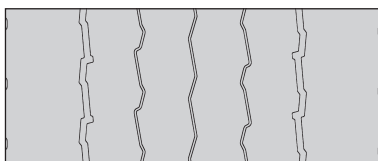
Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.

ULTRA GRIP MAX T 22.5"

New tyre tread



80% worn



Regrooved tyre



Maximum regrooving depth 3 mm, regrooving width 6-8 mm. Retreadable by Goodyear TreadMax.