

## Application of treads with wings

To obtain better results on retreaded tyres using treads with wings, Vipal presents the following guidelines, which offer better finishing and conservation of the casing:

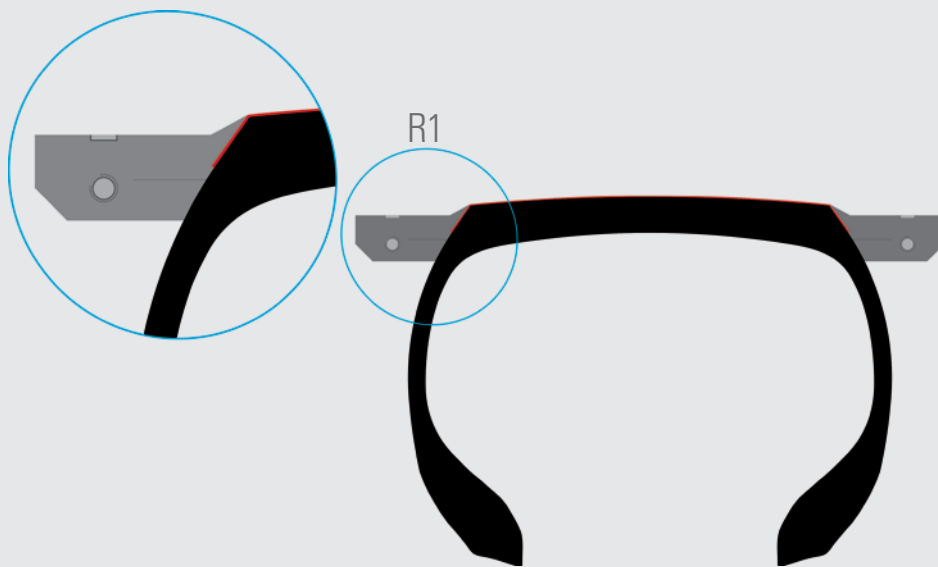
**Radius (R):** Buff according to Vipal's buffing radius guidelines\*

**Buffed surface width (W):** Buff the tyre's surface with a dimension between 5 and 8mm smaller than the "useful" tread width (do not consider wings)

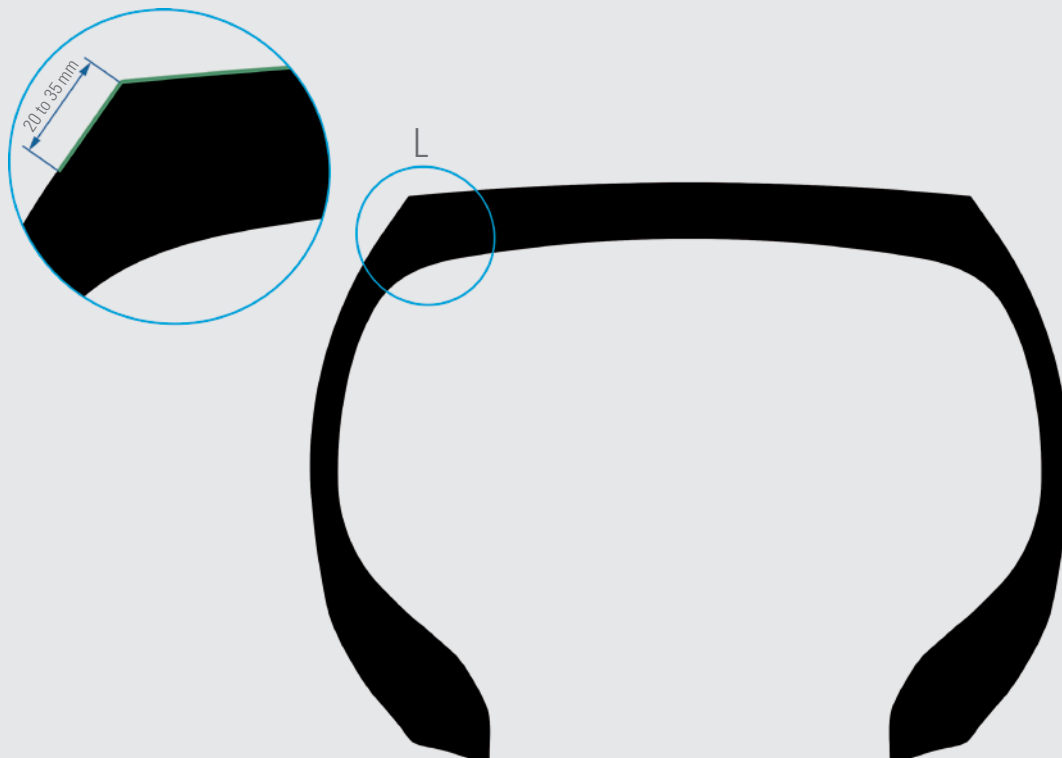


\*Consult About Rubber about Buffing Radius (December/2015)

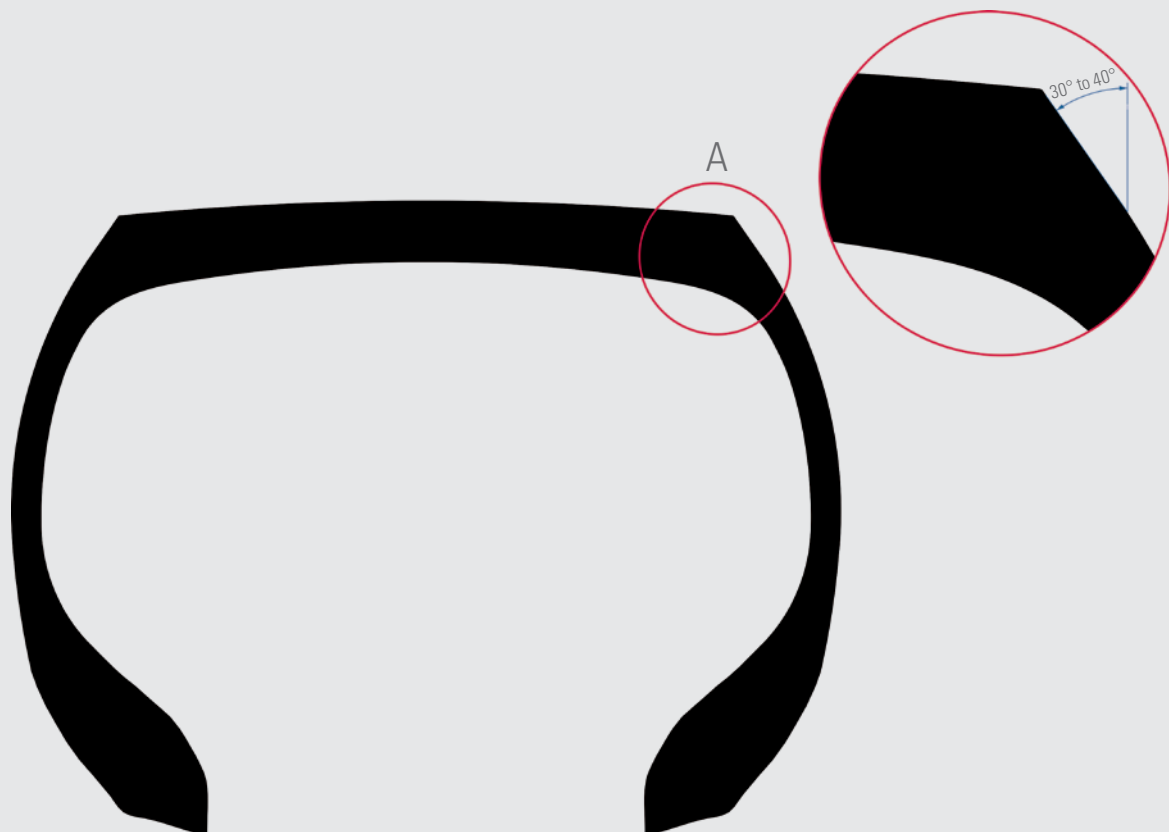
**Shoulder (R1):** When using cushion gum in calendered form, consider an 1mm buffing radius on the tyre's shoulder. If using orbicushion, the shoulder buffing radius can range from 1 to 4mm, according to the tool used in the extruder (for example, if the model wing form is used, it should have the closest shape possible to that of the buffed casing).



**Sidewall buffing (L):** It can range from 20 to 35mm, according to the finishing desired by the customer.



**Sidewall buffing angle (A):** It can range from  $30^{\circ}$  to  $40^{\circ}$ , according to the finishing desired by the customer.



## Notes:

This buffing profile can be obtained in automatic buffers through pre-defined formulas according to the guidelines above. Due to the many variables (dimensions, brand, type of tyre, model, and scraper's brand, tread characteristics, etc.), there are multiple possible formulas. Thus, the buffing formula must be defined alongside the customer, creating a customized reference chart. For other retreading processes, follow the guidelines of the Technical Manual for Retreading Commercial Truck Tyres.