ICS 83.160.01
CCS G 41

NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 26732-2025

Replacing GB/T 26732-2011

Process for retreading of tyres

轮胎翻新工艺

Issued on: January 24, 2025 **Implemented on: August 1, 2025**

Issued by: State Administration for Market Regulation;
Standardization Administration of the PRC

Table of Contents

Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part 1: Structure and drafting rules for standardization documents" Drafting.

This document replaces GB/T 26732-2011 "Tire Retreading Process". Compared with GB/T 26732-2011, except for structural adjustment and editing, In addition to the changes in performance, the main technical changes are as follows.

- Changed the scope of application (see Chapter 1, Chapter 1 of the 2011 edition);

- Added some terms (see 3.1, 3.2 and 3.3);

- Changed the description of the process stages (see 4.1, 4.1 of the 2011 edition);

- Added relevant provisions for tire conveying system (see 4.1);

- Changed the requirements for main equipment for tire selection (see 4.2.1.2, 4.2.1.2 of the 2011 edition);

- Changed the requirements for crown and shoulder grinding [see a) in 4.2.2.1.1 and a) in 4.2.2.1.1 of the 2011 edition];

- Deleted the relevant provisions of hydraulic grinders (see 4.2.2.1.2 of the 2011 edition);

- Changed the requirements for damage repair and grinding [see b) in 4.2.2.2.1 and b) in 4.2.2.2.1 of the 2011 edition];

- Change the liner to a patch (see 4.2.3.3, 4.2.4.3 of the 2011 edition);

- Changed the requirements for spraying adhesive (see 4.2.4.1, 4.2.3.1 of the 2011 edition);

- Added the main molding equipment, annular pre-cured tread molding machine (see 4.2.5.2);

- Deleted the expressions "according to the construction card" and "according to the construction card" in the molding method (see 4.2.5.3 of the 2011 edition);

- Change the molding methods from 3 to 4, and add relevant requirements (see 4.2.5.3, 4.2.5.3 of the 2011 edition);

- Added the provision that the outer envelope can be added with a snap ring during vulcanization [see 4.2.6.3a)];

- Added crank-connecting rod mechanism vulcanizing press (see 4.3.3.2).

Please note that some of the contents of this document may involve patents. The issuing organization of this document does not assume the responsibility for identifying patents.

This document was proposed by the China Petroleum and Chemical Industry Federation.

This document is under the jurisdiction of the National Technical Committee for Tire and Rim Standardization (SAC/TC19).

This document was drafted by: China Chemical Equipment Technology Group Co., Ltd., Sailun Group Co., Ltd., Shandong Linglong Tire Co., Ltd.

Company, Wuhan Huazhong Recycling Technology Co., Ltd., Beijing Rubber Industry Research and Design Institute Co., Ltd., Qingdao Taikaiying Special Tire Co., Ltd.

Company, Gaotang Xinglu-Bendaco Tire Strengthening Co., Ltd., Jiangsu Yisheng Investment Group Co., Ltd., Guizhou Tire Co., Ltd., Prinx Chengshan (Shandong) Tire Co., Ltd., Fengshen Tire Co., Ltd., Fujian Zhengkun Rubber Technology Co., Ltd., Bridgestone (China) Investment LIMITED.

The main drafters of this document are: Tan Zhibin, Wang Zhiwen, Peng Lei, Wang Feng, Huang Lvjie, Li Shuhuan, Li Miaomiao, Zhang Yanlong, Tian Jianguo, Wang Caixia, Dai Fangwen, Wu Xiangxin, Tian Bin, Gao Juying, Zhu Cheng, Mou Shouyong, Xu Lihong, Zheng Rui.

This document was first published in 2011 and this is the first revision. Tire retreading process

1 Scope

This document specifies the process requirements for retreading pneumatic tires.

Note. It does not include the plasticizing and mixing process of rubber for retreaded tires; it does not include the production process of pre-vulcanized tread, pre-vulcanized cushion

rubber and other materials.

This document is applicable to the retreading of pneumatic passenger car tires, truck tires, and engineering machinery tires, but not to the replacement of belt pneumatic tires.

Tire retreading and solid tire retreading.

2 Normative references

GB/T 6326

GB/T 7037

GB/T 14646

GB/T 21286

GB/T 45291

3 Terms and definitions

The terms and definitions defined in GB/T 6326 and the following apply to this document.

3.1 Mouldless vulcanized

The retreaded tire after the green rubber tread is formed is vulcanized without a mold in the vulcanizing tank.

3.2 Tread engraving

A pattern is engraved on a tire tread without a pattern using an engraving machine.

Note. There are two types of tread engraving. engraving before tread vulcanization and engraving after tread vulcanization.

3.3 No-mold engraving renovation

Retreaded tires use moldless vulcanization and tread engraving technology.

Note. Mainly used for retreading tires of large engineering machinery.

4.1 General

Tire retreading processes are divided into three categories according to technical characteristics.