

Workflow

The regrooving of tyres is a skilled operation which should only be undertaken by skilled personnel in a aerated workplace. The following notes describe the procedure to be followed to ensure safe and effective regrooving:

- 1** Make sure you have the correct tools to hand to do the job; regrooving tool, tread depth gauge, the correct regrooving blades any regrooving stand, regrooving information relating to the tyre which is to be regrooved.
- 2** Check that the tyre is suitable for regrooving. Look for the word "regroovable" on the sidewall of the tyre. If this is absent consult tyre manufacturer for further information.
- 3** In a well bright area check the tyre for signs of damage to the tread and sidewall area and if any damage is found, repair it correctly. Also remove any flints etc. embedded in the tread otherwise the regrooving blade may be damaged or broken during the regrooving process.
- 4** Measure the remaining tread depth at several places around the tyre and use the smallest depth to set the depth of the

- that the tyre mentioned "regroovable"
- that regrooving may be carried out when 2 - 3 mm of tread depth remains
- that the law requires any regroov-

regrooving blade in the regrooving tool. Regrooving smooth or irregularly worn tyres is not advisable because you do not know how much rubber is left.

- 5** Consult the tyre manufacturer's regrooving instructions for the tyre in question. The blade setting is determined by the width and depth stated in the manufacturer's instructions. These will also show the shape of the blade to choose rounded or wedge-shaped.

- 6** Before fitting or removing a blade from the regrooving tool, always make sure it is disconnected from the mains electricity supply. Set the blade to the depth specified by the manufacturer. IMPORTANT NOTE: Check that the instructions clearly say that the depth setting includes the pattern depth remaining, or that you have to add the pattern depth remaining, because this rule will vary between manufacturers.

ing to follow the manufacturer's recut tread pattern.

- 7** Regroove a small area of the tyre approximately 150 mm long. Remove the rubber you have cut and, using the tread depth gauge, check that you are cutting the recommended depth and that you are not exposing any cords.

- 8** Now regroove the tyre in line with the manufacturer's regrooving tread pattern. Make sure the hand which is not holding the regrooving tool is placed on the lower sidewall of the tyre and not on the tread area in front of the regrooving tool. This will avoid accidents.

- 9** Finally, even the tyre has been fully regrooved, inspect it to make sure that no cords have been exposed. The tyre is now ready for refitting to a vehicle.



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ourselves as one of the world leaders in this field. We have sold more than 300.000 devices in more than 100 countries. These are highly valued by our customers which recognize these machines as being of high quality, durable and the standard in the regrooving industry. RUFF has become a synonym for high-tech re-

grooving equipment. Time and again these and other reasons allow us to be at the fore front with innovative developments and enable us to provide our customers with the most pioneering and future orientated technology. Convince yourself!

Tyre Stand

for truck tyre regrooving
Artikel-Nr. 1573281



Rillfit® Six



**BUTTS OF
BAWTRY**
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Technical Data

Rillfit[®] six

Type **Tyre regroover**
Model **RILLFIT[®] six**
Power Supply/Frequency **230 V - 240 V, 110 V, 50/60Hz**
Weight **4,4 kg**
protection class **isolated protection class 2**
Connection **plug and socket device**
Type of Frequency **Interrupting flow**
Version **area changeable**
Type of safety **IXPO**
Power **240 Watt**



RILLFIT-Evolution since 1948



Accessories and Spare Parts

Casing RILLFIT[®] six
article no. 1471421



Carry handle
article no. 1400044



Button for rotary switch
article no. 1400045



Rotary switch
article no. 1400103



Bottom plate
article no. 1471419



Handle casing
left and right
article no. 1580020



Connection cable
article no. 1580156



Handlegrip complete
article no. 1571611



Power supply cable
without plug
article no. 1471410



Power supply cable
with plug
article no. 1471416



Blade-head complete
article no. 1580155



Blade-head set
left and right
article no. 1571637



Set bladeholder blocks
article no. 1580125



Clamping jaw set
left and right
article no. 1571638



Clamping jaw set
for small blades
article no. 1580158



Unit without head
and contacts
article no. 1580126



Contact lever complete
article no. 1580136



Built-in unit with head
article no. 1571603



Copper rod long
article no. 1560004



Copper rod short
article no. 1560003



Hexagon key
article no. 1450182



Depth gauge
article no. 1400047



Transformer
according to the country voltage



Switch on/off
article no. 1871008



Tyre stand
article no. 1573281



RILLCUT Regrooving Blades

RILLCUT blades are made out of unique special steel material in our workshop. Know how of manufacturing process ensure uniform and

outstanding quality. Therefore, always use the original RILLCUT blades, only RILLCUT blades ensure cor-

rect blade Temperatures! Special design of any shape and reinforced steel material on request.

Standard Blades

article no.	15800-	49	50	51	52	53	54
Angle Blades		W1	W2	W3	W4	W5	W6
		mm	mm	mm	mm	mm	mm
	A = cutting width	3	5	7	9	11	23
	B = cutting depth	7	7	10	12	12	12
	C = upper cutting width	5	6	10	13	15	28
	D = side length	21	21	22	24	23	24
pcs per set		20					10

article no.	15800-	55	56	57	58	59	
Round Blades		R1	R2	R3	R4	R5	
		mm	mm	mm	mm	mm	
	A = cutting width	3	5	6	8	10	
	B = cutting depth	7	7	10	12	12	
	C = upper cutting width	5	8	15	16	18	
	D = side length	21	21	23	25	24	
pcs per set		20					

Personal Blades

Angle Blades		1	2	3	4
		mm	mm	mm	mm
	A = cutting width				
	B = cutting depth				
	C = upper cutting width				
	D = side length				
	E = heel side				
	material thickness				

Round Blades		1	2	3	4
		mm	mm	mm	mm
	A = cutting width				
	B = cutting depth				
	C = upper cutting width				
	D = side length				
	E = heel side				
	material thickness				

Special Blades

article no.	1580-	111	112	113	114	115	060
Angle Blades		W14	W16	W18	W20	S01	W6/1
		mm	mm	mm	mm	mm	mm
	A = cutting width	14	16	18	20	20	23
	B = cutting depth	12	12	12	18	18	12
	C = upper cutting width	17	19	21	25	23	28
	D = side length	24	24	23	32	32	27
pcs per set		10					

Angle Blades		SO W2/1 45° left or right	
		mm	
	A = cutting width	5	
	B = cutting depth	14	
	C = upper cutting width	7	
	D = side length	35	
	E = heel side	5	
pcs per set		10	

Round Blades		SO R2/1 45° left or right	
		mm	
	A = cutting width	5	
	B = cutting depth	14	
	C = upper cutting width	7	
	D = side length	35	
	E = heel side	5	
pcs per set		10	

Angle Blades		SO W2 45° left or right	
		mm	
	A = cutting width	5	
	B1 = cutting depth 1	10	
	B2 = cutting depth 2	14	
	C = upper cutting width	7	
	D = side length	31	
Stück pro Set		10	

Round Blades		SO R2 45° left or right	
		mm	
	A = cutting width	5	
	B1 = cutting depth 1	10	
	B2 = cutting depth 2	14	
	C = upper cutting width	7	
	D = side length	31	
Stück pro Set		10	

BUTTS OF
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