

# 2025 HOT CURE RETREADING

Process and Product Data

**K\_base-H**

**K\_tech-H**

**K\_plus-H**



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**Process**

The hot cure retreading process is the mould-based vulcanisation of a tire to be retreaded at a temperature of around 150°C. The tread and sidewalls of the tire are built from unvulcanized rubber compounds. The shaping and formation of the tread pattern take place in a tire press.

**Advantages**

- » Suitable for any tire application, including passenger car tires and aircraft tires.
- » Material prices are lower than for the higher-refined products for cold retreading.
- » Hot cure retreading also allows extensive repairs to the tire casing (e.g., belt renewal).
- » Even diagonal casings can be hot retreaded without any issues.

**Disadvantages**

- » A separate mould is required for each tread design and dimension. This necessitates significant investments in the mould program and its continuous updating.
- » Production must be designed for high volumes. This requires a central production facility, an extensive area of operation, and consequently relatively high logistics effort.
- » The mileage performance results are generally lower than with cold retreading.



PRODUCT DESIGNATION	KR-TH	KR-H	KR-SITEC
<p><b>Short description</b></p> <ul style="list-style-type: none"> <li>- Speed index up to and including</li> <li>- Delivery forms</li> </ul>	<p><b>High-Speed-Winter</b></p> <p>T</p> <p>Feeding strips</p>	<p><b>High-Speed-Winter</b></p> <p>H</p> <p>Feeding strips</p>	<p><b>High-Speed-Winter</b></p> <p>H</p> <p>Feeding strips / Camelback</p>
<p><b>Tire properties</b></p> <ul style="list-style-type: none"> <li>- Field of application</li> <li>- Hardness in shore A</li> <li>- Mileage performance</li> <li>- Grip on dry and wet roads</li> <li>- Winter conditions</li> <li>- Suitability for all-season tread design</li> </ul>	<p>Suitable for heavily siped tread designs</p> <p>64</p> <p>Very good</p> <p>Good</p> <p>Very good</p> <p>Yes</p>	<p>Suitable for heavily siped tread designs, Off Road</p> <p>63</p> <p>Very good</p> <p>Good</p> <p>Very good</p> <p>Yes</p>	<p>Partial - Silica Compound</p> <p>64</p> <p>Very good</p> <p>Very good</p> <p>Very good</p> <p>Yes</p>
<p><b>Processing properties</b></p> <ul style="list-style-type: none"> <li>- Extrudability                             <ul style="list-style-type: none"> <li>a) Stripwinding extruders</li> <li>b) Camelback extruders</li> </ul> </li> <li>- Tack of the compound                             <ul style="list-style-type: none"> <li>a) in relation to each other</li> <li>b) to the casing</li> </ul> </li> <li>- Solvent-free processing</li> <li>- Vulcanization speed</li> </ul>	<p>Limited *</p> <p>Good</p> <p>Good</p> <p>Good</p> <p>Possible without cushion gum</p> <p>Standard</p>	<p>Limited *</p> <p>Good</p> <p>Good</p> <p>Good</p> <p>Possible without cushion gum</p> <p>Standard</p>	<p>Limited *</p> <p>Good</p> <p>Good</p> <p>Good</p> <p>Possible without cushion gum</p> <p>Standard</p>

\*Very often dependent on the age of the extruder!

Standard delivery form of feeding strips: feeding strips are provided as tear-off feeding strips in dimensions 10mm x 95mm and 9mm x 130mm and are delivered on a wooden pallet measuring 1,200mm x 800mm (LxW).

## TRUCK TIRES STANDARD - Tread Compounds



PRODUCT DESIGNATION	ECON-H-02	ECON-H-51
<b>Short description</b> - Application recommendation - Axle position - Delivery forms	<b>Truck-Standard</b> Mixed use (road, construction site) Traction and rolling tires Feeding strips / Camelback	<b>Truck regional and local transport</b> Local transport (road) Traction tires Feeding strips / Camelback
<b>Tire properties</b> - Field of application - Hardness in shore A - Mileage performance - Heat-built-up - Tear and fracture resistance	Compound for use on light truck and truck tires with low performance requirements 63 Satisfactory Acceptable, Conditionally suitable for high sustained speed and high ambient temperatures Good	Compound for use on light truck and truck tires with good mileage performance 62 Good, Acceptable, Conditionally suitable for high sustained speed and high ambient temperatures Sufficient
<b>Processing properties</b> - Extrudability a) Stripwinding extruders b) Camelback extruders - Tack of the compound a) in relation to each other b) to the casing - Solvent-free processing - Vulcanization speed	Very good* Very good Very good Good Without the use of a cushion gum possible Standard	Good* Good Sufficient Sufficient Only with the use of cushion gum possible Standard

\*Very often dependent on the age of the extruder!  
 Standard delivery form of feeding strips: feeding strips are provided as tear-off feeding strips in dimensions 10mm x 95mm and 9mm x 130mm and are delivered on a wooden pallet measuring 1,200mm x 800mm (LxW).

## SUPERMEILER Trailer - Trailer an Semi-Trailer Tires



PRODUCT DESIGNATION	BASE-H-90	TECH-H-29	PLUS-H58
<b>Short description</b> - Application recommendation - Axle position - Delivery forms	<b>SUPERMEILER-Allround</b> Local transport, Regional transport, Mixed use Feeding strips / Camelback	<b>SUPERMEILER-Cool running</b> Local and long-distance transport(road) Trailers and semi-trailers Feeding strips / Camelback	<b>SUPERMEILER-Long distance</b> Local and long-distance transport(road) Trailers and semi-trailers Feeding strips /Camelback
<b>Tire properties</b> - Field of application - Hardness in Shore A - Mileage performance - Heat-built-up - Tear and fracture resistance	Balanced allround compound suitable for the renewal of heavily siped tread patterns 66 Good Very good	Compound specifically designed for use on super single tires 63 Very good Very low heat generation; suitable for continuous operation and high ambient temperatures Very good	High-performance compound with high stiffness (modulus) for use on rolling tires in long-distance transport 66 Very good Very low heat generation; suitable for continuous operation and high ambient temperatures Very good
<b>Processing properties</b> - Extrudability a) Stripwinding extruders b) Camelback extruders - Tack of the compound a) in relation to each other b) to the casing - Solvent-free processing - Vulcanization speed	Limited * Good Very good Good Possible without the use of a cushion gum Standard	Limited * Good Good Good Possible without the use of a cushion gum Standard	Limited * Good Very good Very good Possible without the use of a cushion gum Standard

\*Very often dependent on the age of the extruder!  
 Standard delivery form of feeding strips: feeding strips are provided as tear-off feeding strips in dimensions 10mm x 95mm and 9mm x 130mm and are delivered on a wooden pallet measuring 1,200mm x 800mm (LxW).

## SUPERMEILER SPECIAL - Construction Site and Winter Tires



PRODUCT DESIGNATION	BASE-H-08	BASE-H-90	TECH-H-29
<b>Short description</b> - Application recommendation - Axle position - Delivery forms	<b>SUPERMEILER-Tear resistant</b> Mixed use (road, construction site, off-road) Traction Feeding strips/ Camelback	<b>SUPERMEILER-Allround</b> Mixed use (road, construction site) Traction Feeding strips/ Camelback	<b>SUPERMEILER-Long distance</b> Local and long-distance transport (road) Traction Feeding strips/ Camelback
<b>Tire properties</b> - Field of application - Hardness in shore A - Mileage performance - Winter characteristics	Highly tear-resistant compound 64 Good Very good	Balanced allround compound; suitable for the renewal of heavily siped tread patterns 66 Satisfactory Very good	High-performance compound suitable for the renewal of heavily siped tread patterns 66 Very good Very good
<b>Processing properties</b> - Extrudability a) Stripwinding extruders b) Camelback extruders - Tack of the compound a) in relation to each other b) to the casing - Solvent-free processing - Vulcanization speed	Limited* Good Very good Very good Without the use of a cushion gum possible Standard	Limited* Good Very good Good Without the use of a cushion gum possible Standard	Limited* Good Very good Very good Without the use of a cushion gum possible Standard

\*Very often dependent on the age of the extruder!

Standard delivery form of feeding strips: feeding strips are provided as tear-off feeding strips in dimensions 10mm x 95mm and 9mm x 130mm and are delivered on a wooden pallet measuring 1,200mm x 800mm (LxW).

## SUPERMEILER TRACTION - Traction Tires



PRODUCT DESIGNATION	BASE-H-90	PLUS-H-66	PLUS-H-58
<b>Short description</b> - Application recommendation - Axle position - Delivery forms	<b>SUPERMEILER-Allround</b> Local transport, Regional transport, Mixed use Feeding strips/ Camelback	<b>SUPERMEILER-Long distance</b> Local and long-distance transport (road) Traction Feeding strips/ Camelback	<b>SUPERMEILER-Long distance</b> Local and long-distance transport (road) Traction Feeding strips/ Camelback
<b>Tire properties</b> - Field of application - Hardness in shore A - Mileage performance - Tear and fracture resistance	Balanced allround compound suitable for the renewal of heavily siped tread patterns 66 Satisfactory Very good	High-performance compound suitable for the renewal of block patterns 67 Very good Satisfactory	High-performance compound suitable for the renewal of heavily siped tread patterns 66 Very good Very good
<b>Processing properties</b> - Extrudability a) Stripwinding extruders b) Camelback extruders - Tack of the compound a) in relation to each other b) to the casing - Solvent-free processing - Vulcanization speed	Limited* Good Very good Good Without the use of a cushion gum possible Standard	Limited* Satisfactory Good Good Without the use of a cushion gum possible Standard	Limited* Good Very good Very good Without the use of a cushion gum possible Standard

\*Very often dependent on the age of the extruder!

Standard delivery form of feeding strips: feeding strips are provided as tear-off feeding strips in dimensions 10mm x 95mm and 9mm x 130mm and are delivered on a wooden pallet measuring 1,200mm x 800mm (LxW).

## Sidewall material and rubber solution



PRODUCT DESIGNATION	Sidewall veneer	Rubber solution KRAIBURG solution
<b>Short description</b>	<b>SP</b>	<b>KRAIBURG solution</b>
- Application recommendation	High-quality bead-to-bead renewal of all tire types	Assembly aid between casing and tread material or sidewall Contains gasoline „Observe the safety instructions!“ Stir before use!
- Field of application	PK-, LK-, EM-tire	Low N-hexane solution (< 3% N-hexane) suitable for spraying and brushing
- Properties	Abrasion-resistant, ozone-resistant, high dynamic durability	Applicable on all common spray systems special gasoline 60/95** - quick drying
- Embodiments	Calendered sheet cut/uncut, perforated, dusted	Gasoline solution with 10%, 12%, or 17% solids content
- Solvent-free processing	Yes	Under appropriate conditions
<b>Delivery forms</b>	Calendered sheet, Feeding strips	Solution in buckets
- Perforation*	Yes*	---
- Dusting (matte surface)*	Yes*	---
- Roll width uncut* (in mm)	1040	---
- Roll width cut to size* (in mm)	From 30-220 mm in 5-mm-steps*	---
- Roll diameter (in mm)	165, 320, 500	---
- Core inner diameter (in mm)	50	---
- Sheet thickness* (in mm)	1,0 – 1,2 – 1,5 – 2,0	---
- Film color	Red	---
- Film texture	Diamond shape	---
- Package size	----	20 Liter = 17 kg
- Tread material strip dimension (in mm)	8 x 35	---
<b>Storage capability</b>	6 Months (according to DIN 7858)	9 Months

\*=Non-standard designs and dimensions only available on request with minimum order quantity or surcharge

\*\*=Dilution exclusively with special gasoline 60/95!

## Padding material and tread plate



PRODUCT DESIGNATION	Cushion gum	Cushion feeding strips	Tread material
<b>Short description</b>	<b>PO-sheet</b>	<b>PO-feeding strips</b>	<b>LK-sheet</b>
- Application recommendation	Adhesion layer in solvent-free retreading (Bonding tackiness) Covering textile and steel cord areas Filling repair spots	Adhesion layer in solvent-free retreading (Bonding tackiness) Covering textile and steel cord areas Filling repair spots	Adjusting the covering dimensions to the mould dimensions Tread repair material
- Field of application	PK-, LK-, EM-tires	PK-, LK-, EM-tires	LK-, EM-tires
- Properties	Not ozone-resistant, very sticky	Not ozone-resistant, very sticky	Ozone-resistant, abrasion-resistant
- Embodiments	Calendered sheet Cut/uncut Also suitable for hand extruders	Feeding strips	Calendered sheet Cut/uncut
- Solvent-free processing	Possible	Possible	No
<b>Delivery forms</b>	<b>Calendered sheet</b>	<b>Feeding strips</b>	<b>Calendered sheet</b>
- Roll width uncut* (in mm)	0,6 x 580 / 0,8 x 580 1,0 x 1040 / 1,2 x 1040 / 1,6 x 1040	---	1,0 x 1040 / 1,2 x 1040 / 1,6 x 1040 / 2,0 x 735
- Roll width cut to size* (in mm)	1,0 x 520 und 1,2 x 520 1,2 x 30-130 in 20 mm steps 1,2 x 155-275 in 10 mm steps 4,0 x 15 und 4,0 x 50	---	1,2 x 520 1,2 x 30-130 in 20 mm steps 1,2 x 155-275 in 10 mm steps 2,0 x 50 und 2,0 x 200 4,0 x 15 und 4,0 x 50
- Roll diameter (in mm)	165	---	165
- Core inner diameter (in mm)	50,0	---	50,0
- Film color	Blue	---	Blue
- Film texture	Diamond shape	---	---
- Tread material strip dimensions (in mm)	---	7 x 40 / 10 x 50 / 5 x 25	Diamond shape
<b>Storage capability</b>	6 Months	2 Months	6 Months

\* = Non-standard designs and dimensions only available on request with minimum order quantity or surcharge



**KRAIBURG Austria GmbH & Co. KG**

Webersdorf 11, A-5132 Geretsberg T +43 (0)7748 7241-0 Fax +43 (0) 77 48 / 72 41 - 11  
welcome@kraiburg.at www.kraiburg-austria.com

