

4.3 帘线角度

成品轮胎帘线性能检测结果表明,胎冠帘线角度为 55.5° ,满足企业标准要求($55.9 \pm 0.5^{\circ}$)。

4.4 实际路试

任意抽选 6 条轮胎进行定点装车试验。结果表明,轮胎的各种性能优越,耐磨性能、支撑性能、操纵性能和平衡性能好,负荷能力强,下沉量小。

5 结语

工业用 18.4—26 12PR R-4A 无内胎农业轮胎的充气外缘尺寸、物理性能和帘线角度达到相关国家标准和企业标准要求。该规格轮胎在批量

生产过程中工艺稳定、外观质量缺陷少,产品投放市场后,用户反馈轮胎外形美观,牵引性能、耐磨性能和抗刺扎性能以及自洁性能良好,为公司创造了较好的经济和社会效益。

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Design of 18.4—26 12PR R-4A Tubeless Agriculture Tire

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Abstract: The design of 18.4—26 12PR R-4A tubeless agriculture tire for industrial applications was described. In the structure design,the following parameters were taken:overall diameter 1 430 mm,cross-sectional width 425 mm,width of running surface 385 mm,height of running surface 45 mm,bead diameter at rim seat 662 mm,bead width at rim seat 390 mm,maximum width position of cross-section(H_1/H_2) 0.67,R-4A tread pattern,pattern depth 28.5 mm,block/total ratio 33%,and total number of pitches 19. In the construction design,two-formula and three-piece tread was designed,2 layers of 1400dtex/2 dipped nylon 6 cord were applied for breaker ply,6 layers of 1400dtex/2 dipped nylon 6 cord were used for carcass ply,and $\Phi 1$ mm 19[#] tempered bead wire was used. The tire was built using the semi drum building machine and cured in an autoclave. It was confirmed by the tests of the finished tire that,the peripheral dimension,physical properties and cord angle met the requirements of relative national and enterprise standards.

Key words: agriculture tire for industry;structure design;construction design

轮胎翻新方法

中图分类号:TQ336.1⁺6 文献标志码:D

由山东忠诚橡胶有限公司申请的专利(公开号 CN 103831987A,公开日期 2014-06-04)“轮胎翻新方法”,涉及的利用废旧全钢子午线轮胎进行翻新再利用的方法包括以下步骤。①通过削磨轮胎去除污损胎面,使表面呈螺纹状粗糙;②在轮胎表面刷涂胶浆和玻璃钢树脂的混合物;③把全新的挂胶钢丝帘布缠绕在胎冠上,并贴合

中垫胶;④将适配的胎面胶贴合在经过钢丝帘布缠绕的胎冠上;⑤将加强了带束层的轮胎送入硫化罐硫化。该轮胎翻新方法不破坏轮胎平衡性,提高了操控舒适性;提高了胎冠抗刺扎、抗爆能力,保持轮胎胎体骨架不变形,提高了轮胎再次翻新机率;钢丝帘布配以中垫胶提高了胎体与胎面的粘合效果和花纹块抗撕裂能力,减少了崩花现象,提高了轮胎承载及缓冲能力。

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