



6
MILLION
RETREADED
TYRES

GQR //

Guaranteed and Qualified Retreading

*Tyre conditions to Vipal
Guaranteed and Qualified Retreading
Program for radial tyres.*

 **VIPAL**[®]
RUBBER

Guaranteed and Qualified Retreading

The GQR (Guaranteed and Qualified Retreading) program is the most comprehensive tyre retreading guarantee on the market covering **16 brands of new tyres.**

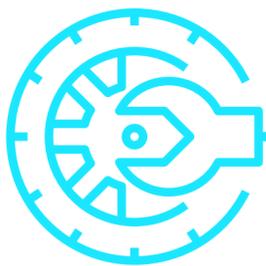
GQR //

Guaranteed and Qualified Retreading



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GENERAL TYRE CRITERIA



- Not have been previously retreaded;
- Not tread damage (cracks in the design groove);
- Manufacture date must be less than 3 years old (DOT);
- No contamination with oil or grease;
- Not cracking on the shoulder of the casing that requires large fillings;
- No deformation to the beads area due to signs of overload, overheating or incorrect mounting;
- No evidence of low pressure or overload;
- No present uneven tread wear;
- No exposed plies/belts on the tread area;





- No remaining rubber groove below the limit established by the TWI;
- After tyre buffing a minimum of 2 mm of rubber must be left on top of the plies/belts;
- No excessive skiving which reaches the tyre plies/steel belts;
- The protective belt can not be removed;
- A groove can not be opened.

END-USER REPLACEMENT CHART

2.1 Replacement Chart Calculation

TYRE WEAR PRORATE (tread depth)	SERVICE REPLACEMENT % (when case can be reused)	SERVICE & CASING REPLACEMENT % (casing failed and it can not be reused)
Up to 20%	100%	100% + 100%
Up to 30%	70%	70% + 70%
Up to 40%	60%	60% + 60%
Up to 50%	50%	50% + 50%
Up to 60%	40%	40% + 40%
Up to 70%	30%	30% + 30%
Up to 80%	20%	20% + 20%
OVER 80%	NO WARRANTY	NO WARRANTY

RADIAL TYRES



For tube type tyres, up to two (2) repairs are allowed, as long as the following criteria are met:

- Repairs are only to be made to the tread area;
- The tyre must not have more than two (2) damages: each with a maximum diameter of 15mm and have a distance of at least 45 deg or 1/8 of the tyre perimeter between them (up to a RAC 22 and RA 31 sized patch);
- Only Vipal RAC and RA patches can be applied;
- All repairs must be applied following the Vipal “Technical Manual for Tyres and Inner tubes Repairs”;

RADIAL TYRES



For tube less type tyres, only one (1) repair is allowed, as long as the following criteria are met:

- Repairs are only to be made to the tread area;
- The tyre may only have one (1) damage: with a maximum diameter of 15mm (up to a RAC 22 and RA 31 sized patch);
- Only Vipal RAC and RA patches can be applied;
- All repairs must be applied following the Vipal “Technical Manual for Tyres and Inner tubes Repairs”;
- Our warranty is for a period of twenty four (24) months from the date each tyre is retreaded.

Note: All other procedures in the retreading process must follow Vipal’s current edition of the “Load Tyres Retreading Technical Manual”

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GENERAL CONDITIONS:

1.1 In the case of a tyre retread failure, the retreader must notify the Vipal Technician and lodge the tyre as a claim into the GQR software.

1.2 The Vipal Technician will undertake a technical visit to the Retreaders' facilities to investigate the claim.

A report will be provided to the Vipal Retreader, who will then make the replacement according to the details specified in Item 2.1 Replacement Chart Calculation.

1.3 To be able to issue the report, it is mandatory a copy of the tax invoice is provided.

1.4 Only in the case a customer requires emergency replacement, the Vipal Retreader is permitted (under his responsibility) to evaluate the claim and proceed with the replacement.

A report and photographs must be provided to the Vipal Technician.

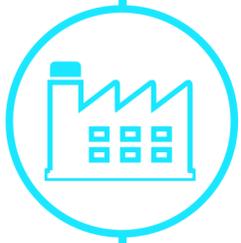


ACCREDITED TYRES

The warranty applies to the following brands of tyres and sizes in the chart below. Only the models currently registered in the GQR software are covered.

NOTE: Any inclusions or exclusion of tyre brands and models from the GQR is at the sole discretion of Vipal Rubber





TYRE MANUFACTURES

BF GOODRICH

BRIDGESTONE

FATE

FIRESTONE

HANKOOK

MARSHAL

SUMITOMO

TOYO

CONTINENTAL

DUNLOP

GENERAL

GOODYEAR

DRC

PIRELLI

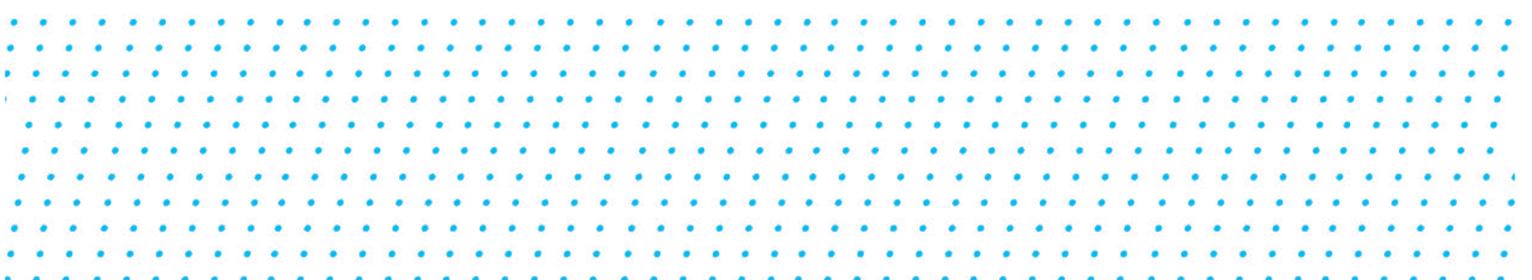
YOKOHAMA

MICHELIN

TYRE SIZES

7.00R16	12R22.5	275/70R22.5
7.50R16	12R24.5	275/80R22.5
8.5R17.5	13R22.5	295/60R 22.5
9.00R20	215/75R17.5	295/80R22.5
10R22.5	205/75R17.5	295/80R24.5
10.00R20	235/75R17.5	305/70R 19.5
11R22.5	285/70R19.5	315/80R22.5
11R24.5	255/70R22.5	315/70R22.5
11.00R20	265/60R 22.5	275/70R22.5
11.00R22	265/70R 19.5	275/80R22.5

Note: Any inclusions or exclusion of tyre brands and models from the GQR is at the sole discretion of Vipal Rubber.



REPLACEMENT PROCEDURE:

The GQR – Vipal Guaranteed and Qualified Retreading covers defects arising from retreading products failures, processes employed in the retreading process or casing manufacture failures. The warranty does not cover failures or defects caused by improper tyre use or accidents.

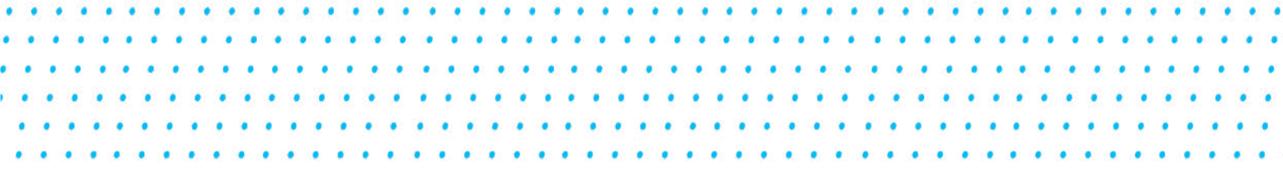
Only tyres with the label “Guaranteed and Qualified Retreading” applied onto its casing will be accepted as a claim.

Guaranteed and Qualified Retreading

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Following lodgement of a claim, Vipal Headquarters will review the report and an automatic email will be sent directly to the end user with the claim outcome.



Credit to the end user will be provided as specified in Item 2.1 Replacement Chart Calculation (page 4).

Any Service Replacement is in the form of tyre product, not monetary value. Casing replacement is with tyre product.

The amount assigned either to the Service Replacement % and Casing Replacement % will be indexed to the cost of the retread as per the tax invoice.

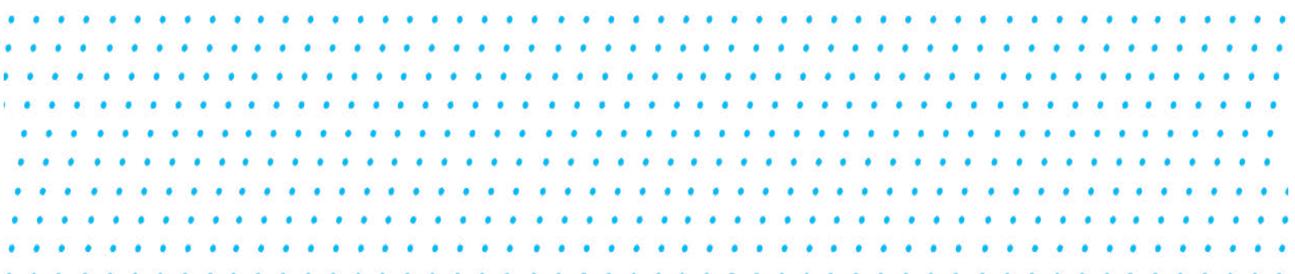
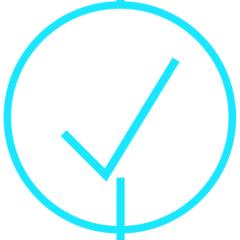
The replacement products value to be provided to the Retreader will be calculated according to the original products purchase price.



CLAIM ELIGIBILITY AND HOW TO CLAIM:

Replacement will be by Vipal
in the case of:

- **Shoulder Separation;**
- Separation between Belts (not caused by a puncture);
- **Separation Belt Package;**
- Tyre Sidewall Separation (not caused by underinflation);
- **Inner Liner Bubbles & Blisters;**
- Tread Delamination;
- **Tread Surface Porosity.**



CLAIM ELIGIBILITY AND HOW TO CLAIM:

Replacement will be by Retreader
in the case of:

- Open Tread Splice;
- Tread Chucking at Splice;
- Tread Lift/Separation;
- Tread Edge Lifting;
- Improper Tread Width;
- Skive Failure;
- Missed Nail Hole;
- Repair Failure;
- Unfilled Nail Hole Repair;
- Bridged Repair;
- Bias Repair Applied onto Radial Tyres;
- Previous repair out of specification;
- Number of repairs out of specifications;
- Failure caused by improper Buffing Casing;
- Bond Line Porosity (Vulcanization Failure).

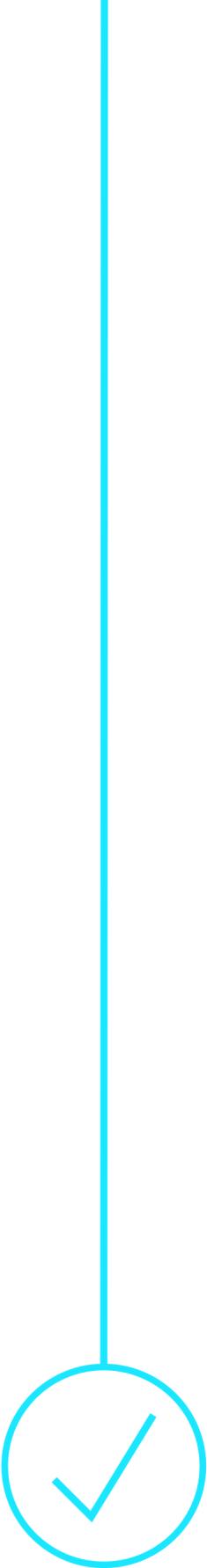


CLAIM ELIGIBILITY AND HOW TO CLAIM:

A tyre claim will be ineligible when:

- Torn, Cut and Kinked Beads;
- Burned Beads (underinflation/ overload or excessive usage of brakes);
- Tearing Mounting/Dismounting Damage (Beads);
- Reinforce/Chafer Separation (circumferential crack above bead);
- Shoulder Separation (tight turns);
- Cuts and Snags on the Tyre Sidewall;
- Sidewall Separation/Bulge;
- Impact Break (Radial Split);
- Circumferential Fatigue Rupture (Zipper);
- Vehicle/Equipment Damage;
- Break Skid Damage;
- Spin Damage;
- Penetrations and Road Hazards;
- Stone Drilling;
- Petrol/Lubricant Damage;



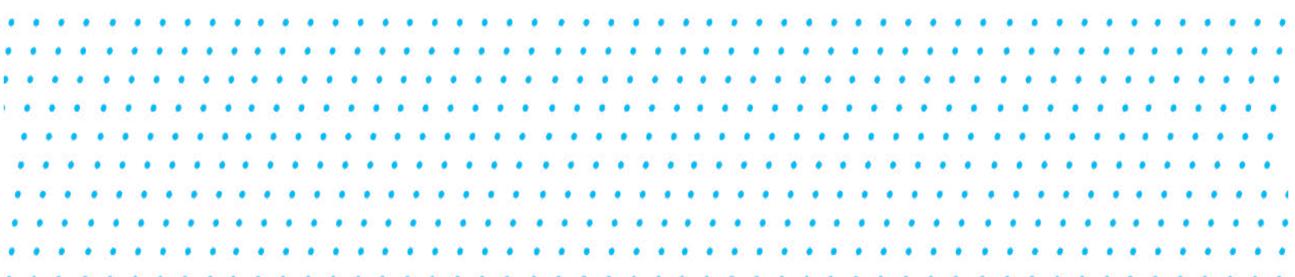
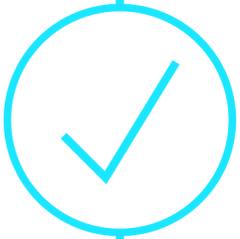
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- Weathering (numerous tiny cracks in the rubber surface);
 - **Chipping / Chunking Tread;**
 - Lug Base Cracking;
 - **Rib Tearing;**
 - Regrooving Damage;
 - **Diagonal Cracking/Wear;**
 - Groove Cracking;
 - **Inner Liner Cracking ;**
 - Open Inner Liner Splice;
 - **Failed Repair for Underinflation;**
 - Run Flat;
 - **Full Shoulder Wear;**
 - Feather Wear;
 - **Scallop Wear;**
 - One-Sided Wear;
 - **Diagonal Wear;**
 - Hell/Toe Wear;
 - **Rapid Shoulders Wear (underinflation);**
 - Rapid Centralized Wear (overinflation);
 - **Tread Disintegration;**
 - Repair performed for a non-accredited Vipal Retreader;
 - **Tread wear greater than 80%.**



Vipal Technician lodging the claim will remove the branding, serial number and the GQR label from the casing. Only products manufactured by Vipal are eligible for Vipal's Guaranteed and Qualified Retreading warranty.

Please note the list as following:

- **Precured Tread;**
- **Cushion Gum MB/AC;**
- **Strip Rubber Compound;**
- **Orbicushion;**
- **Shatter Proof Veneer;**
- **Rope Extruder Gum;**
- **Vulk Cement;**
- **Vulcanizing Cement CV;**
- **RAC and RA patches.**



**COUNT ON THE EXPERIENCE
OF THE LEADER IN RETREADING
TYRES IN LATIN AMERICA.**

#57-VB-F-In-B-10/22

**CONTACT THE VIPAL'S TEAM TODAY AND FIND
OUT HOW TO SAVING ON YOUR TYRE BILL.**

VIPAL RUBBER ———



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