

Specification	Rev.	Description	Current on date	Status	Approved by	
XGG_BF66A17J1	2	Greentyre BMW F66A17	2023/02/15	CRRNT QR2	Kitti Toth	GYO
			2023/02/15	CRRNT QR2	Kitti Toth	GYO
Format No	FS-TECH-004/31.12.2020		Electronically generated copy. No signature required.			

Bill of Materials

					Spot (degrees)
Function	Part-no.	Quantity	UoM	Weight (kg)	
Sidewall L/R	XGS_WBTV120TN	1.312	m	0.921	.
Innerliner	XGL_LAQ1360F360N	1.312	m	0.859	120
Body Ply 1	XGR_PK08490L80	1.323	m	0.982	240
Flipper L	XGR_WR01450085	1.000	m	0.136	.
Flipper R	XGR_WR01450085	1.000	m	0.136	.
Bead apex	XGB_AH138700124543	2.000	pcs	0.640	.
Belt 1	XGR_GSA1327195	1.838	m	0.805	40
Belt 2	XGR_NSA1327185	1.845	m	0.721	220
Capstrip	GR_NB01000012	31.440	m	0.298	295
Tread	XGT_PSTBF66A17D2	1.857	m	2.977	
8.476					

Assembly Properties

+ tol	Position	+ tol		UoM	Description	Colour	Target	Location
.	.	.		mm	.	.	120	.
.	.	.		.	.	.	.	.
.	.	.		mm	.	.	65	.
l	.	.		mm	.	.	1.15	.
.	.	.		mm	.	.	360	.
.	.	.		mm	.	.	360	.
.	.	.		mm	.	.	0.6	.
l	.	.		mm	.	.	1.3	.
.	.	.		mm	.	.	490	.
.	.	.		°	.	.	90	.
.	.	.		mm	.	.	85	.
.	.	.		mm	.	.	80	.
ll	.	1		mm	.	.	85	.
ll	.	1		mm	.	.	85	.
l	.	.		mm	.	.	12	.
l	.	.		mm	.	.	1	.
.	.	.		°	.	.	27	.
.	.	.		mm	.	.	195	.
l	.	.		mm	.	.	1.05	.
.	.	.		°	.	.	27	.
.	.	.		mm	.	.	187	.
l	.	.		mm	.	.	0.75	.
.	.	.		mm	.	.	12	.
.	.	.		°	.	.	.	.
.	.	.		.	.	None	.	.
.	Non operator side	.		.	.	Blue	.	70
.	.	.		mm	.	.	190	.
.	.	.		mm	.	.	222	.
.	.	.		.	Yes	.	.	.

Properties

Greentyre properties

	UoM	Target
Circumference greentyre	mm	1897
Circumference shape to tread	mm	1893
Total width capstrip	mm	203
Sidewall distance (in turnup pos.)	mm	
Number of capply layers	.	1

Construction parameters

	MAXX
Rimcushion under bead	Yes
Sidewall over tread	Yes
Endless capply	Yes

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Processing Gyongyoshalas / General

Process capstrip

	Width [mm]	Degrees [°]	Pitch [mm/rev.]	Pre-stress [N]
Phase 1		331	0.1	30
Phase 2	.	2729	12.6	30
Phase 3	.			

Spotting

	UoM	Value
Capply	.	295
Tread	°	
Pre-assembly	°	120
Ply 1	°	240

Processing Gyongyoshalas / PTBM:PCT Tyre building machine group

Recipe no.

	Value
Recipe no.	XGGBF66A17J1

Building machine settings

	UoM	Target
Circumference carcass drum	mm	1310
Circumference B&T drum	mm	1836
PA overlap (sidewall / innerliner)	mm	12
PA width	mm	576
Preshaping distance	mm	315
Bead distance	mm	368
Shaping distance	mm	260
Turn-up distance	mm	260

Tooling

	Value
B&T stamps	NO
B&T segments	NO
Centerdeck	CD1795
Side ring (SR)	LSR1725
Bead holder rings (BRH)	BRH17
Bar code Position	12 mm

Processing Gyongyoshalas / PTBMSC: PCR TBMwith steel chafer group

Recipe no.

	Value
Recipe no.	XGGBF66A17J1

Building machine settings

	UoM	Target
Flipper outside distance	mm	436