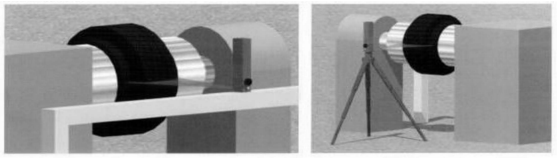

图 1　胎坯均匀性扫描系统

5　结语

轮胎均匀性受轮胎成型过程中诸多因素的影响，冠带条缠绕张力与胎面接头量对轮胎均匀性的影响较大。采用胎坯均匀性分析系统可以有效掌握胎坯的外观形状，快速确认成型机参数，减少废料，提高产品性能。轮胎结构设计人员应研究出更多提高轮胎均匀性的方法，更好地提升轮胎性能和品质。

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Effect of Molding Process on Uniformity of Semi-steel Radial Tire

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Abstract: In this paper, the green tire uniformity analysis system was introduced and the factors influencing the uniformity of semi-steel radial tire were analyzed. Main factors were winding tension and rubber volume at tread joint. It was found that when the tire flat rate increased, the winding tension of crown belt increased, the high-speed performance of the tire decreased, but the variation of tire uniformity was not clear. The winding tension should be adjusted based on tire flat rate. When the joint volume was too much or not enough, the maximum amplitude of the radial force variation of the tire centered on the joint position, which affected the tire uniformity. It was demonstrated that with green tire uniformity analysis system, the green tire shape could be optimized in advance and the product quality was improved.

Keywords: semi-steel radial tire; molding process; uniformity; crown belt; winding tension; joint volume

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