

Contents

1	Tires	1
1.1	Tire Manufacturing	4
1.1.1	Mixing	4
1.1.2	Inner Liner	6
1.1.3	Carcass	6
1.1.4	Bead Cable and Apex	8
1.1.5	Belt	8
1.1.6	Tread Rubber	10
1.1.7	Assembly	10
1.1.8	Vulcanization	11
1.1.9	Quality Check	12
1.2	Tire Development Process	13
1.2.1	Geometry and Load Capacity	14
1.2.2	Tire Requirements Book	19
1.3	Project Management	26
1.3.1	Costs	28
1.3.2	Weight	29
1.3.3	Schedules	30
1.3.4	Tire Database and Documentation	30
1.4	Mobility Strategy	32
1.4.1	Full-Fledged Spare Tires	36
1.4.2	Emergency Minispare and Folding Tires	36
1.4.3	Tirefit and Self-sealing Tires	37
1.4.4	Series-Manufactured Special Tires, Special Rims, and Supporting Elements	38
1.4.5	Run-Flat Tires	39
1.5	Testing and Validation	49
1.5.1	Indoor Objective Testing	53
1.5.2	Outdoor Objective Testing	79
1.5.3	Outdoor Subjective Testing	100

1.6	Tire Characteristics	111
1.6.1	Driving and Steering Characteristics: Forces and Torques	112
1.6.2	Driving Comfort—Noise and Vibrations	133
1.7	Tire Models and Simulation	141
1.7.1	Tire Models for Tire Development	143
1.7.2	Tire Models for Vehicle Development	148
2	Wheels	157
2.1	Wheel Terminology	159
2.2	Steel Wheels	163
2.2.1	Steel Wheel Concepts	165
2.2.2	Steel Wheel Design	167
2.2.3	Choice of Material	169
2.2.4	Steel Wheel Manufacturing Process	170
2.3	Light Metal Wheels	176
2.3.1	Light Metal Sheet Wheels	179
2.3.2	Light Metal Cast Wheels	179
2.3.3	Light Metal Forged Wheels	193
2.4	Synthetic and Carbon Wheels	197
2.5	Wheel Development	201
2.5.1	Design Drafts	201
2.5.2	Choice of Surface Treatment	204
2.5.3	3D Volume Modelling	212
2.5.4	Verification, Operational Stability, and Release	213
2.5.5	Large-Scale Series Production	218
2.6	Quality Assurance	223
2.6.1	X-ray, Computed Tomography, and Metallography	223
2.6.2	Radial and Axial True-Run	224
2.6.3	Balance	225
2.7	Lightweight Engineering Techniques	226
2.8	Aerodynamics	228
2.9	Wheel Trim	230
2.10	Wheel Bolt and Wheel Assembly	230
3	Tire Pressure Monitoring Systems	243
3.1	Indirect Systems	246
3.2	Indirect Systems with Diffusion Detection	248
3.3	Direct Systems	250
4	Wheel Assembly	255
4.1	Valve Assembly	255
4.2	Wheel Uniformity	257
4.3	Wheel Mounting	258
4.4	Matching	258
4.5	Filling and Tire Inflation Pressure	259

4.6	Bead Seat Optimization	259
4.7	Tire Uniformity	260
4.8	Balancing Process	260
4.9	Quality Assurance	261
Outlook		263
References		265
Index		269