

## SERVICING SINGLE-PIECE RIM WHEELS

1. All employees who service rim wheels will be trained in the hazards involved and the safety procedures to be followed.
2. Each employee must demonstrate and maintain the ability to service rim wheels safely by correctly performing the following tasks:
  - a. Demounting tires, including deflation
  - b. Inspecting and identifying rim wheel components
  - c. Mounting tires, including inflating them within a restraining device or other safeguard
  - d. Handling rim wheels
  - e. Inflating tires when single-piece rim wheels are mounted on a vehicle
  - f. Understanding the necessity of standing outside the trajectory during inflation of the tires and of inspecting the rim wheels following inflation
  - g. Installing and removing rim wheels

The employee's performance will be evaluated regularly and additional training will be provided, if necessary, to assure that each employee maintains his or her proficiency.

### Single-Piece Rim Wheels

1. The tire must be completely deflated by removal of the valve core before demoting.
2. Mounting and demounting of the tire must be performed only from the narrow ledge side of the wheel. Care must be taken to avoid damaging the tire beads, and the tire must be mounted only on a compatible wheel of mating bead diameter and width.
3. A nonflammable rubber lubricant must be applied to bead and wheel mating surfaces before assembling the rim wheel, unless the tire or wheel manufacturer recommends against the use of any rubber lubricant.
4. If a tire changing machine is used, the tire may be inflated only to the minimum pressure necessary to force the tire bead onto the rim ledge and create an airtight seal before removal from the tire changing machine.
5. If a bead expander is used, it must be removed before the valve core is installed and as soon as the rim wheel becomes airtight (when the tire bead slips onto the bead seat).
6. The tire may be inflated only when contained within a restraining device, positioned behind a barrier, or bolted on the vehicle with the lug nuts fully tightened.
7. The tire must not be inflated when any flat, solid surface is in the trajectory and within 1 foot of the sidewall.
8. The tire must not be inflated to more than the inflation pressure stamped in the sidewall, unless the manufacturer recommends a higher pressure.
9. Employees must stay out of the trajectory when the tire is being inflated.
10. Heat must not be applied to a single-piece wheel.
11. Cracked, broken, bent, or otherwise damaged wheels must not be reworked, welded, brazed, or otherwise heated.

---

Date