

WAC 296-307-53015 What are the safe operating procedures for servicing single-piece rim wheels? You must establish safe operating procedures for servicing single-piece rim wheels, and ensure that employees are instructed in and follow the procedures. Your procedures must include at least the following:

- (1) Before demounting, remove the valve core to completely deflate the tire.
- (2) Mount and demount tires only from the narrow ledge side of the wheel. Take care to avoid damaging the tire beads while mounting. Only mount tires on compatible wheels of matching bead diameter and width.
- (3) Apply nonflammable rubber lubricant to bead and wheel mating surfaces before rim wheel assembly, unless the tire or wheel manufacturer recommends against it.
- (4) When using a tire changing machine, inflate tires only to the minimum pressure necessary to force the tire bead onto the rim ledge while on the tire changing machine.
- (5) When using a bead expander, remove the bead expander before the valve core is installed and as soon as the rim wheel becomes airtight (the tire bead slips onto the bead seat).
- (6) Always inflate tires within a restraining device, positioned behind a barrier, or bolted on the vehicle with the lug nuts fully tightened.
- (7) Inflate tires only when the trajectory area is clear of flat, solid objects.
- (8) Employees stay out of the trajectory when inflating a tire.
- (9) Tires must not be inflated to more than the inflation pressure stamped in the sidewall unless a higher pressure is recommended by the manufacturer.
- (10) Tires must not be inflated above the maximum pressure recommended by the manufacturer to seat the tire bead firmly against the rim flange.
- (11) Heat must not be applied to a single-piece wheel.
- (12) Cracked, broken, bent, or otherwise damaged wheels must not be reworked, welded, brazed, or otherwise heated.

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