

# STANDARD OPERATING PROCEDURE

## Removal and Installation of Budd Type Tire / Wheel Assemblies for Haul Trucks

Document Number: 960C-SOP-812

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Revision Number: 4

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# REMOVAL AND INSTALLATION OF BUDD TYPE TIRE / WHEEL ASSEMBLIES FOR HAUL TRUCKS

						
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*The following is a step-by-step procedure on how to complete a specific task or meet a facility specific requirement. Standard Operating Procedures (SOPs) are written for all identified critical tasks. By virtue of the hazard or complexity associated with critical tasks it is paramount that the SOP be followed as written. SOPs contain a listing of high-level hazards associated with the task, for detailed hazard analysis reference the applicable Task Hazard Assessments. SOPs do not replace the requirements contained in the company Standards, Codes, and Processes nor does it replace the need to comply with required legislation. Section 8.0 references documentation that the worker shall understand before work commences.*

### 1.0 PURPOSE

- To establish a Company standard to safely and effectively carry out work as it applies to the safe removal and installation of Budd type tire / wheel assemblies for haulage trucks.

### 2.0 SCOPE AND APPLICATION

- This document applies to all Company Heavy Construction and Mining operations. Ensure all site-specific requirements are being met or exceeded before performing the task.

### 3.0 HAZARDS AND CONTROLS

- Uncontrolled movement of equipment.
  - Isolate all forms of hazardous energy and use wheel chocks.
  - Inspect equipment prior to use.
  - When using tire manipulators to install/remove tires and wheel components:
    - (a) Do not stand in the line of fire.
    - (b) Do not stand under manipulator arms.
    - (c) Ensure Park brake has been set before exiting tire manipulator.
    - (d) Follow 960C-SOP-806 Manipulator Use to Remove and Install Tire Wheel Assemblies.
- Tool failure.
  - Inspect all tools prior to task and ensure they have been calibrated as required.
  - Only use impact sockets with impact wrenches.
  - Fit test sockets on wheel nuts by hand prior to removal to ensure proper socket size.
  - Clean all studs and nuts with a wire brush prior to removal.
  - Keep work area clear of unnecessary tools and equipment.
- Tire rupture during installation and removal of tires and wheel components.
  - Ensure tire-wheel assemblies are fully deflated prior to mount-dismount. Run a wire down the valve stem to remove obstructions that would prevent full deflation.
  - Do not stand in the line of fire or trajectory zone when inflating tire.

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- Contact with foreign objects when deflating tires.
  - Do not stand in the line of fire, always stand to one side to avoid contact with dirt and debris.
- Noise exposure when deflating tires.
  - Wear hearing protection when deflating tires. Double hearing protection may be required for tires with super large bore or larger valve stems; alternatively, a muffler may be used to reduce the noise.
- Uncontrolled work area.
  - Communicate with co-workers involved in the removal-installation process.
  - Keep work area clear of unnecessary personnel, erect barriers as required.
- Equipment falling off jacks and stands.
  - Use jacks rated for the weight of the equipment and install under manufacturer designated lifting points.
  - Isolate all forms of hazardous energy, use wheel chocks on the opposite side of the equipment being jacked.
  - Never support an axle end with a jack by itself. Use stands with sufficient safe working load or cribbing to support the equipment. Jack stands with load holding rings or u-rings may be used to support the load providing personnel are not under the equipment.
  - Do not push or pull too aggressively when removing tire from vehicle.

#### 4.0 CHECKLIST

- Attend all preparatory meetings (IE: daily PSI; job scope; review of JSA's and SOPs for the job)
- Complete FLRA cards before starting the work.
- Ensure all personnel involved in the task are aware of the hazards and the controls to be used, as identified in the SOP's; JSA's; and FLRA's
- Conduct a pre-job inspection of all equipment to be worked on and tools to be used.
- Standard of Training required for working on this job: On-the job training.**

#### 5.0 DEFINITIONS

##### 5.1 Company

Means North American Construction Group Ltd. (NACG) and all directly or indirectly owned subsidiary companies, including joint ventures.

##### 5.2 Company Personnel

Includes the Company's employees, officers, directors, agents, associates, consultants/contractors, temporary employees and third-party processors.

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## 5.3 HSE

Refers to the Health, Safety & Environment department

## 6.0 PROCEDURE

### 6.1 Removal

- (a) Use a large bore core tool and deflate the tire/wheel assembly(s) by removing the valve cores from the valves. Deflate the inner and outer assembly of a dual wheel application to 10 PSI. This will ensure safety while allowing for easier removal of the wheel assembly and prevent the beads from breaking should the assembly require re-installation.
- (b) Select the appropriate ¾" or 1" drive impact socket for the job and test its fit on the wheel nuts by hand.
- (c) Clean all studs and nuts with a wire brush or steam hose to allow for easy removal of nuts.
- (d) Grasp the tire/wheel assembly with the tire manipulator (see 960C-SOP-806 – Manipulator; Use to Remove and Install Tire-Wheel Assemblies).
- (e) Remove the tire/wheel assembly using the tire manipulator.
- (f) Inspect the studs, nuts, washers and hub for damage or distortion and replace or repair if necessary.
- (g) For dual wheel assemblies, repeat steps 2-5 to remove the inside assembly.

### 6.2 Installation

- (a) Clean and remove dirt and debris from all tire/wheel assemblies, vehicle hub assemblies, mounting surfaces and studs prior to installation.
- (b) Install inside tire/wheel assembly onto hub with tire manipulator (see 960C-SOP-806 – Manipulator; Use to Remove and Install Tire-Wheel Assemblies).
- (c) Install all washers and nuts by hand.
- (d) Using a "star" pattern, gently snug the wheel nuts.
- (e) Torque the wheel assembly (see 960C-SOP-824).
- (f) Install the outer wheel assembly (repeat steps 1-5 ignoring the reference to inside wheel).
- (g) Torque the wheel assembly (see 960C-SOP-824).
- (h) Inflate tires to manufacturers recommended cold inflation using proper inflator.

## 7.0 NOTES

If this task is to be done by a method different than described in this SOP, the work must **STOP**, and the alternate method must be **DOCUMENTED** with an adequate hazard assessment tool such as a JSA. The document must be **APPROVED** by a supervisor before such procedures are implemented.

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## 8.0 REFERENCES

- Alberta Occupational Health and Safety Act, Regulation and Code – Part 12, Section 193, Tire Servicing
- Alberta Occupational Health and Safety Act, Regulation and Code – Part 14, Sections 208 & 209, Lifting and Handling Loads
- Tire Industry Association Earth Mover Tire Service Training Program
- Equipment Manufacturer Service Manuals
- Jack Manufacturer's Operation Manual
- 960C-SOP-501 Rad Gun Use
- 960C-SOP-503 Hytorque Wrench; Use
- 960C-SOP-504 Hand Tools; Use of
- 960C-SOP-806 Manipulator Use to Remove and Install Tire-Wheel Assemblies
- 960C-SOP-824 Torqueing of Tire-Wheel Assemblies
- 950C-C-028 Hazardous Energy Isolation Code

## 9.0 APPENDICES

- No appendices.