

# PROCEDURE FOR CHANGING TYRES IN AGRICULTURAL MACHINES

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1. Verification of the vehicle lift points.
2. Lifting a vehicle or 1 side of the vehicle, taking into account the safety rules.
3. Verification of the presence and status of pressure sensors (conversation with the customer/ information form/vehicle diagnostics).
4. Initial visual verification of the condition of the tyres, rims to detect any damage and indicate to the customer.
5. Unscrewing the wheel bolts/nuts and putting them in an adapted place/container.
6. Disassembly of the ballast (if present) in a way that allows reassembly.
7. Taking out of the wheel from the hub, if necessary with the use of a specialized bouncer.
8. Releasing all air from the wheel.
9. Placing the wheel in the tyre changer in accordance with the device's operating instructions.
10. If pressure sensors are found, the presser footer must be on the opposite side to the pressure sensor.
11. During pulling off the upper tyre foot from the rim, align the wheel so that the valve is close to the foot of the tool changer and about 15 cm in front of the assembly bucket. Lubricating the presser foot and rim of the rim with assembly paste. Taking out of the presser foot is clockwise.
12. Careful verification of the technical condition of the dismantled tyre for wear and damage (foot, side, inner sealing layer, tread depth) and inner tube if present.
13. If there are pressure sensors for disassembly and assembly, the tires must be made so as not to damage the sensors.
14. Careful verification of valve status, if technically possible. Replace the valve after informing the customer, if aging changes in the valve rubber or signs of wear of the valve rubber parts are found.
15. Careful verification of the rim condition and its cleaning, especially from the hub side and the shelves of the foot mounting on the rim.
16. Careful verification of the technical condition of the tyre to be installed - even in the case of a new tyre (tread, side walls, feet, inner sealing layer).
17. If the pressure sensors are mounted, the assembly must follow the manufacturer's instructions for these sensors.

18. Verification of the direction of the tread of the mounted tyre and its external/internal side.
19. Lubrication of both tyres with specialist paste/assembly ointment. If pressure sensors are present, avoid applying the mounting paste to the sensor itself, which could cause the opening over the pressure sensor to clog.
20. Tyre application by the manufacturer's instructions for the manufacturer fitting.
21. In the case of the presence of pressure sensors when placing the tire on the rim, the wheel should be placed in such a position that the assembly of the tire ends near the valve.
22. In the presence of pressure sensors, be careful not to pinch the valve between the rim of the rim and the tyre foot.
23. Verification of the pressure level according to the vehicle manufacturer's recommendations (sticker, instruction manual, professional databases) or after consultation with the customer.
24. Initial inflation of the wheel to 1-2 bar (in the case of problems with sealing use of the inflator).
25. Placing the wheel in the cage for inflating the wheels.
26. Inflating the wheel with a compressor using an approved manometer (for a very good and exemplary level also calibrated by a calibration unit). Pumping the wheel by the value specified in the „tyre cross-section” on the side wall of the tire (approx. 2-3.5 bar depending on the requirements of the tire manufacturer) and release the pressure to the recommended one.
27. Thorough verification of the condition of the inflated tire (possible bulges, cracks).
28. Use for balancing weights appropriate to the type of wheel or the approved powder.
29. Cleaning the nuts/bolts and hub contact with the rim using a wire brush.
30. Inserting bolts/nuts and screwing them into the thread by hand.
31. Pre-tightening of bolts/nuts opposite the star line with a pneumatic or electric key.
32. Lowered the vehicle and offset of the hoist components.
33. Verification of the tightening torque of bolts/nuts in accordance with the manufacturer's instructions for the vehicle.
34. Final tightening of the bolts/nuts using an approved torque wrench using the torque value as recommended by the vehicle manufacturer.
35. Verification of the condition of pressure sensors (if any). Activation of sensors, if this was not done before mounting the sensors.
36. Restoration of cleanliness of the vehicle that he had before entering the position.
37. Preparation for moving the vehicle out of the station.