

Trelleborg
ANEUTRAC[®]



Mounting and demounting procedure



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Safety first

Wear appropriate hearing protection, safety glasses, work gloves, and safety shoes. The use of a helmet is recommended and becomes mandatory if required by the employer or local company regulations.



Tools needed

Tire fitting machine



Clip

Plate

Tools supplied



4 CLAMPS

- 2 small clamps for 16"-20"
- 2 big clamps for 24"-28"



3 RUBBER SPACERS

Needed only during PneuTrac® demounting.



1 RIM EDGE PROTECTOR

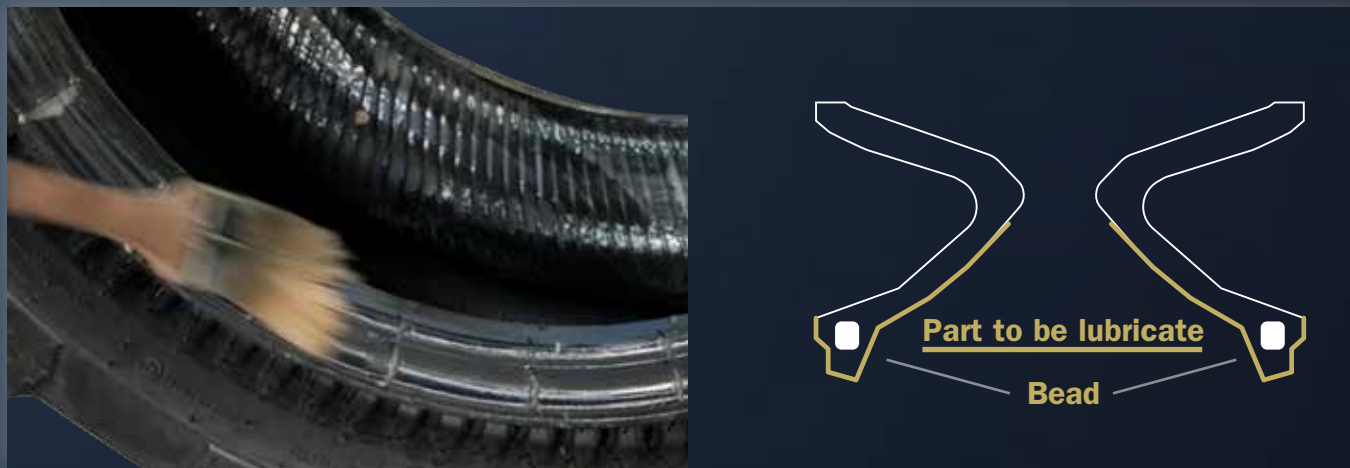
Rim and PneuTrac® preparation

- Check the rim size: Verify the exact size by consulting the PneuTrac® catalogue.
- Check the rim integrity: The rim must be clean and in perfect condition. If the rim shows any structural defects, such as deformations or bending of the balconies, cracks in any part, or excess material in the balcony area (e.g. welding), it must not be used and should be discarded. If the defect is purely cosmetic, such as a painting flaw, the rim is still suitable for use, but it is not acceptable for commercial sale.
- Fasten the valve: Insert the valve into the dedicated hole in the rim and tighten it securely.
- Prepare the tire fitting machine: Bring the rim close to the tire fitting machine and secure it by opening the forks until they grip the rim at the shrink hole.
- Lift the rim: Use the remote control of the tire fitting machine to lift the rim into position.



- Fix the first clamp on the front rim balcony at 12:00 hour position, near the valve.
- Lubricate both rim balconies with a brush, using the proper mounting paste.
- Lubricate the clamp with a brush, applying the proper mounting paste.

- Pick up the PneuTrac® and check its integrity. Inspect the bead area on both sides. It must be uniform, without any deformation or visible cords. If the PneuTrac® shows any defects, particularly in the bead area, it must not be used and should be discarded.



- Lubricate both beads and the inside omega sidewall of PneuTrac® with a brush, using the proper mounting paste.

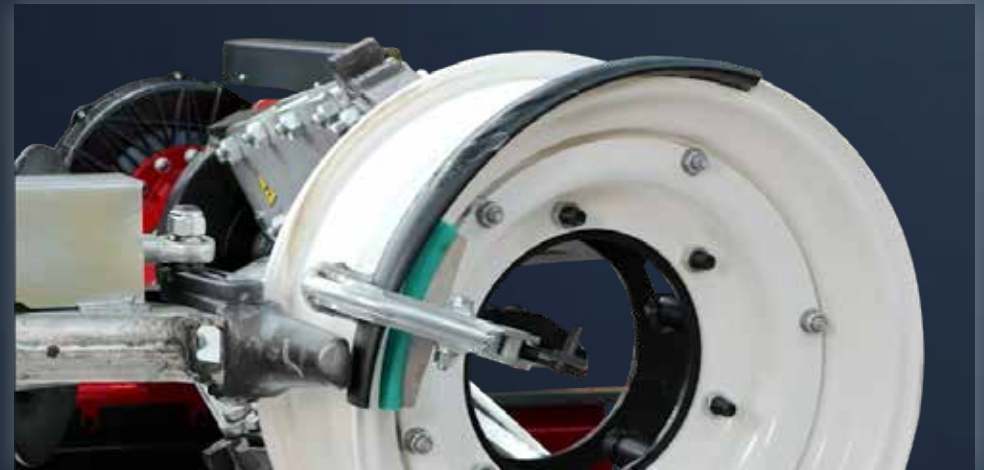


⚠ Important: To facilitate mounting, it is recommended to heat the PneuTrac®. Avoid assembly if the PneuTrac® temperature is lower than 10°C.

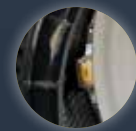
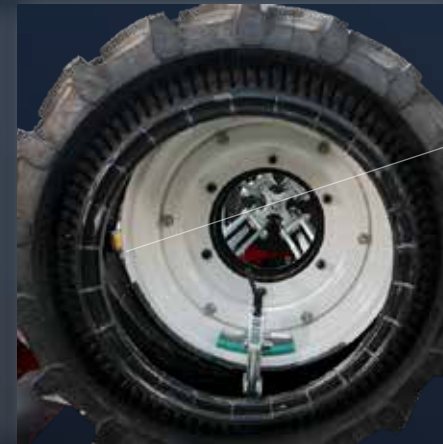
Mounting the PneuTrac®

STEP 1: FIRST BEAD FITTING

- Position the mounting machine clip close to and under the clamp fixed on the rim (at the 10:00 position). Place the rim edge protectors on the rim balcony, sliding them through the clamp.



- Position the PneuTrac® in front of the rim fixed on the tire fitting machine.
- Hang the first bead of the PneuTrac® over the clamp and rotate the rim clockwise until the PneuTrac® bead is completely seated on the balcony.
- Rotate the rim carefully and slowly. Using the clip tip, allow the first bead to pass completely over the rim balcony.



Use the clip tip

- Remove the tire fitting machine clip from the first bead, pulling the tire very carefully and slowly.



- Move the clip of the tire fitting machine in the front part of the rim to perform the fitting of the second bead.



STEP 2: SECOND BEAD FITTING

- With the end of the clip, apply slight tension to the bead. Turn the rim slowly clockwise while moving the clip in and out, bypassing the clamp.
- Once sufficient space is created by increasing the clip tension, insert the second clamp so that it makes contact with the first clamp.



- Turn the rim clockwise very carefully and slowly, allowing the bead to completely pass over the rim balcony. Pay attention not to damage PneuTrac® bead or bend the rim balcony. If necessary, lubricate the PneuTrac® bead again. If needed, alternate between clockwise and counterclockwise rotation while moving the clip in and out to allow the bead to slide into the well. This operation must be performed slowly and carefully.
- Slowly remove the clip, being careful not to touch the rim.



- Rotate the tire fitting machine tool and bring the plate closer to the clamp area.
- Push the PneuTrac® inwards to create sufficient space for removing the clamps.
- Settle the PneuTrac® by applying light pressure on the disc plate along the entire circumference, for both sides.



⚠ Important: While the PneuTrac® is rotating, the pressure on the disc plate must be kept to a minimum.

PneuTrac® manual inflation

- Pick up the pressure gauge connected to the air hose and attach it to the valve on the rim.
- Inflate the PneuTrac® until the beads are properly seated on the rim balcony, ensuring that the inflation pressure does not exceed the maximum pressure indicated on the pictogram (250 kPa).
- Check the bead control lines to confirm that the beads are properly seated on the rim.
- If beads are not correctly positioned on the rim balconies, completely deflate the PneuTrac® and restart the operations.
- Once the bead control lines are correctly aligned with the rim balconies, deflate the PneuTrac® up to the nominal pressure or the required pressure.



PneuTrac® demounting

FIXING THE PNEUTRAC® ON THE FITTING MACHINE

- Identify the PneuTrac® to be demounted and bring it near the fitting machine.
- Fix the PneuTrac® on the fitting machine by clamping the center bore of the rim. Open the forks of the fitting machine until they grip the rim tightly at the shrink hole.
- Lift the PneuTrac® approximately 10 cm from the base.
- Open the valve to release the air and completely deflate the PneuTrac®.



DETACHMENT OF THE 2ND PNEUTRAC® BEAD

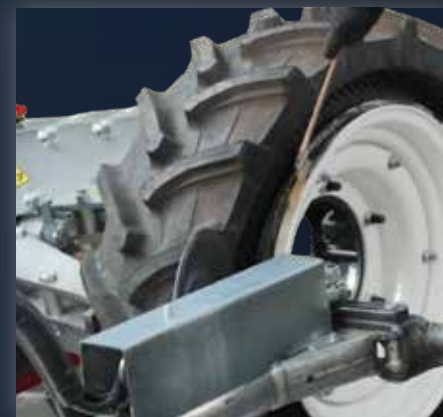
- Position the disc plate on the sidewall, **ensuring it does not touch the rim.**
- Push the disc plate to detach the sidewall from the rim.
- Lubricate the rim balcony with a brush, using the proper mounting paste.
- Repeat the lubrication around the entire circumference of the PneuTrac®.
- Insert the two clamps, placing them 90° apart (one at the 12:00 position and one at the 3:00 position).



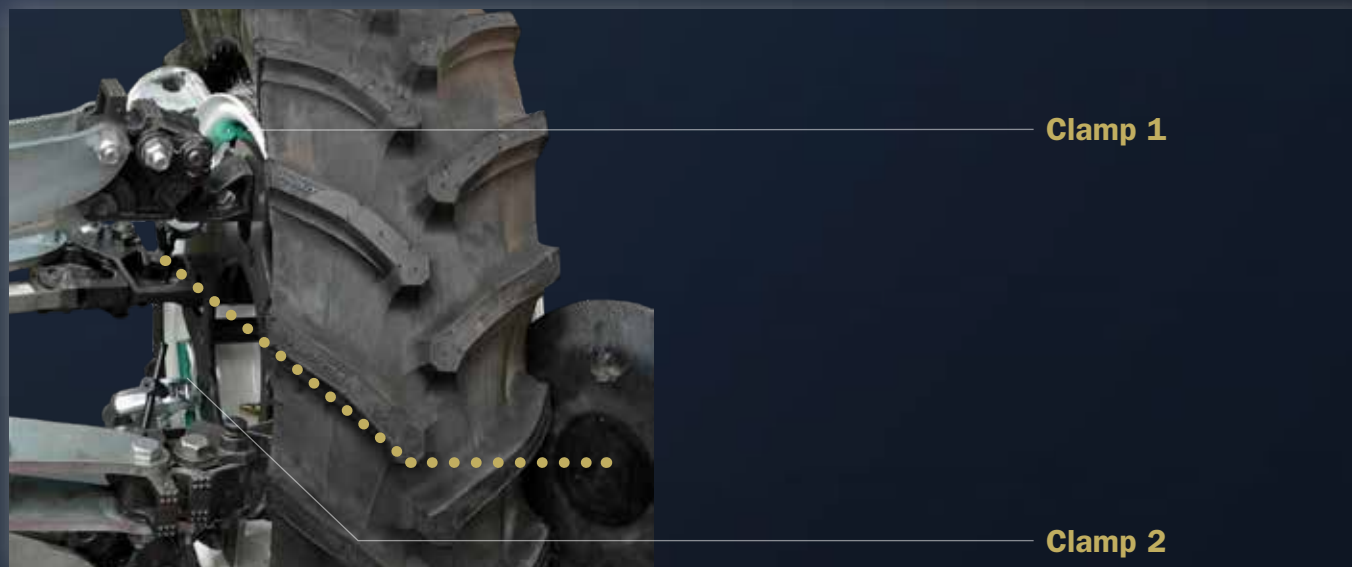
- Move the tire fitting machine tool to the front.
- Position the disc plate on the sidewall, **ensuring it does not touch the rim.**
- Push the disc plate to detach the sidewall from the rim.



- Lubricate rim balcony with a brush, using the proper mounting paste.
- Repeat this process around entire circumference of the PneuTrac®.



- Rotate the PneuTrac® until the disc plate remove on the front side is approximately 180° from the midpoint between the two clamps on the rear side.



PNEUTRAC® DEMOUNTING PROCEDURE

- Increase disc plate pressure on the sidewall of the PneuTrac®.



- Lubricate the Red Rubber Spacer with a brush, using the proper mounting paste.



- Insert the Red Rubber Spacer between the bead and the rim, ensuring the spacer's geometry adapts to the rim balcony.



- Insert the clip of the tire fitting machine into the space created by the Red Rubber Spacer.



- Use the clip to maintain tension on the bead.
- Remove the Red Rubber Spacer.



- Rotate the PneuTrac® slowly until the clip on the front side is at 0° position relative to the midpoint between the two clamps on the back side.



- Raise up the clip and turn the spindle slightly counterclockwise.
- Continue **turning the spindle very slowly** counterclockwise while raising up the clip.



- During this operation, **move the clip back and forth in the gap between the rim and the bead every few centimeters.**





Important:

For sizes 24" and 28", a hand lever support is required.

- Insert the lever immediately next to the clip of the fitting machine.
- Continue to **turn the spindle very slowly** counterclockwise while raising up the clip.
- The hand lever must maintain the gap between the bead and the rim.



- When the second bead is completely detached from the rim, remove the clip from the bead as well.
- Remove the clamps.
- Move the fitting machine mounting tools back to position the disc plate against the sidewall of the first bead.
- Push the disc plate against the sidewall, **avoiding contact with the rim.**
- Push and turn until there is space between the bead and the rim on the opposite side
- Turn the spindle around the entire circumference to allow the PneuTrac® bead to detach completely from the rim.



Important:

During this operation, the operator must be positioned in front of the PneuTrac®, ensuring it is secured to prevent it from falling suddenly.





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Yokohama TWS S.p.A.
Via Nazionale Tiburtina, 143 - 00019 Villa Adriana - Tivoli (RM), Italy
Phone: +39 0774 3841 – info.tws@yokohama-tws.com
www.trelleborg-tires.com