



Procedures for Replacing Handles

Reference AREMA Chapter 5 Part 6 Paragraph 6.6.5

The following procedures should be used to replace tool handles:

- 1. ALWAYS WEAR EYE PROTECTION.**
2. Remove old handle by sawing close to the tool.
3. Place the tool on a proper support and drive out part of handle remaining in the eye from the side opposite the wedges.
4. Clean the eye. Check inside the eye for pieces of the old handle and for any damage to the tool.
5. Select the correct replacement handle. Do not use a handle if it is not the right size or shape.
6. Partially insert the handle into the eye to check for a proper fit. Check to see if the handle and tool come into contact on the entire circumference of the eye.
7. Lubricate the eye portion of the handle. Waterless hand cleaner or a wax crayon may be used.
8. Place tool on a proper support so eye portion of handle can be driven through the tool to insure a tight fit. Drive the handle on tight. Be careful not to drive the handle to a point where the back side of the tool cuts deeply into the handle. This will damage the handle and could lead to the handle failing. The collar of the handle should be approximately 3/4" to 1" from the tool.
9. After the handle has been properly seated, cut off the excess of the handle sticking out from the eye flush with the tool.
10. Open slot in the eye of tool handle with chisel or similar tool.
11. Drive wooden wedge into slot as deeply as is possible. Trim or file wedge flush with the tool.
12. Drive the 2 steel wedge in center of eye. The steel wedge may be either circular or flat. If flat, it is to be driven at right angle to wooden wedge. Drive wedge flush with the tool. Be careful of glancing blows that may cause the steel wedge to chip or mushroom.
13. The above instructions apply to drive on handles. For slip on handles used with tools such as picks and adzes, drive out the old handle, slip head onto new handle, and tap firmly on a solid base until a tight fit is achieved.

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