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## **Love's Travel Stops & Country Stores Distribution Center - Operational Plan**

### **Proposed Location:**

3010 Roy Orr Boulevard  
Suite 100  
Grand Prairie, TX 75050

### **General Description**

Love's Travel Stops & Country Stores is pleased to propose a new commercial truck tire and light mechanical parts distribution center accompanied by a commercial truck tire retreading operation. The proposed facility will occupy 94,689 square feet of the west end of above mentioned location. This facility would initially provide product shipments to sixty-nine (69) Love's Tire Care Shops as well as multiple external fleet customers. We anticipate our customer base of Love's Tire Care Shops and external fleet customer to increase over time as our business expands.

The products to be distributed by this facility initially would include new commercial truck tires sourced from domestic and international manufacturers, retreaded commercial truck tires that would be recycled through our retreading operation and approximately five hundred (500) to seven hundred (700) light mechanical commercial truck parts.

### **Distribution Process Description**

The Distribution Center operation will occupy approximately 76,000 square feet of the proposed footprint.

#### **Storage:**

The inventory storage system will consist of fixed pallet rack with wire decking for storage of light mechanical parts and any other non-Tire items. Tires will be stored on their sidewall in stacks on the floor or in portable pallet racks. The specific stacking layout will be arranged in accordance with established fire codes.

All storage of tires, light mechanical parts and other inventory and supplies will be stored on the interior of the facility. There will be no storage on the exterior of the property.

#### **Receiving and Shipping:**

The Distribution Center will receive shipments of new tires from domestic and foreign suppliers via third party shipper's trailers and containers. Used tire carcasses will be picked up by way of our private fleet of trucks and trailers from Love's Tire Care locations as well as from external fleet customers for delivery to the Distribution Center. Additional inventory of used tire carcasses may be delivered from domestic and foreign suppliers via third party shipper's trailers and ocean containers.

Shipments to Love's Tire Care locations and to external fleet customers will be delivered via our private fleet of truck and trailer as well as on Less Than Truckload (LTL) carriers.



### **Retread Process Description**

The tire retreading operation will occupy approximately 18,000 square feet of the proposed footprint for recycling commercial truck tires by retreading a previously used tire carcass (casing). The retread process utilizes state of the art Oliver Retread Equipment which applies new tread rubber onto a used tire.

#### **Initial inspection:**

Upon receipt, the used tires are thoroughly inspected to ensure that they meet established safety and quality standards. Any damage to the interior or exterior is marked for repair. Tires not meeting safety and quality standards are rejected and will be sent to an outside vendor to be recycled for other uses.

#### **Carcass Grinding/Buffering (Tread Removal):**

After the initial inspection, the remaining worn tread rubber is removed and the carcass surface is prepared to accept a new tread. The tire carcass is placed on a shaft and rotated. As the carcass rotates on the shaft assembly, it is placed against a rotating rasp which removes the remaining worn tread rubber. A fine water mist is applied at the rasp to provide cooling for the process. The mist is evaporated during the process and is not exhausted to the recovery system. The crumb rubber that is removed is collected by a rubber recovery system and deposited into a specially designed 53 foot trailer so the material may be recycled at another location. The rubber crumb is generally large pieces of rubber.

#### **Repairing:**

Some tires must be repaired prior to retreading. The operators use hand tools to make repairs to the tire. Repair rubber is packed into the repair areas. In some cases a rubber patch is applied to complete the repair.

#### **Cushion Extrusion and Tread Applications:**

In order to apply a pre-cured tread to the buffed tire a thin layer of cushion rubber is extruded onto the carcass prior to attaching the new tread. Once the cushion rubber is applied the new tread rubber is rolled and compressed onto the cushion rubber.

#### **Retread Tire Curing:**

The tire is placed in an envelope and the air is removed by vacuum. A batch of up to 25 tires are then placed into a curing chamber. The curing chamber is a dry system that is heated electrically. The rubber curing process takes approximately two and half hours to complete.

#### **Final inspection:**

Each tire goes through a final inspection process. At this point the tires may be touched up with a water based black paint. The cured tires are inspected according to safety and quality standards and are then ready to be shipped to a customer.

### **Hours of Operation**

The initial hours of operation for this facility will be 8:00am to 5:00pm, Monday through Friday. One additional shift may be added at a future date to support increasing sales volume.



### **Employment**

It is anticipated that at this location, Love's will initially employ approximately thirty (30) full time employees. Additional staffing of up to sixteen (16) may be added at a future date to support sales volume increases. This additional staff would be assigned to an evening shift.

### **Deliveries, Shipments and Parking**

It is anticipated that this facility would receive four (4) to five (5) trucking deliveries of merchandise daily. It is also anticipated that this facility will ship four (4) to five (5) trucking shipments of customer merchandise daily. The proposed facility has parking capacity for ninety one (91) cars for employees and visitors. There is also eight (8) trailer parking spots allocated to Love's portion of the property.

Love's Travel Stops & Country Store's corporate headquarters is located at 10601 N. Pennsylvania Avenue, Oklahoma City, OK.