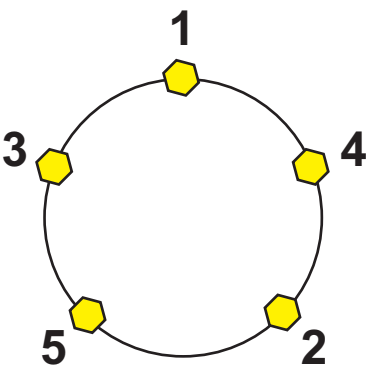


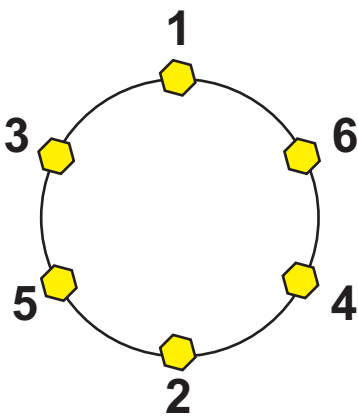
WHEEL TORQUING & ASSEMBLY INSTRUCTIONS

TORQUING PROCEDURES

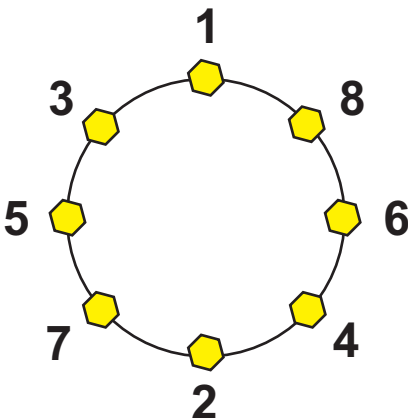
Wheel Lug Nut Diagrams:



5 Lug Nuts



6 Lug Nuts



8 Lug Nuts

WHEEL TORQUE INSTRUCTIONS

1. Start the lug nuts on the studs using fingers to avoid cross threading.

2. Stage 1, Torque: Impact the lug nuts in the appropriate star pattern above until snug to the rim. – See Wheel Lug Nut Diagram above.

3. Stage 2, Torque: Use a calibrated torque wrench to torque each lug nut, in a star pattern shown above, to the value indicated in the chart below. Wheels
- must remain stationary during the torquing process for control purposes.

See Wheel Lug Nut Chart below for appropriate torque readings using the star pattern shown above.

4. Stage 3. Torque all lug nuts to the Recommended Torque listed in the chart below.

WHEEL LUG NUT TORQUE CHART						
Lug Nuts	Rim Size	Rim Type	Stage 1 Torque ft./lb.	Stage 2 Torque ft./lb.	Stage 3 Recommended Torque ft./lb.	Acceptable Torque Range ft./lb.
5-Lug	8"	Steel	20-25	30-50	90	85-95
5-Lug	10"	Steel	20-25	30-50	90	85-95
5-Lug	12"	Steel	20-25	30-50	90	85-95
5-Lug	13"	Steel	20-25	50-70	90	85-95
5-Lug	13"	Alum.	20-25	50-70	90	85-95
5-Lug	14"	Steel	20-25	50-70	90	85-95
5-Lug	14"	Alum.	20-25	50-70	100	85-120
6-Lug	15"	Steel	20-25	50-70	100	85-120
6-Lug	15"	Alum.	20-25	50-70	100	85-120
8-Lug	16"	Steel	20-25	50-70	110	85-130
8-Lug	16"	Alum.	20-25	50-70	110	85-130

ALL TORQUE READINGS MUST FALL WITHIN THE ACCEPTABLE RANGE SHOWN IN THE LAST COLUMN.

IF TORQUE FALLS BELOW THE ACCEPTABLE RANGE, ADDITIONAL TORQUE IS REQUIRED.

See the **Wheel Torque Instructions** and **Wheel Lug Nut Diagram** for the correct pattern and recommended torque value.

DURING TRAVEL, WHEEL LUG NUTS MUST BE CHECKED AND RE-TORQUED, as required, after the first, 50 miles, then periodically thereafter during travel.

FAILURE TO FOLLOW THESE INSTRUCTIONS MAY RESULT IN WHEEL LOSS, OR LOSS OF CONTROL, RESULTING IN DEATH OR SERIOUS INJURY.