

# INSTRUCTIONS

## BEADLOCK KIT

### 253-1510

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**NOTE:** It is recommended that the installation of the beadlock kit be performed using a lathe to accurately align the inner ring and machine the finished mating flange correctly. Satisfactory results can be obtained without the use of a lathe if care is taken during the installation.

- 1) Remove any paint or rust from the outer lip of the wheel. Outer lip and flange should be bare steel.
- 2) Using a caliper, (or similar procedure) measure between the OD of the inner ring and the ID of the outer wheel lip to center the inner ring of the beadlock on the flange of the outer lip of the wheel with the nut inserts toward the wheel center. Clamp the inner ring to the wheel outer flange.

**NOTE:** If using a lathe: Chuck the wheel in lathe, clamp inner ring of beadlock to outer flange of wheel and use dial indicator to accurately center the inner beadlock ring.

- 3) Tack weld ring to wheel in several places. To assure that inner ring remains flat and firmly seated on wheel flange, reposition clamps and continue to tack weld inner ring until the ring is welded to the wheel around its entire circumference.

- 4) Cut or grind off outer lip of wheel flush with the flat surface of the inner ring of beadlock.

**NOTE:** With wheel chucked in lathe, machine the weld bead, and outer wheel lip flush with the inner ring and parallel to the wheel center.

- 5) Install tire and outer beadlock ring, torque bolts to 20 ft lbs.

**CAUTION:** When inflating a tire serious injury may result if the tire explodes or the bead lock and / or weld ring fails to retain the tire. For this reason it is recommended that the tire be inflated in a tire cage (or face down under your truck or trailer) as a safety precaution.

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# IMPORTANT

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