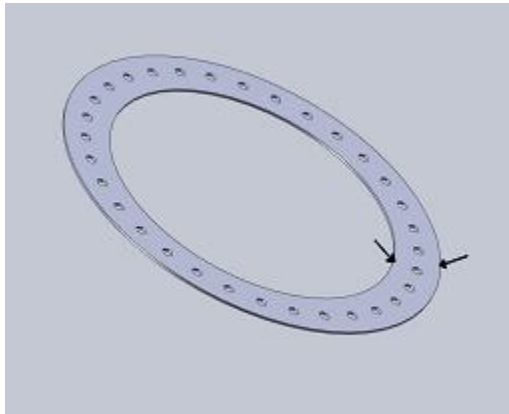


Weld-on Beadlock with Integrated Anti Coning Techonlogy Installation

Materials needed per wheel:
32 - 3/8" x 1.75" grade 8 bolts
32 - 5/16" flat washers
32 - 3/8" nylock nuts.

Step one - Use proper safety equipment (face shield, gloves, hearing protection, etc.).

Step two – Using a grinder slightly bevel both the inner and outer edges of all rings to reduce the sharpness of the edges. A flap type sanding disk (~120 grit) works well.



Step three – Using a grinder remove the paint, chrome, etc. from the face of the wheel. The whole area where the inner ring (smaller in diameter) contacts the wheel should be bare metal. As seen in the following picture.



Step four – Center the inner ring (smaller in diameter) within the lip of the rim. The ring

should be sitting down inside the outer edge of the wheel. There should be a small gap between the edge of the wheel and the edge of the ring as seen in the following picture. This gap aids in weld prep and allows for slight differences between wheel brands.



Step five - Tack weld the edge of the ring to the inner lip of the wheel, skipping around the wheel a few inches at a time.

Step six – Fully weld the ring to the wheel making sure the weld is of high quality (all welding should be performed by a certified welder). Make sure the weld is air-tight if not you will have a leak.

Step seven – Grind down the weld flush with the flat surface of the inner ring and deburr all edges making sure that the surface is free of voids from welding.

Step eight - Bend all of the Integrated Anti Coning tabs upward 90 deg. A large crescent wrench works well for this task. You will have to take bent both sides of each tab up a little at a time until they are as shown in the following picture.



Step nine – After all of the tabs are bent upright place a weld on the outer edge of each tab as shown in the following picture.



Step ten – Clean the wheel of all grinding dust and degrease.

Step eleven – Mask off all wheel surfaces to remain unpainted.

Step twelve – Apply a primer to the inner ring and welded area, see primer can for manufacturer's directions.

Step thirteen – Apply desired paint to wheel using the same directions as for the above steps.

Step fourteen – Repeat priming and painting steps on the outer ring. Allow all painted surfaces to properly dry.

Step fifteen– Install the inner bead of the tire over the front edge of the wheel, a light spray of soapy water or tire lube is helpful here. At this point the tire should be sitting with only the rim inside the inner bead of the tire and the outer bead of the tire sitting outside the rim against the outer surface of the wheel.

Step sixteen – Apply a bead of silicone between the inside of the tire and the outside edge of the inner ring.

Step seventeen – Place the outer ring on the tire and insert a bolt with washer and nylock nut in 4 holes evenly spaced around the wheel, then finger tighten bolts, making sure the tire is centered on the wheel.

Step eighteen– Install remaining bolts, washers, and nylock nuts.

Step twenty – Tighten all bolts to 15 – 20 lbs/feet. You will need to make several passes before this can be accomplished.

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Intended for off-road use only.