

## DC – Heat Cycle

<b>Purpose</b>	To guide the Distribution Center in the correct process of heat cycling tires.	
<b>Heat Cycling Tires</b>		
<b>Step</b>	<b>Action</b>	
1	Sets will verify the correct article is bought to them. Make sure to complete a tire inspection. No kinked beads, torn beads or any other defectives.	
2	Peel off sticker and clean sticker residue of tire.	
3	Mount tire on correct wheel to fit FitVal specs.	
4	Air up tire to 15/20 psi.	
5	Place correctly inside Heat cycle Machine. Make sure you lift the safety bar on the heat cycle and secure with the safety pin. (Don't want wheel to come flying out).	
6	Adjust the pressure of the roller touching the tread of tire.	
7	Turn heat lamp on to face thread of tire.	
8	Install Heat shield.	
9	Run tire till tread temperature is 170 to 180 degrees all across thread.  Check every 10 minutes.	

**Heat Cycling**  
**Tires Cont.**

<b>10</b>	Once tread temperature is met, dismount. Verify the bead is not torn.	
<b>.11</b>	Apply heat cycle sticker.	
<b>12</b>	If more than one tire repeat process till all tires are done.	
<b>13</b>	Ship tires.	
<b>14</b>	Collect DOTs.	

**Contact**

Please see your mentor if you have any questions.