

Installing the Assembly

Properly installing the assembly is essential to ensuring the safety of Our Customers and Our People. It is your responsibility to ensure the assembly can achieve manufacturer's OE torque specifications. This can be done by following the processes outlined in this document.

Pre-Installation

Before installing the assembly, you must verify the following:

- The wheel and hub have been cleaned and buffed
- The hub has no more than one damaged or missing lug or stud
- There are no obstructions present that prevent the wheel from sitting flush on the hub (mis-fitting hub ring, bolt on the hub face, etc.)

Pre-Torquing

Once you have completed the pre-Installation steps, you can begin pre-torquing the assembly onto the vehicle. Please follow the process outlined below, based on what type of impact gun you are using.

1. Start by placing the wheel on the hub and holding it securely while hand threading each lug three full turns of engagement to reduce the chance of cross threading.
2. Maintain pressure on the assembly to hold it securely to the hub until the first two lugs are pre-torqued.
3. Pre-torquing the assembly:

Star Pattern	Pneumatic Impact (2-Star Pattern)	Cordless Impact (3-Star Pattern)
	Use the yellow torque stick.	DO NOT use a torque stick.
1	Feather the lug nuts on. This is when you slowly engage each lug nut in a star pattern until the lug contacts the lug seat of the wheel but does not apply any torque.	Feather the lug nuts on. This is when you slowly engage each lug nut in a star pattern until the lug contacts the lug seat of the wheel but does not apply any torque.
2	Hammer the lug nuts on. This is when the lugs are snug, holding the wheel in place, and you fully depress the trigger for 2-3 seconds.	Pull the trigger until it stops.
3		Pull the trigger until it stops.

Final Torquing

Final torquing is the process that achieves the manufacturer's OE torque specifications.

1. Verify the torque specifications on the work order.
2. Set the torque wrench to the proper setting.
3. Collect the proper torque extension for the vehicle you are servicing. (Blue up to 110 ft-lbs; Grey over 110 ft-lbs)
4. Spin the assembly to confirm clearance.
5. Using a closed palm, torque all exposed lugs including all wheel locks, using one-star pattern.
6. Follow with one circle pattern to validate manufacturer's OE torque has been achieved.

Aftermarket Wheels

When installing aftermarket wheels, you must verify seven full turns of thread engagement.