



## Delta-1 Wheel Bead-loc™ Assembly Procedure

1. Verify all female threads in the wheel are free of foreign matter – compressed air is recommended. For Top Fuel wheels skip steps 2 and 3.
2. Apply 2 drops of Loctite 242 blue thread locker on course threaded end of stud. (5/16” studs for PS1 & PM1)
3. Thread course end of stud into wheel. Torque to 12 in/lbs (1 ft/lb.) to ensure the stud is seated (PS1 & PM1 has 36 studs per wheel).
4. Insert wheel into tire .  
\*Do not allow the wheel to rest on a surface using the bead-loc studs as a stand.\*
5. Locate tire bead onto tire register.  
\*Verify the tire’s bead bundle is clean and free of all potential lubricants and debris. Acetone and lacquer thinner are acceptable cleansing agents.\*
6. Position bead-loc ring onto the tire, over the studs or TF bolt holes.  
\*It may be necessary to rest the wheel on an elevated surface, like a bucket, to allow the tire to hang below the wheel bead flange that you are trying to mount.\*
7. Apply a minimal amount of nickel based anti-seize to spherical surface of spherical washer.
8. Place spherical washers on the bolt-on bead-loc ring.
9. Apply an applicable amount of nickel based anti-seize (or Copaslip or equivalent) to fine threaded portion of stud or TF bolts.
10. Thread on all nuts or bolts by hand (finger tight only).  
\*For a tire with a thick bead bundle, it may be necessary to start 4 nuts onto 4 studs without using the spherical washer to allow enough bead compression throughout the bolt-on ring to start the remaining 14 nuts using each spherical washer. After the 14 have been started, go back to the first 4 nuts and re-install using the spherical washers.\*
11. In a “star pattern”, torque nuts or TF bolts to 100 in/lbs (8.3 ft/lbs.) until each nut has reached initial torque requirement once.
12. Continue to torque nuts or TF bolts in “star pattern” to value “A” on the chart below until each nut has reached torque requirement once.
13. Continue to torque nuts or TF bolts in “star pattern” to value “B” on the chart below until each nut has reached torque requirement once.
14. Re-torque all nuts or TF bolts to value “C” on the chart below in a circular pattern two full revolutions around the bead-loc ring.
15. Re-torque after each pass.

### Torque Values are Based on a Lubricated Fastener

	PS1 and PM1	TF1	Torque Pattern/direction
“A”	175 in/lbs (14.6ft/lbs)	200 in/lbs (16.7ft/lbs)	Star
“B”	225 in/lbs (18.8ft/lbs)	275 in/lbs (22.9ft/lbs)	Star
“C”	264 in/lbs (22ft/lbs)	325 in/lbs (27.1ft/lbs)	Circular (counter or clockwise)

Due to the induced bead-loc ring deflection caused by the thicker tire bead bundle (approximately .950 thick) on the Goodyear 1230 or similar tire, it is recommended that the bead-loc rings used in those applications are only used with tires of equal or greater bead bundle thickness.

### Delta-1 Replacement Parts

Part Number	Delta 1 Part	Application	Unit
P650-5599B	Black Beadlock Ring	PM1/PS1	1 Ring
P650-5599P	Polished Beadlock Ring	PM1/PS1	1 Ring
P650-5699B	Black Beadlock Ring	TF1	1 Ring
P609-PS1-0516-Ti-18	Beadlock Fastener Kit	PM1/PS1	Kit for 1 Ring
P609-TF2-0380-24	Beadlock Fastener Kit	TF1	Kit for 1 Ring

### Weld - Delta-1 TF Heli-Coil Repair Kit

#### Kit will include:

- (1) Kato tangless heli-coil removal tool #2KRTC-6
- (1) Kato tangless heli-coil installation tool - #2KPHC-6
- (1) KATO 3/8 - 16 coil thread tap - #CTC-6SRB-H3
- (1) Tee handle tap driver
- Spare 3/8 - 16 heli-coils
- Spare 3/8 x 16 x 1 1/4” 12 pt bolts
- Removal & installation instructions

To get a heli-coil repair kit, contact your WELD Trackside Sales & Service Specialist or Hyatt Racing Services.

