



DOUBLE BEAD LOCK MOUNTING INSTRUCTIONS

Failure to follow instructions for mounting bead locks may damage bead lock rings and or the bead bundle of the tire.

Required Tools:

- Anti-seize
- 5/16" 12-point socket
- Torque Wrench
- Socket Extension
- Tire mounting irons/spoons
- Caliper

IMPORTANT! Before Attempting to Mount your tires - measure the bead bundle of each tire. The bead bundle should measure a minimum of .600" to .625" thick. If the tire bead bundle is thinner than .600" there will not be enough crush on the bead bundle to seal and or allow the tire to spin on the rim. You can either exchange your tire(s) for a more consistent set or purchase P/N 999112 15" bead lock rings for tires that have a thin bead bundle.

Step 1

Important! - Verify Bead Bundle Thickness.

A tire needs to have .100" to .120" bead crush to seal and grip properly. Crush is the amount the rings will squeeze the bead bundle of the tire. Billet Specialties bead lock rings are precision machined to be .500" when fully closed.

The tire needs to be at least a minimum of .600" or thicker for it to seal and not leak or slip between the bead lock rings. Occasionally some tires may have variances in the bead that are less than .600" if your bead bundle measures less than .600" you have two options.

- Exchange the tire or
- If it is a 15" wheel, Billet Specialties offers a bead lock ring set for 15" tires that measure less than .625". Use P/N 999212 (sold separately). The minimum thickness for this ring is a .472" minimum bead bundle.

Measure the entire circumference of the bead bundle on both sides of the tire with your caliper. Record the thinnest measurement you have and write it down in a decimal format. Repeat for the other side.

Next subtract .500" from your measurement. If it is .100" or larger you are good to go. If not, there is not enough "crush" and the tire will leak or slip.

Step 2

Once the bead bundle has been verified and inspected it is time to mount the tire. On a Comp Series Wheel, you will want to place the tire on the ground with the side that you want to be the back on the floor. Next push the back half of the rim into the tire. Start at an angle and work the rim into the tire. Once in - the back half is done.

Step 3

Next you will have to get the tire bead over the top of the inner bead lock ring on the front of a wheel.

Start by pushing the opposing bead into the drop center of the wheel and hold it there, the higher the better. Next use a tire iron (spoon) or two to carefully lift the opposing bead over the top of the inner bead lock ring. Slowly work your way around the tire until it is completely over the top. Some times it may be necessary to use a lubricant - if you do not have access to a tire mounting lubricant use dish washing soap such as Dawn. Do not use silicone or a petroleum-based lube as this will damage the tire and or make it slip. Tires vary on how hard or easy they are to mount and many things contribute to this such as nylon beads, steel beads, wheel width and correct tire size for the width of the rim.

Step 4

Prepare tire and hardware

Make sure there is not any rubber "flash" on the inside of the bead bundle. The bead bundle should sit nicely on the "shelf" of the bead lock ring without any excessive rubber that can fold over and interface with the seal. Trim away any flash with a sharp knife. Excessive flash can cause a leak or cause difficulty getting the bead lock ring to clamp properly.

Next, prepare the fasteners. Install washers on each fastener then apply anti-seize to the threads.

Step 5

Install Bead Lock Ring

The use of pneumatic or electric assisted tools is not recommended - if you have to use one - only start the fasteners down to touch the tire. Do not use for final tightening!

Position bead lock ring over the inner bead ring, aligning the holes with the inner ring. Install the first four bolts (finger tight) at 12, 6, 3 and 9-o'clock to engage the tire bead. Check the tire bead to ensure it is still located in the "shelf". Install the balance of the hardware only finger tight to engage the tire bead.

Step 6

Tightening procedure

Set torque wrench to 15 ft lbs. In a star pattern tighten each bolt 2-3 full turns until all fasteners have reached 15 ft lbs.

Next set torque wrench to 18 ft lbs. and repeat star pattern. Do not exceed 18 ft lbs.

Step 7

Install second bead lock ring

Repeat steps 4-5 on the other side of the tire.

Step 8

Air tire up to 20 lbs. to allow tire to seat. Finish by adjusting tire to your desired pressure. Now is a good time to make sure both tires have the same roll-out.

Re-Check Torque after first pass.