

Valve Stem Installation Procedures for Truck Wheels (MED/HVY)



ALLOY WHEEL

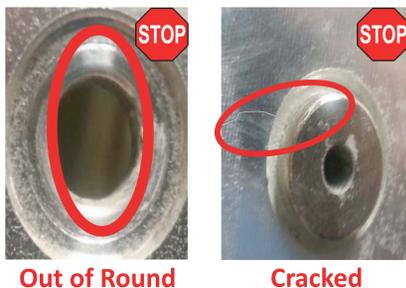


1. Inspect valve stem hole for cracks, burrs, pits or out of round. Remove burrs, debris and corrosion with a wire brush.



2. Verify that the valve stem hole diameter is $\varnothing 0.388 \pm .006$ inches, per Tire & Rim Association specifications. The Go No-Go gauge, as shown above, must go into the valve hole up to the green indicator, but not beyond.

STOP Some conditions require removing wheel from service, such as an out of round valve hole or cracks in the rim.



3. Apply a thin even coating of tire lube to the inside diameter of the wheel and face of the valve stem where the O-ring seals against the wheel. Use #2/Supra™ or equivalent rust and corrosion inhibitor grease.*



**If using 550 series valve stems with rubber grommet, grease is not required. (skip step 3).*



4. Insert valve stem into hole and finger-tighten nut. Tighten nut with a calibrated torque wrench, as shown on right, to **80-125 in-lbs.** (9-14 N·m.) and wipe excess inhibitor grease from around valve stem and nut.



Do Not Overtighten Hex Nut - Use A Calibrated Torque Wrench

Finger tightened nut + 1/2 turn = 100 in-lbs.

Finger tightened nut + 3/4 turn = 200 in-lbs.

STOP OVER STRESSED VALVE!



STEEL WHEEL

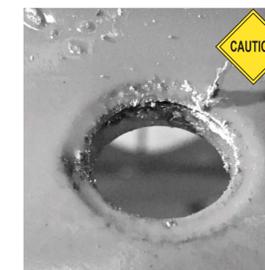


1. Inspect valve stem hole for cracks, burrs, pits or out of round. If debris or surface corrosion/rust is present, cleaning of valve hole may be required with a wire brush.

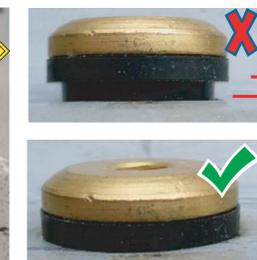
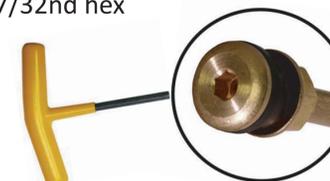


2. Verify that the valve hole diameter is $\varnothing 0.625 \pm 0.008$ inches, per Tire & Rim Association specifications. The Go No-Go gauge, as shown above, must go into the valve hole up to the green indicator, but not beyond.

STOP Some conditions require removing wheel from service, such as an out of round valve hole or cracks in the rim.



3. Insert valve stem into hole and seat the rubber grommet face against the rim. Valve stem may need to be rocked back and forth to ensure proper/tight fitment of the rubber grommet. If needed, use a 7/32nd hex wrench to fit base of valve to eliminate spinning during tightening.



4. Install washer and finger-tighten nut. Tighten nut with a calibrated torque wrench to **35-55 in-lbs.** (4-6 N·m).



Do Not Bend Valve Stem After Installation

If the application requires an angled valve stem, use a pre-bent valve stem provided by the manufacturer. Bending a valve in the rim hole can damage the grommet and result in air loss.



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