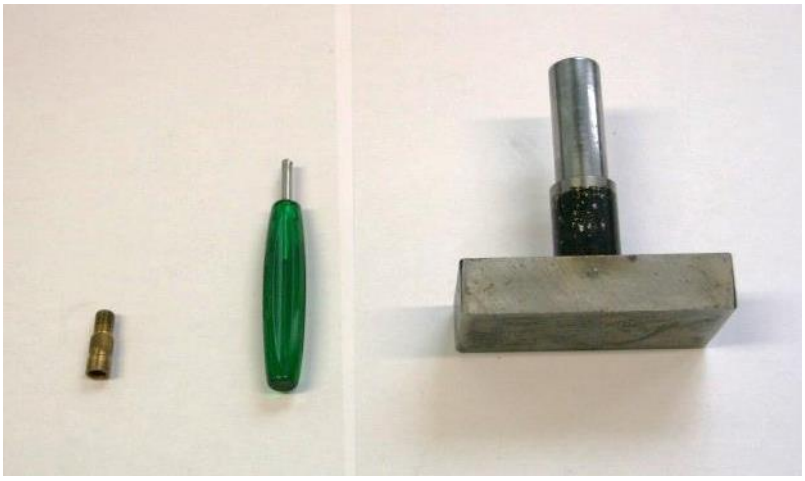
1. Necessary tools and parts

Tools:

- Valve extension (P/N 069980)
- Valve insert remover (P/N 069996)
- Mounting-Axle diameter 20 mm with clamping block for bench vice
- Pressure gauge (not presented on picture)
- Tire bead lubricant (not presented on picture)

Optional but recommended:

- Valve mounting aid (not presented on picture)
- Valve cap assembly tool (not presented on picture)



Parts:

- 3” landing wheel “Moritz” 50-20; P/N 032100 (wheel with mounted tire: P/N 032002)
- 3” tire 210x65 4PR; P/N 062094
- 3” tube 210x65; P/N 062093 (valve cap included)
- Valve tube (PVC; inner diameter 8 mm, wall thickness 1,5 mm, length 26 mm)

2. Preparation of parts

2.1. Mounting axle

Position the mounting axle with clamping block in a proper bench vice.

2.2. Tube

Place PVC tube on valve of tube.

3. Mounting of tire

Place the wheel hub on the mounting axle. The valve hole has to point upwards.

Insert the tube into the tire. To simplify the tire mounting we recommend to heat the tire in an oven (150°C, 10 minutes), that improves the smothness of the tire. After heating, insert the tube. Protective hand gloves are highly recommended.

Grease tire bead with tire bead lubricant on the valve opposed side.

Push the first tire bead, the lower one, of the tire and tube assembly onto the wheel hub. The valve has to point upwards.

Guide the valve through the valve bore, as soon as possible mount the valve extension and positionen the valve. Simultanously, the valve is secured by the valve extension from slipping out again. The tire and tube assembly can be slightly twisted against the wheel hub to achieve a valve position, which prevents the valve from protruding from the wheel hub too far.

Grease the upper tire bead with tire bead lubricant and push the tire bead onto the wheel hub.

Inflate the tire with pressurized air (4,0 bar / 58 PSI rated pressure) in a proper safety cage and sufficent safety distance. If no safety cage is available pay maximum attantion during inflation and adhere a maximum safety distance. The use of a valve extension is highly recommended. After diffusion and leakage test mount the valve cap.

4. Checks after assembly

Carry out visual inspection to proof a concentric fit of the tire on the wheel hub.

Check for unusal unbalances (static or dynamic balancing machine).

The tire and wheel assembly has to be checked if it is leakage free.

Inflate the tire with operating pressure. Check immediately, if the valve is leakage free. Place a waterdrop on the valve and observe for any bubbles.

If the valve check is passed, recheck tire pressure after 3 h. If pressure has dropped under 90% of the operating pressure, disassamble the wheel and search for any leakages, deviations and injuries. If measured pressure is above 90% operating pressure, reinflate to operating pressure and recheck after 12 hours. If tire pressure is ≥ 95% operating pressure, the wheel assembly can be accepted. Reinflate tire to operating pressure and recheck after 24 hours, if pressure is under 95 %. If tire pressure does not reach 95 % of operating pressure after 24 hours, repair or reject the wheel assembly.