

3.2.1.2. Replacing the rear rim on the Speedcity™ and Deemax® UST wheels

Tools needed:

- 1 spoke wrench
- 1 tensiometer + tension-reading conversion chart adapted to the tensiometer used.
- 1 hollow screw wrench M40630
- Oil
- Loctite® 243 type of thread lock or equivalent
- A package of hollow screws (M40595, per packet of 40)

- 1** Prepare the spokes : First put a hollow screw on the spoke head. then tighten the spoke nipple until it stops.
- 2** Start on the free wheel side.
- 3** With the rim flat, locate the valve hole and turn the rim so the bar code sticker is facing you, with the valve hole near you.
- 4** Prepare the 1st half of the free wheel side (braking spokes) :
 - 4.1** Put a spoke in the 1st hole to the right of the valve hole and tighten the hollow screw in the rim one turn, and put the spoke head in the slot inside the hub, free wheel side (the flat surface of the spoke in the axis of the slot).
 - 4.2** Repeat this procedure for all the slots inside the hub, free wheel side, 1 hole out of 4 in the rim: the first half free wheel side is ready;
- 5** Then prepare the 2nd half of the free wheel side (tractor spokes) :
 - 5.1** Put a spoke in the 3rd hole to the right of the valve hole and tighten the hollow screw in the rim one turn, and put the spoke head in the outside slot on the hub, free wheel side (the flat surface of the spoke in the axis of the slot) crossing over the 1st spokes mounted.
 - 5.2** Repeat this procedure for all the outside slots on the hub, free wheel side, 1 hole out of 4 in the rim : the 2nd half free wheel side is ready.
- 6** Turn the wheel over to prepare the 1st half on the side opposite the free wheel (tractor spokes) :
 - 6.1** Put a spoke in the 1st hole to the right of the valve hole and tighten the hollow screw in the rim one turn, and put the spoke head in the slot inside the hub on the side opposite the free wheel (the flat surface of the spoke in the axis of the slot).
 - 6.2** Repeat this procedure for all the inside slots on the hub on the side opposite the free wheel, 1 hole out of 4 in the rim : the first half on the side opposite the free wheel is ready.
- 7** Finally, prepare the 2nd half on the side opposite the free wheel (braking spokes) :
 - 7.1** Put a spoke in the 3rd hole to the right of the valve hole and tighten the hollow screw in the rim one turn, and put the spoke head in the outside slot on the hub on the side opposite the free wheel (the flat surface of the spoke in the axis of the slot) crossing over the spokes from the half.
 - 7.2** Repeat this procedure for all the outside slots on the hub on the side opposite the free wheel to build the last spokes.
- 8** Put a Loctite® 243 type of thread lock on every hollow screw and tighten each screw using the wrench M40630 (torque 5.5 Nm) ;
- 9** Put a drop of oil around each spoke nipple in the hollow screws so the nipple can turn freely in the screw.
- 10** Adjust the final tension of the wheel : 130 - 140 kg for the free wheel side of the front wheel. Since the spoke nipples are a type of ABS, it is not necessary to use thread lock.
- 11** Check the lateral and radial truing of the wheel.

