

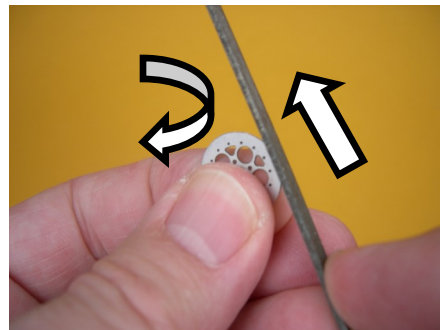
Polishing inserts:

What has worked well for me is start with 3600-12000 grit sanding cloth, with water, working up through the entire lineup of progressively finer grits. I "swirl" the insert about 15 revolutions with each grit. Dry the insert surfaces. I then "dry polish" the surface on 12000 grit cloth.

Wheel inserts are aluminum so material removal is relatively fast. Do not file perpendicular to the insert - flat spots may result

Front wheel inserts should be $\sim .557-.560$ OD when finished; rear wheel inserts should be $\sim .597-.600$ OD when finished

Trim insert from sprue - remove carefully to avoid distorting edge, file around insert to remove remaining sprue. **Note:** It may only take one round of filing to reduce the OD so it will fit inside wheel; file **around** edge while turning the insert. If you possess calipers or micrometer, measure after making one revolution - avoid removing any more material than necessary



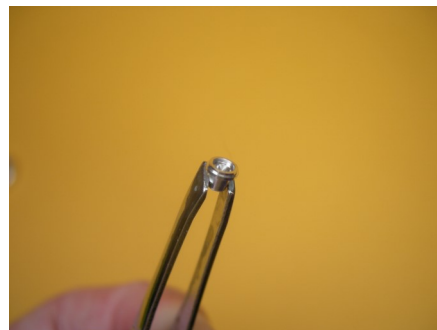
****Insert detailed face first in wheel, face out****

If insert will nearly seat on rear flange of sleeve, it can be pressed in with the flat back side of an X-acto knife. Make sure it is fully seated on flange. Follow same procedure to fit rear insert into sleeve. Align spokes by using tweezers.



When satisfied that front and back inserts line up and are seated, use super glue around joint where insert and sleeve meet.

Installing spindle boss: Front inserts have two different ID holes. The back insert is $.125$ "; "show" side insert is $.140$ ". Spindle bosses have steps machined into back side to locate in inserts. There is very little gluing surface on which to attach the boss. Avoid using excess glue to attach spindle boss to inserts.



Determining what is what: Front wheels have a "show" side, with photo etch details. While difficult to detect, AlumaStar front wheels have slight PE detail around spoke edges. Front wheel back insert will have five wheel stud holes, in case builder wishes to drill through the show side insert to make bolt on wheels. Show" side of the rear wheels includes PE details and 15 small holes located around the outer face of the wheel to simulate fasteners, or allow builder to drill and install RB Motion bolts heads, if desired. Back inserts are plain.