

BUILD-UP of INDUSTRY NINE WHEELS

- Begin with all spokes installed loosely.
- Hand tighten Drive Side (Rear)/Disc Side (Front) spokes until approximately the same number of threads are exposed on all spokes.
- Follow by hand-tightening Non-Drive/Non-Disc spokes in the same manner.
- Place wheel in truing stand.
- Use ½ to ¼ turns, then less, to make round, true, and roughly in-dish with low spoke tension.
- NOTE at this stage that adjustments to trueness also greatly affect out-of-roundness, much like a radially laced wheel.
- Once perfectly round and true, add ½ turn tension to all Drive Side (R)/Disc Side (F) spokes, then re-true and check roundness. Repeat, adding ¼ turn the second time around.
 - NOTE1: This step may cause the wheel to come radically out-of-dish, which is desired in this case.
 - NOTE2: On Singlespeed and 12x150mm DH Rear Wheels, add tension to ALL spokes in this step, roughly maintaining dish. DH rear wheels with .110" spokes may not require the second addition of spoke tension.
- Pre-stress wheel by hand-stretching parallel pairs of spokes around the wheel (EVENLY DISTRIBUTES SPOKE TENSION INEQUALITIES).
Re-true and round wheel following this step.
- Dish wheel by adding tension to all Non-Drive (R)/Non-Disc (F) spokes ¼ turn at a time. Re-true and check roundness using small (1/8-1/6 turn) increments to affected spokes. (HINT: Watch the threaded end of the spoke in the hub to minimize wind-up.)

Check Drive Side (R)/Disc Side (F) tension using DT Tensio™ or Park Tools tensiometer*.

Reading should be within the following ranges:

Spokes	DT Tensio Reading	Park Tensiometer Reading
26" on Stans Crest	2.80-3.00mm	26-28
29" on Stan's Crest	2.80-3.00mm	26-28
29" on Stans' Arch	2.80-3.00mm	26-28
26" All-Mtn	2.90-3.10mm	27-29
26" Enduro	2.90-3.10mm	27-29
26" DH .110 SPOKES	3.60-3.80mm	31-33

- The above deflections translate to 90-100 KgF on Industry Nine spokes.

*(We do not recommend the use of the WheelSmith™ tensiometer for Industry Nine spokes. This tensiometer registers outside of its range with our larger diameter spokes.)

-NOTE THAT NOT ALL SPOKES WILL BE W/IN THIS RANGE, BUT A SAMPLE OF ALL DRIVE/DISC SIDE SPOKES SHOULD RETURN >80% W/IN SUGGESTED TENSION RANGE.

-ALSO NOTE THAT FRONT SPOKE TENSION MAY FALL IN THE LOW END OF THE RANGE, WHILE DRIVE SIDE REAR SPOKES SHOULD FALL IN THE HIGH END OF THE RANGE, DUE TO GREATER DISH.

Add tension evenly, 1/8-1/4 turn at a time on all spokes, until spoke tension falls in the proper range. Maintain Trueness, Roundness, and Dish following each cycle of tension addition.