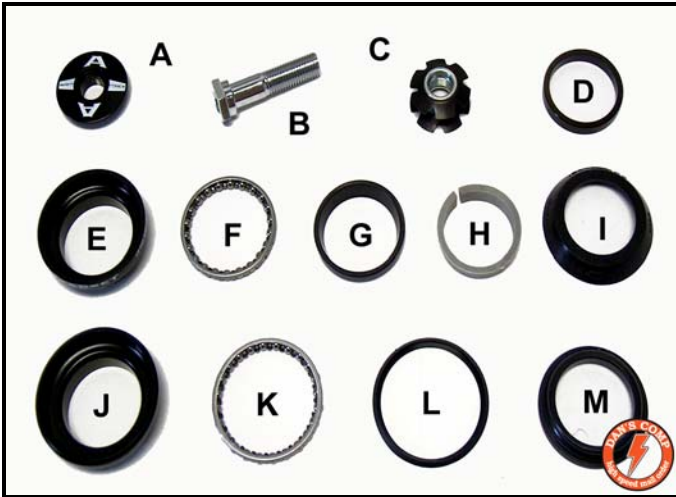


## Dia Compe Aheadset SST Steel 1-1/8 Install



### Parts

- A. Compression Cap
- B. Hollow Compression Bolt
- C. Star Nut
- D. Aheadset Spacer (*Not Included*)
- E. Upper Bearing Cup
- F. Upper Bearings
- G. Upper Bearing Race
- H. Compression Ring
- I. Upper Dust Cover
- J. Lower Bearing Cup
- K. Lower Bearings
- L. Lower Dust Seal
- M. Fork Crown Race

*Dia Compe Aheadset SST Steel 1 1/8. Part # 301003  
Aheadset Spacer 1 1/8". Part # 309045*

### Tools Needed

1. Headset Cup Press
2. Threadless Nut Setter
3. 3 Way Allen Wrench (4,5,6mm)\*
4. Hammer
5. Tapered Flat Punch
6. Adjustable Wrench\*
7. Waterproof Grease
8. Fork Crown Race Setter (*Not Pictured*)



*\* Tools used from the Professional tool kit. Part # 811110  
Park Bearing Cup Press HHP-1. Part # 811347  
Park PCS-1 Home Work Stand. Part # 811356  
Phil Wood grease 3oz. Tube. Part # 811195*



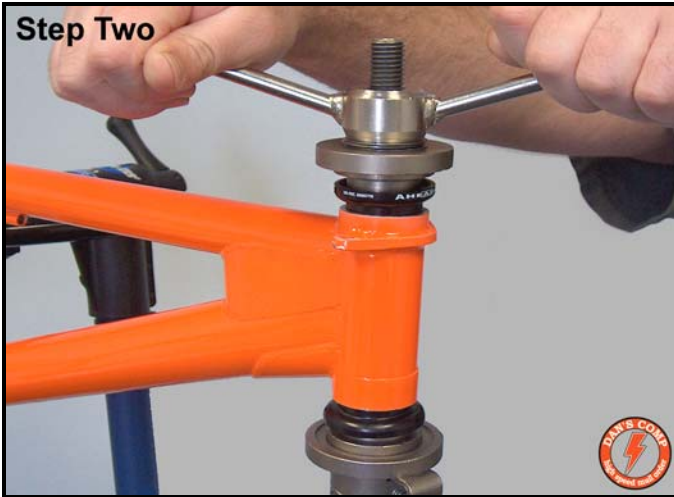
### Preparing the Frame

- If you are replacing an existing headset, be sure to remove the old bearing cups first.
- Inspect the inside surface of the head tube. Use a piece of fine sandpaper to remove any dirt, grit or paint which would prevent the bearing cups from pressing into the frame smoothly (*See Note*).
- Use a small amount of grease or light oil to lubricate the inner surface of the head tube.

*Note: It is recommended to take your frame to a local bike shop to have the headtube reamed and faced. This will help remove any excess paint from inside the headtube and will square the top and bottom surfaces, which will allow the cups to press in easier and square.*

**These instructions are to be used as a guide only. Improperly installed parts may lead to severe injury or harm. We strongly recommend that a properly trained bike mechanic handle all installations, adjustments and repairs on your bike. As always...Ride Safe!**

## Dia Compe Aheadset SST Steel 1-1/8 Install



### Installing the Bearing Cups

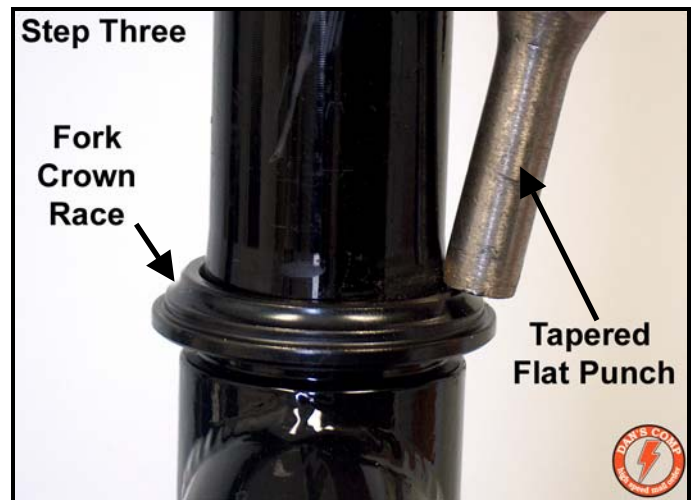
- Press the cups into the frame using a headset press. You can use a wooden mallet or a hammer and a block of wood if you do not have a headset press.
- Be sure to install the smaller cup in the top and the larger cup in the bottom.
- If the cups are pressed in completely and are straight, there should be no gap between them and the top or bottom surfaces of the headtube.
- Apply an even amount of waterproof grease into the upper and lower cups.

*Note: The bearing cups should fit tight into the frame. This prevents the bearing cups from shifting while riding.*

### Installing the Fork Crown Race

- Press the fork crown race onto the fork using a fork crown race setting tool and a hammer. You can also use a hammer and a tapered flat punch.
- Place the fork on the floor or on a workbench to support it while installing the race.
- Be careful not to damage the race by forcing it on the fork. You may need to slightly file or grind down the area in which the race needs to be installed on. Be sure to file or grind the tube evenly around.
- Make sure the race is pressed completely against the bottom of the fork. There should be no gap between the race and the bottom of fork.

*Note: The Fork Crown Race should fit tight onto the fork. This prevents the race from shifting while riding.*



### Installing the Star Nut

- Skip this step if your fork has a star nut already installed that can be used again or one that is welded in.
- Use a Threadless Nut Setter to install the star nut into the steerer tube of the fork straight and to the correct depth (*See Note*).
- Use a hammer to drive the star nut downward into the steerer tube of the fork. Hammer until the bottom of the tool make contact with the top of the steerer tube.
- The star nut must be install straight and approximately 15mm into the steerer tube of the fork. The star nut will want to slip upwards in the steerer tube if it is not installed correctly.

*Note: It is highly recommended to take the fork to a local bike shop to have the star nut installed if you do not have a Threadless Nut Setter.*

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## Dia Compe Aheadset SST Steel 1-1/8 Install

### Step Five



### Installing the Lower Bearings

- Slide the thin plastic dust seal onto the fork and seat it on the outside edge of the fork crown race. There is a recessed edge on the dust seal which faces down.
- Grease the lower bearings with a waterproof bearing grease.
- Slide the larger caged bearings over the steerer tube of the fork and seat it on the fork crown race with the ball bearings facing upwards.
- Slide the fork upward through the bottom of the headtube.

### Installing the Upper Bearings

- Grease the upper bearings with a waterproof bearing grease.
- Slide the smaller caged bearing over the steerer tube of the fork and seat it into the upper bearing cup with the ball bearings facing down.

### Step Six



### Step Seven



### Installing the Upper Bearing Race and Compression Ring

- Slide the upper bearing race over the steerer tube of the fork and place it on top of the upper bearings. The curved race faces down and seats into the bearings.
- Slide the plastic compression ring onto the fork and seat it in the recessed area of the upper bearing race. The pointed end faces down.
- Slide the upper dust cover over the top of the compression ring and upper bearing race (*See Picture*).

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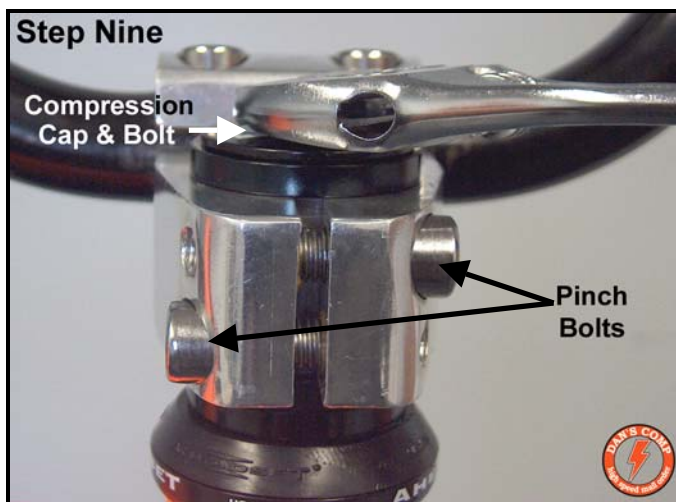
### Installing Spacers and Stem

- With the headset compressed as much as possible, place the stem next to the steerer tube to help determine how many headset spacer need to be installed under the stem.
- Slip the spacer(s) over the steerer tube and seat them on top of the upper dust cover
- Slide the stem onto the fork and slightly tighten the pinch bolts on the side of the stem. Do not tighten them completely yet.
- For proper bearing adjustment, the top of the stem must be 1/4" above the top of the steerer tube of the fork. Additional headset spacers may need to be placed under the stem to raise it. You can also place spacers on top of the stem if you do not want to raise the stem.

### Last, but not least...

- Place the compression cap onto the top of the stem or on top of the headset spacer if there are any on top of the stem.
- Thread the compression bolt into the star nut and lightly tighten until the play is removed from the headset.
- Spin the forks a few times to make sure the bearings spin freely. Do not continue to tighten the compression bolt if the bearings have no play in them and spin freely.
- Align the stem and forks and tighten the pinch bolt on the side of the stem completely.
- You may need to re-adjust the headset after an hour or two of riding.

*Note: The Compression Bolt and Cap are only used to remove the play from the bearings and not to keep the headset tight.*



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