

## Integrated Headset Install



### Parts

- A. Bearings
- B. Upper Cover
- C. Compression Ring
- D. Fork Crown Race
- E. Shim Washer *(If Included)*
- F. Compression Bolt \*
- G. Compression Cap \*
- H. Star Nut \*
- I. Headset Spacer \*

\* *Not Included and Not Pictured*

*Headset Spacer 1 1/8". Part # 309045*

### Tools Needed

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

*3 Way Allen Wrench Part # 811006*

*Park PCS-1 Home Work Stand. Part # 811356*

*Phil Wood grease 3oz. Tube. Part # 811195*



### Preparing the Frame

- 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 from seating into the frame smoothly *(See Note)*.
- Lightly grease the bearing contact surfaces 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 bearings to seat in the frame 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!**

## Integrated Headset Install

### Installing the Star Nut (if included with your headset)

- Skip this step if your fork has a star nut already installed that can be used again or one that is built-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 makes contact with the top of the steerer tube.
- The star nut must be installed 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.*



### Installing the Fork Crown Race

- Skip this step if your fork has an integrated 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 work bench to support it while installing the race.
- Remove any excess paint around the crown.
- 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 Lower Bearing

- Slide one of the bearings over the steerer tube with the angular contact facing upwards and place it on the crown race.
- Insert the fork upward through the bottom of the head tube and seat the bearing into the lower integrated area of the frame.



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### Installing the Upper Bearing and Compression Ring

- Slide the other bearing over the steerer tube with the angular contact facing down and seat it into the top integrated area of the frame.
- Slide the compression ring onto the fork and seat it in the recessed area of the upper bearing race. The pointed end faces down.

### Installing the Upper Cover

- Slide a thin shim washer (if included with your headset) over the steerer tube and place it on top of the compression ring.
- Slide the upper cover over the steerer tube and place it over the shim washer and compression ring.



### Installing Spacers

- 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 cover
- For proper bearing adjustment, the top of the stem must be  $\frac{1}{4}$ " above the top of the steerer tube of the fork.

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### Installing the Stem

- Slide the stem onto the fork and slightly tighten the pinch bolts on the side of the stem. Do not tighten them completely yet.
- 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.



### Adjusting the Headset

- 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.

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

### Last, but not least...

- 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.



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