

## Assembly Procedure Road & Gravel bike

Bike	: Stock:	Size:
Frame		
	Surface the mounting brackets of the brake calipers (Frame and Fork)	P.T. DT-5.2
	Pass the cable/electrical wire sheaths	
_	Install the rear brake caliper and pass the hose through the frame	
_	Install the derailleurs	6-8 N m
_	Tighten the LIDH if annlicable	20-25 N m
_	Install frame internal housing damper for noise reduction	
_	Install the seatnost (and Di2 hattery)	
_	Check and tighten the bolts of the accessories (frame and handlebars)	3-4 N m
_	Installing the frame protectors	
Fork		
-	Installing the front brake caliper	
-	Grease the headset bearings	
	Cut the pivot	
	M1 - Steering column height: (With cups)	mm
	M2 - Stem thickness:	mm
	M3 - Height of the spacers: (Including the headset heading)	mm
	Total Pivot Length: (M1+M2+M3)	mm
-	Clamping clearance available between the top of the steerer and the stem:	2-3 mm
-	Mounting the stem and tightening the steerer tube	5-6 N m
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Cockpi	t	
-	Mounting the handlebars and controls	6 -8 N m
-	Finalize the routing (retouching) of cables/hoses	
	Setting up the cockpit	
	Shifter Side Angle:	Degree
	Vertical angle (tilt) of shifters:	Degree
	Height of the casseroles:	mm
	Bottom Hanger Angle:	Degree
-	Bleed and <b>preload</b> the brake hydraulics	
Cranks	et	
-	Grease the bottom bracket bearings	
-	Install the bottom bracket (Pressfit = Grease / Threaded = ASC)	
-	Installing the Pedalboard	4-5 N m
-	Validate the clearance of the chainrings with the frame	
-	Tighten the left crank	15-20 N m
-	Install the pedals	20-25 N m



## Assembly Procedure Road & Gravel bike

Wheels  - Validate the wheel assembly confirmation certificate (4 criteria> 100%)  - Greasing the wheel hub bearings - Install the cassette - Installing the brake rotors - Unveiling the brake rotors on the working bench - Mount the tires on the rims with the logos aligned with the valves - Mounting the rear wheel to the frame - Align the rear brake caliper with Feeler Gauges (LR Tolerance = 0.004") - Pairing shifters and software updates - Password: - Install the chain. Chain Length: (Point 0+X) - Adjust the rear derailleur tilt - Check on gears + high and + low - Adjust the gear changes (clutch clutch if applicable) - Mounting the front wheel on the frame - Align the front brake caliper with Feeler Gauges (LR Tolerance = 0.004") - Adjust the symmetry of brake lever strokes - Install brake caliper fall arrest devices - Validate the centering of the wheels in the frame and fork  Final settings - Laser Align the Handlebar and Tighten the Stem - Install and adjust the seat height (6-8 N m) - Saddle height: - Saddle inclination: (Validate indication and/or perineal issues with the athlete) - Check that the plugs of the "bleed port" are in place - Install the bar tapes (Wrap inwards) - Install finishing tapes/sleeves and screw-on caps for bar tape - Pressurize the tires - Front:   Ib Rear: - Weighing the bike: - Test the bike on the road - Cleaning the bike	): 		Stock:		Size:		
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