

# TANGE SEIKI HEADSET

**Your New Tange Headset has been designed and machined to give you the absolutely best performance money can buy. With reasonable care it will provide miles and miles of superb service.**

## ASSEMBLY INSTRUCTIONS NOTE:

It is very important that you determine the exact sizes of the inside diameter of the head tube, the outside diameter of the steer tube, and the headset stack height before proceeding (headset stack height is the steer tube length minus head tube length). After these measurements have been made and the proper size headset parts have been acquired, assembly can begin (use of calipers for measuring is highly recommended).

### 1. INSTALLATION OF STATIONARY CONE AND BOTTOM STATIONARY CUP

To ensure proper fit, the head tube may have to be reamed using a Head Tube Reamer. Align both Stationary Cone and Bottom Stationary Cup and insert into the head tube using a Head Press Tool (refer to drawing for correct positioning). A pressure of 250-1500 Kg/cm<sup>2</sup> is recommended to compress the upper cone and the lower cup into the head tube.

### 2. INSTALLATION OF CROWN RACE CONE ONTO THE FORK STEER TUBE

Using the Crown Race Installation Tool, insert the Crown Race Cone onto the steer tube with the bearing surface facing up. If necessary mill the fork crown to fit the inside diameter of the Crown Race Cone. A pressure of 250-1500 Kg/cm<sup>2</sup> is recommended to compress the Crown Race Cone onto the fork crown.

### 3. ASSEMBLY OF FORK TO HEAD TUBE

- Apply sufficient grease to the Stationary Cone, Crown Race Cone, Adjustable Cup, Bottom Stationary Cup and Ball Retainers.
- Refer to the drawing for proper Ball Retainer positioning, and install one onto the Crown Race Cone on the fork steer tube.
- Insert the fork steer tube into the head tube.
- Assemble the Ball Retainer, Adjustable Cup, Lock Washer and Lock Nut onto the fork steer tube. Refer to the drawing for correct positioning. Make sure the Ball Retainers are always inserted with their top sides facing upwards.

### 4. ADJUSTMENT

Screw the Adjustable Cup down to a point where the fork can be turned lightly without play. Install the handlebar stem before tightening the Lock Nut. While tightening the adjustable cup, take care to ensure the Cup and Ball Retainer are always in uniform contact and be sure not to over-tighten. With the adjustable cup securely in position, assemble the washer and lock nut and tighten to a torque of 300-400 Kg/cm<sup>2</sup>.

