



INSTALLATION INSTRUCTIONS

For best results, have your PROTAPER components installed and serviced by a professional bicycle dealer. Improper installation or adjustment may weaken the components and shorten their lifespan.

If you choose to install them yourself, read and follow the instructions carefully.

- 1** Carefully examine the bars and steerer tube for any nicks or gouges as these can create stress risers and severely limit the life span of the product. Be sure there are no sharp edges where they would contact the stem clamp surfaces.
- 2** Clean all stem mating surfaces and mating parts with Isopropyl alcohol before installation.
- 3** Install headset and fork according to the component manufacturer's instructions.
- 4** Place stem and headset spacers on steerer tube. If the fork's steerer tube needs to be cut, please use: **TABLE 1, GUIDELINES FOR STEERER TUBE LENGTH**
- 5** Cut steerer tube to length. Remove any burrs from steerer tube.
- 6** Install star nut (alloy steerer tube) or compression plug (carbon steerer tube)
- 7** Re-install headset spacers and stem and tighten the top cap bolt to the headset recommendations.
- 8** Tighten the direct mount bolts or steerer clamp bolts in alternating, one turn increments. Tighten to the torque values in **TABLE 2, TORQUE TABLE**. Never exceed handlebar or fork manufacture maximum torque specification. **CAUTION:** Do not over tighten bolts. The result could damage the steerer tube, handlebar, and stem causing premature failure and possible injury. **CAUTION:** Do not apply grease, oil, or lubricant to the threads of the clamp bolts.
- 9** Install and position handlebar to desired settings. Line up the centering marks on the handlebar with the clamping area of the stem. **CAUTION:** do not twist the bar back and forth to move it through the handlebar clamp. This will gouge and scratch the bar and can significantly weaken the component.
- 10** Install the face plate.
- 10a** For the Vice and MTB stem, tighten the top two bolts completely, torque to the specified torque. Next, tighten the bottom two bolts evenly to the specified torque.
- 10b** For the ATAC stem, tighten all 4 face plate bolts evenly to the specified torque, leaving an even gap between the top and bottom of the stem and the face plate.
- 10c** For the D-Vice and Direct Mount stem, tighten the four bolts that engage with the fork crown to the specified torque. Next, tighten the two front bolts to the specified torque.
- 11** Slide the brake levers and shifters on to the handlebar. Tighten the clamps to the manufacturer's recommended torque values. **CAUTION:** Do NOT slide brake and shift levers over the bend and/or taper of the handlebar's midsection as this can shorten the life of the handlebar. **CAUTION:** ONLY clamp the shifters and levers on the 22.2mm section of the handlebar.
- 12** Install the grips and the bar end plugs to finish the installation.

TABLE 1.

GUIDELINES FOR STEERER TUBE LENGTH	
Standard Steerer Tube	Steerer should protrude or be $\leq 4\text{mm}$ below the top of the stem
Carbon Steerer Tube	Steerer should protrude from the top of the stem by 2-3mm
Dual Crown Fork	Ensure steerer protrudes above top crown face

Important: Be sure to take into account the full stack height of the stem, spacers, and headset before cutting the steerer tube. Measure twice – cut once! For all bikes, ensure that there are adequate spacers to preload headset without bottoming top cap on steerer.

TABLE 2.

TORQUE TABLE		
ITEM	TORQUE (in-lb)	TORQUE (N-m)
Direct Mount Stem Bolts	80-90	9.0-10.2
D-Vice Mount Bolts	53.1	6
D-Vice Face Plate Bolts	44.25	5
MTB Steerer Clamp Bolts	115	13
MTB Face Plate Bolts	60-70	6.8-7.9
Vice Steerer Clamp Bolts	88.5	10
Vice Face Plate Bolts	53.1	6
ATAC Steerer Clamp Bolts	53.1	6
ATAC Face Plate Bolts	44.25	5

WARNING: As with all mechanical components, the bicycle is subjected to wear and high stress. Different materials and components may react to wear, impact or stress fatigue in different ways. If the design life of the component has been exceeded, it may suddenly fail, possibly causing injuries or death to the rider.

WARRANTY

For full warranty information please visit: hayesbicycle.com/warranty