

Pre-assembly (for shipment) instructions:

1. Machine down bearing width if needed (depending on bore depth)
2. Bearing installation
  - a. Add lead in on parts: edge break bore and bearing
  - b. Clean aluminum plate bore
  - c. Pre-heat aluminum plate to 275-300F (set oven to 300-325F) for 20-30 minutes
  - d. Add a handful of drops of Loctite 609 in bearing bore w/ dropper
  - e. Drop in bearing w/ install tools... press to end w/ arbor press
  - f. Wick in Loctite 609 around perimeter of bore
  - g. Install snap ring w/ sharp side up (loaded side = sharp side)
  - h. Verify snap rings w/ go/no-go gauge
  - i. Recheck entire lot w/ go/no-go gauge + flashlight
3. Press on plastic spring centering ring
4. Test bearing motion with long extension
5. Install misalignment spacers
6. Place square nut in position
7. Run zip tie through spacers and square nut
8. Install 3x ¼-20 screws
9. Clean parts with IPA
10. Thermal deburr top/bottom dust cap
11. Break in threads on dust cap assy
12. Add oring into dust cap
13. Package
14. Ship

Package contents/BOM:

Qty	part
<u>2</u>	<u>mounting plates</u>
<u>2</u>	<u>internal retaining rings</u>
<u>2</u>	<u>3/8 square G5 nut</u>
<u>2</u>	<u>COM10T-F1 bearings</u>
<u>6</u>	<u>1/4-20 BHCS</u>
<b>2</b>	<b>soft o rings, 140, 50 duro</b>
<b>2</b>	<b>dust caps</b>
<u>2</u>	<u>spring centering rings</u>
<u>4</u>	<u>misalignment spacers</u>
1	full ass racing sticker
1	Printed instructions