PRsix GEN 1.5 STEM
INSTALLATION INSTRUCTIONS

IMPORTANT DETAILS WITHIN
TOOLS NEEDED

- Razor Blade
- 3mm, 4mm & 5mm Hex Wrench
- Torque Wrench

GEN 1.5 STEM SMALL PARTS
GEN 1.5 STEM ANATOMY

TORQUE SPECS
HEADSET AND INTEGRATED FORK SPACING

Proper installation of the headset bearings, upper headset race, headset shim spacers, and integrated fork spacers are critical to proper headset function.

- Install the lower headset bearing onto the fork with the tapered side facing up.
- Install the upper headset bearing into the top of the frame with the tapered side facing down.
- With the fork and bearings properly positioned into the frame, install the race onto the fork with the tapered side facing down into the upper bearing.
- Determine the number of integrated fork spacers needed for proper fork function. Due to the raised bevel on the bottom of the stem base, the stack of integrated fork spacers should be 3mm lower than the top of the headset race.
- If necessary, use headset shim spacers to achieve the necessary 3mm drop between the top of the headset race and the integrated fork spacers.
LOWER CRADLE MOUNTING

- Position the lower cradle at the stem length and height of your choice. Height is adjusted by using either 0, 1, 2 or 3 spacers beneath the cradle. Use the appropriate M6 x 1.0mm button head bolts for the number of spacers you choose to use to locate the lower assembly. It should engage no less than five complete turns.

- Route brake cables and Di2 wires through the lower cradle cable ports according to the cable routing guides below.

- It may be helpful to loosely position one of the M5 x 0.8mm clamp spacer bolts to prevent the lower cradle from turning while tightening the M6 x 1.0mm button head bolt to 4Nm. Once properly torqued, remove the loose small bolt that aided alignment.
HANDLEBAR MOUNTING

- Position the handlebar into the properly torqued lower cradle.
- Install the top clamp with the proper length M5 x 0.8mm bolts.
- The rear clamp bolts will be considerably longer as they reach through the entire assembly and thread into the stem. The front clamp bolts reach through the top clamp only and thread into the lower cradle. All bolts should be engaged by no less than five complete revolutions (threads).
- Make final handlebar position adjustment and evenly torque the clamp bolts to the handlebar manufacturers specified torque specifications.

TRAVEL NOTE

For breakdown, packing and travel, we suggest only removing the four M5 x 0.8mm bolts holding the top clamp, and only removing the handlebar. We do not suggest removing the stem. If packing into an ordinary cardboard bike box from your dealer, it will be necessary to remove both wheels from the bike and properly brace/pad the frame and fork dropouts. Your wheels should be packaged separately.