

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 entry and bearing ***test: is this still needed?***
 - b. Sand/deburr snap ring groove if burrs are present
 - c. Clean aluminum plate bore
 - d. Prep bearing orientation: Install smaller outer race ID towards me and bigger outer race ID into the mount (rebound force > compression force so we want more outer race support downwards)
 - e. ***Test: add light coat of retaining compound to bearing if it doesn't contaminate snap ring groove***
 - f. Pre-heat aluminum plate to 275-300F (set oven to 300-325F) for 20-30 minutes ***Test: try to minimize assembly temp for more retaining compound time***
 - g. Add a handful of drops of Loctite 609 in bearing bore w/ dropper
 - h. Drop in bearing w/ install tools... press to end w/ arbor press
 - i. Wick in Loctite 609 around perimeter of bore
 - j. Install snap ring w/ sharp side up (loaded side = sharp side)
 - k. Verify snap rings w/ go/no-go gauge
 - l. 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. Install masking funnel and spray a light coat of dry film lube to prevent rust
7. Place square nut in position
8. Run zip tie through spacers and square nut
9. Install 3x 1/4-20 screws
10. Clean parts with IPA
11. Thermal deburr top/bottom dust cap
12. Break in threads on dust cap assy
13. Add oring into dust cap
14. Package
15. 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>
2	soft o rings, 140, 50 duro
2	dust caps
<u>2</u>	<u>spring centering rings</u>
<u>4</u>	<u>misalignment spacers</u>
1	full ass racing sticker
1	Printed instructions

