

Installation of Steering Components

Job code	IP-20230124
Summary	The purpose of this job is to install steering components.
Work type	Structure
Role	C202214
Expected time	20
Work cell	30
Previous job	IP-20230123
Next job	IP-20230125
Work order	-
Revision	A

PREREQUISITES

CAUTION: This job may involve working with dangerous materials. Use all necessary safety equipment. Ensure that all materials, parts, and assemblies are installed according to the instructions, specifications, plans, and procedures. Only qualified personnel should perform certified tasks.

PARTS LIST

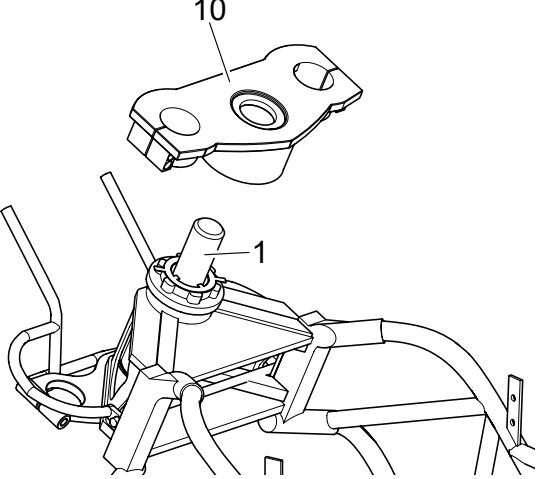
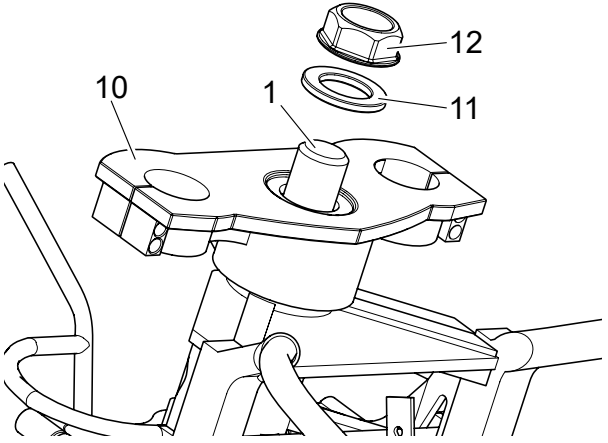
Part number/ Alternative part number	Description	Quantity
C3D-12110-E01	Stem	1
C3D-12310-E01	Seal	1
C3D-12127-E01	Bushing	1
C3D-12128-E01	Lower Seal	1
C3D-12126-E01	Bearing	1
C3D-12124-E01	Bearing	1
C3D-12125-E01	Upper Seal	1
C3D-12122-E01	Dust Seal	1
C3D-12123-E01	Fix Washer	1
C3D-12201-E01	Top Bridge	1
C3D-12121-E01	Washer	1
C3D-12120-E01	Steering Mounting Nut	1
C3D-70312-E01	Bolt	4
C3D-21200-E01	Front Fork Assy Right	1
C3D-21100-E01	Front Fork Assy Left	1
C3D-70012-E01	Bolt Flange	2
C3D-70512-E01	Bolt	2
C3D-12210-E01	Control Arm Left	1
C3D-12220-E01	Control Arm Right	1
C3D-21221-E01	Nut Cap Fork	2

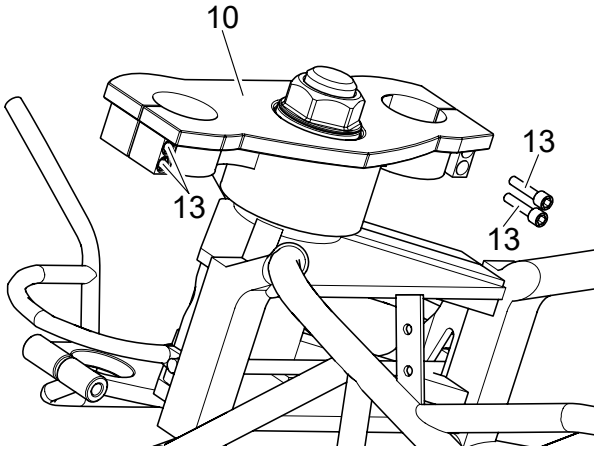
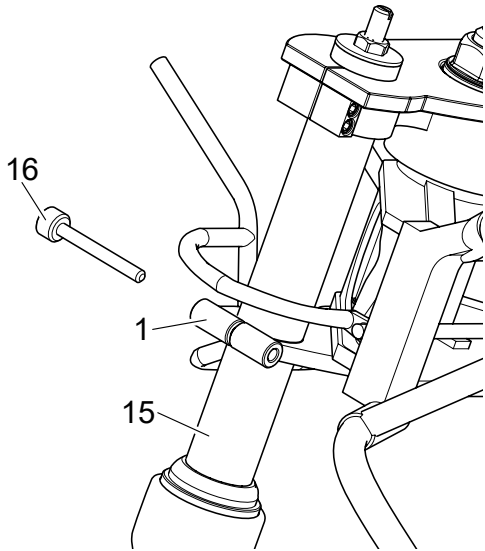
RESOURCES

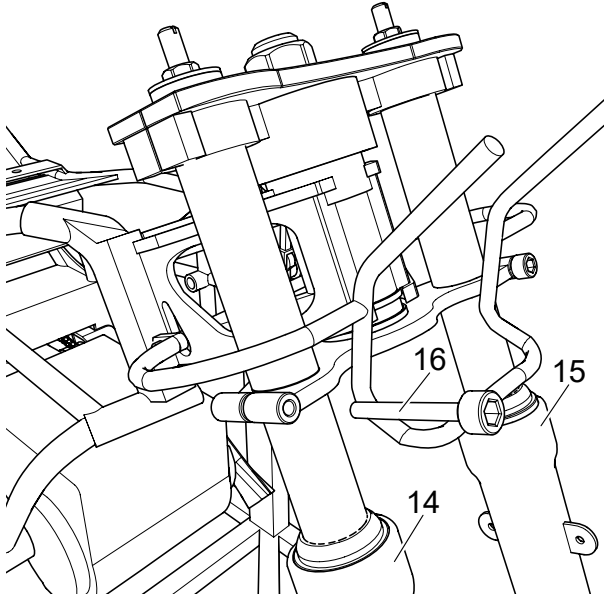
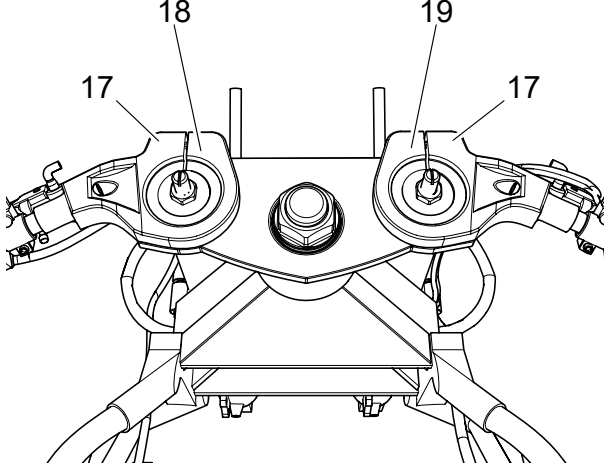
Part number/ Alternative part number	Description	Quantity
RIGT18TT15-01	Jack	1
K100TT111-01	Dynamometric Key	1
0000000-01	Dry Cloth	As Required

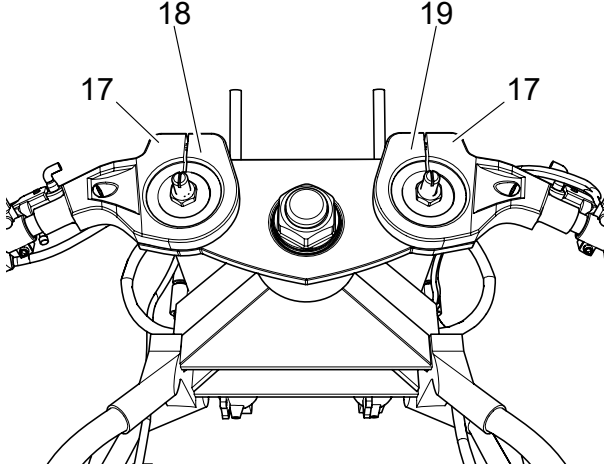
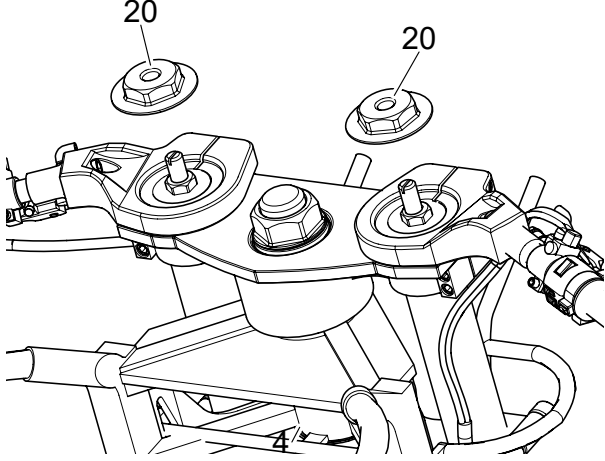
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№	Task	Illustration
1	<p>CAUTION</p> <p>Securely fasten the vehicle to prevent it from falling.</p> <p>Apply grease to the Stem (1). Install the Seal (2), the Bushing (3), and the Lower Seal (4) on the Stem (1). Grease the Bearing (5) and install it onto the Stem (1). Install the Stem (1) into the frame.</p>	<p style="text-align: center;">Figure 1</p>
2	<p>Grease the Bearing (6) and install it onto the Stem (1). Install the Upper Seal (7). Install the Dust Seal (8) and the Fix Washer (9).</p>	<p style="text-align: center;">Figure 2</p>

№	Task	Illustration
3	Install the Top Bridge (10) onto the Stem (1).	 <p data-bbox="1139 913 1238 943">Figure 3</p>
4	Install the Washer (11) and tighten the Steering Mounting Nut (12) with a torque wrench to 95-100 N·m. <div data-bbox="220 1120 850 1279" style="border: 1px solid blue; padding: 5px;">NOTE Wipe off any excess grease with a dry cloth.</div>	 <p data-bbox="1139 1644 1238 1673">Figure 4</p>

№	Task	Illustration
5	Install the four Bolts (13) into the Top Bridge (10) without tightening.	 <p data-bbox="1139 909 1238 943">Figure 5</p>
6	Install the Left Front Fork Assy (15) into the Top Bridge and screw in the Flange Bolt (16) onto the Stem (1) .	 <p data-bbox="1139 1637 1238 1671">Figure 6</p>

Nº	Task	Illustration
7	Install the Right Front Fork Assy (14) into the Top Bridge and screw in the Flange Bolt (16) onto the Stem .	 <p style="text-align: center;">Figure 7</p>
8	Tighten the Flange Bolt (16) on the right side of the Stem to 28 N·m and the Bolts on the right side of the Top Bridge to the recommended torque of 22 N·m.	
9	Tighten the Bolts on the left side of the Top Bridge to the recommended torque of 22 N·m and the Flange Bolt (16) on the left side of the Stem to 28 N·m.	
10	Install the Left Handlebars (18) and the Right Handlebars (19) and screw in the Bolts (17) by hand.	 <p style="text-align: center;">Figure 10</p>

№	Task	Illustration
11	<p>Adjust the position of the Handlebars (18, 19) and tighten the Bolts (17) to the recommended torque of 22 N·m.</p> <div data-bbox="220 389 850 551" style="border: 1px solid blue; padding: 5px;"><p>NOTE</p><p>Make sure the handlebar grips are in the same position on both sides.</p></div>	 <p data-bbox="1134 913 1244 943">Figure 11</p>
12	<p>Install the Nut Caps (20) on the right and left side of the Front Fork Tubes and tighten them with a torque of 18-20 N·m.</p> <div data-bbox="220 1122 850 1350" style="border: 1px solid orange; padding: 5px;"><p>CAUTION</p><p>Inspect and witness the application of run-on torque and final torque according to the engineering drawing or document requirements.</p></div>	 <p data-bbox="1134 1644 1244 1673">Figure 12</p>