

# Installation of Steering Components

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

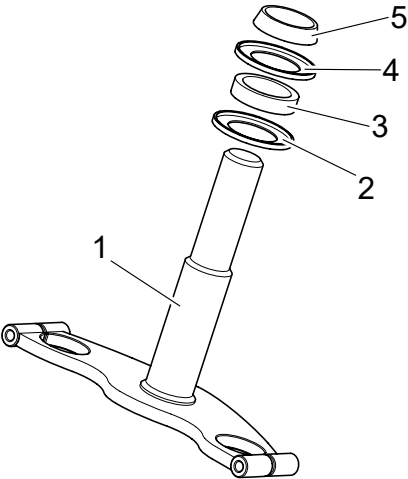
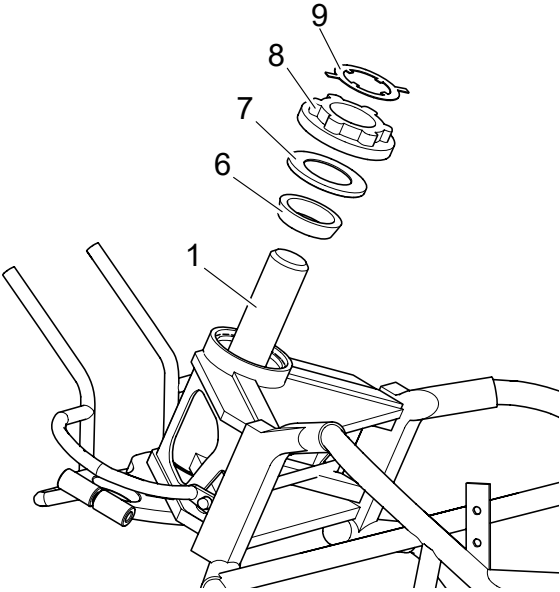
## PARTS LIST

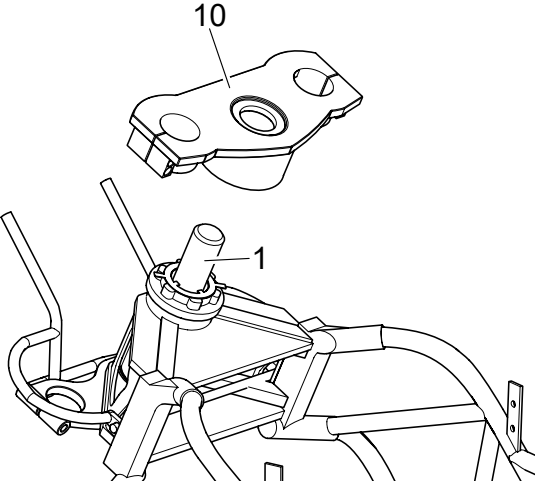
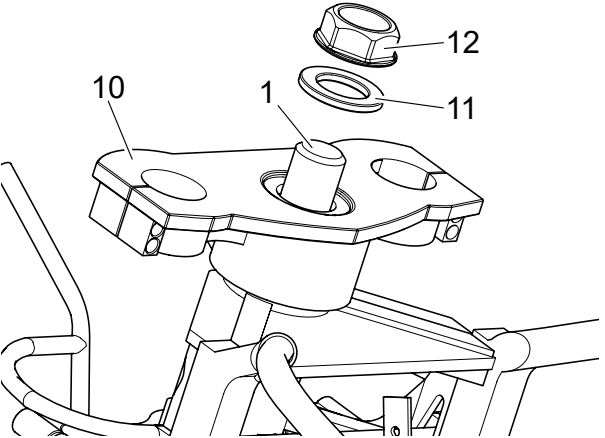
Part number/ Alternative part number	Description	Quantity
C3D-12110-E01	Stem	1
C3D-12310-E01	Seal	1
C3D-12127-E01	Bushing	1
C3D-12128-E01	Lower Seal	1
C3D-12126-E01	Bearing	1
C3D-12124-E01	Bearing	1
C3D-12125-E01	Upper Seal	1
C3D-12122-E01	Dust Seal	1
C3D-12123-E01	Fix Washer	1
C3D-12201-E01	Top Bridge	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

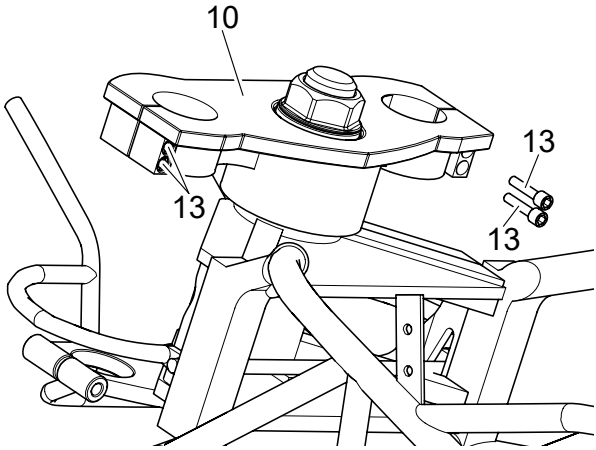
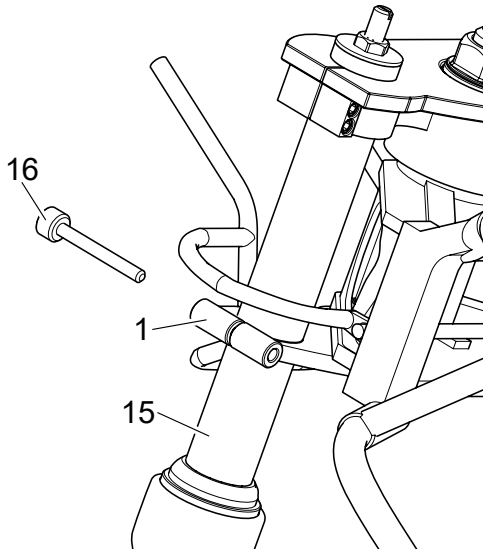
## RESOURCES

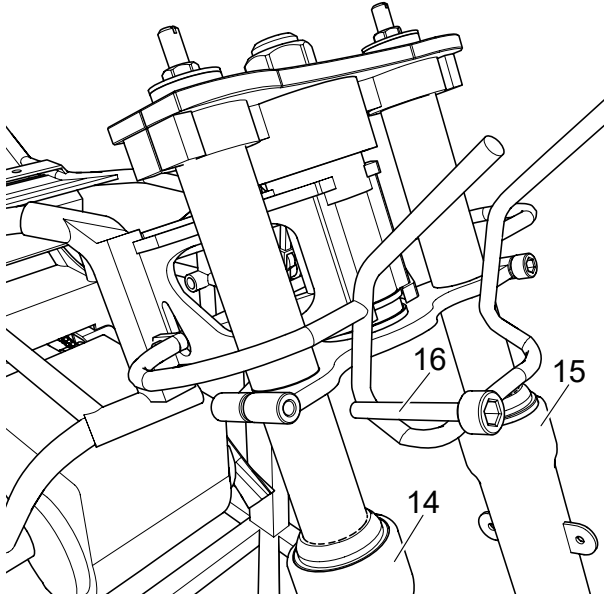
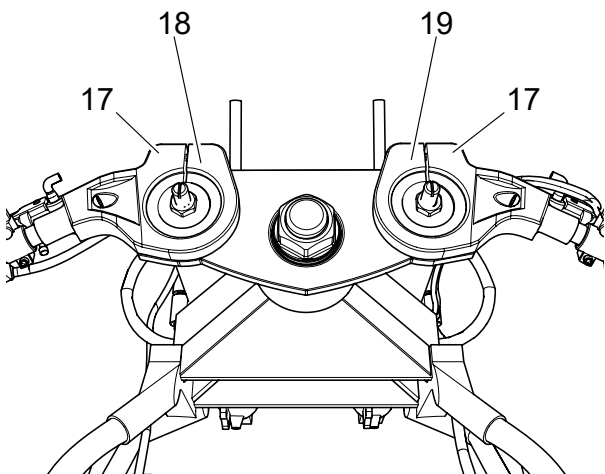
Part number/ Alternative part number	Description	Quantity
RIGT18TT15-01	Jack	1
K100TT111-01	Dynamometric Key	1
0000000-01	Dry Cloth	As Required

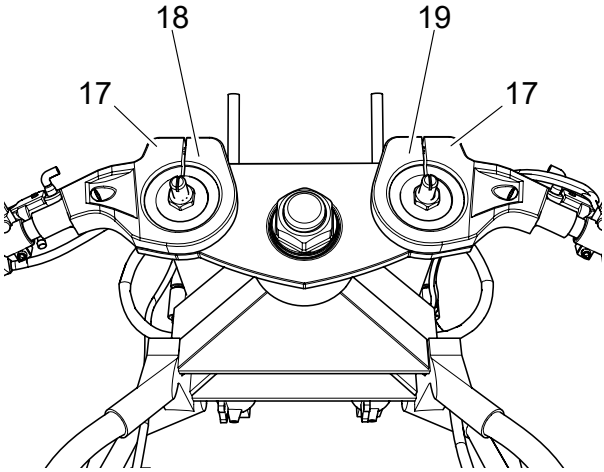
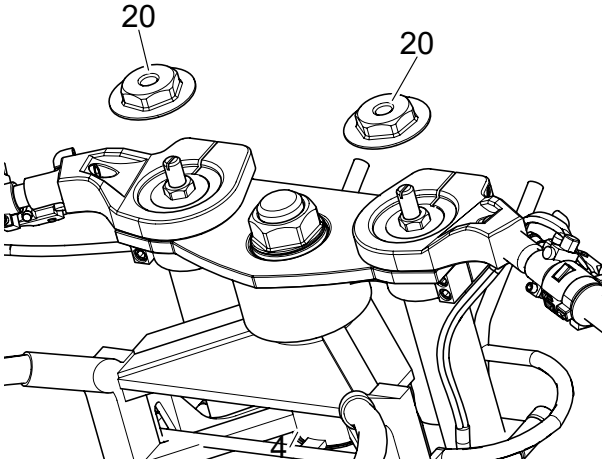
## Installation of Steering Components

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

№	Task	Illustration
3	Install the <a href="#">Top Bridge</a> (10) onto the <a href="#">Stem</a> (1).	 <p data-bbox="1141 909 1238 943">Figure 3</p>
4	<p data-bbox="217 992 855 1093">Install the <a href="#">Washer</a> (11) and tighten the <a href="#">Steering Mounting Nut</a> (12) with a torque wrench to 95-100 N·m.</p> <div data-bbox="217 1115 855 1279"><p data-bbox="233 1149 320 1182"><b>NOTE</b></p><p data-bbox="296 1200 775 1267">Wipe off any excess grease with a dry cloth.</p></div>	 <p data-bbox="1141 1637 1238 1671">Figure 4</p>

№	Task	Illustration
5	Install the four <a href="#">Bolts</a> (13) into the <a href="#">Top Bridge</a> (10) without tightening.	 <p data-bbox="1142 909 1238 943">Figure 5</p>
6	Install the <a href="#">Left Front Fork Assy</a> (15) into the <a href="#">Top Bridge</a> and screw in the <a href="#">Flange Bolt</a> (16) onto the <a href="#">Stem</a> (1) .	 <p data-bbox="1142 1637 1238 1671">Figure 6</p>

№	Task	Illustration
7	Install the <a href="#">Right Front Fork Assy</a> (14) into the <a href="#">Top Bridge</a> and screw in the <a href="#">Flange Bolt</a> (16) onto the <a href="#">Stem</a> .	 <p data-bbox="1141 907 1236 940">Figure 7</p>
8	Tighten the <a href="#">Flange Bolt</a> (16) on the right side of the <a href="#">Stem</a> to 28 N·m and the <a href="#">Bolts</a> on the right side of the <a href="#">Top Bridge</a> to the recommended torque of 22 N·m.	
9	Tighten the <a href="#">Bolts</a> on the left side of the <a href="#">Top Bridge</a> to the recommended torque of 22 N·m and the <a href="#">Flange Bolt</a> (16) on the left side of the <a href="#">Stem</a> to 28 N·m.	
10	Install the <a href="#">Left Handlebars</a> (18) and the <a href="#">Right Handlebars</a> (19) and screw in the <a href="#">Bolts</a> (17) by hand.	 <p data-bbox="1141 1892 1236 1926">Figure 10</p>

№	Task	Illustration
11	<p>Adjust the position of the Handlebars (18, 19) and tighten the <a href="#">Bolts</a> (17) to the recommended torque of 22 N·m.</p> <div data-bbox="220 387 850 551"><b>NOTE</b> Make sure the handlebar grips are in the same position on both sides.</div>	 <p data-bbox="1134 909 1244 943">Figure 11</p>
12	<p>Install the <a href="#">Nut Caps</a> (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 1120 850 1350"><b>CAUTION</b> Inspect and witness the application of run-on torque and final torque according to the engineering drawing or document requirements.</div>	 <p data-bbox="1134 1637 1244 1671">Figure 12</p>