

# **Assembly Manual**

## **-1 Piece Stem-**

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# Foreword

Dear Customer,

be sure to read this assembly manual carefully, keep it safely and follow all of the steps it describes.

If you have any further questions or have not quite understood certain points, you should contact a specialist bicycle mechanic for your own safety.

Carefully read this guide in its entirety before your first ride and keep it close to your bicycle so that it is always available. If you lend your bicycle to a third party, please give them this manual along with the bicycle.

## Safety Instructions

This operating manual contains four different types of pointers

One providing important information about your new bicycle component and how to use it, a second referring to possible damage to property and the environment, and a third type warning against potential falls and serious damage, including physical injury. The fourth pointer helps you to apply the proper torque so the parts don't loosen or break.

When you see these symbols, there is always a risk that the described danger may occur.

The text which the warning covers always has a grey background.

The warnings break down as follows:



### **Note**

This symbol provides information about how to use the product or highlights specific parts of the operating instructions that are particularly important.



### **Attention**

This symbol warns of misuse which could result in damaging the product or the environment.



### **Danger**

This symbol indicates possible dangers to your health and life that could arise if specifications or appropriate care is not taken.



### **Important bolted connection**

Precise torque must be applied here when tightening. To find out the correct tightening torque, you can either look on the bike part itself or in the tension values which are found in this manual. In order to apply a precise torque, you must use a torque wrench. If you don't have a torque wrench, contact an expert. Parts which do not have the correct torque could fall off or break! This may result in severe falls and injuries.

# Intended Use



## Dangers of improper use

Only use your bicycle component for its intended use. This also includes adherence to the operating, servicing and maintenance conditions that are described in this manual. Inform other users of the intended use and the dangers of not adhering to it. Improper use, overloading and lack of maintenance may lead to accidents and falls involving severe injuries to you and other people!



If you want to use the 1 Piece Stem with other handlebars you should consider with your Handlebars Manufacturer whether the handlebar is allowed to be used with our 1 Piece Stem or not.



Permitted total weight:  
**120 kg** (Rider's weight + Bicycle weight + Baggage weight)

The 1 Piece Stem is categorised as a category 5 component.

If your bicycle is equipped in line with national law, the following is permitted:

- Bicycle parts of **category 5** -inspired by ASTM F2043-13 / category 5- can be used on public roads and off-road.
- **Category 5** is a set of conditions for operation of a bicycle that includes extreme jumping or downhill grades on rough trails at speeds in excess of 40 km/h (25 mph); or a combination thereof.
- Appropriate protective equipment (full-face helmet, full-finger gloves, protectors) should be worn.
- Manufacturers and dealers are not liable for damage resulting from use outside of intended use. This applies particularly to damage resulting from non-adherence to the safety instructions, e.g., in terms of carrying excess weight and / or making improper repairs to defects.

# Legal regulations



Before riding your bicycle on public roads or private property, you should inform yourself about the applicable national regulations in your specific country. This section provides information on how the bicycle has to be equipped to be permitted to participate in public road traffic or on private property.

# Assembly

Remove the protective packaging material.



Dispose of the packaging material properly and according to regulations at an appropriate disposal site.



1. Wear suitable protective clothing, protective gloves and protective goggles during all installation and maintenance work.

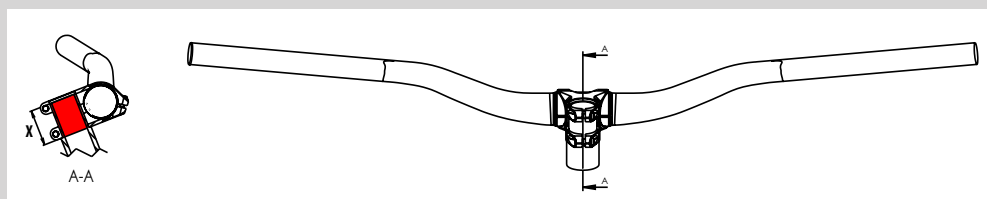


2. Be sure to check that all bolted connections and fasteners are securely fixed after assembly and adjustment.

**!NEVER RIDE WITH A LOOSE STEM OR HANDLEBAR!**

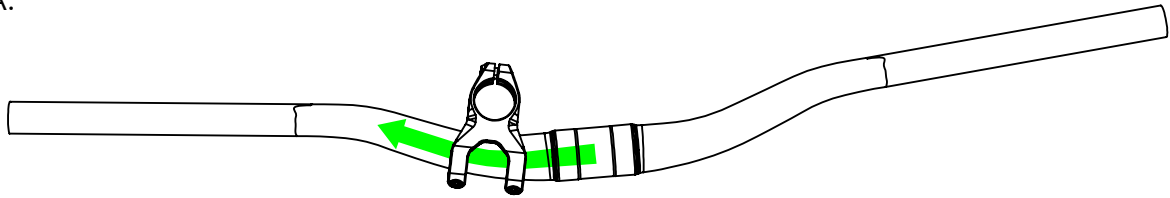
In case of a crash inspect your stem and handlebar. Please contact us if you have any doubt that the stem or handlebar is in good condition. Do not ride your bike with broken or defective components!

3. Steerer tube clamping area must be at least 39 mm/1.54" (X) long. Clamping areas must be clean and free of grease.

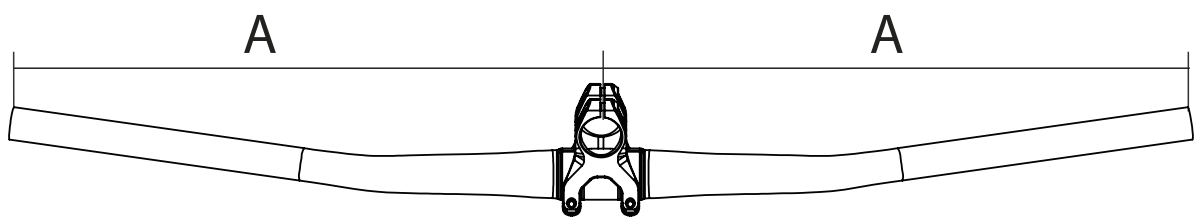


1. Loosen handlebar clamping and steerer tube clamping bolts.
2. Carefully slide handlebar into the 1 Piece Stem (A) and center it (B) A=A. Make sure not to scratch the handlebars surface.

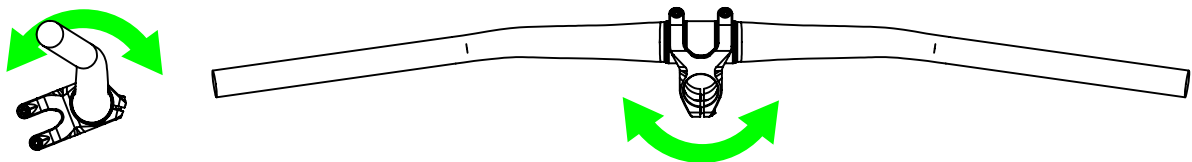
A:



B:



3. Tighten handlebar clamping bolts (M5x15) slightly.
4. Install stem and handlebar unit onto your steerer tube and add spacers if needed. For alloy steerer tube slightly grease. For carbon fiber steerer tube use carbon friction paste.
5. Install the top cap and tighten it until the head set is free of play. Angle and align your handlebar until it is comfortable and in line with your front wheel.





6. Tighten all screws using a torque wrench.



Tighten handlebar clamping **5-6 Nm / 3.7-4.5 ft-lbf**  
Tighten steerer tube clamping **6-8 Nm / 4.5-5.9 ft-lbf**



Ensure that your carbon fiber steerer tube can be tightened with a torque of **6-8 Nm / 4.5-5.9 ft-lbf**.

## Maintenance



Do not use chemical cleaner.

Regularly inspect the stem for all kind of damages. If you find any damage or change in the appearance of the stem, do not ride with it anymore. First ask a specialist bicycle mechanic or 77designz for assistance.

# Legal disclosure

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