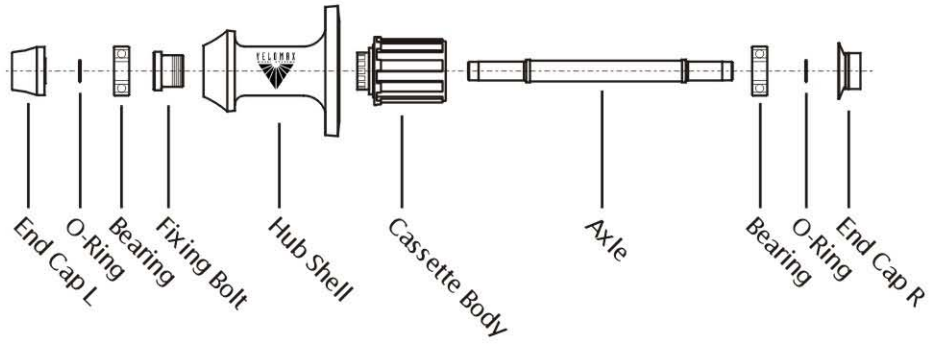
Technical Manual

Circuit Rear Hub Disassembly / Assembly

EXPLODED VIEW



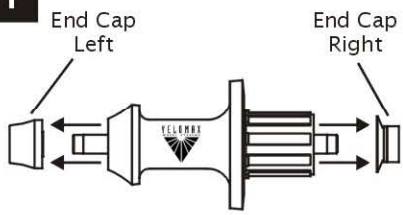
TOOLS/SUPPLIES REQUIRED:

- Needle Nose Pliers
- Plastic Mallet
- Velomax Bearing Drifts (2 SILVER)
- Waterproof Grease
- 12mm Hex Wrench
- Quick Release Skewer
- Loctite Green 638 (alternates: 609, 603, 620)

DISASSEMBLY

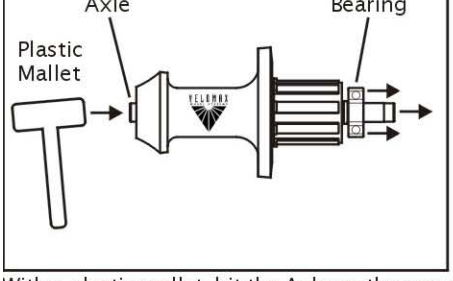
Read instructions through before starting

1



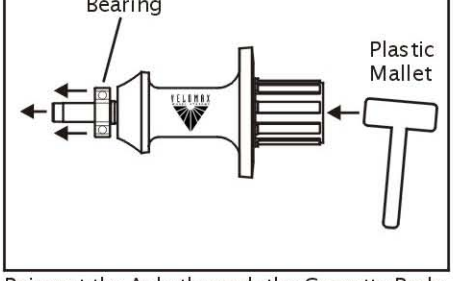
Remove the End Caps by hand.

2



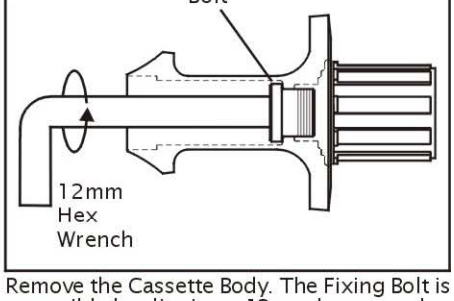
With a plastic mallet, hit the Axle on the non-drive side to drive the Bearing out of the Cassette Body.

3



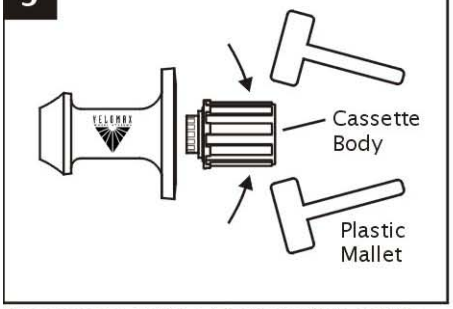
Reinsert the Axle through the Cassette Body and drive the non-drive side Bearing out of the Hub.

4



Remove the Cassette Body. The Fixing Bolt is accessible by slipping a 12mm hex wrench through the Hub Shell. Unscrew the Fixing Bolt and Remove the Cassette Body.

5



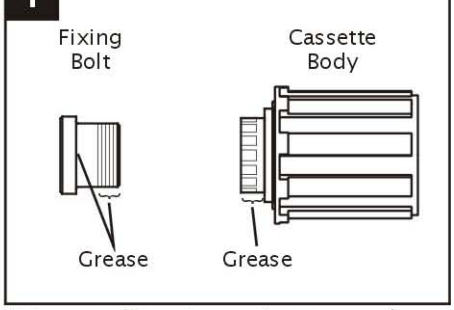
If necessary, using a plastic mallet, gently tap the Cassette Body on alternate sides until it works loose. DISASSEMBLY is now completed.

ASSEMBLY

Read instructions through before starting

Before starting, make sure all surfaces are free of grease, oil or contaminants.

1

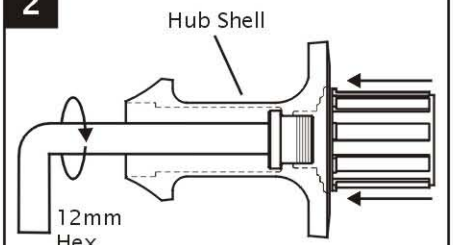


Using a quality waterproof grease, apply a thin film to the splines on the Cassette Body and the threads and seat of the Fixing Bolt.

Technical Manual

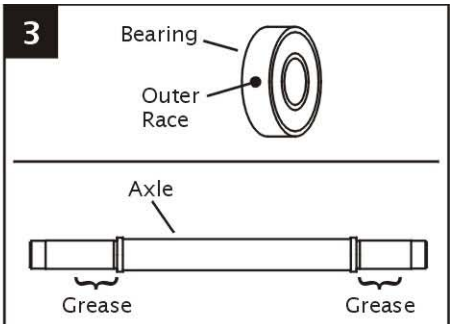
Circuit Rear Hub Disassembly / Assembly

2



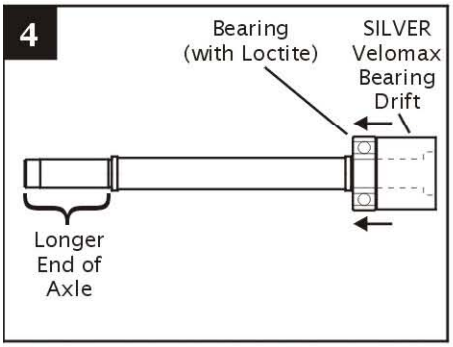
Slip the Cassette Body into the Hub Shell. Using a 12mm hex wrench, insert the Fixing Bolt through the non-drive side of the Hub Shell and tighten firmly (24 ft-lbs torque).

3



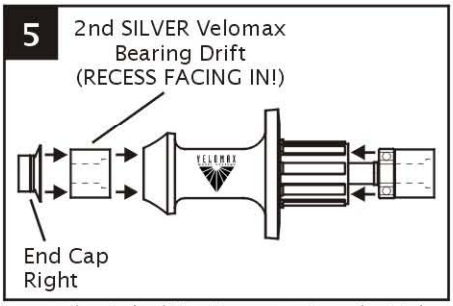
Apply a thin film of grease to the bearing seat sections of the Axle. Apply a thin coat of Loctite 638 (or alternate) to the outer race of ONE of the Bearings.

4



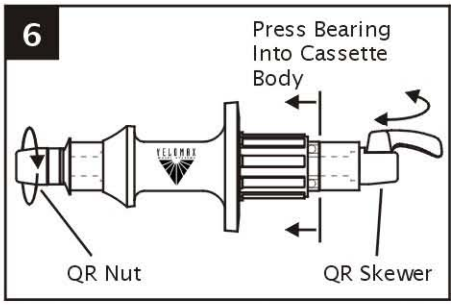
Slip the coated Bearing onto the shorter of the Axle ends. Slip the SILVER Velomax Bearing Drift onto the Axle with the recess side of the Drift facing OUT.

5



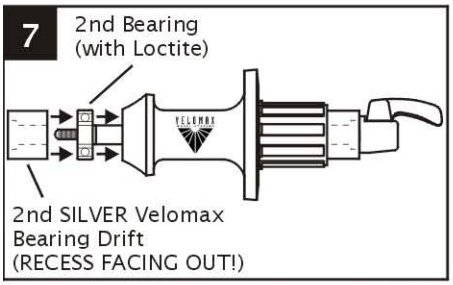
Insert the Axle / Bearing assy. into the Hub through the Cassette Body. Slip the other SILVER Bearing Drift into the Hub on the non-drive side. IMPORTANT - The recess on this Drift MUST BE FACING INTO THE HUB SHELL. Place the rubber flanged End Cap against the Drift (it acts as a spacer).

6



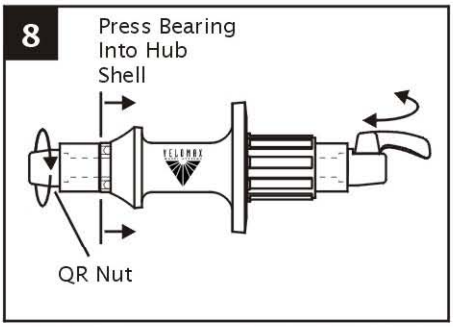
Slip a quick release skewer through the Axle / Drift assy. With the QR lever open, tighten the QR nut onto the skewer. Close the lever to press the Bearing into the Hub. Open the lever and tighten the QR nut again. Repeat until the Bearing is FULLY bottomed into the Cassette Body.

7



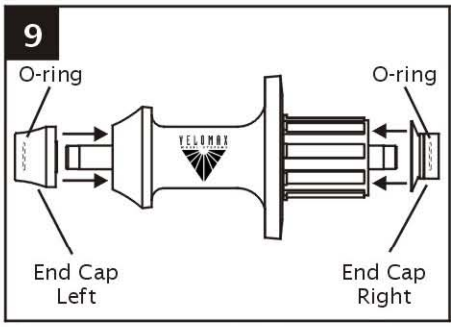
Release the QR Lever and remove the QR nut and Bearing Drift from the non-drive side of the Hub Shell. Apply a thin film of Loctite 638 (or alternate) to the 2nd Bearing and slip it onto the Axle, lining it up with the Hub's bearing bore. Place the 2nd Bearing Drift against the Bearing. **IMPORTANT - The recess in this Drift MUST NOW FACE OUT!**

8



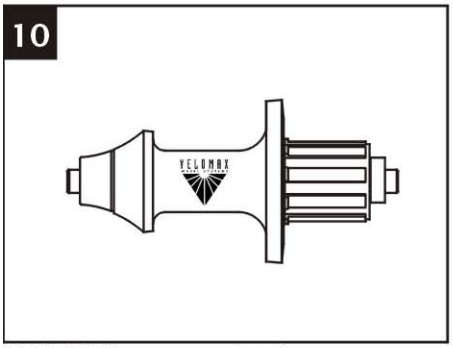
With the QR lever open, tighten the QR nut onto the skewer. Close the lever to press the Bearing into the Hub. Open the lever and tighten the nut again. Repeat until the Bearing is FULLY bottomed into the Hub Shell. Remove the QR skewer.

9



Wipe away any excess Loctite around the Bearings. Look inside each End Cap to make sure there is an O-ring installed. If disassembled or missing, use a ball point pen or tweezers to install the O-ring. Slip the End Caps onto the ends of the Axle by hand.

10



ASSEMBLY is now completed.

To make sure that everything was done right, check the following:

1. Push on alternate sides of the Axle. If there is any play, then the Bearings are installed wrong.
2. Make sure the Bearings are fully bottomed.
3. Clamp the wheel into the bicycle frame dropouts. Spin the wheel with the QR open. As the wheel is spinning, tighten the QR. If the wheel slows down quickly, then the Bearings are installed wrong.