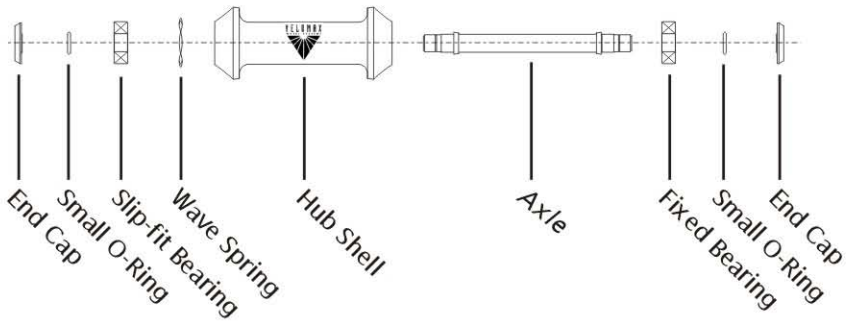
Technical Manual

R2 Front Hub Disassembly / Assembly

EXPLODED VIEW



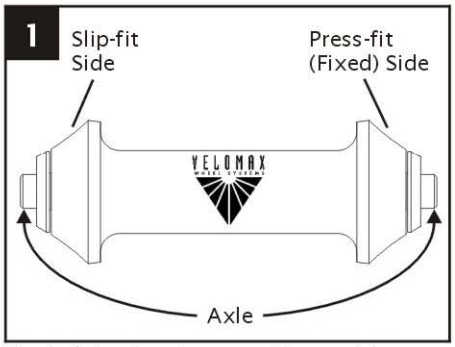
TOOLS/SUPPLIES REQUIRED:

- Needle Nose Pliers
- Plastic Mallet
- Velomax Bearing Drifts (1 BLACK and 1 RED)
- Waterproof Grease
- Quick Release Skewer (front)
- Loctite Green 638 (alternates: 609, 603, 620)

DISASSEMBLY

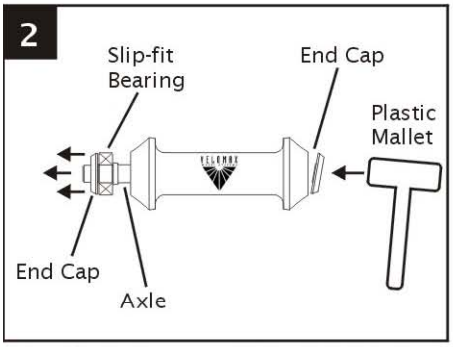
Read instructions through before starting

1



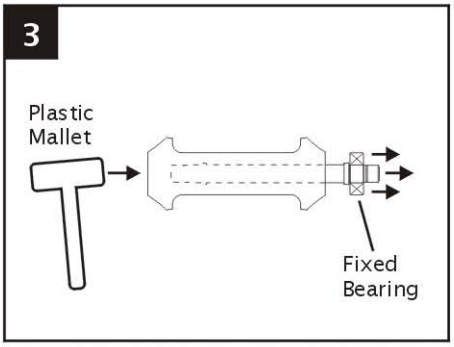
The hub has bearings on either end, however, one is a slip fit while the other is a press fit. Using the Velomax logo as a guide, the press fit bearing is usually (but not always!) On the same side as the letter "X".

2



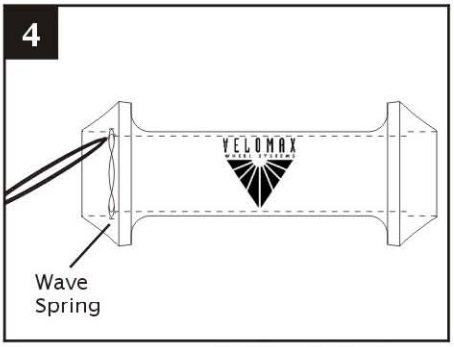
Using Plastic Hammer, hit the Axle into the hub on the "X" (press fit) side. This will drive out the Slip-fit Bearing and End Cap on the other side. *Hint - you may need to pry off the end caps to get the bearing all the way out.*

3



Reinsert the Axle (without bearing) into the Hub and use the Plastic Hammer to drive the Press-fit Bearing from the Hub Shell.

4



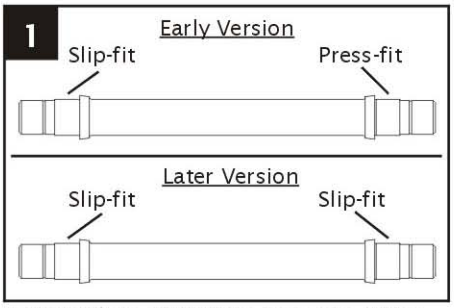
If necessary, remove the Wave Spring by using tweezers or needle nosed pliers to pull the spring from its groove. *Note: The Wave Spring is intentionally cut.* DISASSEMBLY is now completed.

ASSEMBLY

Read instructions through before starting

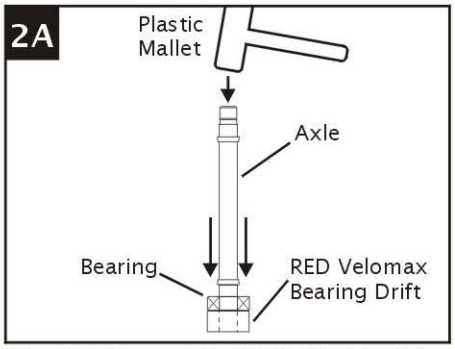
Before starting, make sure all surfaces are free of grease, oil or contaminants.

1



Early versions of R2 Hubs had axles with a press-fit side and a slip-fit side. Later versions are slip fit on both sides. Try to slip a bearing onto both sides of the Axle. If one side will not go all the way on, proceed to Step 2A. If both sides slip on, proceed to Step 2B.

2A

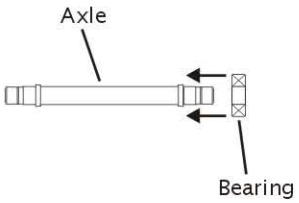


Slip a bearing onto the PRESS FIT side of the Axle. Slip the RED Velomax Bearing Drift against the bearing. Using the Plastic Hammer, drive the Axle into the bearing until it is FULLY SEATED. Skip to Step 3.

Technical Manual

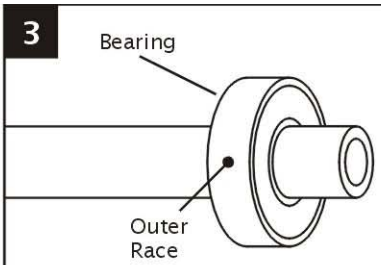
R2 Front Hub
Disassembly / Assembly

2B



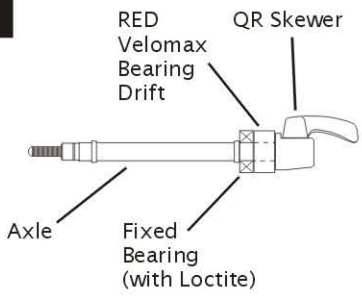
Slip a bearing onto the Axle end.

3



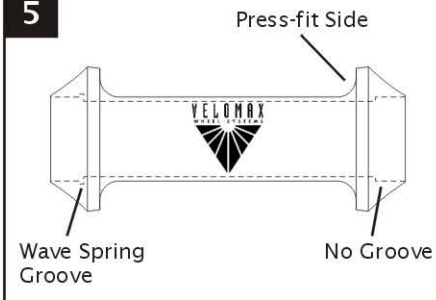
Apply a thin coat of Loctite to the outer race of the bearing.

4



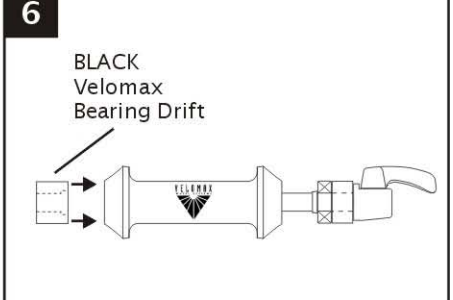
Slip the RED Velomax Bearing Drift against the bearing. Insert a Quick Release Skewer through the Axle.

5



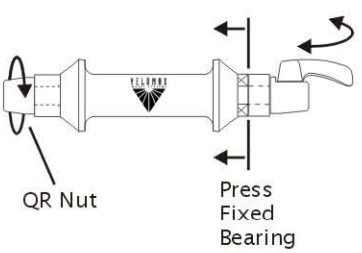
One side of the Hub Shell has a Wave Spring groove, the other does not. The side without the groove is the press-fit side.

6



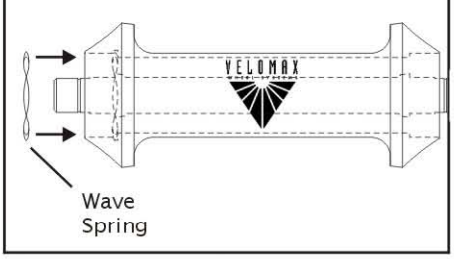
Insert the BLACK Velomax Bearing Drift into the Wave Spring side of the Hub Shell. *IMPORTANT - the recess in the drift must be facing IN.* Insert the Axle/Bearing assy. Into the press-fit side of the Hub Shell.

7



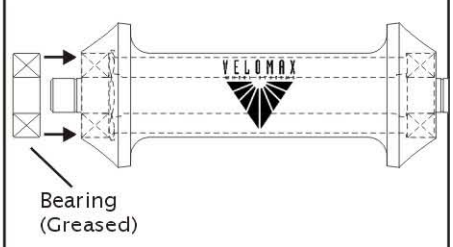
With the QR Lever open, screw on the QR Nut until tight. Press the Fixed Bearing by closing the QR Lever. Open the Lever and re-tighten the Nut, then close the Lever again. Repeat until Bearing is FULLY BOTTOMED.

8



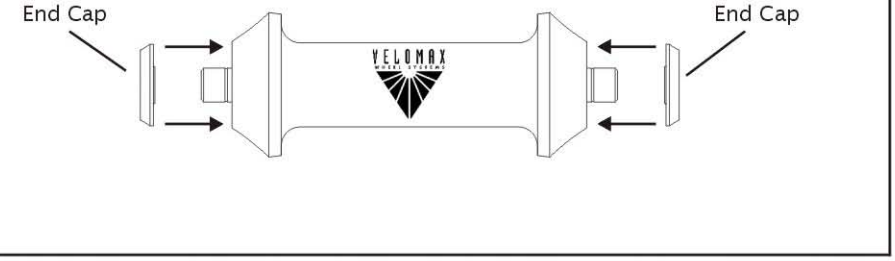
Remove the QR and Bearing Drifts from the Hub. Wipe away any excess Loctite. Slip the Wave Spring into the groove in the slip-fit side of the Hub Shell. Make sure it snaps FULLY into its groove. Note - The Wave Spring is intentionally cut!

9



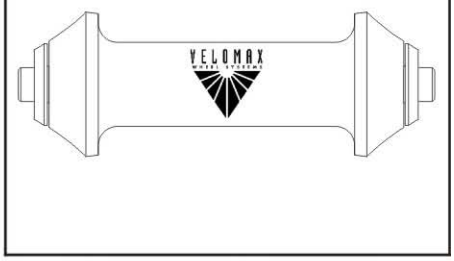
Apply a thin film of waterproof grease to the outer race of the remaining Bearing. Slip the Bearing into the slip-fit side of the Hub Shell by hand.

10



Install the End Caps onto the Axle ends. *Hint* - slip the End Caps partially on either end of the Axle. Grasping both Caps, twist them in opposite directions while applying inward pressure. *Note* - The End Caps come with rubber O-rings already installed. If the O-rings are missing, they can be replaced.

11



Completed R2 Front Hub. ASSEMBLY is now completed.