

Hardware kits must be replaced with each rotor ring replacement. Hardware kits are included with replacement rotor rings.

**NOTE: THE M5 CAP SCREWS HAVE DIFFERENT LENGTHS, ONE IS 22mm, THE OTHER 25mm!**

1. Open the hardware kit and do a pre-assembly. Find the 22mm M5 cap screw and the Belleville washer and place them as shown in Figure 4. Now find the 25mm M5 cap screw, the flat washer, spring clip and square washer. Assemble as shown in Figure 5. Apply a thread locking fluid to all M5 cap screws.
2. Clean the back of the hat where the hub contacts and scrub the flange where the rotor bolts to. There should be no rust, scale, dirt, debris or burrs prior to assembly. The mating surfaces needs to be **CLEAN!**
3. Now you are ready to do the final assembly. Place a drive bushing in the brake hat (Figure 1) and from the back of the rotor insert a screw assembly (Figure 2). Alternate the screw assemblies around the rotor. Depending on the application, you can have a total of 8,10 or 12 screw assemblies.
4. Once the brake hat is fully assembled to the rotor ring, torque all M5 cap screws to 60 in./lb or 7 N/M. Do not over-tighten.



Figure 1



Figure 2

<p>Flat part of bushing rests on hat</p> <p>Drive bushing</p>	<p>22mm M5 cap screw</p> <p>Belleville washer (it is not flat!)</p> <p><b>NOTE:</b> dome of the washer to head of screw</p>	<p>25mm M5 cap screw</p> <p>Flat washer</p> <p>Spring clip</p> <p>Square washer</p>
<p>Figure 3</p>	<p>Figure 4 (screw assembly)</p>	<p>Figure 5 (screw assembly)</p>