TECHNICAL NOTE 2.0 (Rev.C)

2-Piece Floating Iron Rotor Assembly

Caution 1: *Hardware (bolts, fasteners and fittings) must be replaced with every iron rotor ring replacement. Hardware kits are included with the replacement rotor rings.*

Caution 2: *The screws provided may have different lengths & sizes, depending on the hat design. If this is the case, the different screw configurations are alternated around the hat.*

Step 1: If not already pre-assembled, open the hardware kit and do a pre-assembly. Find the "M5" screw and the "domed" washer and place them together. NOTE: These washers are not flat – place the rounded dome of the washer towards the head of the screw.

Step 2: Find the other sized "M5" screws, flat washers, spring clips and square washers. Assemble previous.

Step 3: Clean the back of the aluminum hat thoroughly (if pre-used), where the hub contacts the rotor. There should be no dirt, rust, scale or debris. Use brake cleaning fluid and small wire brush if needed to thoroughly clean the mating surface.

Step 4: Final assembly: Place the aluminum hat on the new rotor disc. Insert all the Drive Bolts through the top of the hat and through the rotor disc. On the pre-assembled screw assemblies, apply a small drop of thread locking fluid to all of the "M5" screws towards the threaded start section. From the back of the rotor, insert a screw assembly. If your hat has two different screw assemblies, alternate these assemblies around the hat.

Step 5: Once the hat and rotor is fully assembled, torque the M5 screws as follows (NOTE: these are LOW TORQUE specs! A quality, precision torque wrench must be utilized to ensure proper torque.

- 6.3 and 6.5mm bolts: **13-14 NM.**
- 8.1, 8.5 and 9.0mm bolts: **17 NM.**

This should be done in a "star" pattern around the disc (ie; not in a clockwise fashion). The torque wrench should be applied from the TOP of the rotor.