

9. Position handlebar in face of stem and place faceplate over bar, loosely threading in all 4 screws by hand.
10. Carefully note that the gap from stem to faceplate is equal on top and bottom of stem, and should be equal left to right when all 4 bolts are tightened to the point of just contacting the faceplate.
11. Using a torque wrench, tighten all 4 bolts in sequence A, B, C, D relative to the pattern shown. Tighten one at a time in half turn increments repeating the A,B,C,D pattern until the specified 6 N-m torque is achieved in all bolts.
12. Bolt torque should be periodically checked to ensure ideal performance and longevity. At minimum, bolt torque should be checked 2 times per year.



Along with regular bolt torque inspections, also inspect the components for any damage, cracks, or chips. Also inspect all components after any crash or accident. If any visible damage or questionable cracks, chips or stress marks are visible, these products must be replaced without further use. Failure to do so could result in serious injury.

This product is warranted for 1 year against defects in materials or workmanship. Warranty is for original owner only and proof of purchase is required for any warranty claim.

Any questions please visit [www.zipp.com](http://www.zipp.com)  
or call us at 1.800.472.3972



**145 Carbon Stem**  
Assembly Instructions



ZIPP Speed Weaponry - 1180 N. Main St. Suite A - Speedway IN - USA

**ZIPP**  
SPEED WEAPONRY



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## CAUTION

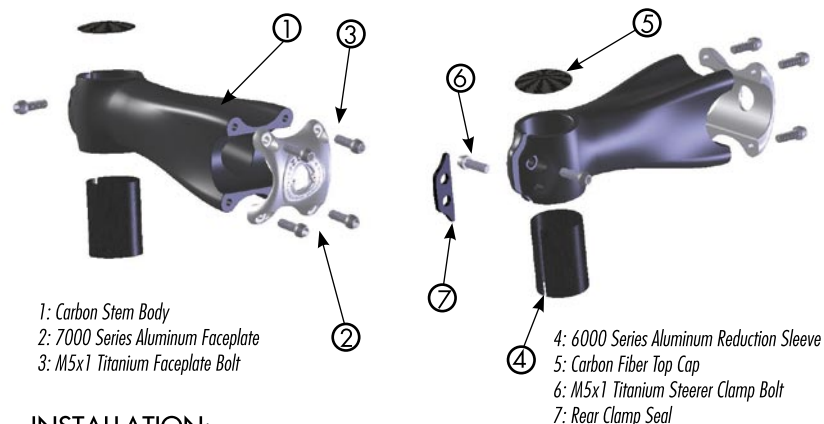
All handlebar and stem products should be installed by a professional bicycle mechanic using the appropriate tools.

**Zipp assumes no responsibility for damages or injury related to improperly installed components.**

### CRITICAL DETAILS:

1. The Model 145 stem can be installed on either 1" or 1 1/8" steerer tubes. To install the stem on a 1" steerer the included reduction sleeve must be utilized.
2. Zipp Model 145 is available for either 26.0mm or 31.8mm diameter handlebars, and your handlebar must be sized accordingly.
3. Zipp bars and stems are designed to function optimally as a system so we cannot guarantee the products when used with handlebars of other manufacturers, and all warranty is VOID if stem is used with handlebars of non-compatible diameters (i.e. 25.9mm is not compatible with 26.0mm and 31.7mm is not compatible with 31.8mm)
4. All mating surfaces must be properly cleaned and NOT LUBRICATED before installation. The steerer tube and handlebar should be cleaned with alcohol or similar as should be the stem face and stem steerer clamp.
5. All bolts should be properly coated with anti-seize compound. The stem is supplied with this compound in place and it should not be removed. If it is removed please call Zipp at 1.800.472.3972 for replacement anti-seize compound.
6. Proper installation of the headset and fork star-nut/expanding wedge must be first completed following the instructions of these component manufacturers before attempting to install the Model 145 stem.

### STEM OVERVIEW AND COMPONENTS:



### INSTALLATION:

1. Loosen steerer clamp bolts.
2. Assemble fork into headtube and headset and hold in place with elastic bands or toe-strap. Fork must already be cut to proper length as instructed by fork manufacturer.
3. If using 1" fork, slide reduction sleeve onto fork steerer with cut in sleeve facing rearward, if not proceed to step 4.
4. Slide stem onto steerer tube (or tube and reduction sleeve) careful not to scratch or nick fork steerer tube.
5. Finger tighten both steerer clamp bolts until bolt head contacts stem surface.
6. Carefully align stem so that it is parallel to front wheel and install top cap utilizing 6mm bolt and expanding nut/star nut already inserted into fork. Tighten 6mm top cap bolt to manufacturers spec in order to pre-load headset assembly and remove any play from system.
7. Using a torque wrench with 4mm hex key, carefully tighten stem steerer clamp bolts in half turn increments, one at a time until 6N-M is achieved in both bolts.
8. Carefully remove faceplate making sure not to wipe anti-seize compound from bolt threads.