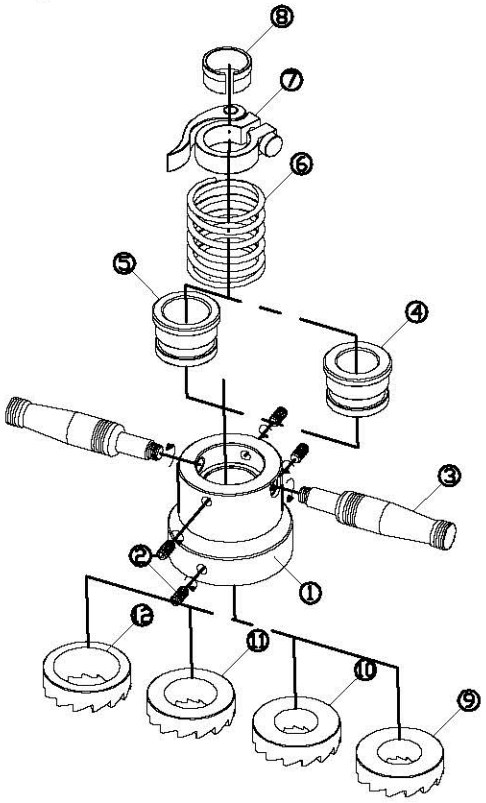
1 Parts description



NO.	PARTS	Q'TY
①	Cutting tool body	1
②	Set screw M5*8L	4
③	Handle	2
④	Guide 1"	1
⑤	Guide 1-1/8"	1
⑥	Spring	1
⑦	Quick-release seat 1-1/8"	1
⑧	Adaptor 1"	1
⑨	Cutter ∅54*25.6 (948-A)	1
⑩	Cutter ∅54*27.1 (948-B)	1
⑪	Cutter ∅54*30 (948-C)	1
⑫	Cutter ∅54*40 (948-D)	1
⑬	Spring spacer	1

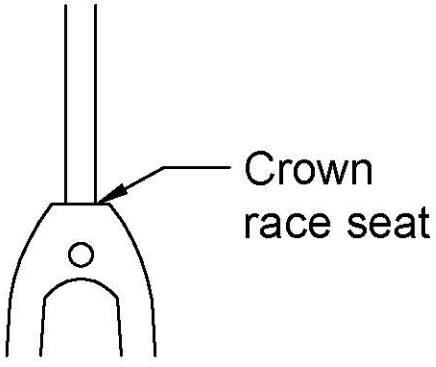
2 Assembly

Please contact to the fork manufacturer if the diameter of the crown race seat is over the standard. (Data source: S.H.I.S.)

1.Set up the cutting tool body ① with handle ③.
2.Measure the diameter of the crown race seat. (see picture 2)
3.Select the appropriate cutter with the measurement. (see picture 1)
4.Put the cutter on the bottom of the cutting tool body, and fasten the set screw ② on the cutter (Max : 1.0Nm). (see picture 3、4、5 & 6)
5.Set up the guide ④、⑤ and cutting tool body ①
5-1.When used on 1" or 1-1/8" regular steerer, put the guide ④ or ⑤ (which is counterpart of the cutter) into the upper side of the cutting tool body and fasten the set screw ② into and loosen it for 1/4 round until the set screw ② engages with the guide. (see picture 3、4 & 5)
5-2.When used on 1-1/8"、1-1/2" tapered steerer, don't need the guide, just make sure the set screw ② (used to fit guide) has been screwed off to avoid scratch on steerer. (see picture 6)

The diameter crown race seat	Cutter
26.43~26.49	948-A
27.03~27.09	948-B
30.015~30.075	948-C
39.79~39.85	948-D

(Picture 1)



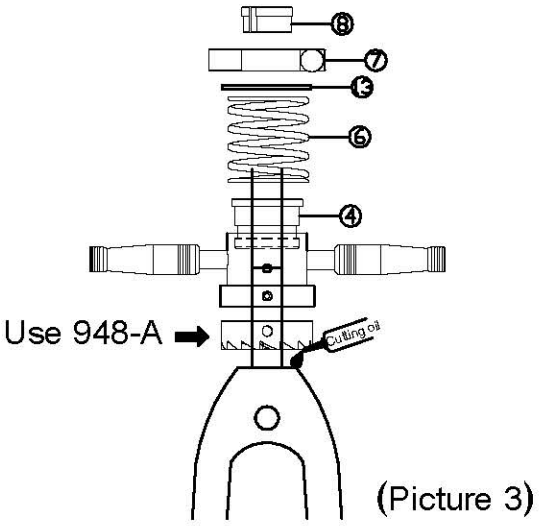
(Picture 2)

3 Instruction

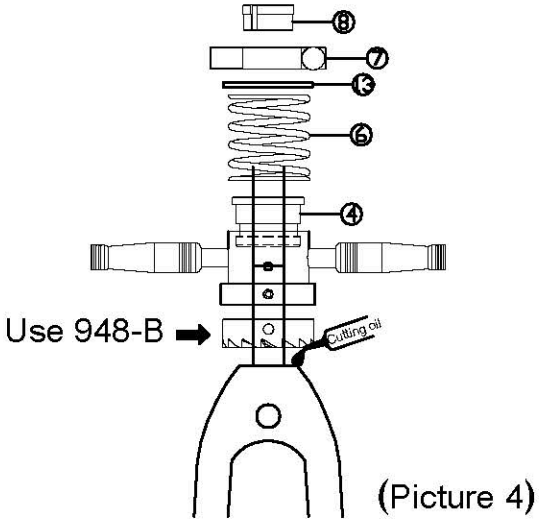
1.Apply the cutting oil crown race seat and cutter.
2.Mount the cutting tool body ① on crown race seat.
3.Mount the spring ⑥ through steerer on cutting tool body ①
4.Plcace the spring spacer ⑬ through steerer on the spring ⑥.
5.Mount quick-release seat ⑦ through steerer on spring spacer ⑬. (see picture 3)
5-1.Only use quick-release seat ⑦ on 1-1/8" steerer. (see picture 5)
5-2.Use adaptor ⑧ and quick-release seat ⑦ on 1" steerer. (see picture 3&4)
6.Apply proper pressure on quick-release seat ⑦ and then clamp the quick-release. Use the spring to strongly press the cutting tool body.
7.Turn the crown race seat cutting tool clockwise with balanced pressure on both sides of handle ③.
8.Release quick-release seat ⑦ to check the crown race seat is flat enough.
9.If crown race seat is not flat enough, please repeat step 6 to 8.

4 Note

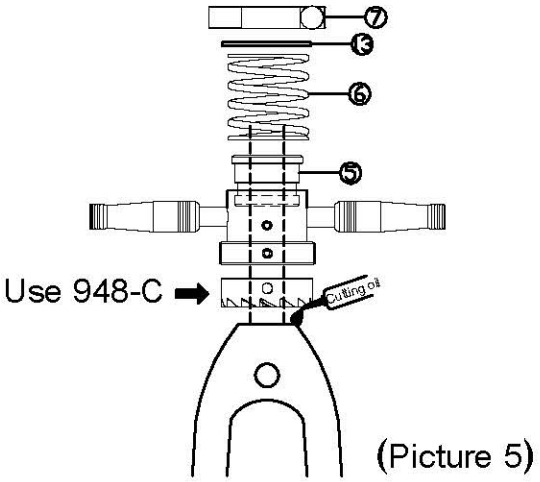
1.Please don't operate the cutting tool counterclockwise.
2.TB-1948 is not suitable for whole full carbon fiber steerer and crown race seat ' besides, it is not suitable for the chrome-plated crown race seat because the cutter will be dulled quickly.



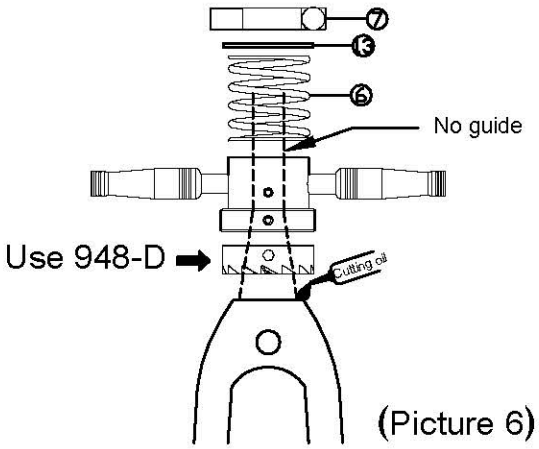
(Picture 3)



(Picture 4)



(Picture 5)



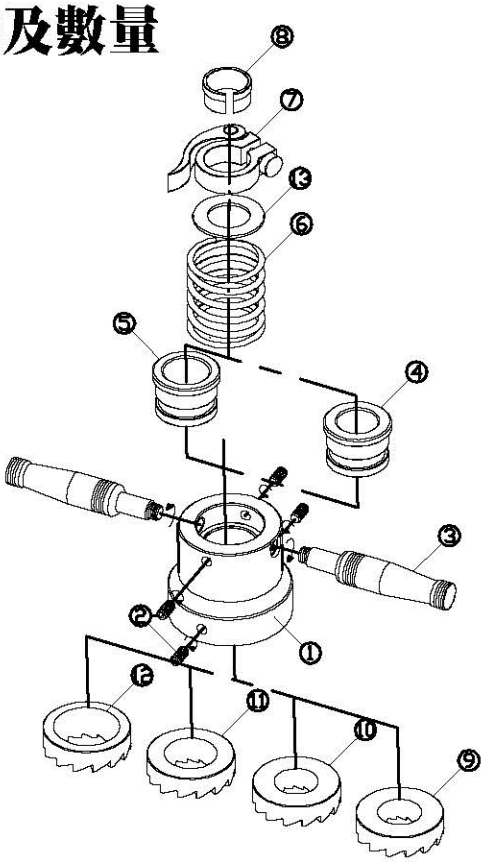
(Picture 6)

SUPER B® tool excellence

TB-1948

通用型座環基座銑削工具 使用說明書

1 零件名稱及數量



編號	名稱	數量
①	銑削器主體 ∅70*50L	1
②	止付螺絲 M5*8L	4
③	手柄	2
④	導引管 1"	1
⑤	導引管 1-1/8"	1
⑥	彈簧	1
⑦	快拆	1
⑧	轉接套	1
⑨	面銑刀 ∅54*25.6 (948-A)	1
⑩	面銑刀 ∅54*27.1 (948-B)	1
⑪	面銑刀 ∅54*30 (948-C)	1
⑫	面銑刀 ∅54*40 (948-D)	1
⑬	彈簧加壓片	1

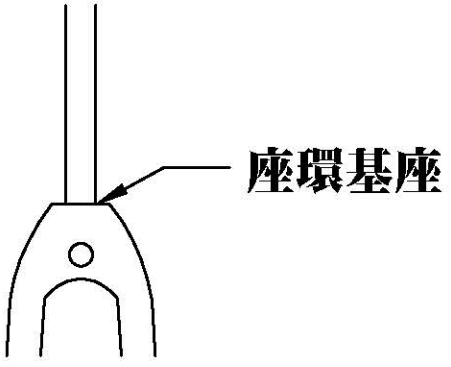
2 組裝步驟

若座環基座管徑超出標準，請與前叉製造商聯絡。
(資料來源: S.H.I.S)

1. 組裝銑削器主體①與手柄③。
2. 測量座環基座管徑。(如圖二所示)
3. 依測量結果選擇適當的銑刀。(如圖一所示)
4. 將確認後的銑刀放入銑削器主體底部，確認銑刀側面的孔位對準銑削器主體的止付螺絲②，再將螺絲鎖上(最大1.0Nm)。(如圖三、圖四、圖五、圖六所示)
5. 組裝導引管④、⑤與銑削器主體①
   - 5-1. 使用於1"與1-1/8"一般型前叉上管。將導引管(與銑刀相對應的)放入銑削器主體上部，將止付螺絲②鎖入直到當螺絲接觸到導引管後退出1/4圈。(如圖三、圖四、圖五所示)
   - 5-2. 使用於上1-1/8"、下1-1/2"錐形前叉上管，不需使用導引管，但須注意銑削器主體上的導引塊固定用止付螺絲②是否已經退出，以避免止付螺絲②刮傷前叉上管。(如圖六所示)

座環基座尺寸	適用牙刀
26.43~26.49	948-A
27.03~27.09	948-B
30.015~30.075	948-C
39.79~39.85	948-D

(圖一)



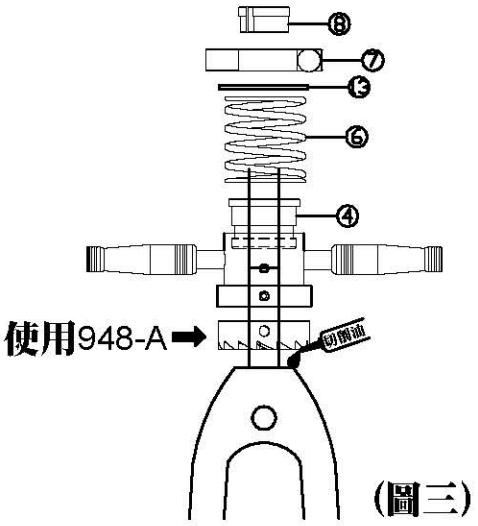
(圖二)

3 使用說明

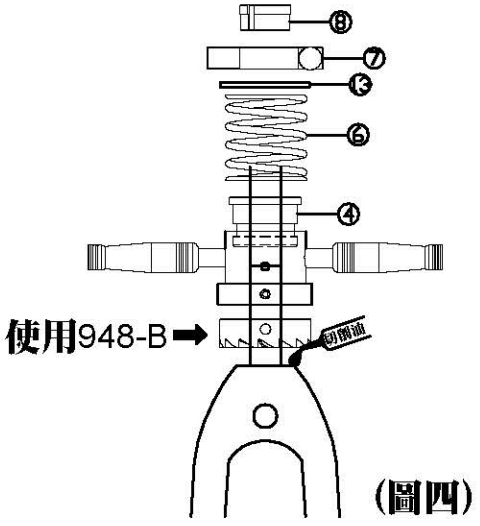
1.加入切削油於座環基座與銑刀上。
2.將銑削器主體①置於座環基座上。
3.將彈簧⑥穿過前叉上管置於銑削器主體①上。
4.將彈簧加壓片⑬穿過前叉上管置於彈簧⑥上。
5.將快拆座⑦穿過前叉上管置於彈簧加壓片⑬上。(如圖三所示)
5-1.當使用於前叉上管尺寸1-1/8"時，不需將快拆轉接套⑧置入快拆座⑦中。(如圖五所示)
5-2.當使用於前叉上管尺寸1"時，請將快拆轉接套⑧置入快拆座⑦中。(如圖三、圖四所示)
6.施加適當壓力於快拆⑦上並將快拆鎖上。利用彈簧⑥彈力將銑削器主體①向下壓。
7.雙手平均施力於手柄③上順時針方向旋轉座環基座銑削工具。
8.將快拆座⑦放鬆，檢查座環基座是否已平整。
9.如表面依然不平整，請重複步驟6到步驟8，直到座環基座表面平整。

4 注意事項

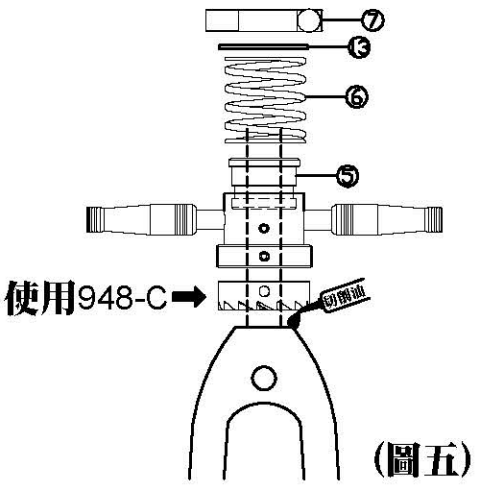
1.切削時請勿逆時針旋轉座環基座銑削工具。
2.TB-1948不建議使用於全碳纖維的前叉上管與座環基座，另外，不建議使用於經過鍍鉻處理的座環基座，這將會增加銑刀磨損的速度。



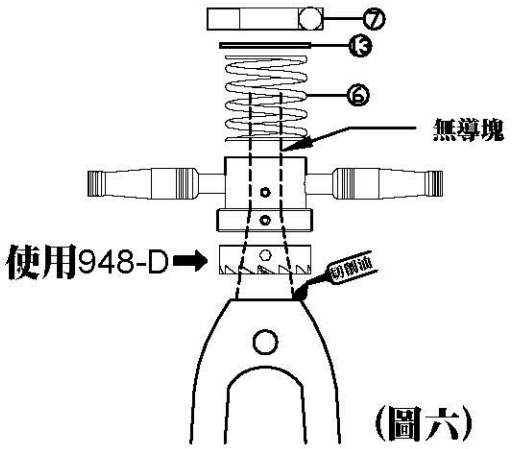
(圖三)



(圖四)



(圖五)



(圖六)