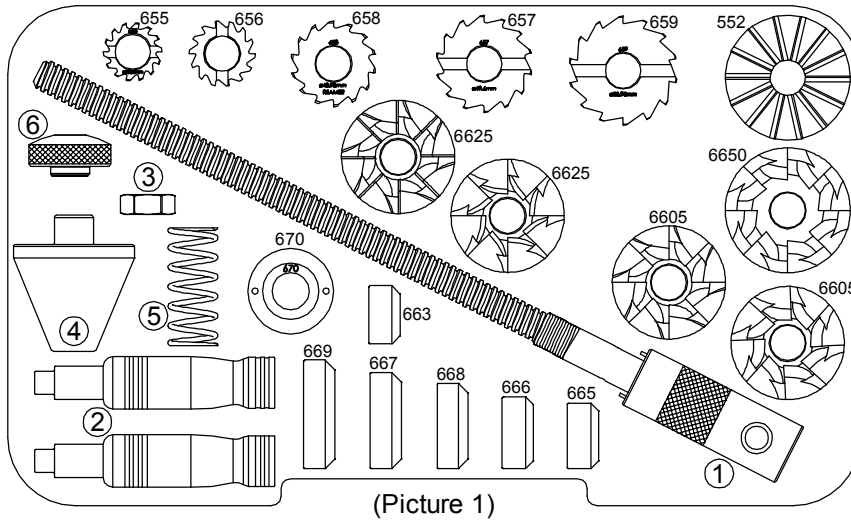


1 Part description



Model	Parts	
TB-HT10	Facer	552(64mm)
	Reamer	655(30.05mm), 656(33.9mm)
	Guide	663(29.8mm), 665(33.7mm), 666(36.8mm), 670(reamer extender)
TB-HT11	Facer	552(64mm)
	Reamer	658(43.95mm), 659(55.95mm)
	Guide	668(43.8mm), 669(55.8mm), 670(reamer extender)
Optional	Reamer	657(49.6mm)
	Cutter sets	6605(upper/lower)(41.15mm), 6625(upper/lower)(41.95mm), 6650(52.05mm)
	Guide	667(49.4mm)

No	description	Qty
①	Body	1
②	Handle	2
③	Hex nuts	1
④	Centering cone	1
⑤	Tension spring	1
⑥	Thrust washer	1

2 Notes

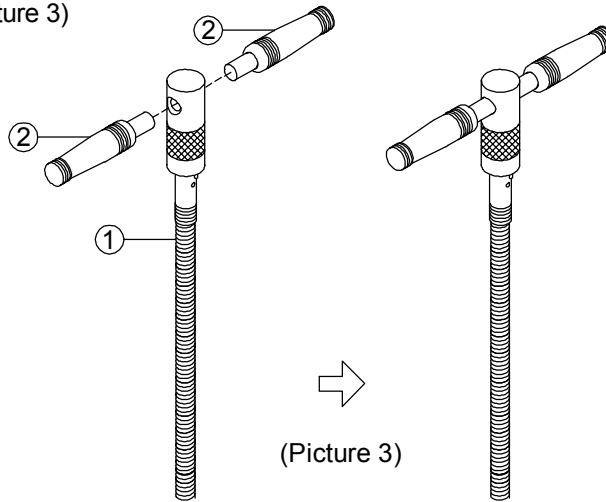
1. Read the instructions before use.
2. Select the correct reamer, facer and guide on the head tube (see picture 2); otherwise, head tube will get damaged.
3. Contact local dealer/distributor for the inquiry of replacement or optional cutters.
4. During the process of using, you will need to apply cutting fluid. Be sure to have some on hand before starting to work.

Headset Standard 頭管標準	Headset Cup Dimension 頭碗尺寸	Head Tube Dimensions 頭管尺寸	Required for Reaming and Facing 適用的銑刀與導塊	Required for Facing Only 適用的銑刀
1" Traditional-JIS	30.00~30.10 mm O.D.	29.85~29.90 mm I.D.	N/A	
1" Traditional-Professional	30.20~30.30 mm O.D.	30.05~30.10 mm I.D.	655	663
1-1/8" Traditional	34.05~34.15 mm O.D.	33.90~33.95 mm I.D.	656	665
1-1/4" Traditional	37.05~37.15 mm O.D.	36.90~36.95 mm I.D.	N/A	666
1-1/2" Traditional	49.70~49.75 mm O.D.	49.57~49.61 mm I.D.	552, 657	552, 667
1-1/8" Semi-Integrated	44.05~44.10 mm O.D.	43.95~44.00 mm I.D.	552, 658	552, 668
1-1/2" Semi-Integrated	55.99~56.04 mm O.D.	55.90~55.95 mm I.D.	552, 659	552, 669
1-1/8" Integrated-IS Top	no cup	41.10~41.2 mm I.D., 3.10~3.20 mm Depth, 45 Angle	6605	N/A
1-1/8" Integrated-IS Bottom	no cup	41.10~41.2 mm I.D., 6.90~7.0 mm Depth, 45 Angle		
1-1/8" Integrated-Italian Top	no cup	41.95~42.05 mm I.D., 2.8~3.0 mm Depth, 45 Angle	6625	N/A
1-1/8" Integrated-Italian Bottom	no cup	41.95~42.05 mm I.D., 6.60~6.80 mm Depth, 45 Angle		
1-1/2" Integrated-Bottom	no cup	52.05~52.15 mm I.D., 7.30~7.50 mm Depth, 45 Angle	6650	N/A

(Picture 2)

3 Assembly

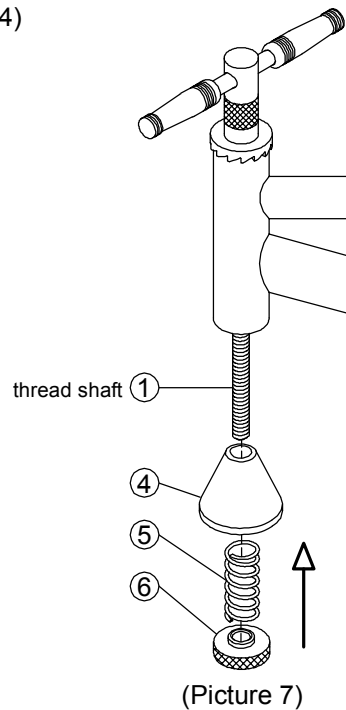
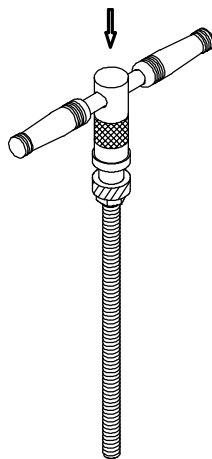
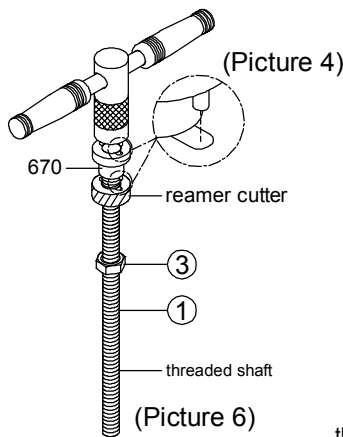
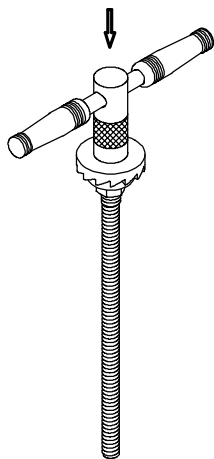
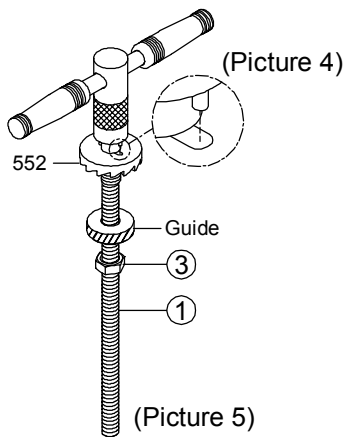
1. Assemble handles ② and body ①. (see picture 3)



4 Operation


1. Check above specification list (see picture 2) to use the correct reamer, facer and guide. Assemble cutter as following instruction:

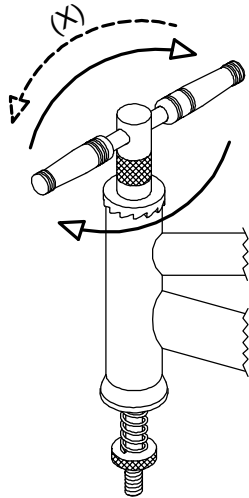
- 1-a. Facing head tube: Insert facer 552 to body ① (see picture 4), put a guide to body ① and tighten hex nuts ③ to secure facer 552 and guide. (see picture 5)
- 1-b. Reaming inner tube: Insert extension guide 670 and a reamer cutter to body ① (see picture 4) and tighten hex nuts ③ to secure extension guide 670 and reamer cutter. (see picture 6)



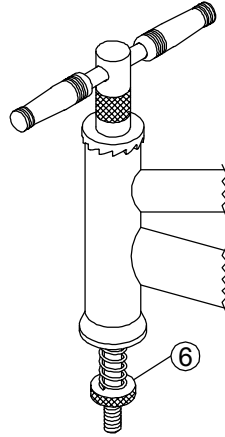
2. Place thread shaft through head tube of frame and insert centering cone ④, then tension spring ⑤ and screw thrust washer ⑥ upto secure all components until centering cone ④ is aligned with head tube. (see picture 7)

3. Apply cutting fluid to cutters and headtube of frame.
4. Turn the handle clockwise and applying additional cutting fluid every two turns. Keep turning handles until cutters create a clean cut (see picture 8). During the process of turning handles, please screw thrust washer^⑥ properly to ensure centering cone is always aligned with headtube. (see picture 9)

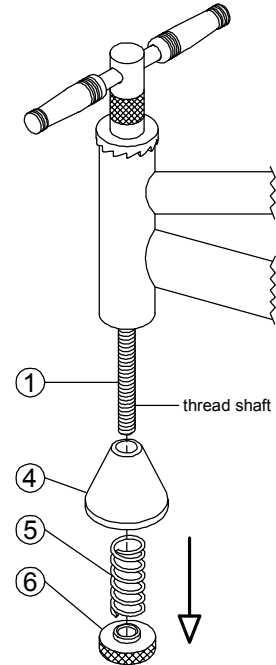
 Note: Please turn handles clockwise ONLY. Turning counter clockwise will get cutters or head tube damaged.



(Picture 8)



(Picture 9)

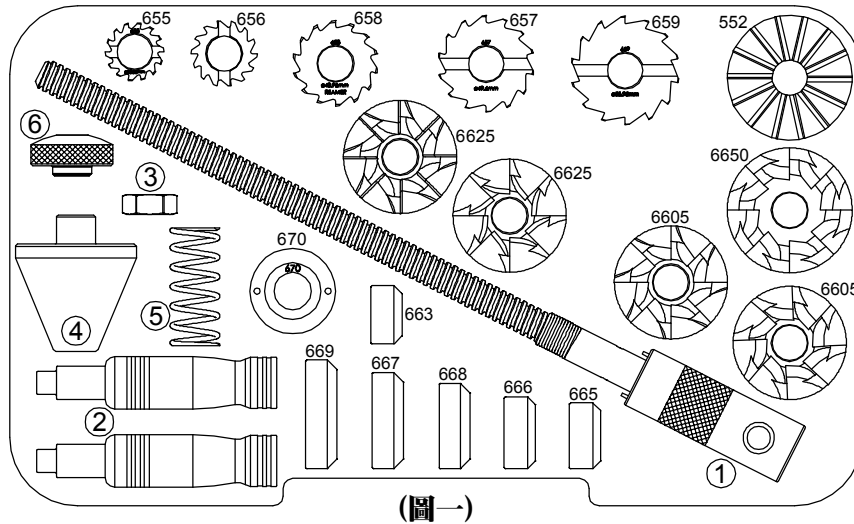


(Picture 10)

5. Remove the parts from thread shaft (see picture 10). Check the surface of head tube is clean and flat. If not, please repeat steps 4 to 5 until clean face is created.
6. Repeat steps 1-5 for facing the other side of head tube.

Note: 1. Wear safety glasses as reaming or facing tubes.
 2. Make sure to use a deburr tool or file to remove sharp edges from head tube. Otherwise, the headset may get damaged when installed. Do NOT clean the clippings by air compressor.
 3. Cutter parts should be cleaned, wiped with oily cloth and stored in original blow case.

1 零件名稱及數量



(圖一)

型號	零 配 件	
TB-HT10	面銑刀	552(64mm),
	內管銑刀	655(30.05mm), 656(33.9mm),
	導塊	663(29.8mm), 665(33.7mm), 666(36.8mm), 670(延長導塊),
TB-HT11	面銑刀	552(64mm),
	內管銑刀	658(43.95mm), 659(55.95mm),
	導塊	668(43.8mm), 669(55.8mm), 670(延長導塊),
選配刀組	內管銑刀	657(49.6mm),
	錐管銑刀	6605(上/下)(41.15mm), 6625(上/下)(41.95mm), 6650(52.05mm),
	導塊	667(49.4mm),

項次	名稱	數量
①	主體	1
②	握把	2
③	固定螺帽	1
④	錐形定位塊	1
⑤	增壓彈簧	1
⑥	彈簧增壓器	1

2 注意

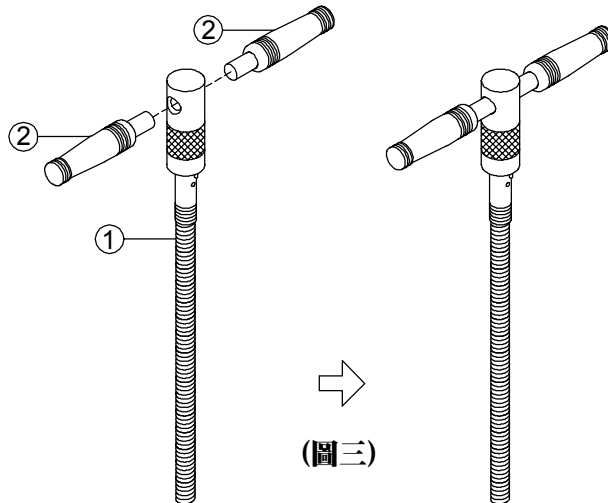
1. 使用前請詳閱本說明書。
2. 請參照圖二依規格選擇正確的內管銑刀、面銑刀及導塊，否則將會導致頭管損壞。
3. 若需選購選配配件或更換刀組，請連絡當地經銷/代理商。
4. 使用本產品的過程中，您將需使用切削液，使用前，請確認您手上已有此產品。

Headset Standard 頭管標準	Headset Cup Dimension 頭碗尺寸	Head Tube Dimensions 頭管尺寸	Required for Reaming and Facing 適用的銑刀與導塊	Required for Facing Only 適用的銑刀
1" Traditional-JIS	30.00~30.10 mm O.D.	29.85~29.90 mm I.D.	N/A	
1" Traditional-Professional	30.20~30.30 mm O.D.	30.05~30.10 mm I.D.	655	663
1-1/8" Traditional	34.05~34.15 mm O.D.	33.90~33.95 mm I.D.	656	665
1-1/4" Traditional	37.05~37.15 mm O.D.	36.90~36.95 mm I.D.	N/A	666
1-1/2" Traditional	49.70~49.75 mm O.D.	49.57~49.61 mm I.D.	552, 657	552, 667
1-1/8" Semi-Integrated	44.05~44.10 mm O.D.	43.95~44.00 mm I.D.	552, 658	552, 668
1-1/2" Semi-Integrated	55.99~56.04 mm O.D.	55.90~55.95 mm I.D.	552, 659	552, 669
1-1/8" Integrated-IS Top	no cup	41.10~41.2 mm I.D., 3.10~3.20 mm Depth, 45 Angle	6605	N/A
1-1/8" Integrated-IS Bottom	no cup	41.10~41.2 mm I.D., 6.90~7.0 mm Depth, 45 Angle		
1-1/8" Integrated-Italian Top	no cup	41.95~42.05 mm I.D., 2.8~3.0 mm Depth, 45 Angle	6625	N/A
1-1/8" Integrated-Italian Bottom	no cup	41.95~42.05 mm I.D., 6.60~6.80 mm Depth, 45 Angle		
1-1/2" Integrated-Bottom	no cup	52.05~52.15 mm I.D., 7.30~7.50 mm Depth, 45 Angle	6650	N/A

(圖二)

3 組裝說明

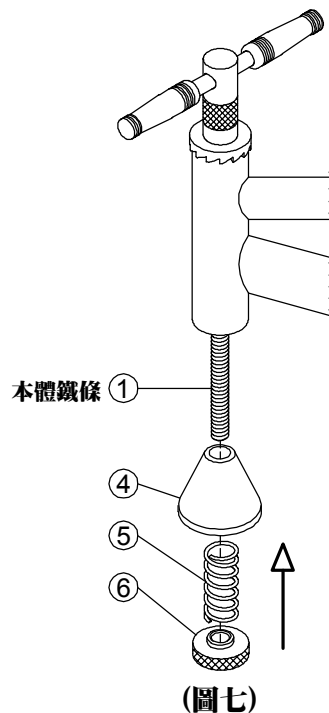
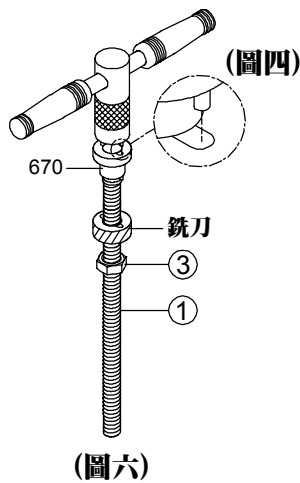
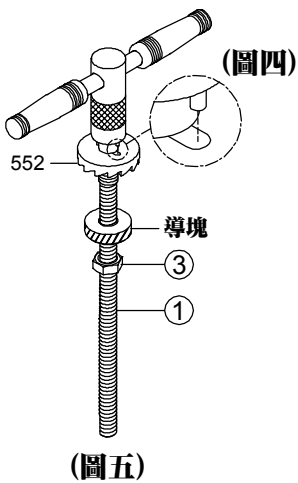
1. 安裝握把②於本體①(參見圖三)。



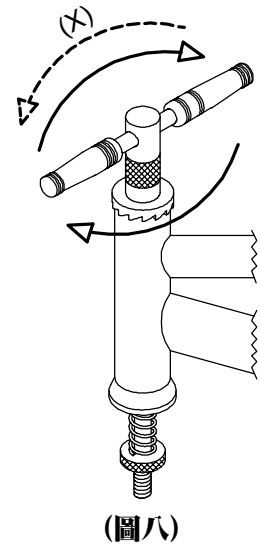
4 操作說明

1. 參考(圖二)規格表使用正確的內管銑刀、面銑刀及導塊，請依下列指示安裝工具：

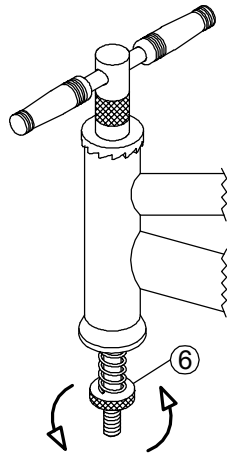
- 1-a. 銑頭管面：依序放入面銑刀 (552)及導塊，然後鎖入固定螺帽 ③將銑刀鎖緊(參見圖五)。
- 1-b. 銑頭管內管：依序放入延長導塊 (670)及內管銑刀於本體，然後鎖入固定螺帽 ③將銑刀鎖緊(參見圖六)。



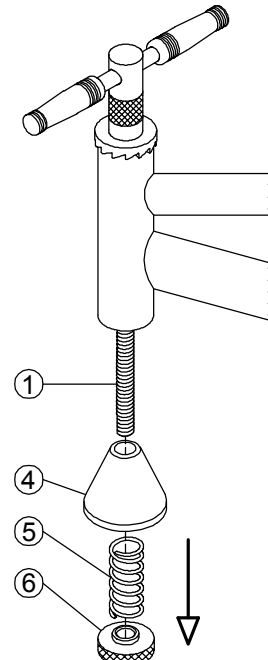
⚠ 注意：握把只可順時針旋轉，逆時針旋轉將會導致銑刀或頭管損壞。



- 2. 將組裝好銑刀及導塊的本體穿過車架頭管，並依序安裝錐形定位塊 ④、加壓彈簧⑤後，鎖入彈簧增壓器⑥上至鎖緊所有零件，直至錐形定位塊 ④與頭管平行(參見圖七)。
- 3. 使用切削液於銑刀及車架的頭管。
注意：握把只可順時針旋轉，逆時針旋轉將會導致銑刀或頭管損壞(參見圖八)。
- 4. 順時針方向旋轉，並每旋轉 2 圈額外添加切削液。持續旋轉握把直至頭管銑出乾淨的面或內管(參見圖八)。旋轉的過程中，請適時旋緊彈簧增壓器 ⑥以確保錐形定位塊 ④隨時與頭管平行(參見圖九)。



(圖九)



(圖十)

5. 將本體上的零件拆卸掉(見圖十)。
6. 檢查頭管的表面是否乾淨且平整，若否，請重覆步驟 3至5直至產生乾淨的表面。
7. 重覆步驟2至7，以完成頭管另一邊的切削。

注意：1. 使用本產品時，請帶護目鏡。

2. 確實用去毛邊工具或挫刀將頭管上尖銳的邊緣清除，否則，頭碗安裝時可能會損壞。
請勿使用壓縮空氣清理鐵削。

3. 銑刀應清理過，並用油紙包覆妥善儲放於原位。