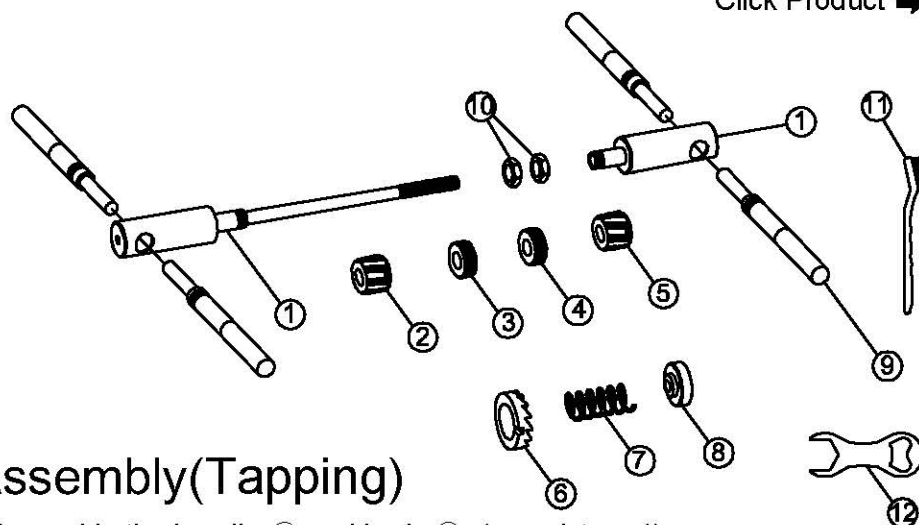


1 Parts description

Visit operation detail at Super B

Website: <http://www.superbiketool.com/>,

Click Product ➡ Frame & Fork ➡ 3. ➡ TB-98150



NO.	PARTS	Q'TY
①	Body	2
②	Tap 1.37**24T (R)	1
③	Bushing 1.37*24T (R)	1
④	Bushing 1.37*24T (L)	1
⑤	Tap 1.37**24T (L)	1
⑥	Facing Mill Cutter	1
⑦	Spring	1
⑧	Spring Retainer	1
⑨	Handle	4
⑩	Nut	2
⑪	Brush	1
⑫	Open wrench	1

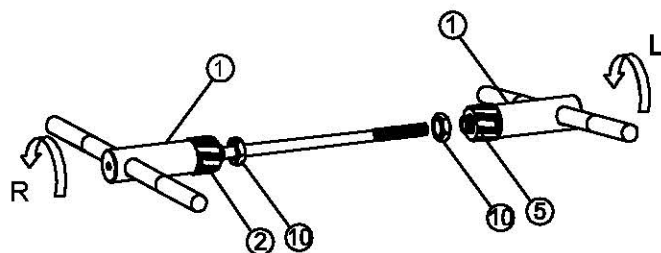
2 Assembly(Tapping)

1. Assemble the handle ⑨ and body ①. (see picture 1)
2. Assemble the tap ② ⑤ and body ①, and fix the tap by tightening the nut ⑩ with open wrench ⑫, check the tap is right or left before assembling. (see picture 1)

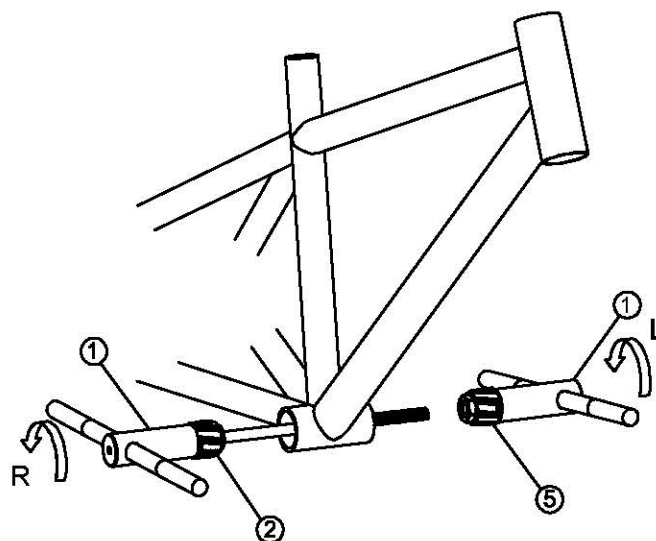
3 Instruction(Tapping)

1. Mount the frame on the stable work stand, suggest use Super B work stand TB-WS40.
2. Add cutting oil on the thread of B.B.
3. Lightly (without forward pressure) turn the handle until the tap ② ⑤ engages the thread of the B.B. (see picture 2)
4. Rotate the handle into B.B. in accordance with the picture. Must follow principal of three forward and two backward when tapping, and continue to add cutting oil.
5. In order not to damage the thread of B.B. must remove the tap ② ⑤ of both sides at the same time. Do not remove either tap until both tap are fully disengaged from the threads of the frame.
6. Clean the cutting oil and chips on tool set and thread of B.B. by brush ⑪.

Notice: B.B. tapping tool is used to remove broken thread, extra paint or metal chips, but it can't be used to tap new thread.



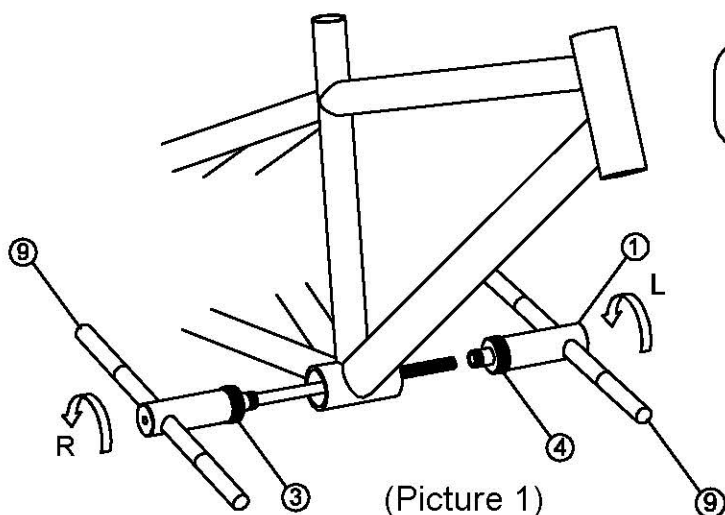
(Picture 1)



(Picture 2)

1 Assembly(Facing)

- 1.Assemble the handle ⑨ and body ① accordance with picture. (see picture 1)
- 2.Assemble the bushing ③ ④ through body ①. (see picture 1)
- 3.Install the bushing ③ ④ into B.B. by rotating the body ①. (see picture 1)
- 4.Pull out the both body ①.



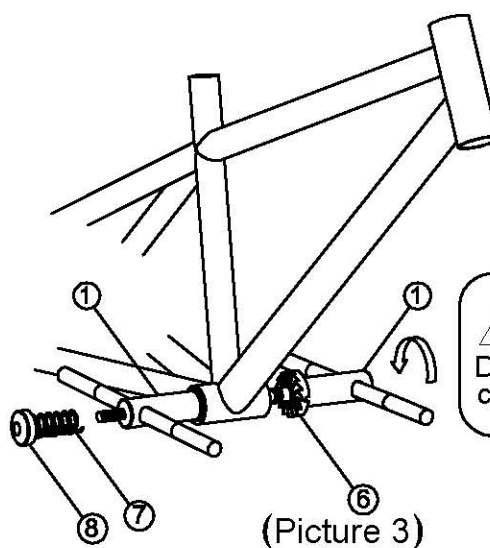
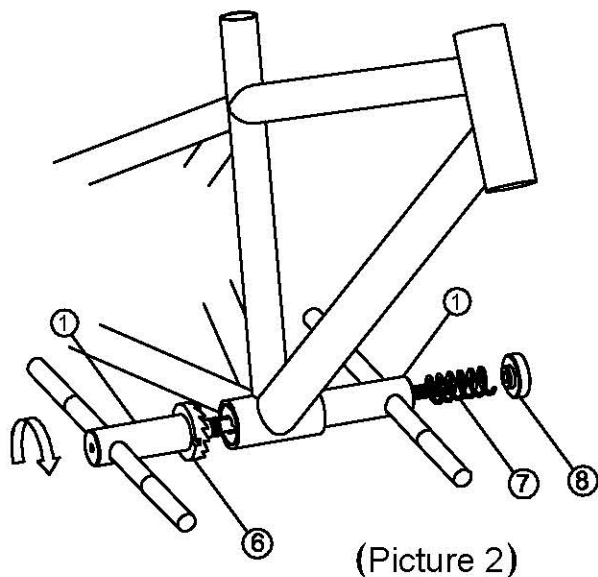
Before assembly, please make sure the width of B.B. is longer than the standard. Do not use this tool if the width of B.B. is below or equal to the standard.

2 Instruction(Facing)

- 1.Assemble the facing mill cutter ⑥ through the body with axle ①. Put the body with axle through the bushing ③ ④ and another body. (see picture 2 & 3)
- 2.Put the spring ⑦ through the axle and rotate the spring retainer ⑧ into axle until facing mill cutter contact the B.B.
- 3.Add cutting oil on the facing mill cutter ⑥.
- 4.Rotate the spring retainer ⑧ to adjust the pressure of spring ⑦ on facing mill cutter.
- 5.Rotate the handle with facing mill cutter ⑥ clockwise until the surface of B.B. is smooth.



Please keep measuring the width of B.B. during the facing. Notice! Please do not overly face the width of B.B. for fear of being below the standard.

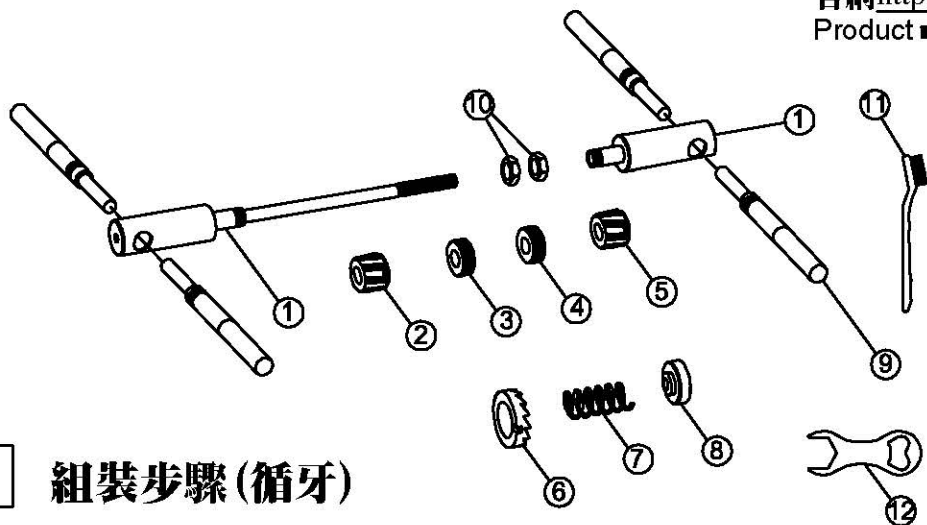


Do not rotate facing mill cutter counter-clockwise.

1 零件名稱及數量

詳細操作影片請至 Super B

官網<http://www.superbiketool.com/>觀看，點擊
Product ➡ Frame & Fork ➡ 3. ➡ TB-98150



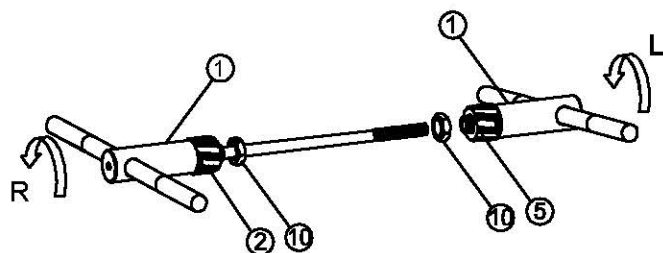
編號	名稱	數量
①	主體	2
②	牙刀 1.37**24T (R)	1
③	軸心襯套 1.37**24T (R)	1
④	軸心襯套 1.37**24T (L)	1
⑤	牙刀 1.37**24T (L)	1
⑥	銑面銑刀	1
⑦	彈簧	1
⑧	彈簧固定環	1
⑨	握柄	4
⑩	螺帽	2
⑪	毛刷	1
⑫	開口扳手	1

2 組裝步驟(循牙)

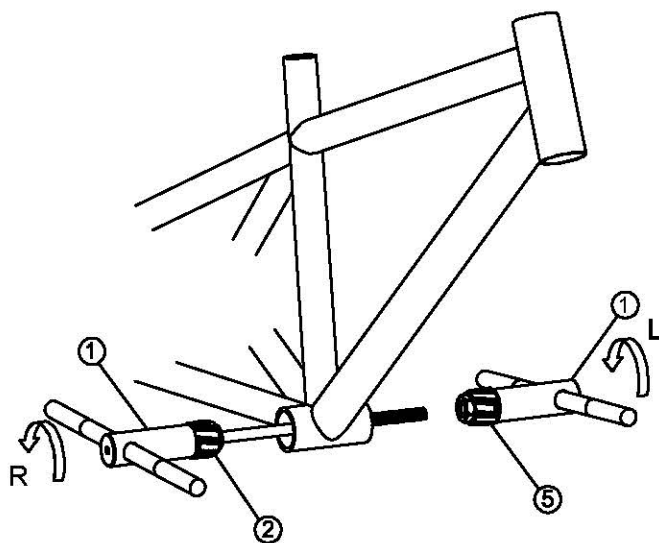
1. 將握柄⑨組裝於主體①上。(如圖一所示)
2. 依圖示組裝牙刀②⑤與主體①，再用內附的開口扳手⑫鎖緊螺帽⑩將牙刀固定，安裝前請確認牙刀為左邊或右邊。(如圖一所示)

3 使用說明(循牙)

1. 將車架固定在穩固的修車架上，建議搭配 Super B 的修車架 TB-WS40。
 2. 加入切削油於五通內的螺牙上。
 3. 輕輕的同時旋轉兩邊的牙刀②⑤直到對上五通內的螺牙。(如圖二所示)
 4. 依照圖示的旋轉方向，將牙刀②⑤旋轉入五通，依循進三退二的攻牙原則來進行循牙的動作並不斷補充切削油。
 5. 循牙完成後，需同時移除兩邊的牙刀②⑤，為避免傷害五通內的螺牙，請勿單獨移除其中一邊的牙刀。
 6. 使用內附的毛刷⑪將五通螺牙上與工具組上的碎屑與切削油清理乾淨。
- 注意：五通循牙工具是用於修整五通內損壞的螺牙、多餘的烤漆或金屬屑，並無法於五通內銑出新的螺牙。



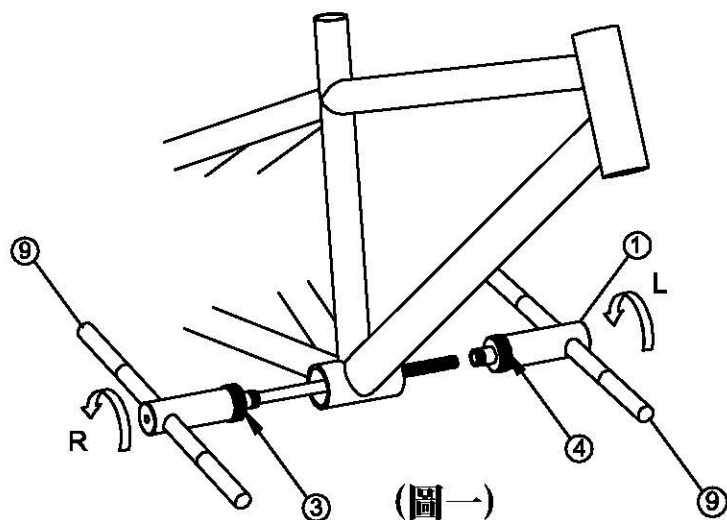
(圖一)



(圖二)

1 組裝步驟(銑面)

1. 將握柄⑨組裝於主體①上。(如圖一所示)
2. 將軸心襯套③④與主體①結合。(如圖一所示)
3. 旋轉主體將軸心襯套③④安裝於五通軸心內。(如圖一所示)
4. 取出主體①。



(圖一)



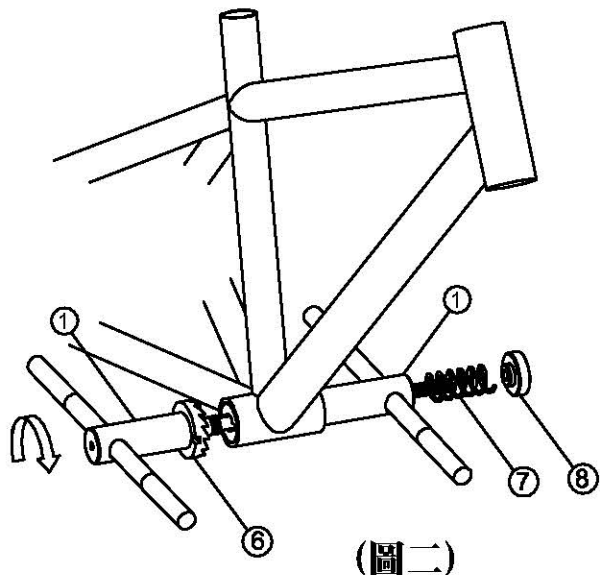
組裝前，請測量五通寬度。五通寬度須大於標準值才能使用五通銑面工具。若小於或等於標準值請勿使用此工具

2 使用說明(銑面)

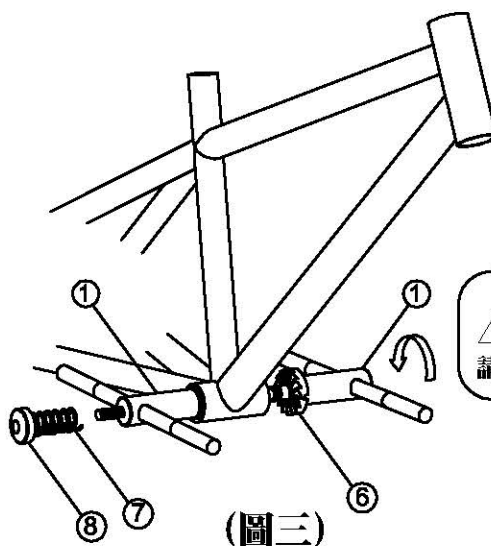
1. 將銑面銑刀⑥安裝於帶有軸心的主體①上。將帶有軸心的主體穿過襯套③④與另一邊的主體(如圖二、三所示)。
2. 將彈簧⑦穿過軸心並將彈簧固定環⑧旋入直到銑面銑刀⑥接觸五通。
3. 加入切削油於銑面銑刀⑥上。
4. 旋轉彈簧固定環⑧調整彈簧⑦在銑面銑刀⑥上的壓力。
5. 順時針旋轉帶有銑面銑刀⑥的握柄直到五通表面平整。



在銑面過程中請持續測量五通寬度。
注意! 請勿將五通寬度銑至低於標準值



(圖二)



(圖三)



請勿逆時針旋轉銑面銑刀