

FIT PEDAL CRANK ARMS

This tutorial shows how to fit the Pedal Crank Arms into the XE-1

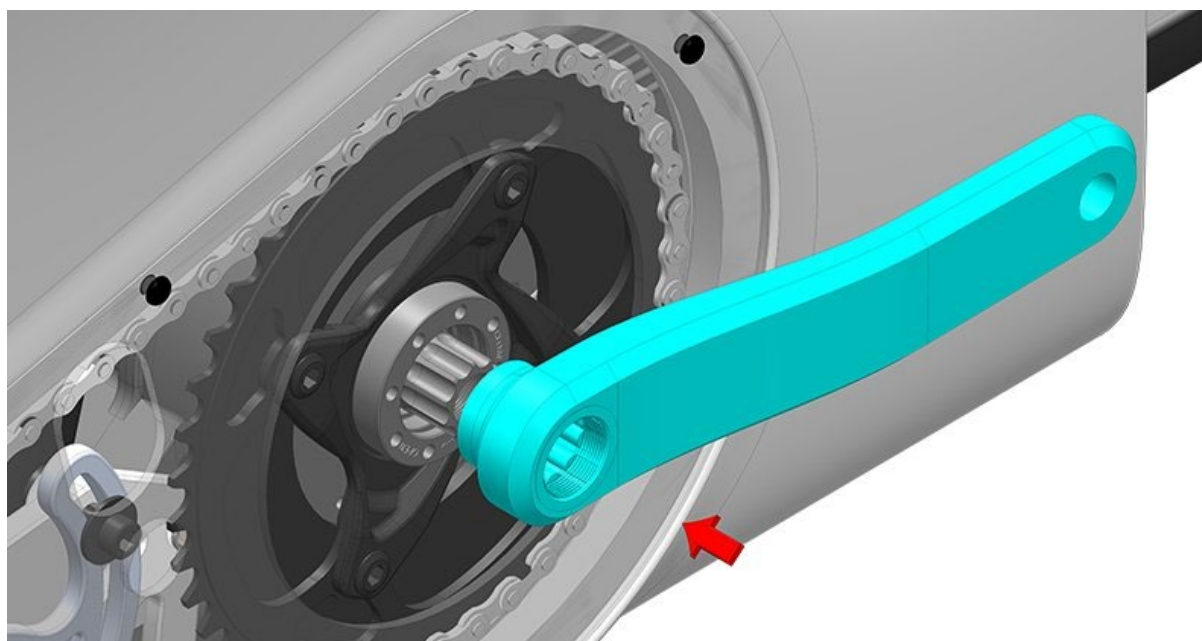
1. Fit Pedal Crank Arms LH and RH

TOOLS REQUIRED

ID	Description	Task
	Hex Key 8 mm	Remove Crank Bolts
	Torque Wrench (20 – 60 Nm)	Fasten Crank Bolts (50 Nm)
	Rubber Mallet	Assemble Crank Arms to Motor Drive Shaft Spline

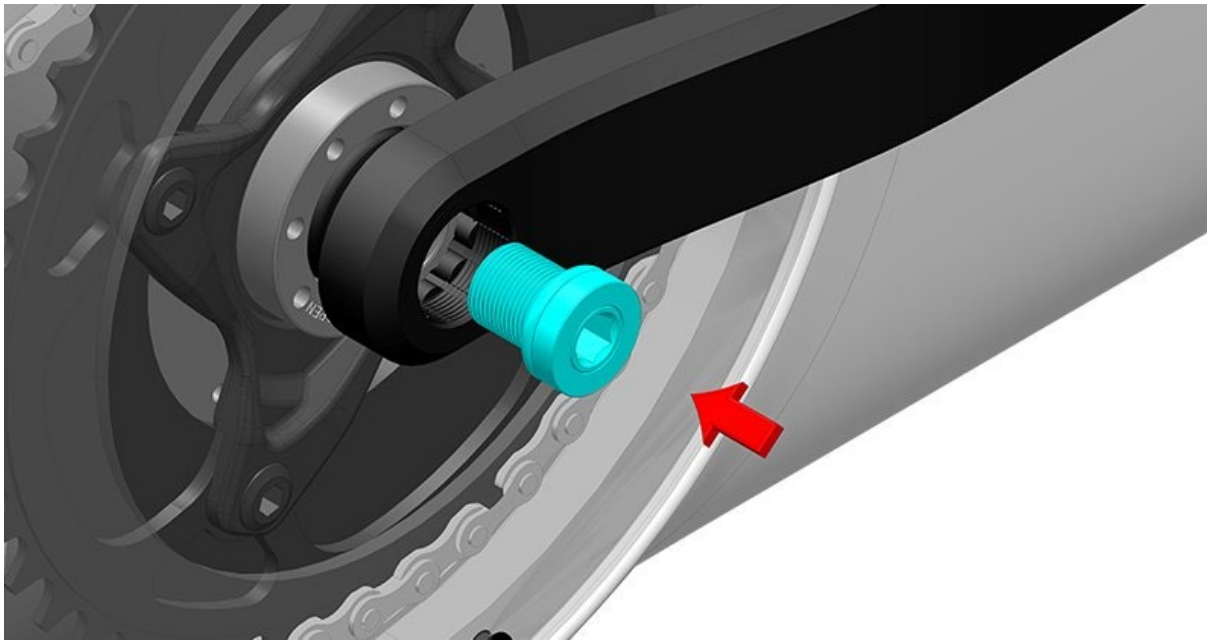
THIS TASK CAN BE ONLY PERFORMED BY MANTA5 SERVICE AGENTS, BIKE MECHANICS (OR EQUIVALENT) WITH FULLY EQUIPPED WORKSHOP.

1.1 Assemble RH Crank Arm to Motor Drive Shaft Spline and secure with 15 mm Crank Bolt. [Tools: Rubber Mallet, 8 mm Hex, Torque Wrench set to 50 Nm]



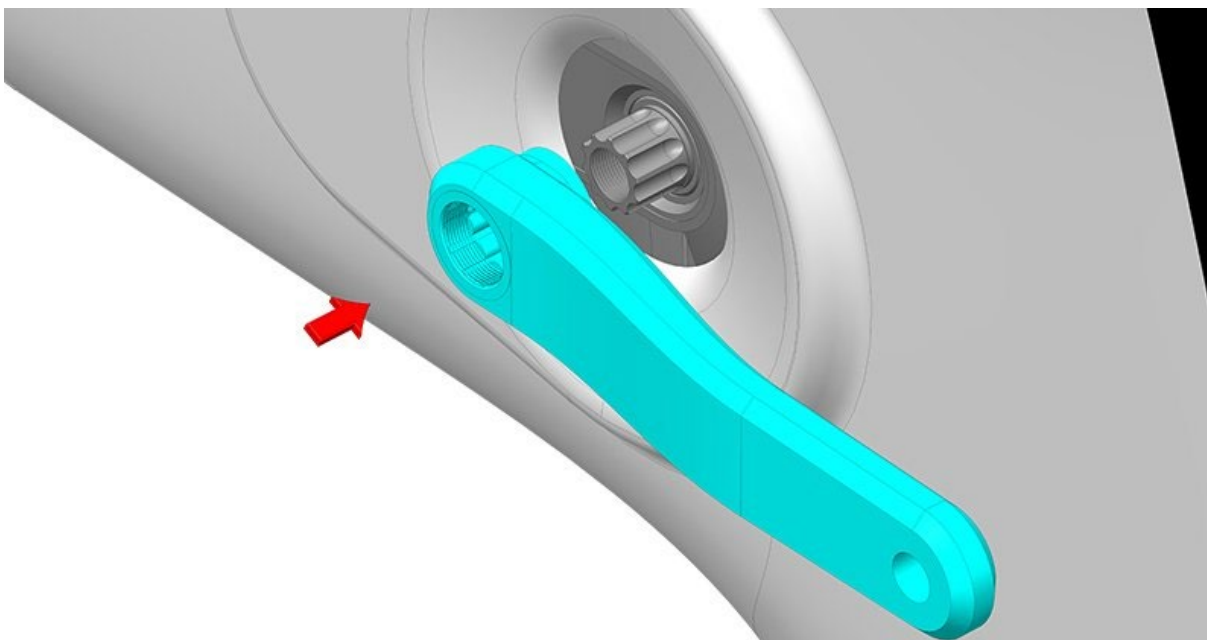
INFORMATION: Fit the Right-Hand Crank Arm (marked RH on outside face adjacent to Pedal thread) to the Drive shaft Spline and tap it firmly into place using a small head rubber mallet without making contact with buoyancy components. The Crank Bolt must progress at least two full turns without tension before tightening. Fastening the Crank Bolt with only one thread engaged can strip the thread from the Crank Bolt in which case it must be replaced.

1.2 Fit a 15 mm ISIS Crank Bolt through the Right-Hand Crank to engage the internal thread of the Motor Drive Shaft. [Tools: 8 mm Hex, Torque Wrench]



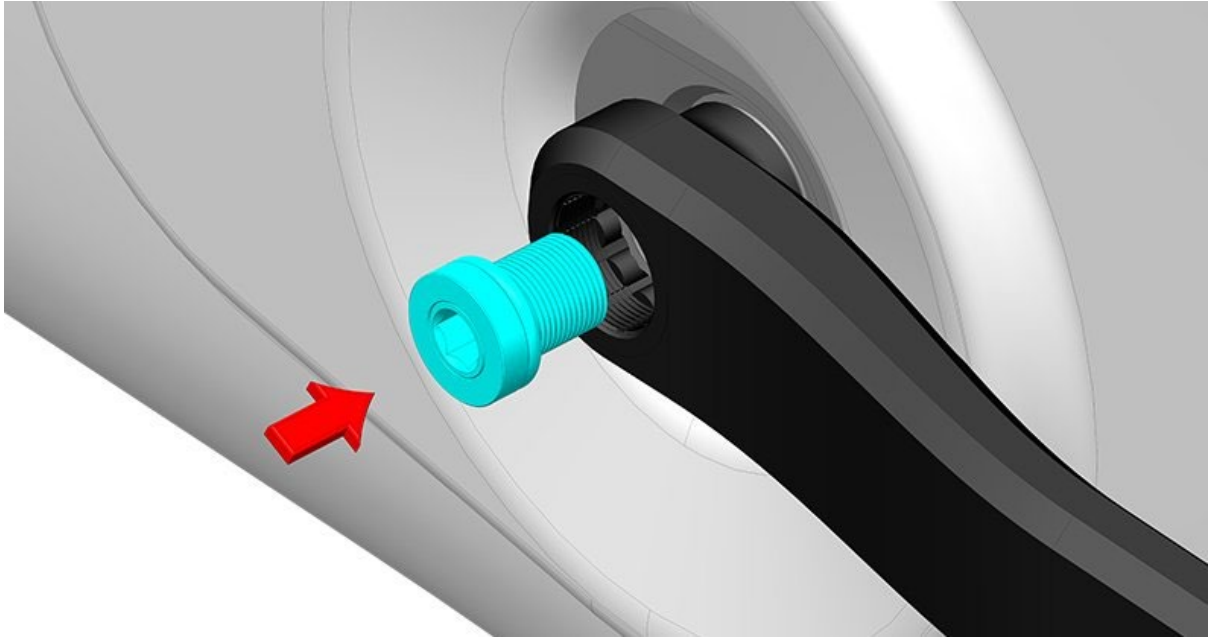
INFORMATION: Use the Torque Wrench set to 50 Nm and fasten to the pre-set torque level. Rotate the Crank Bolt clockwise (right-hand thread) to fasten.

1.3 Assemble Left-Hand Crank Arm to Motor Drive Shaft Spline and secure with 15 mm Crank Bolt. [Tools: Rubber Mallet, 8 mm Hex, Torque Wrench set to 50 Nm]



INFORMATION: Fit the Left-Hand Crank Arm (marked LH on outside face adjacent to Pedal thread) to the Drive shaft Spline and tap it firmly into place using a small head rubber mallet without making contact with buoyancy components. The Crank Bolt must progress at least two full turns without tension before tightening. Fastening the Crank Bolt with only one thread engaged can strip the thread from the Crank Bolt in which case it must be replaced.

1.4 Fit a 15 mm ISIS Crank Bolt through the Left-Hand Crank to engage the internal thread of the Motor drive Shaft. [Tools: 8 mm Hex, Torque Wrench]



INFORMATION: Use the Torque Wrench set to 50 Nm and fasten to the pre-set torque level. Rotate the Crank Bolt clockwise (right-hand thread) to fasten.