



**TOOLS REQUIRED:** 4mm allen (hex) key.

**STEER TUBE PREPARATION:**

- 1) The Race Face Deus XC and Evolve XC stem fits 1.125" (28.6mm) fork steer tubes only.
- 2) The Race Face Deus XC and Evolve XC stem requires 40.0mm (1.57") min of exposed steer tube above all the headset components and spacers to ensure adequate clamping surface. This is derived from this formula:

Deus XC/Evolve XC "stack height"	40.0mm (1.57")
Subtract headset compression gap:	- 2.0mm (0.079") MAX
<b>Total</b>	<b>= 38.0mm (1.49")</b>

**NOTE:** The Race Face Deus XC and Evolve XC stem has a relatively low stack height at 40.0mm.

**INSTALLATION**

1. Make sure that there are no sharp burrs on the top outside edge of the steer tube. File or sand to remove if necessary. Install all headset components and optional spacers onto the steer tube. It is very important to make sure the steer tube is clean and dry (NO GREASE).
2. Slide the stem onto the steer tube. Some back and forth rotation may be required to slide the stem down until it touches the headset spacers.
3. Install the headset "top cap" and "compression bolt" on top of the stem. Adjust the headset pre-load as per the headset manufacturer's specifications. (typically until all "play" is removed, but rotation is still smooth).
4. Remove the steer tube clamp bolts and lightly grease the bolt threads and under the bolt head. Line the stem up straight with the front tire, re-install and tighten both STEER TUBE CLAMP BOLTS to 65-70 in.lbs. (5.4-5.8 ft.lbs/ 7.4-7.9 Nm) your 4mm allen key. Alternate back and forth between the two bolts until torque setting is achieved.
5. Remove all the bar clamp bolts, place your bar into the clamp. Lightly grease the bolt threads and under the bolt head. Re-install HANDLE BAR CLAMP and BAR CLAMP BOLTS, and tighten bolts to 55-65 in./lbs (4.6-5.4 ft.lbs/ 6.2-7.5Nm) using your 4mm allen key. Alternate between the four bolts in a cross pattern until full torque setting is achieved. Check to ensure that the gap between the HANDLEBAR CLAMP and the STEM BODY is even between the top and bottom. (approx. 1mm).

**WARNING!** Strictly adhere to the following. Failure to do so could result in pre-mature failure of the part which could affect the rider's control of the bicycle and result in serious injury.

1. All bolts used on the Deus XC and Evolve XC stem are DIN grade 10.9 CrMo steel chrome plated. The size is M5X16mm. Do not substitute with inferior lower strength hardware such as DIN grade 8.8 steel, titanium or aluminum. These metals do not have the strength required for this application. Do not use shorter bolt lengths. Full thread engagement is required. If replacement is required, use DIN grade 10.9 M5X16mm only. OEM replacement parts are inexpensive and available from your RaceFace dealer.

2. "HEADSET TOP CAP" and "HEADSET COMPRESSION BOLT" must be left in place at all times during operation of the bicycle. These components assist retention of headset adjustment.

**MAINTENANCE:**

1. Check hardware periodically for tightness. Use caution not to over-tighten.
2. Inspect all parts of the stem periodically, including bolts, for damage or cracks. This is a good idea with ANY and ALL lightweight aluminum bike parts. This is especially important after any big crashes. If you notice anything suspicious, have your Race Face dealer inspect it for you, or replace it.
3. Although not critical to the continuing function of the stem, re-greasing the hardware occasionally wouldn't hurt. You can apply a light film of grease to all bolt threads and the underside of bolt heads. Take care to keep steer tube and steer tube clamp area clean and free from grease.

**WARRANTY:**

1. The Deus XC stem carries a limited 3 year warranty for defects in materials and workmanship. The Evolve XC stem carries a 1 year warranty.
2. This warranty is limited to the original purchaser. Proof of purchase is required. This can take the form of a photocopy of the original sales receipt.
3. This warranty does not cover defects arising from misuse, abuse, alterations, lack of preventative maintenance and routine maintenance or failure to install according to the instructions and proper procedures.
4. Race Face warranties do not cover fading of colours.

