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For the warranty to be valid, the bicycle must be fully assembled by an authorized Argon 18 dealer. High end components, particularly carbon parts, need extra care when assembled. Those components must be installed using a calibrated torque wrench to make sure every bolt is at the right torque setting to prevent damage.



1. Frame inspection



2. Fork installation



3. Handlebar installation



4. Handlebar assembly

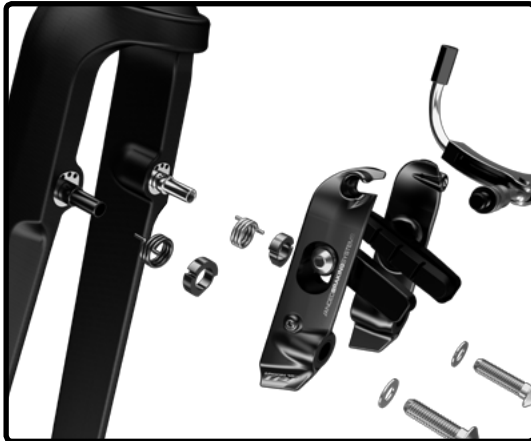


5. Cable housing installation

IMPORTANT NOTICE: It is easier to install the cables and cable housings before the bearings.



6. Electronic drive-train specification



7. Front brake installation



8. Rear brake installation



9. Armrest assembly



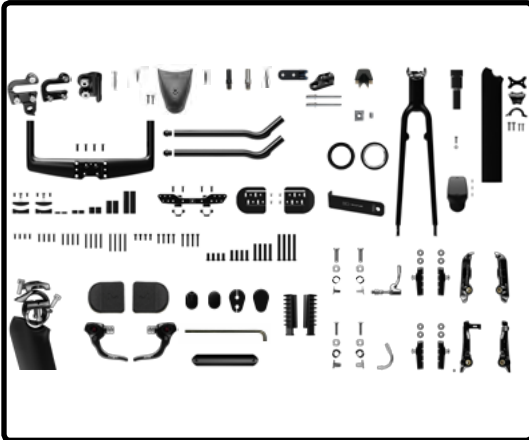
10. Seatpost installation



11. Saddle adjustment



12. Derailleur hanger adjustment

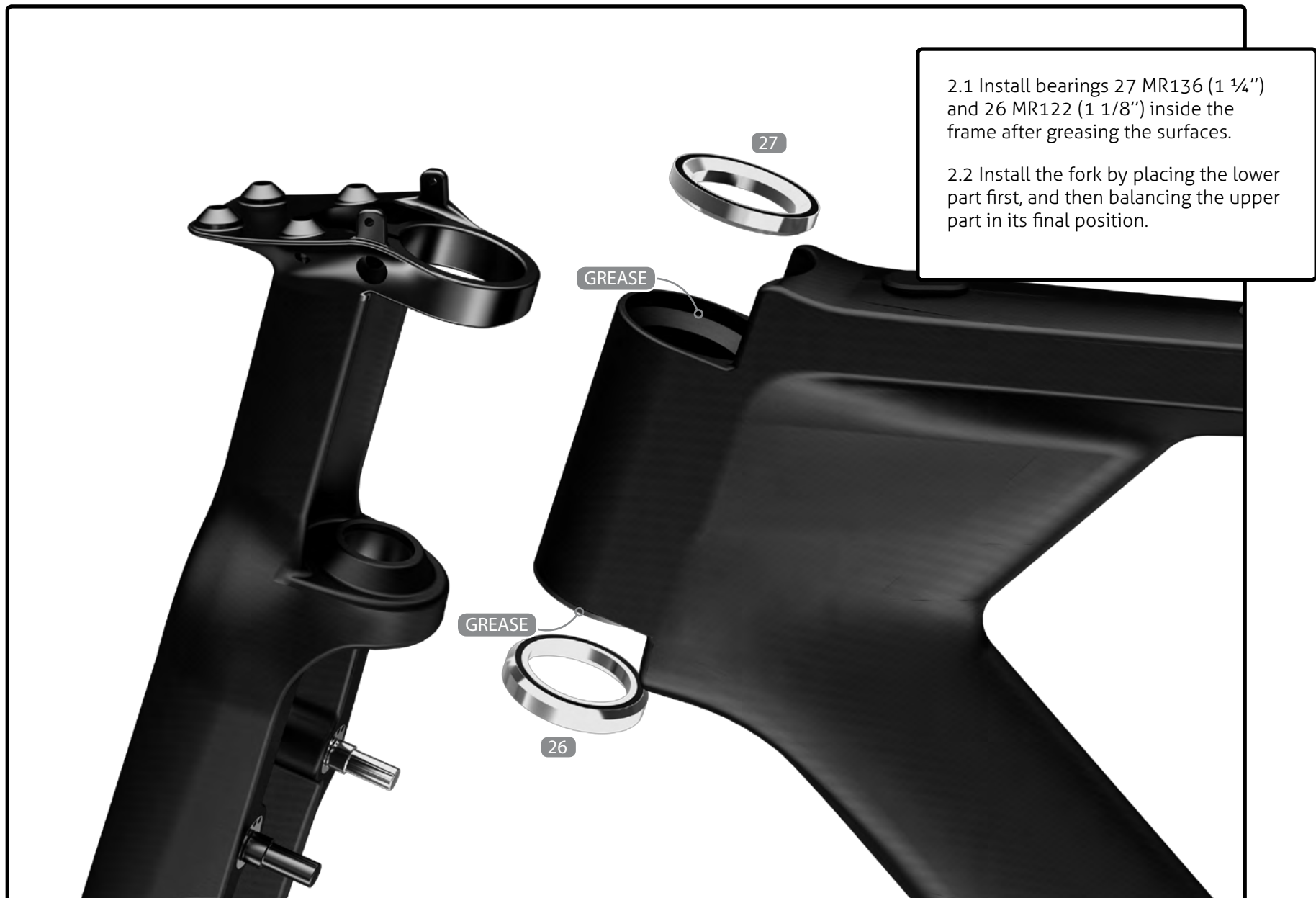


13. Parts listing



When assembling a new frame, be sure to check if the following parts are assembled correctly.

Parts installed on the frame Description			Screw type	Torque Nm	Detail
1	Front derailleur hanger	Screw (2)	3mm	4Nm	Loctite
2	Rear derailleur hanger	Screw (2)	3mm	4Nm	Loctite
3	Bottle cage	Screw (4)	4mm	3Nm	Grease
4	Bottom bracket cover	Screw (2)	5mm	2Nm	Grease





2.3 Slightly unscrew the steering column set screw (4c) located on the fork.

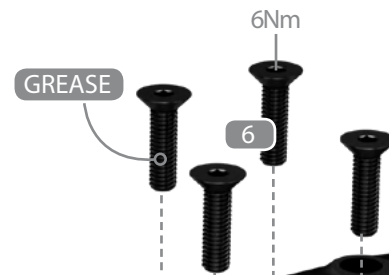
2.4 Screw in the compression column (4b) (specific to the size of your frame) inside the head tube. The threads must be lightly greased until the compression column can be inserted smoothly and tightly.

2.5 Screw in the safety screw (4c) at 6Nm.



3.1 Choose the desired position of the handlebar: high (+ 2.5cm) or low (- 2.5cm).

3.2 Apply grease on the 4 screws (6) (M6x22mm) and tighten them at 6Nm in an alternate way.





3.3 Install vertical spacers (17) and two sleeve nuts (15).

See next page for stack configuration options.





Parts needed to adjust pads stack's height

Total stack height (mm)	0	5	10	15	20	25	30
WITH SWIVEL							
Required spacer	X	X	X	X	None	5	10
Sleeve nut					20mm	20mm	30mm
Screw (flat head)					15mm	15mm	15mm

WITHOUT SWIVEL

Required spacer	None	5	10	5 + 10	20	5 + 20	10 + 20
Sleeve nut	20mm	20mm	30mm	30mm	30mm	30mm	50mm
Screw (flat head)	15mm	15mm	15mm	15mm	25mm	25mm	15mm

Total stack height (mm)	35	40	45	50	55	60	65
WITH SWIVEL							
Required spacer	5 + 10	20	5 + 20	10 + 20	5 + 10 + 20	40	5 + 40
Sleeve nut	30mm	30mm	30mm	50mm	50mm	50mm	50mm
Screw (flat head)	15mm	25mm	25mm	15mm	15mm	25mm	25mm

WITHOUT SWIVEL

Required spacer	5 + 10 + 20	40	5 + 40	10 + 40	5 + 10 + 40	20 + 40	5 + 20 + 40
Sleeve nut	50mm	50mm	50mm	50mm	50mm	80mm	80mm
Screw (flat head)	15mm	25mm	25mm	35mm	35mm	15mm	15mm

Total stack height (mm)	70	75	80	85	90	95	100
WITH SWIVEL							
Required spacer	10 + 40	5 + 10 + 40	20 + 40	5 + 20 + 40	70	5 + 70	10 + 70
Sleeve nut	50mm	50mm	80mm	80mm	80mm	80mm	80mm
Screw (flat head)	35mm	35mm	15mm	15mm	25mm	25mm	35mm

WITHOUT SWIVEL

Required spacer	70	5 + 70	10 + 70	5 + 10 + 70	20 + 70	5 + 20 + 70	10 + 20 + 70
Sleeve nut	80mm	80mm	80mm	80mm	80mm	80mm	80mm
Screw (flat head)	25mm	25mm	35mm	35mm	45mm	45mm	55mm

Notes:

- Always place the smaller spacers underneath
- Make sure you have at least 6 full threads on each screw
- Every spacer screw must be tightened to 5Nm
- The M6 screw (5mm allen key) that enables the swivel adjustment must be tightened to 8Nm
- The screws linking the extension connectors to the swivel are 12mm long (M5 flat head)



3.4 For an inclined position, use the swivel assembly (14).

STEP 1 : Swivel assembly content:

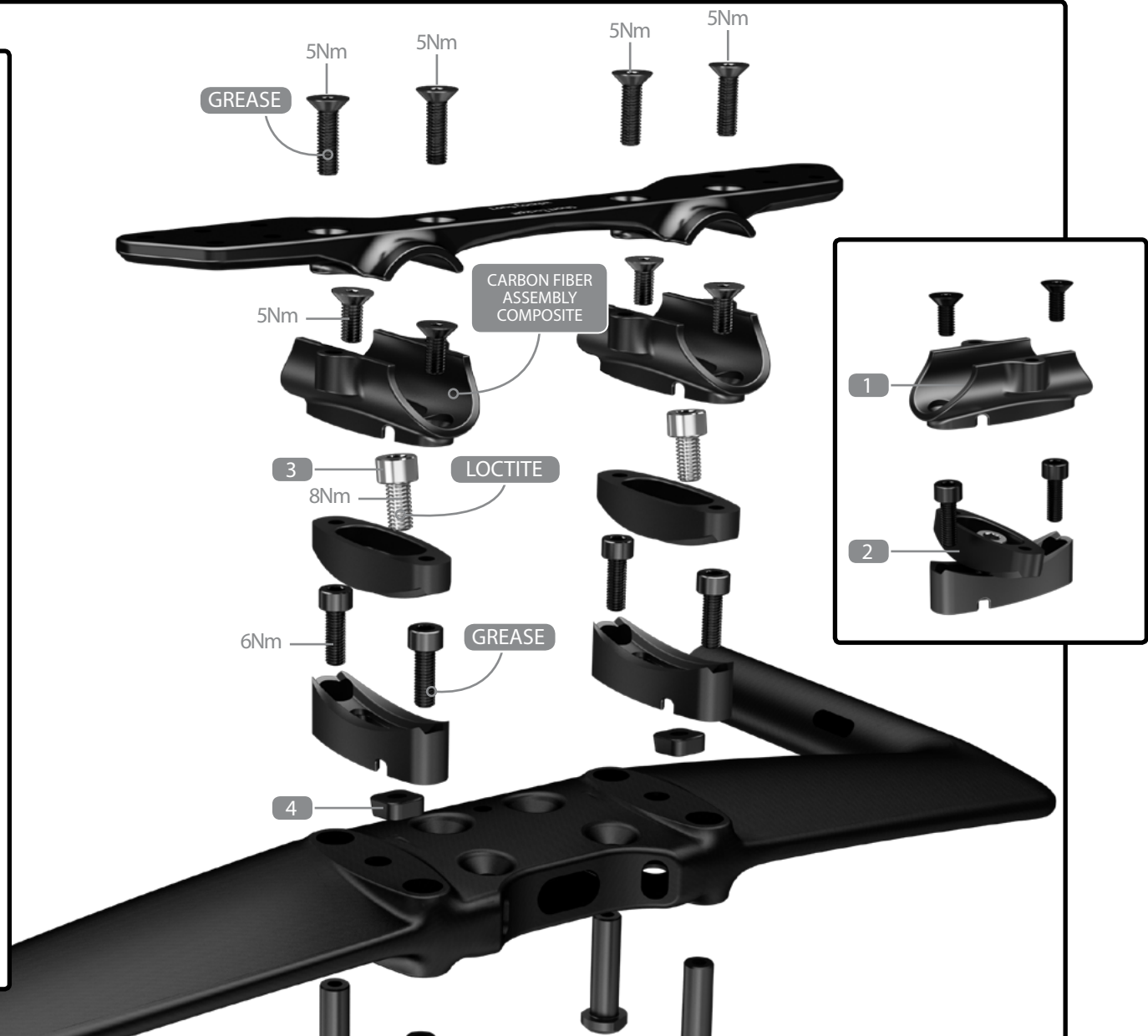
- 1- Connector base (8)
- 2- Swivel spacer (14a + 14b)
- 3- Swivel screw (14c)
- 4- Swivel square nut (14e)

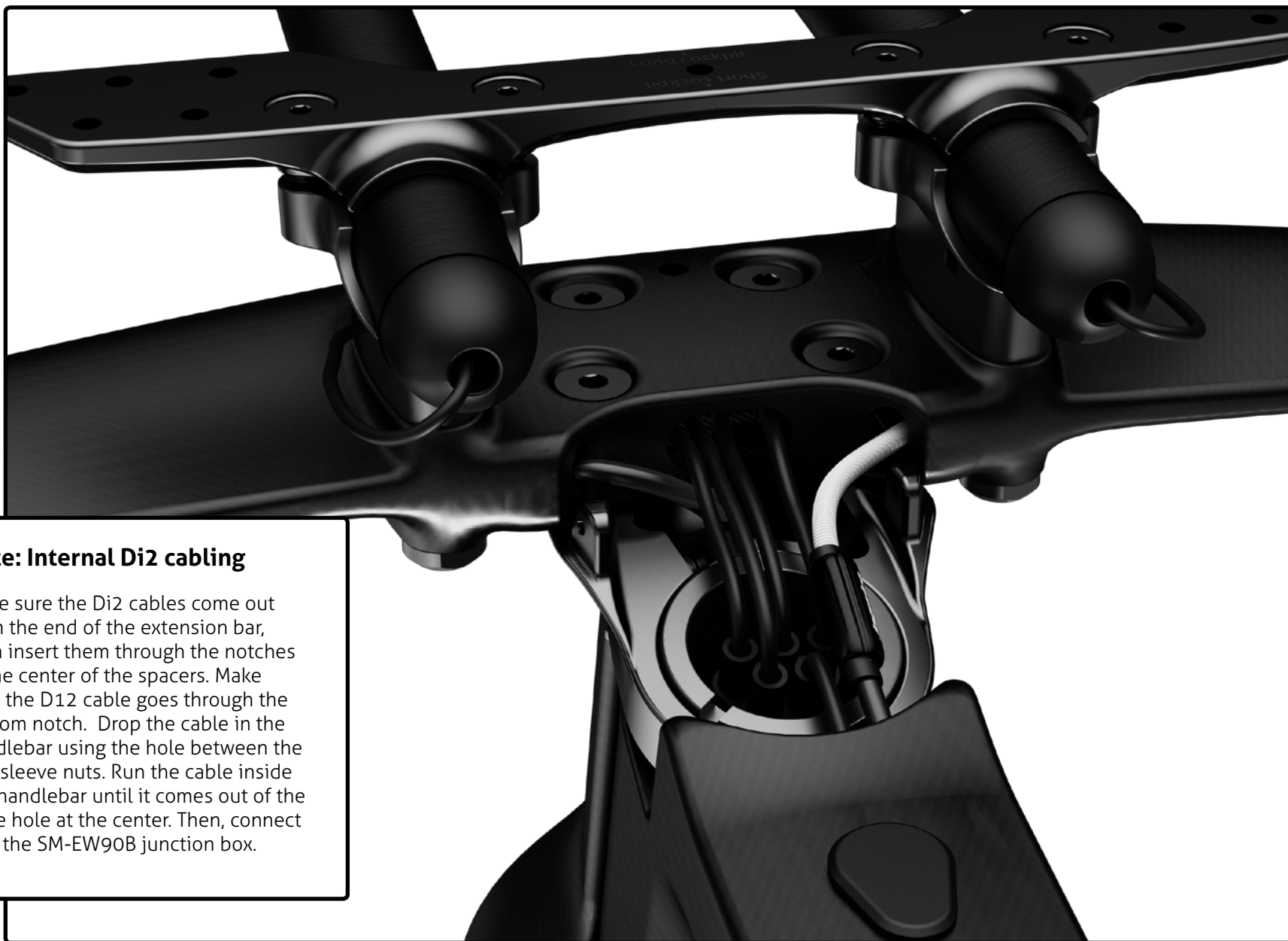
Assemble the unit and leave it unscrewed, just enough to allow adjustment and also allow to turn the swivel 90 degrees to have access to the bottom hole to fix the flat head screw at 6Nm. Once the proper angle is set, use a marker to obtain a reference and adjust both spacers with same angle. Use the Di2 hole as a starting point.

Fix the 6mm flat head of the swivel screw (silver) to 8Nm.

STEP 2 :

The connector base must be fixed to the top of the swivel assembly, not on the sleeve nuts. The sleeve nuts will be used to fix the spacers later.



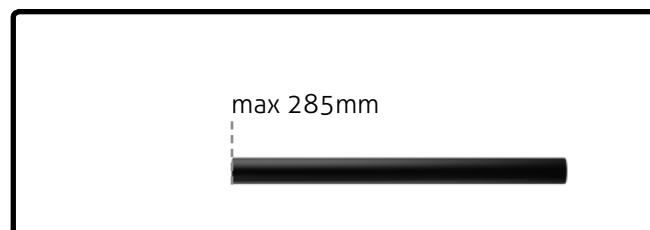
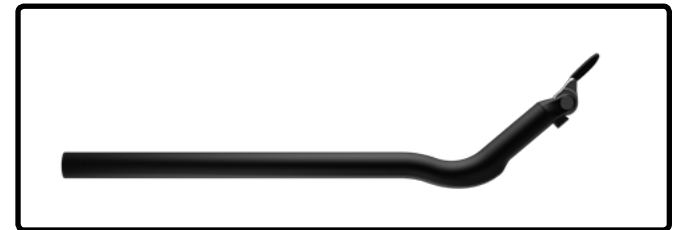
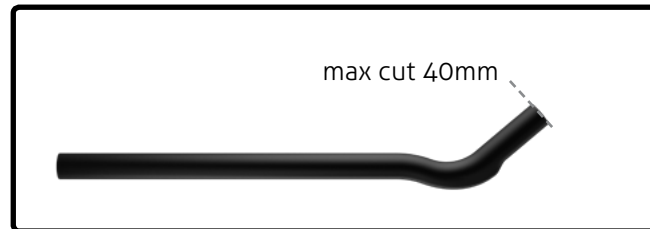
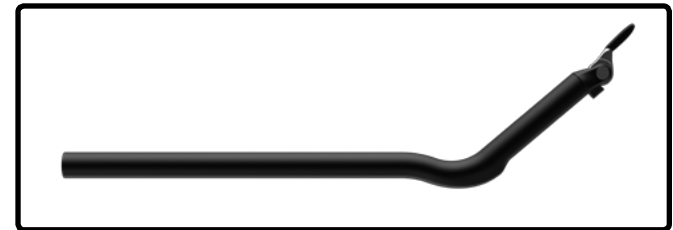
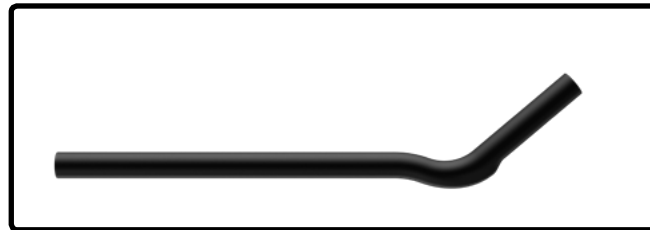
**Note: Internal Di2 cabling**

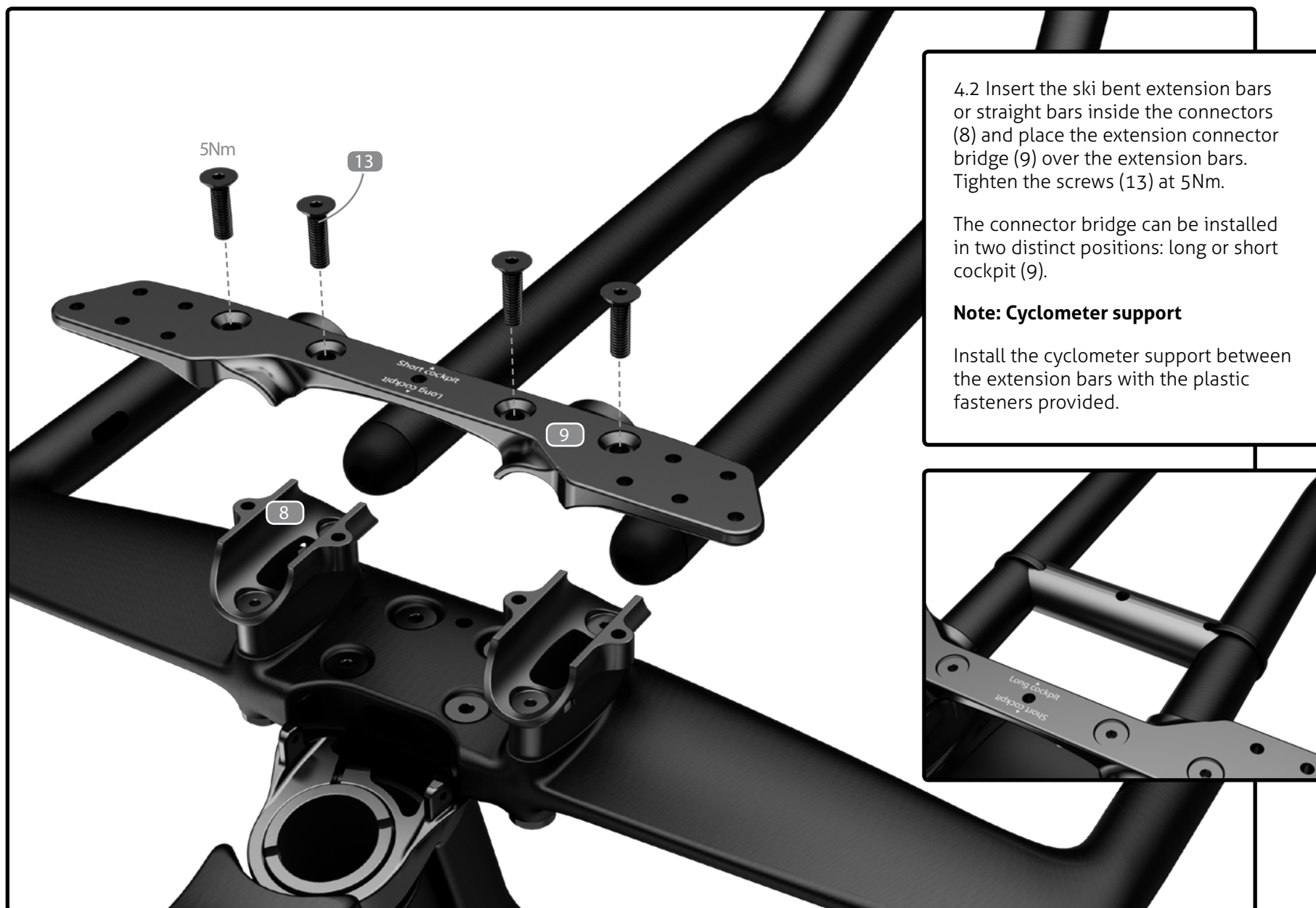
Make sure the Di2 cables come out from the end of the extension bar, then insert them through the notches at the center of the spacers. Make sure the D12 cable goes through the bottom notch. Drop the cable in the handlebar using the hole between the two sleeve nuts. Run the cable inside the handlebar until it comes out of the large hole at the center. Then, connect it to the SM-EW90B junction box.



4.1 Cut the extension bars (7) at the desired length to obtain a straight post*. The bars must not exceed 285mm in length. **The cut must be made on the elbow side.** The other end of the bar is used exclusively to install the shifter. Apply some carbon fiber assembly gel in the clamping area.

***Warning: If using a ski bent section, no more than 40mm can be cut out.**







5.1 Install the rear derailleur cable housing starting at the drive side's drop-out.

5.2 Install the front derailleur cable housing starting under the bottom bracket shell.

5.3 Install the front brake cable housing starting at the center of the handlebar. Make sure that the cable housing does not go through the compression column, but through the space in front of the compression column (see image A, page 16).

5.4 Install the rear brake cable housing starting under the bottom bracket shell.

See the table below for the cable housing length suggested.

Suggested lengths of the cable housing*

(the medium frame is used as a reference)

Cable housing/length	XS	S	M	L
FRONT brakes (KEB leftover)	40cm	41cm	43cm	45.5cm
REAR brakes (Gray EZ-Bend housing)	106.5cm	108cm	110cm	112.5cm
FRONT derailleur	140cm	142cm	144cm	150cm
REAR derailleur	198cm	200cm	202cm	204cm

* For guidance purposes only. Can vary according to the shifters used.



Note: To make the brake cable housing go inside the handlebar more easily, use a brake cable as a guide and insert it head first (from the middle of the handlebar towards the brake lever) using one of the two side holes. Follow the curves of the handlebar. Once the cable is out, slide the cable housing along.

IMPORTANT : You must cut the metal ferrule located at the end of the rear brake EZ-Bend cable housing prior to install it correctly on the rear brake barrel adjuster.

A



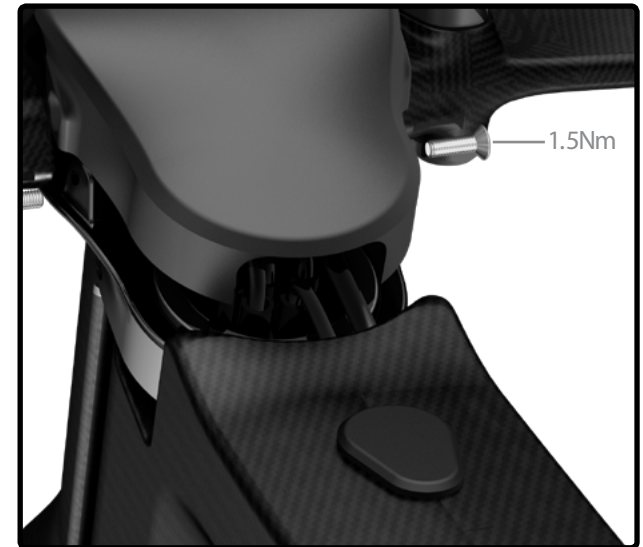
Mechanical drive-train configuration

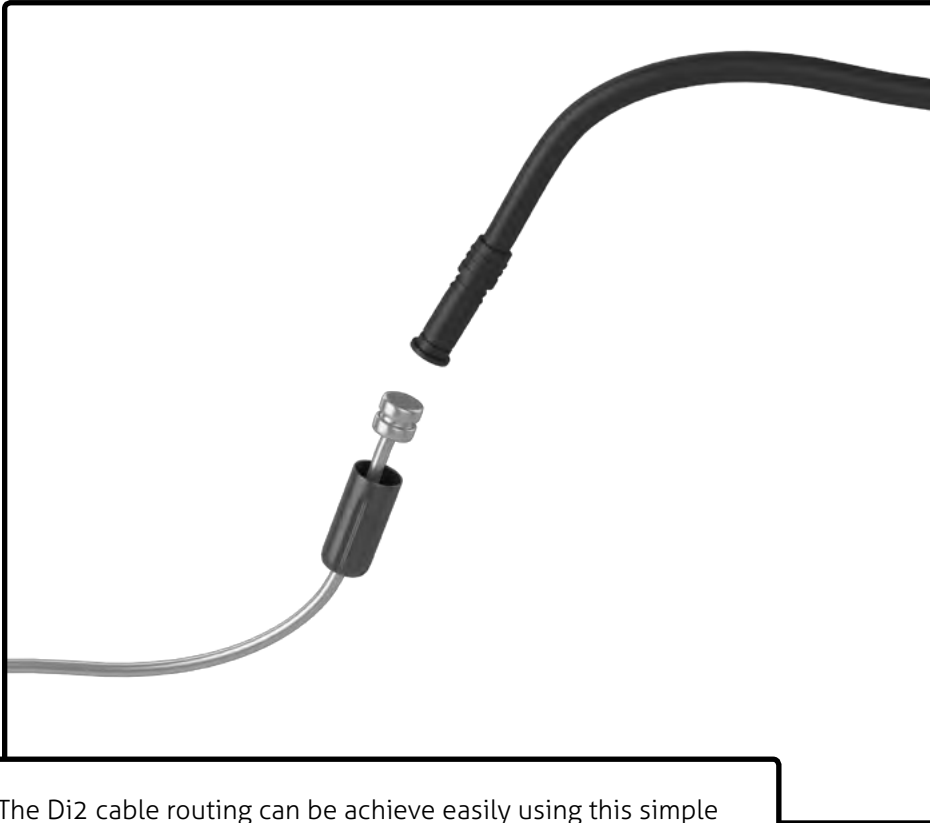
B



Electronic drive-train configuration

C





The Di2 cable routing can be achieved easily using this simple trick: use a brake cable and a metal cable end to fix the Di2 cable. For more information on Shimano Di2 electronic system installation, go to : <http://si.shimano.com>.

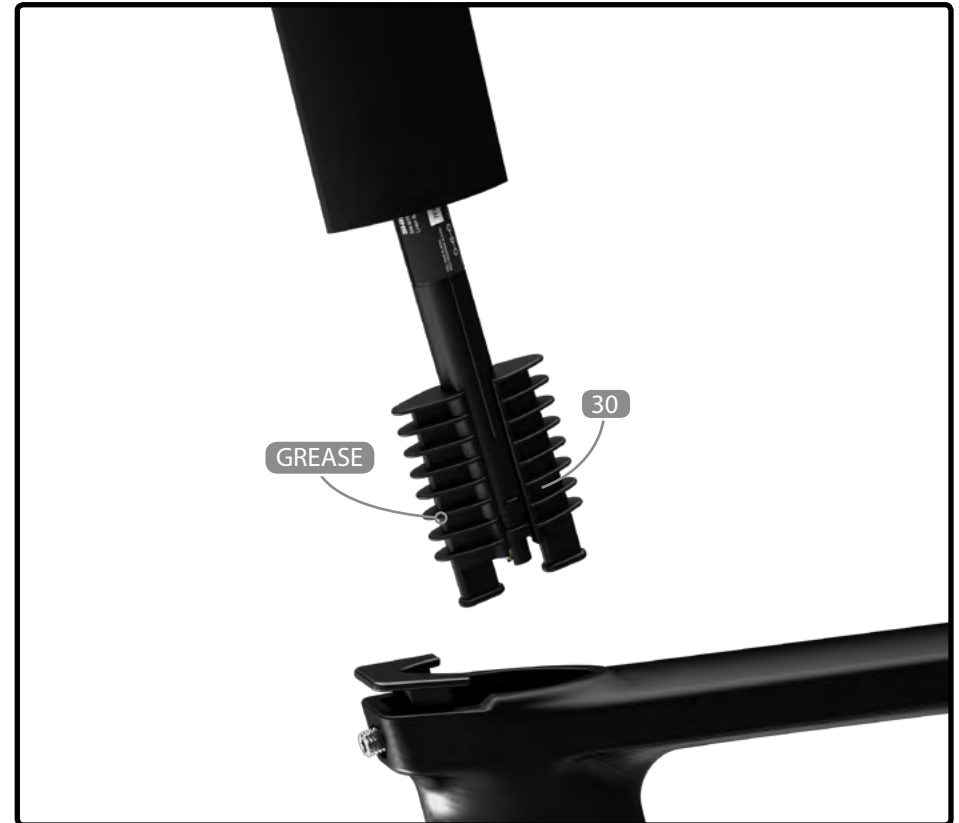


Use the proper grommet on the top tube to fix the cable correctly (depending if you use electronic shifting or mechanical drive train).



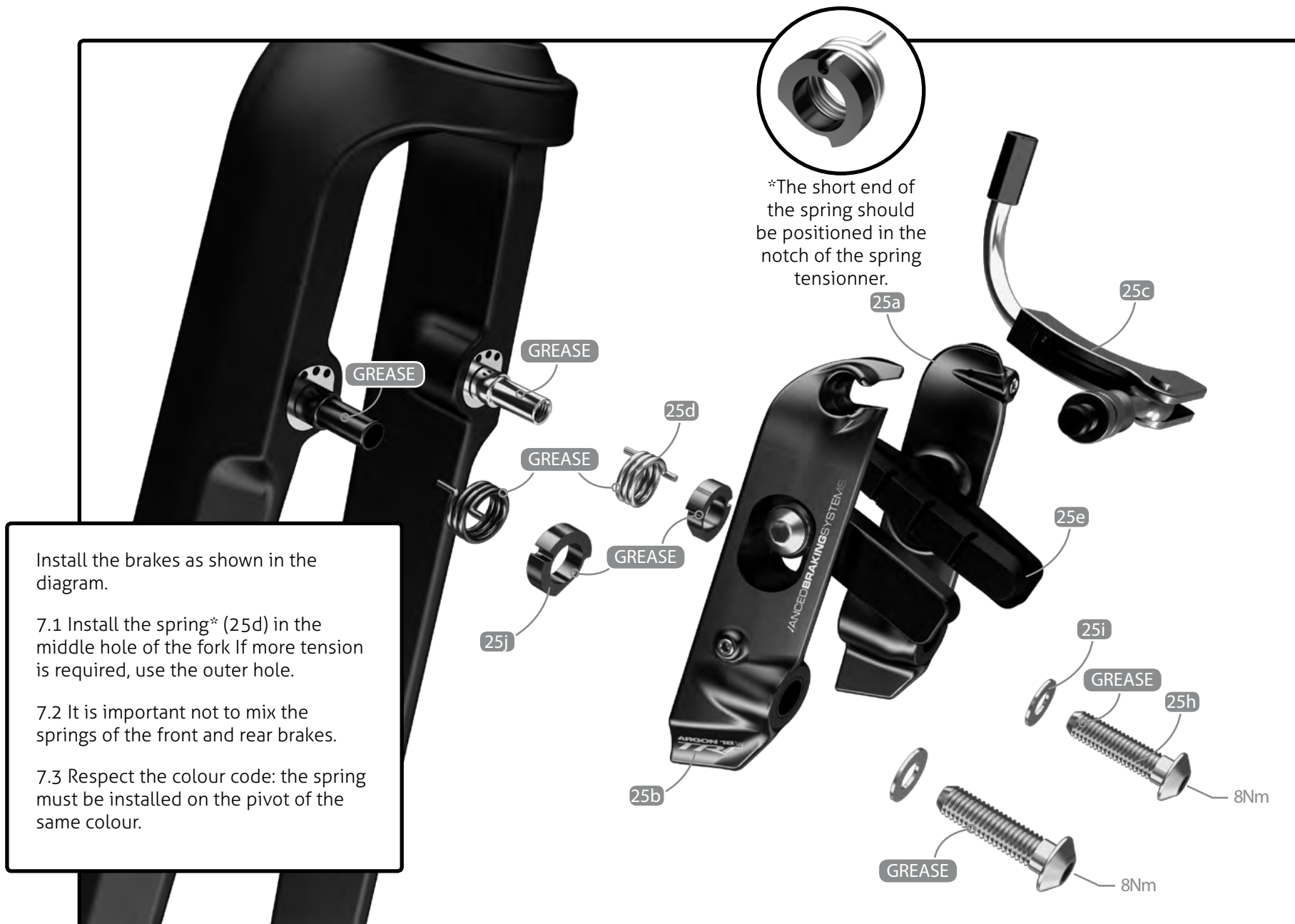


The Di2 battery can go either under the left chainstay (Shimano SM-BTR1) or inside the seatpost (Shimano SM-BTR2) by using the Di2 battery older (30). For this configuration, apply a slight amount of grease on both parts.





Use the proper grommet for the front derailleur cable depending if you use mechanical (19b) or electronic drive train (19a).





7.4 Adjust brake pads according to the width of your rims:

To install the cable/cable housing inside the head tube, the cable and cable housing must go through the front part of the frame

Pass the cable through the curved straw and then in the appropriate guide. Make sure that the length of the cable housing is sufficient for the guide to remain horizontal.

Fix the cable to the caliper with the 3mm screw and tighten it to 4Nm.



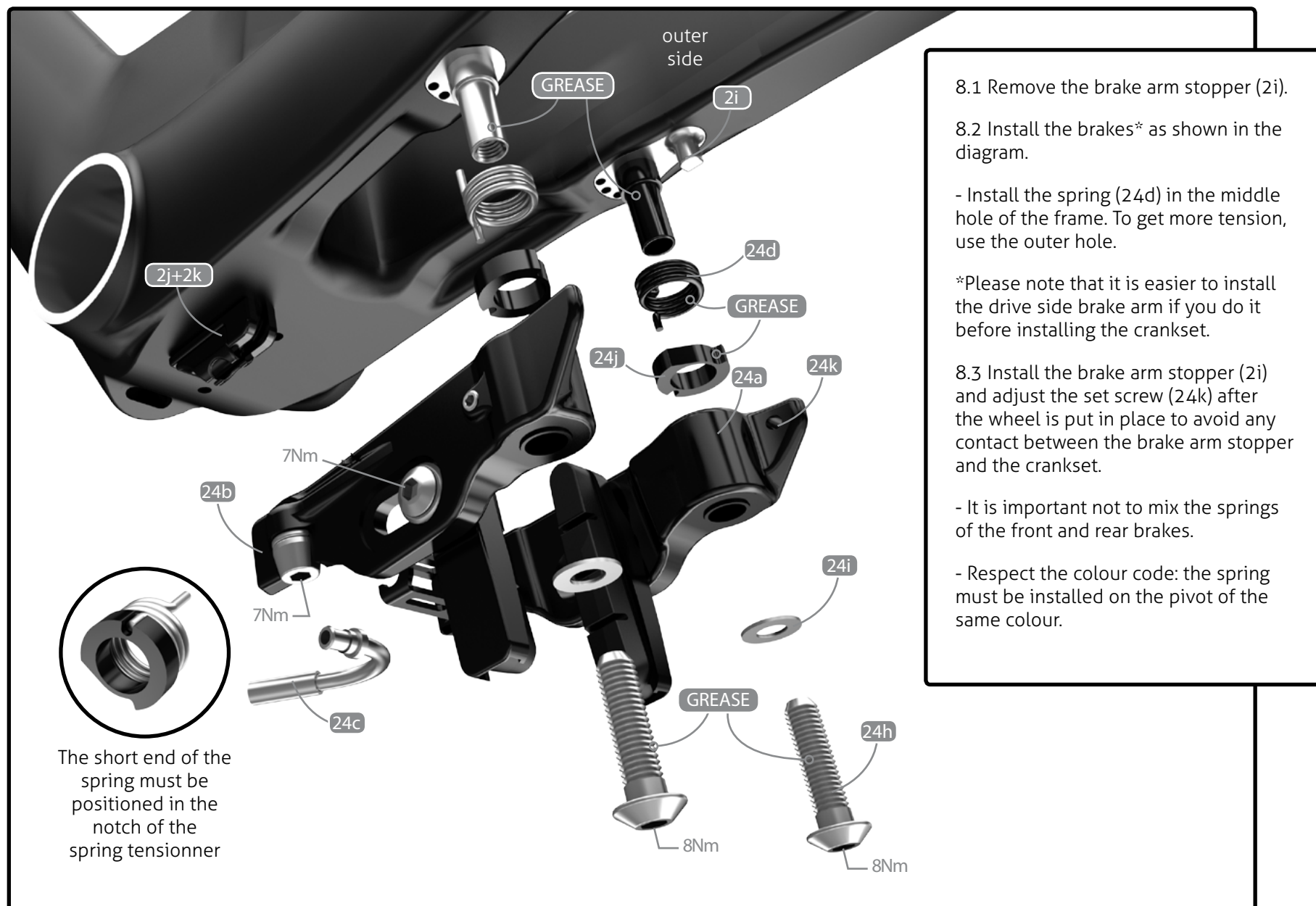


Adjust brake pads according to the width of your rims:

- You can configure the brake pad spacing with 1mm (25f), 2mm (25g) or no spacers behind the brake pads depending of the rim width you are using.

Spacers required according to the rim width

Rim width	Spacer combinaison
19mm (ex.: Shimano C50)	2mm spacer
24mm (ex.: 808 clincher/Enve)	1mm spacer
26 to 27mm max (ex.: 808 TU/303 TU)	NO spacer







9.1 Install the adhesive Velcro on the armrests (10&11).

9.2 Screw the armrests (10&11) into the extension bar connector bridge (13) at 5Nm in the position desired. Reverse the left and the right armrests to obtain a more forward or backward setup.

9.3 Finish the assembly by installing the armrest pads (22).





11.1 Install the saddle on the rocker (20f) and slightly tighten the rail clamp using a ball end hex key.

11.2 Tighten the upper screw of the rocker clamp (20a) by keeping a space of 2 to 3 mm between the aluminum and carbon parts.

11.3 Adjust the angle of the saddle and tighten the lower screw of the rocker clamp (20b).

11.4 Adjust the saddle offset and finish tightening of the rail clamp (20c).



The 2waypost ASP-7500 can be flipped to achieve a triathlon or a road position (75°/78°).

The seat clamp offset can be set by flipping the rail clamp (20d) and the rocker (20f).

Road : -10mm to -15mm

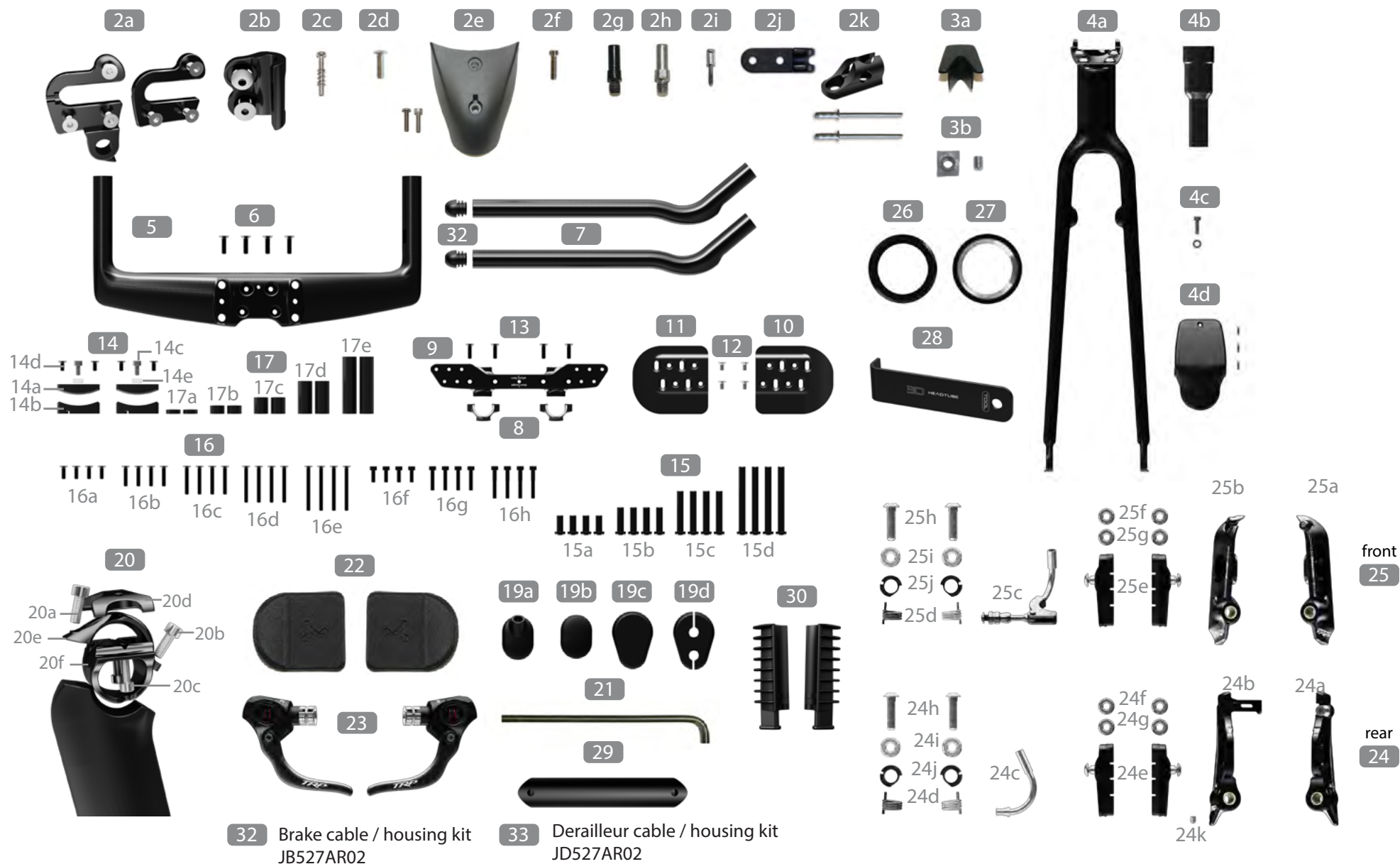
Tri : +10mm to 15mm





The front derailleur hanger can be adjusted according to the front derailleur angle to get an equal curve between the derailleur and the big chain ring. Once at the right angle, use blue 242 Loctite and screw in at 6Nm.





Images are for reference only. Proportions are not accurate.



No.	Name	A18 SKU#	Qty
#	Frameset Parts		
1	E-118 frame		1
#	Parts installed on the frame		
2a	Rear derailleur hanger and drop out insert with screws M4x7mmF	38175	1 set
2b	Front derailleur hanger with screws M5x16mmB & M5x16mmF - Model D	36197	1
2c	Rear axel adjustment round head Phillips screws M3x20mm and springs		2
2d	Screws for water bottle cage M5x16mmB	38234	5
2e	Plastic BB cap with screws M5x20mmB and M5x16mmS	36660	1
2f	Di2 battery mount screw M4x16mmS	38233	2
2g	Font brake pivot	36914 (left; black)	1 black
		36915 (right; silver)	1 silver
2h	Rear brake pivot	36914 (left; black)	1 black
		36915 (right; silver)	1 silver
2i	Brake arm stopper round head Phillips screw M3x20mm + Aluminium sleeve		1
2j	Base of FD cable guide	36661	1
2k	FD cable guide with rivets	36659	1
#	Seat clamp kit		
3a	Seat clamp wedge	36658	1
3b	Seat clamp thread with screw M8x10mm	36657	1



No.	Name	A18 SKU#	Qty
#	Fork kit		
4a	E-118 Fork		1
	XS	FK.E118N.XS.216A	*
	S	FK.E118N.S.216A	*
	M	FK.E118N.M.216A	*
	L	FK.E118N.L.216A	*
4b	Steerer		1
	XS	80071	*
	S	80070	*
	M	80069	*
	L	80068	*
4c	Stem clamp socket head screw M5x15mm and washer	38987	1
4d	Stem cap with screw M3x10mmF	80033	1



No.	Name	A18 SKU#	Qty
#	Handlebar kit		
5	TT05 Handle Bar	80011	1
6	HB Screws M6x22mmF	38908	4
7	TT05 extension bar	80061	2
8	TT05 extension conector base	38912	2
9	TT05 extension conector bridge	38914	1
10	E-118 armrest-Right	80013	1
11	E-118 armrest-Left	80012	1
12	Amrest screws M5x10mmF	33338	4
13	Extension connector screw (bridge) M5x18mmF	38907	4
14	Swivel spacer		
14a	Swivel top bracket	38915	2
14b	Swivel bottom bracket	38916	2
14c	Swivel socket head screw M6x12mm	38911	2
14d	Extension connectors screw for swivel		
14e	Swivel square nut	80382	2
15	Sleeve Nut		
15a	Sleeve Nut 20mm	38917	4
15b	Sleeve Nut 30mm	38918	4
15c	Sleeve Nut 50mm	38913	4
15d	Sleeve Nut 80mm	38919	4



No.	Name	A18 SKU#	Qty
#	Handlebar kit (continued)		
16	Extension connectors screws		
16a	M5x15mmF	38989	4
16b	M5x25mmF	38990	4
16c	M5x35mmF	38991	4
16d	M5x45mmF	38992	4
16e	M5x55mmF	38993	4
16f	Socket head screw M5x15mm	38994	4
16g	Socket head screw M5x25mm	38995	4
16h	Socket head screw M5x35mm	38996	4
17	Extension spacers		
17a	Extension spacer 5mm	38997	2
17b	Extension spacer 10mm	38998	2
17c	Extension spacer 20mm	38999	2
17d	Extension spacer 40mm	39000	2
17e	Extension spacer 70mm	39001	2
18	Extension connectors screw for swivel M5x12mmF	39002	4
#	Di2 configuration specific parts		
19a	FD cable Di2 grommet	36195	2
19b	Grommet plug for Di2 hole filler (non Di2)	36678	2
19c	Top tube cable grommet (Di2)	38881	1
19d	Top tube cable grommet (non Di2)	38880	1



No.	Name	A18 SKU#	Qty
#	Seat post with the following parts assembled		
20	E-118 seatpost (ASP-7500)	SPE118N.216A	1
20a	Upper HexSocket screw (M6*20mm S) for rocker clamp		1
20b	Lower HexSocket screw (M6*20mm S) for rocker clamp		1
20c	HexSocket screws (M5*20mm S)		2
20d	Top rail clamp		1
20e	Rocker clamp		1
20f	Rocker		1
#	Additional parts		
21	4mm allen key for brake adjustment	37589	1



No.	Name	A18 SKU#	Qty
#	Also included with the frameset - shipped separately		
22	Armrest foam pads	36623	1 set (left+right)
23	RL977 brake levers	37470	1 pair
24	TKB77 rear brake - including the following parts	36602	
24a	Brake Arm right		1
24b	Brake Arm left		1
24c	Tektro rear brake noodle (125 degrees)	36713	1
24d	• Springs	36714 (black)	1
		36715 (silver)	1
24e	• Brake pad – P963.12 for alloy rim		2
24f	• 2mm spacer for TKB77 & TKB78 brakes	36717	2
24g	• 1mm spacer for TKB77 & TKB78 brakes	36716	2
24h	• Pivot bolts		2
24i	• Pivot washer		2
24j	• Spring tensionner		2
24k	adjustments set screw		



No.	Name	A18 SKU#	Qty
#	Also included with the frameset - shipped separately		
25	TKB150 front brake - including the following parts	38968	
25a	Brake Arm right		
25b	Brake Arm left		
25c	Tektro front brake noodle assembly (97 degree)	39004	
25d	Springs	39005 (black)	1
		39006 (silver)	1
25e	Brake pad P961.11 for alloy rim		2
25f	1mm spacer for TKB150 brake 1mm spacer for TKB150 brake		2
25g	2mm spacer for TKB150 brake 2mm spacer for TKB150 brake		2
25h	Pivot Bolt		2
25i	Pivot Bolt washer		2
25j	Spring tensionner		2
26	Headset bottom bearing	38933	1
27	Headset top bearing	38934	1
28	3D headset tool	36718	1
29	Computer mount	38975	
30	Di2 battery holder for Aero SP	38757	2
31	Bar end plug		2



No.	Name	A18 SKU#	Qty
#	Also included with the frameset - shipped separately		
32	Brake cable / housing kit - including the following parts		
32a	Housing 5mmKEB-SL		1
32b	Housing 5mmCGX-SL		
32c	End caps		2
32d	End caps		1
32e	End caps		2
32f	Cable		2
32g	Barrel adjuster		2
32h	EZ Bend Housing		1
33	Derailleur cable / housing kit - including the following parts		
33a	Housing LEX40-SL		1
33b	End caps		2
33c	End caps		2
33d	Cable		
33e	Barrel adjuster		2