



## PN's 17-450/455/460/463/415 Axle Block Kit Installation Instructions

*Note-To help prevent marring or scratching when assembling this product, use soft jaws or a thick, clean rag in your bench vise in all steps of disassembly and assembly.*

- Place bike on a secure stand and remove the rear axle. Clean axle assembly and swingarm area by removing any dirt and/or grease.
- Secure the drive side axle assembly's axle block in the bench vise.
- By hand thread the supplied square nut onto the axle threads until it bottoms.
- Screw the stock axle nut onto the axle until it mates against the square nut.
- Place a 32mm wrench on the square nut and a 32mm socket on the axle nut. Lock them against each other by tightening them firmly together. **Figure 1.**
- Remove axle assembly from bench vise.
- Apply a heat source (heat gun, etc.) to the drive end of the axle assembly to help release the thread locking agent applied at the factory.

**⚠ WARNING** *Touching hot surface could result in serious injury/burns*

- Secure the drive side axle assembly's axle block back in the bench vise.
- Place the wrench on the square nut and unthread the axle from the stock axle block. Be aware it could take a large amount of force to break it free. Once removed, clean the axle threads thoroughly.
- Remove the stock axle block from the bench vise.
- Apply an ample amount of Red Threadlocker (Loctite 271, etc.) to the exposed axle threads.
- By hand thread the Titanium receiver onto the threadlocked threads. **Figure 2.**
- Place the Titanium receiver end of the axle in the bench vise and tighten vise securely enough to hold it, yet not so tight it distorts or damages the Titanium receiver.
- Place the 32mm socket on the axle nut and torque to 70 ft/lbs.

**NOTE-Allow 24-hour cure time for the Red Threadlocker.**

- Remove the axle assembly from the bench vise and set it on a flat surface. Place the wrench on the square nut and with the other end of the wrench touching the flat surface. Use your socket to break free the two nuts. Remove the axle nut and square nut from the axle.
- Slide the supplied drive side axle block onto the axle so it mates with Titanium receiver.
- Insert the axle assembly into the swingarm and wheel.
- Install the brake side axle block and axle nut.
- Per factory specifications: adjust chain tension and torque axle nut.

