



General order of assembly:

Prep all PE parts (soak and drill)

Prep all 3D parts (remove sprues, clean and dry fit)

Mock up rotor/hub assembly before arm attachment

Attach PE caliper brackets & steering arms

Prep/paint parts

Rotors to hubs (align interlocking lugs)

Fit calipers over rotors and Attach to brackets

Attach stainless tubes inside strut body

Attach 3D upper strut bodies after fitting over tubing

Fit springs over top of strut body

Fit CNC retainer over tubing and attach

Soak all photo etch in acetone or similar solvent to remove blue mask and rubber backing.

Remove sprue remnants from back side of (hub) spindle boss, spindle nose and calipers. Finish as desired.

As currently designed, alignment pins on steering arm mounts (on 3D spindles) locate photo etch steering arms slightly too close to rotor when assembled. Pins should be removed from strut body brackets and eyeball final arm location after rotors and hubs have been trial fitted.

Drill out holes in caliper brackets to $\sim .028$ " to fit over simulated bolts in 3D gusseted spindle mounts.

Drill 3D hub centers to $.093$ " diameter. Be sure to test fit hub on spindle before assembly to assure ease of fit. Assembly will be simplified if hub slides over spindle without binding. File hub ID or spindle OD for fit without being sloppy. Boss on front of hub should protrude very slightly beyond nose of spindle.

After strut body with caliper brackets and steering arms is assembled, slide hub/rotor assembly over spindle and trial fit caliper so it straddles rotor and fits adjacent to caliper mount.