

# Stem Fixture Instructions

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Congratulations on the purchase of your Alex Meade Bikeworks stem jig. It should give you years of flawless service.

A few things to know about your jig:

- 1) The two 0.625" shafts that hold the adapter rings are made of stainless steel. All other parts except the Park stand shaft are steel or tool steel, and can be lightly coated with oil to prevent surface rust in storage. The Park stand shaft is aluminum. Remove the oil prior to setup and brazing or welding.
- 2) Your stem jig comes with adapter rings to allow you to make stems of particular steerer and bar diameters. There are four different ring sizes available, and a full set would consist of six pairs, as follows:

(2) 1 inch (1) 26mm (1) 1-1/8 inch (2) 1-1/4 inch

Tube sections should be reamed or bored to proper internal size prior to using the jig

- 3) The two parts that form the "L" shaped steerer clamp support are a mated assembly. If you remove the 6mm bolt holding the two parts of the "L" together, it's possible that you'll lose alignment accuracy. I recommend keeping these parts together, checking the bolt tightness from time to time. Should you have a need to disassemble the two shafts, I recommend checking the assembly with a surface plate and height gauge after reassembly to ensure that the stem shaft is parallel to the reference face of the disk at the base of the assembly.
- 4) The standoff of the centerline of the stem is 4.5" from the base plate. The jig is designed to use a 1.5" long section of tubing to form the bar clamp. This will place the stem extension tube at the correct standoff and perpendicular to the bar clamp. The recessed cap for the steerer clamp allows for variation in steerer clamp length, up to about 4.5" length. I can supply the jig with greater length capability if needed. I can also supply options for quill stems and TIG back-purging.

