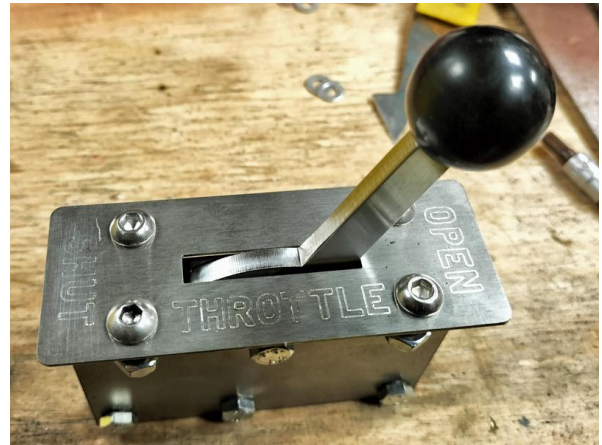
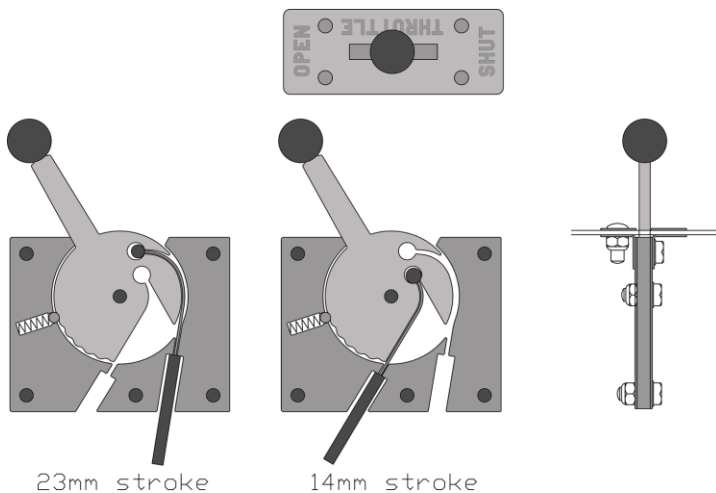


Instructions for Throttle Lever

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Before painting the laser cut parts need all the cut edges cleaning up on to remove any black residue, a simple wire brushing is sufficient. Most parts will have a tiny tab where the cutting begins and ends, this isn't normally a problem but occasionally it occurs where two parts will mate together or a bearing is fitted and needs to be filed flush.

The lever should be fitted to the panel with four M6 button headscrews and nyloc nuts.



Assembly

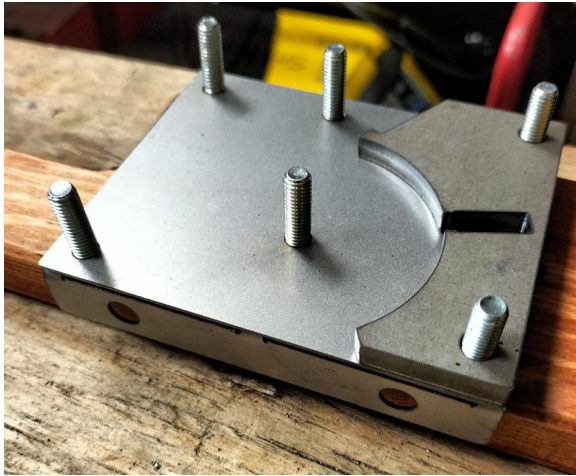
Round off the sharp edges of the lever with a rotary flap wheel in an electric drill or a flap wheel in an angle grinder, then use emery cloth to polish it up, trying to keep all the scratches along the lever which will give a better appearance. Peel the plastic film off the stainless top plate and wipe the residue off with white spirit, rubbing only in the direction of the brushed finish or you may mark the surface.



< Put each of the brackets in the vice in turn and fold them to 90 degrees, a piece of wood placed behind and pulled towards you gives an even bend.

> Don't flatten the bends with a hammer, they are designed to be used with a gentle bend.





< Place washers over the threads of 5 screws, push two through the holes in a bracket and lay the back plate on top. Begin to add the body parts.

> Add the rest of the body parts, place a spring washer and plain washer over the 6th screw, fit it through the centre hole.

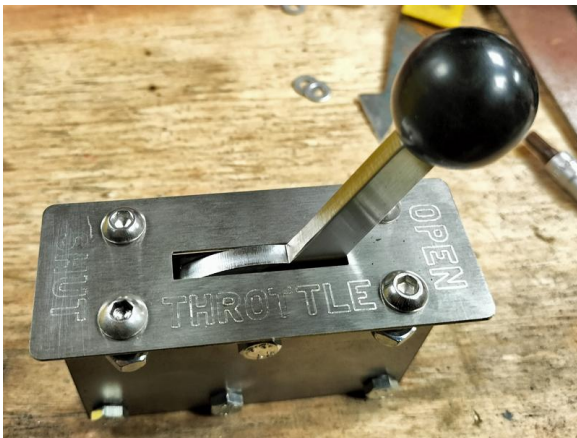


< Place a thin form B washer over the central pivot and add the lever as shown. Place the ball bearing in it's slot and add the spring. Beware – the spring want's to launch itself across the room and so does the ball. Add the bicycle brake cable according to whether you want a 14mm travel or a 25 mm travel as shown in the diagram at the top.

> Add the second side and bracket and tighten the nuts, keeping all the body parts aligned with the edges.



< Add a nut to the centre screw, it fits in the cutout allowing you to adjust the friction by turning the screw without having to find a second spanner. Tighten it until the lever has the resistance that you want.



< Add the stainless top plate, then drill out the ball with an 8mm drill and try to push it onto the end of the lever. You will need to gradually take the corners off the lever with a file until the ball just pushes on. Leave the oiling of the moving parts until after painting. When fitting to a panel the top plate can be used as a template to mark out the holes that need to be cut in the panel.