



Step:

1. Loosen the four clamp screws on the tube-clamp base that secure carbon tubes 1–4. Route the power-train harness through the carbon tube, insert the tube fully into the clamp base, and verify that the power set is horizontal after assembly.
2. Tighten clamp screws in the following order: 1 \rightarrow 3 \rightarrow 2 \rightarrow 4, repeating the sequence until only pre-tension is achieved. Do not fully tighten any screw in a single pass.
3. Final torque for screws 1–4 must be $2.5 \text{ N} \cdot \text{m} \pm 10 \%$.
4. If required, drill holes in the carbon tube and add corresponding pilot holes above/below the clamp base for rivets (pull rivets) to secure the power set.