FACTOR

FACTORBIKES.COM

2025 ONE MANUAL

INTRODUCTION

Congratulations on the purchase of your FACTOR product. Please review thoroughly the following instructions and only follow them for correct operation and use. Should you fail to follow the following instructions and warnings, this could result in damage of the product, damage to the bicycle and in severe situations cause possible injury and or death.

Since specific tools and bicycle service experience is required for proper assembly installation, it is recommended that the product be assembled by a qualified bicycle mechanic. FACTOR BIKES assumes no responsibility for damages or injury due to improper assembly and installation of the product(s).

LIMITED LIFETIME WARRANTY ON BICYCLES AND FRAMESETS

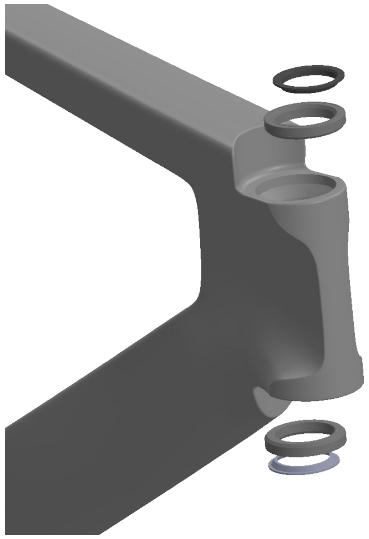
To qualify for FACTOR'S LIMITED LIFETIME WARRANTY please visit www.factorbikes.com and register your product(s) within 15-days of purchase.

WARRANTY

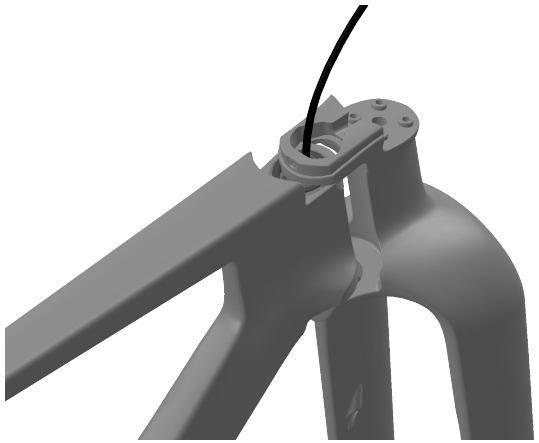
PRODUCT REGISTRATION

Fork mounting

Prep the tension rod by ensuring interface with the collet is well greased. Thread the collet in until it lightly contacts the tension rod. Lightly grease the M6 bolt but don't install yet. Verify the rotation stop is installed.



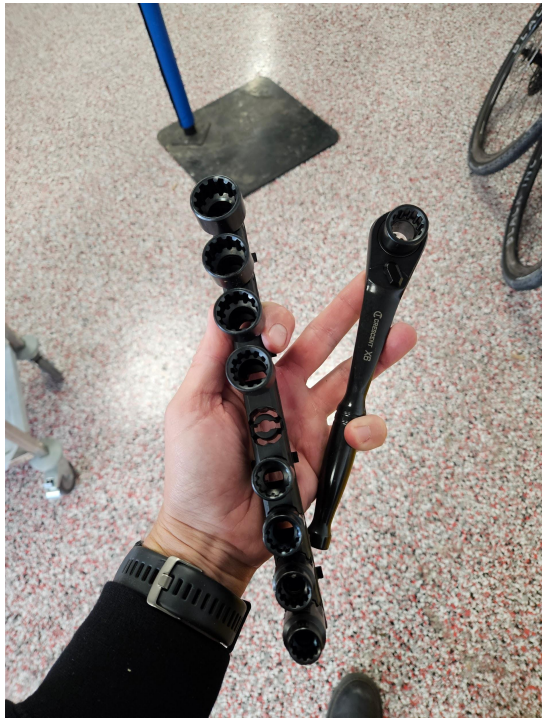
Thoroughly grease the bearing/frame interface, and install the bearings. Use a relatively viscous di-electric grease in this area. Grease and place the upper and lower bearing centering rings, note they are marked clearly as upper or lower.



While the grease retains the bearings, slip the fork overtop of the entire head tube assembly. If you have already pulled the hoses through the frame then pull them through, otherwise install the brake hoses after the HS is assembled.

Fork mounting-Recommended tools

High quality T-Handle hex wrenches (6 and 5mm) are recommended for the next steps. A high quality dielectric grease acts to insulate the aluminium compression rod from the carbon and prevent galvanic corrosion from occurring. Many conventional greases also have dielectric (non-conductive) properties.



A high quality 14mm pass-through socket is strongly recommended for tightening the collet.

Fork mounting

Apply dielectric grease to the outside of all alloy components contacting carbon, hand thread the compression rod to the upper bearing centering compression tophat.

Use an 6mm allen key to tighten the preload until adequate.

Fork mounting

Place the end of a 14mm or passthrough ratchet on the 14mm Collet land. Pass a 6mm allen key through this wrench or socket. Hold the tension rod static with the 6mm Allen while turning and tightening the 14mm ratchet. Tighten to a max of 8Nm, or until snug. Caution must be taken here to not spin the preload rod HS will become over tight.

Fork mounting

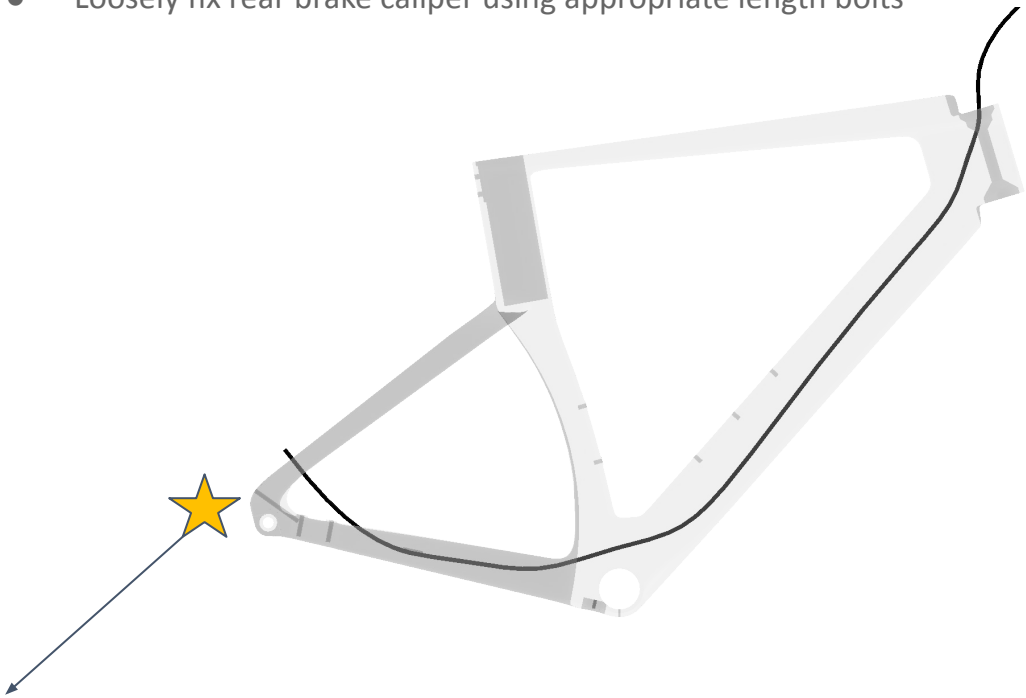
Place the end of a 14mm or passthrough ratchet on the 14mm Collet land. Pass a 6mm allen key through this wrench or socket. Hold the tension rod static with the 6mm Allen while turning and tightening the 14mm ratchet. Tighten to a max of 8Nm, or until snug. Caution must be taken here to not spin the preload rod HS will become over tight. You may find it helpful to brace your arm against the fork to hold the preload rod static.

Fork mounting

Insert and tighten the setscrew into the underside of the tension rod/collet assembly to lock the collet in place. Ensure the Loc-Tite blue is in place, and add a dab if reinstalling.

Hose routing

- Install rear brake and fish hose through the frame and out the head tube
- install the anti rattle rear brake hose foam sleeve
- Insure that the clear plastic anti wear guard portion of the anti rattle hose covering is adjacent to the head tube to shield the brake hose from the compression rod rotation
- Loosely fix rear brake caliper using appropriate length bolts



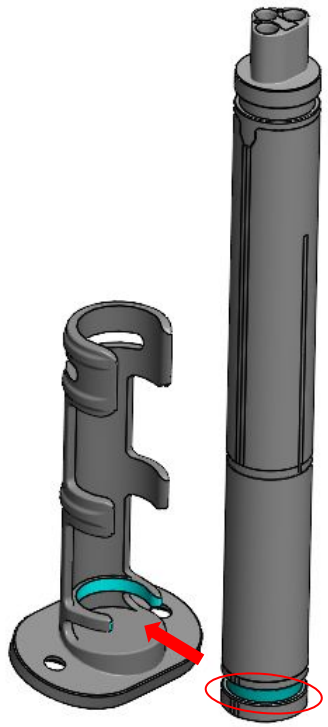
NOTE: Please ensure to use the supplied rear adapter for SRAM 160mm rear rotor configuration.

Di2 routing

- Install the Front and rear derailleur Di2 wires as needed, out the respective ports in the frame, prepare these wires to be attached to the top of the battery in the next step

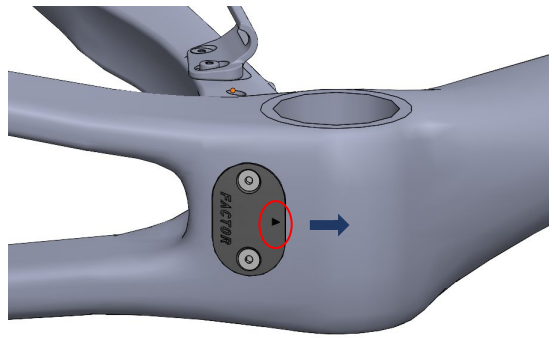
Di2 Battery installation

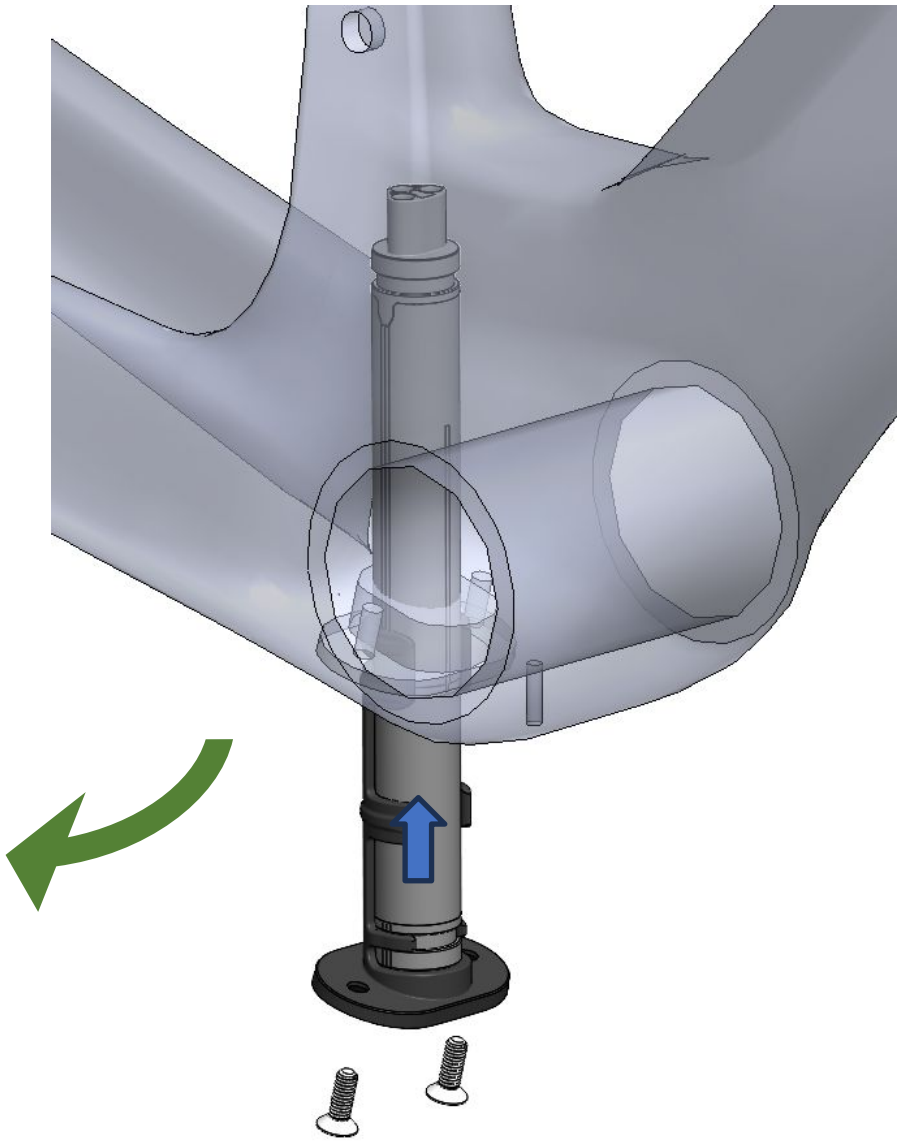
- Affix the Di2 Battery to the battery carrier
- Attach the Di2 Leads to the battery, give preference to the RD being attached to the center plug position for best function.
- Depending on the severity of your roads (ie, cobblestones) you may want to add either a wrap of electrical tape, or a zip tie to the battery holder. In extreme cases you may also want to surround the top of the battery with foam tape such as handlebar tape to mitigate any potential for “knocking”, however in practical applications this is not necessary.



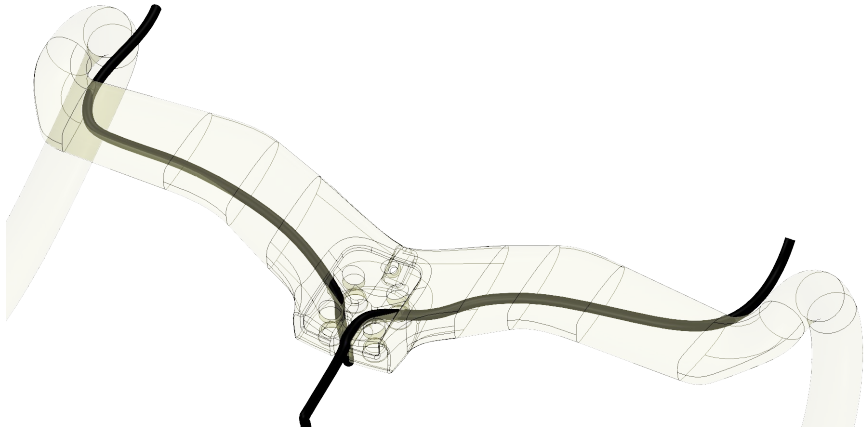
Di2 Battery fixation

- Carefully slide the Di2 Battery holder and wires into the frame, leaving adequate slack in the cables to allow them to traverse the seattube past the battery without kinking them
- Install the two taperhead screws to fix the battery holder in position, tightening them to 2Nm

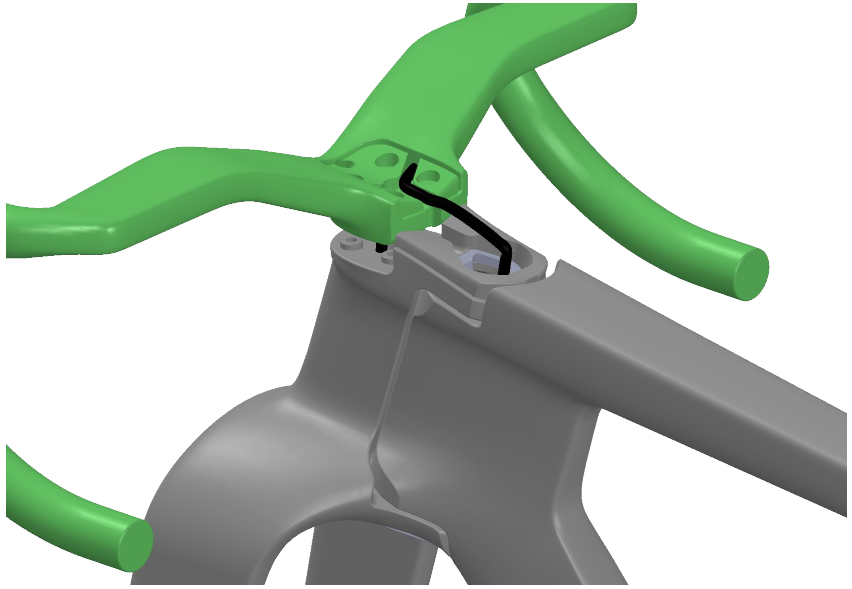




Fork mounting

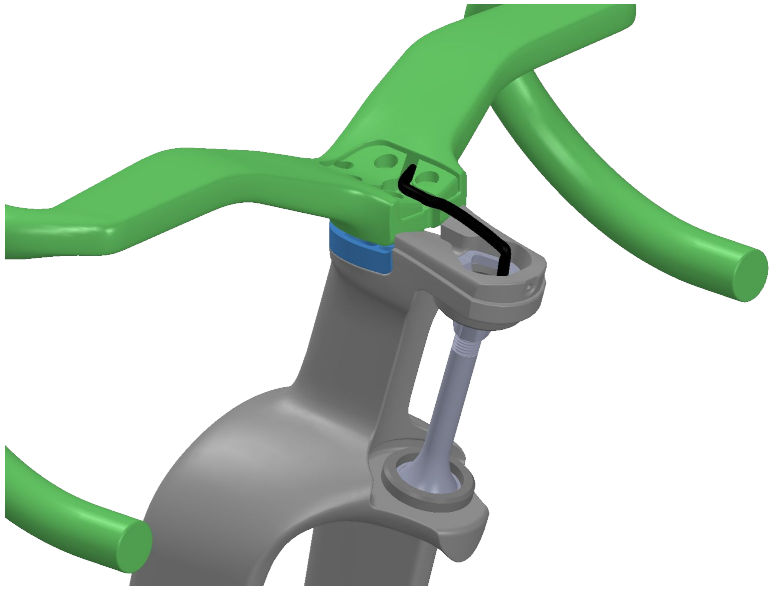


Snake hoses the hoses coming from the top of the frame and fork through the bar, respecting which is left and which is right and corresponding front/rear brakes



Pull excess hose from the frame through the barstem gently, inching the two components together until snug.

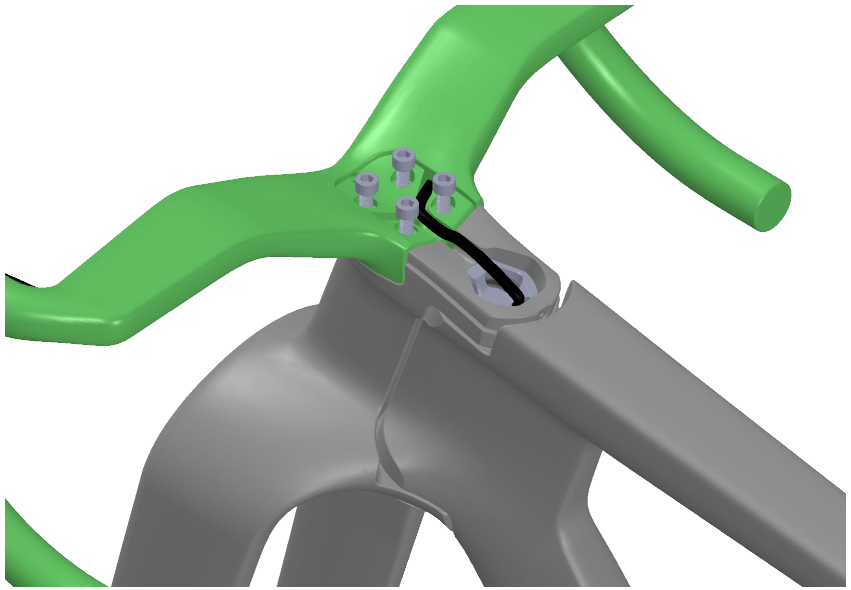
Fork mounting



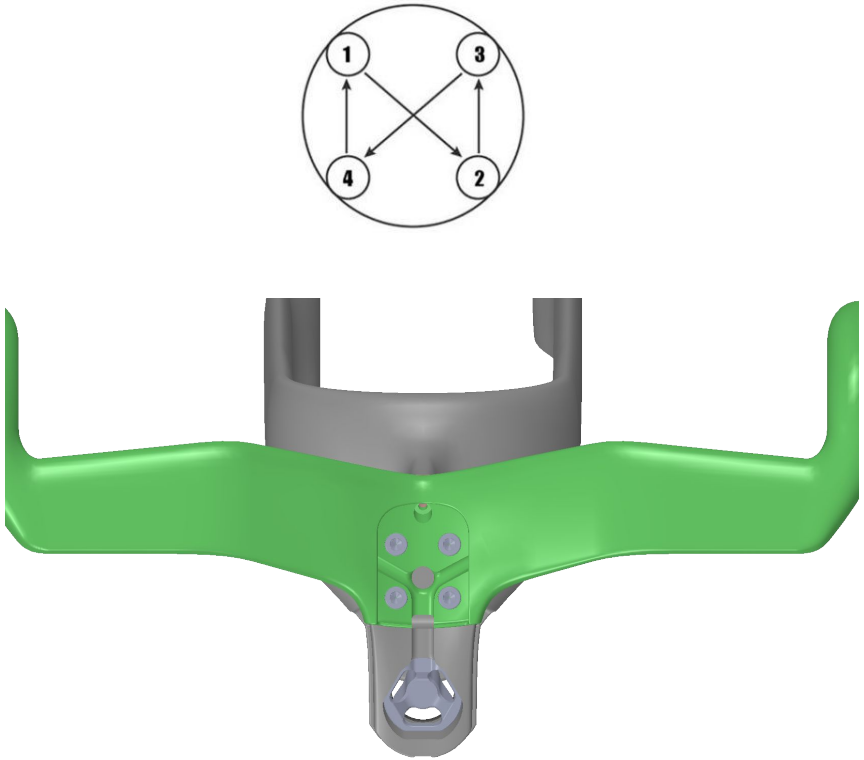
At this point add any spacers in conjunction with the above step, bringing the barstem gradually onto the top of the fork.

Spacer and bolt chart here

Fork mounting

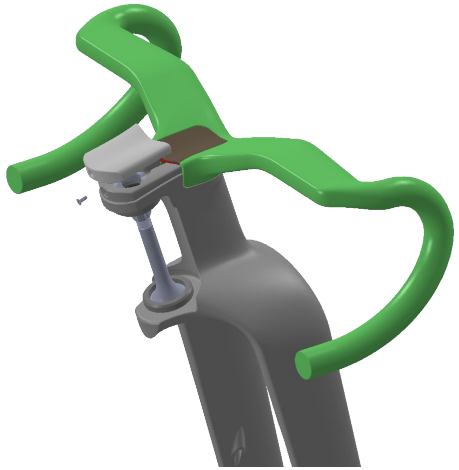


Lightly grease and hand thread in the correct length bolts

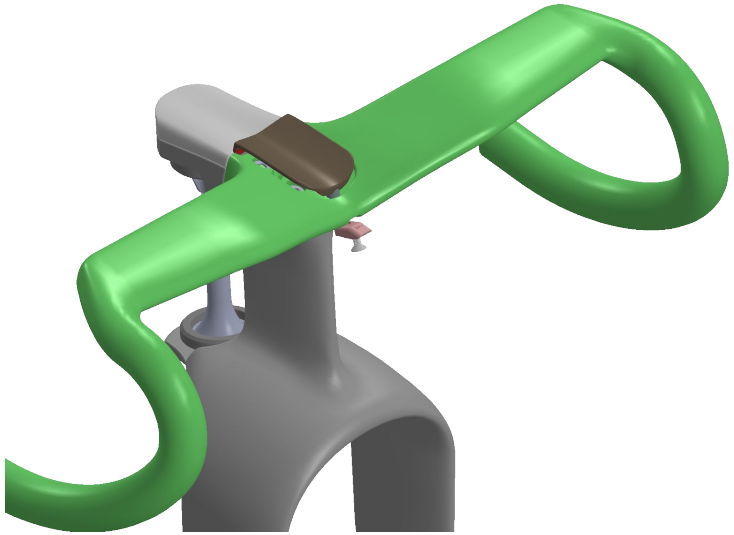


Gradually tighten the bolts in a X sequence, to a maximum of 6 Nm

Fork mounting



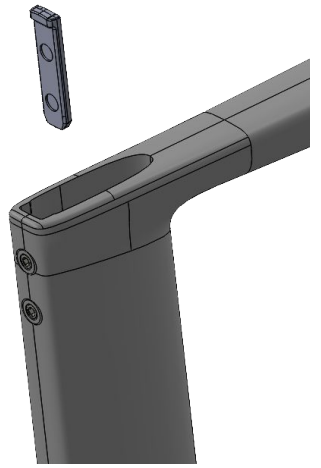
Incline the handlebar to the left or the right, and install the compression cover to no more than 1.5Nm

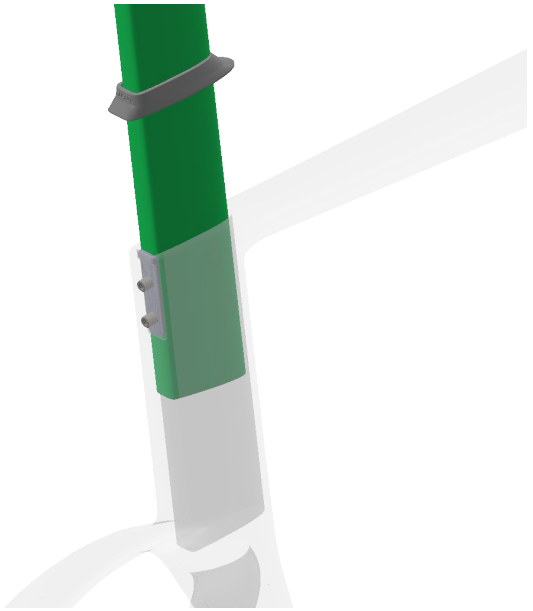


Working from the computer mount, either install the computer mount or the blanking plate followed by the associated screw to affix the barstem cover using a torque value of 2Nm

Seat Post fixation

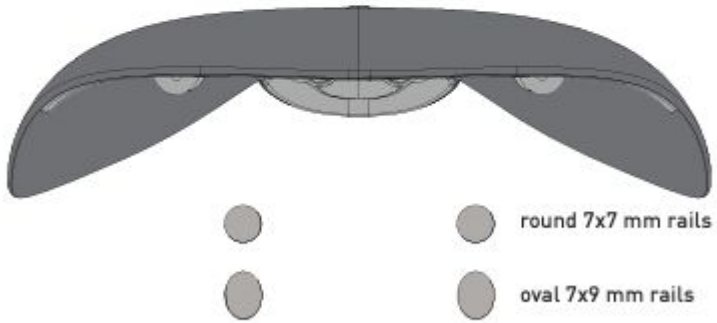
- Grease the rear side of the Seat Post Clamp inorder to “stick” it to the inside of the flat area in on the frame, at the rear of the seat post hole.
- Slide the seatpost gasket onto the seat post
- Liberally apply carbon paste to the seat post
- Set desired SP height
- Sequentially tighten the SP bolts, alternating from the upper bolt to the lower in small increments of half to ¾ of a turn. Tighten to 4-5 Nm using a high quality tool, ensuring complete engagement with the hex head.





Seat attachment

- Determine the type of SP rails on your saddle and choose the appropriate clamp setup from the Pizza Box of parts



Factor frame sets are shipped with 7X9 mm outer rail clamps for carbon rail saddles. 7x7 mm outer rail clamps for traditional saddle rails are available through your Factor dealer.

- Apply carbon paste liberally to the SP clamp assembly, assemble the seat post clamp, adjust saddle angle and seatback, and tighten to 12Nm.

If you are using a 1x setup, remove the FDM and set aside. Install the provided blanking plates for the FD mounting holes. Note you may benefit from a small dab of adhesive or silicone when installing these as they can rattle out with time.

If you are using a 2x setup, install the FD, and adjust accordingly. Torque to 3Nm.

If you are using a 1x setup, remove the FDM and set aside. Install the provided blanking plates for the FD mounting holes. Note you may benefit from a small dab of adhesive or silicone when installing these as they can rattle out with time.

If you are using a 2x setup, install the FD, and adjust accordingly. Torque to 3Nm.

2025 ONE

Your frame is provided with blanking plates for wireless shifting, and grommets for shifting needing electric wires. Install both at the FD and the RD to prevent foreign material ingress.

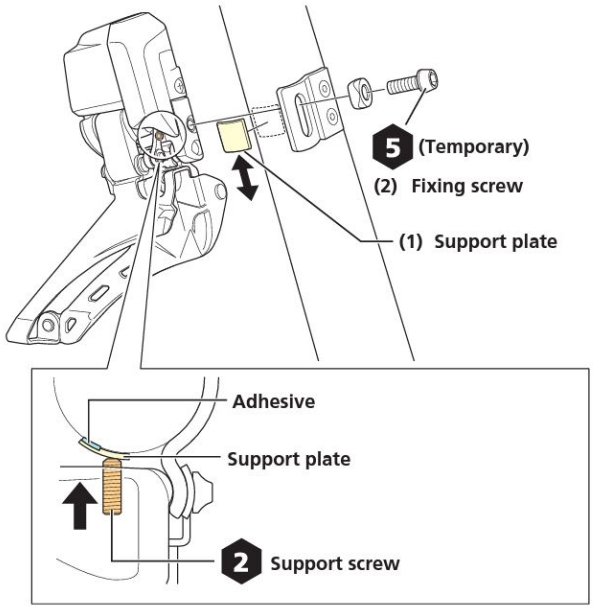
FDM

- The 2025 ONE is configured for the use of a front derailleur, as well as supporting 1x only function. If using 1x, remove the FDM and install the supplied blanking plate.
- Be sure to follow all manufacturer recommendations for supporting plates, wedges, and screws when using the ONE, and tighten the FDM to no more than 3Nm.

Installation/removal

Temporarily installing the front derailleur

(2) Temporarily install the front derailleur.

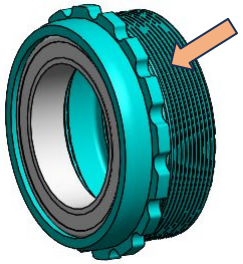


CHECK THE WEDGE

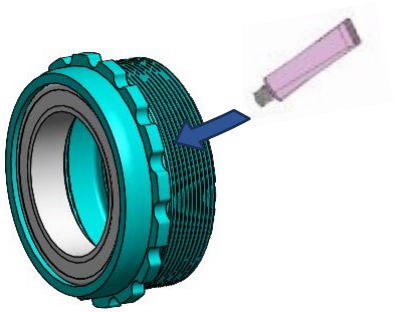
Look at the back side of the front derailleur to see if the support wedge is installed and adjusted properly. Without it, outer limit adjustment needs to compensate to produce a fast shift, but then you run the risk of an over up-shift chain drop.

If the wedge is missing on a bike that came with an eTap AXS front derailleur, see your local dealer to ask for a free replacement. If you bought the derailleur to install on a bike, a selection of wedges was included in the original packaging. This is an important part of the front derailleur setup process because it provides a significant increase in stability when upshifting to the big ring.

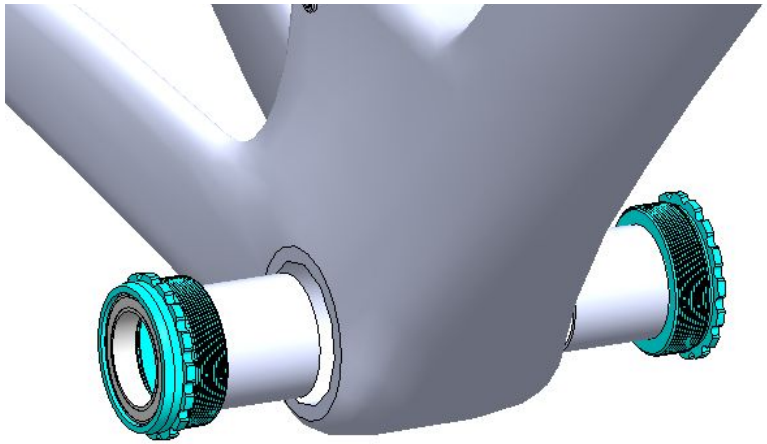
2025 ONE



Clean the inside of the frame bottom bracket & the bottom bracket cups with an isopropyl alcohol.

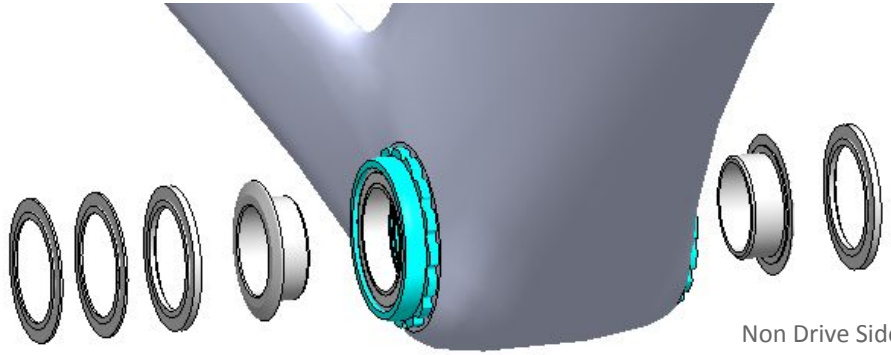


Apply a layer of good quality assembly paste to the threads of both bottom bracket cups. We recommend assembly paste from Morgan Blue (Aquaproof Paste) or r.s.p. (Creak Freak Assembling Paste).



Thread the cups into the frame and torque the cups down to 30nm for the drive side and 40nm for the non drive side. We recommend using Park Tool BBT-47.

For SRAM DUB cranksets, install the included 29mm reducers and spacers in the following sequence.



Drive Side
1mm+1mm+3mm+29mm reducer

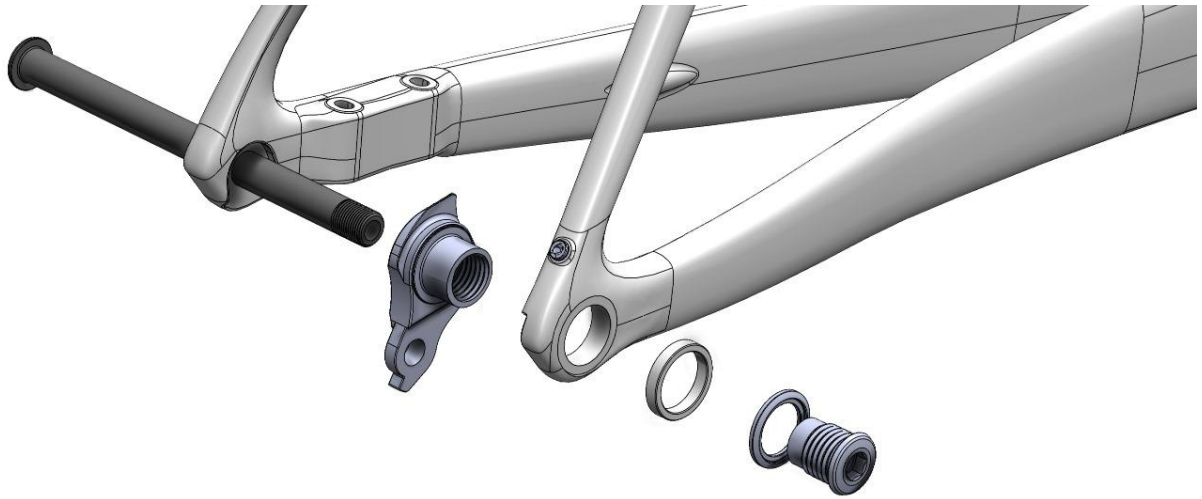
Non Drive Side
29mm reducer+3mm

For Shimano Hollowtech II cranksets, install the included 24mm Wheels MFG reducers and spacer in the following sequence.

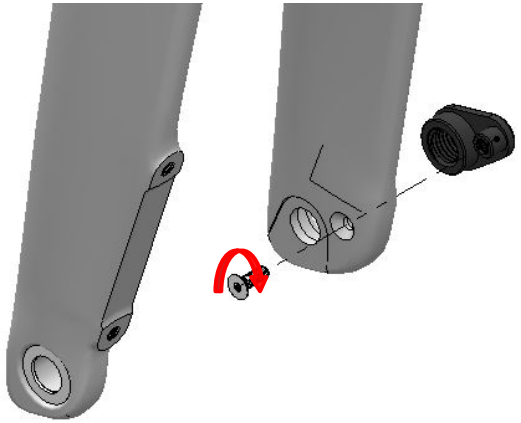
Drive Side
24mm reducer

Non Drive Side
24mm reducer+1mm+1mm+0.5mm

The Frame is fitted with a Mini-UDH interface. If you use the UDH hanger, or a Sram Full mount derailleur you must insure the 4.5mm spacer is in place.

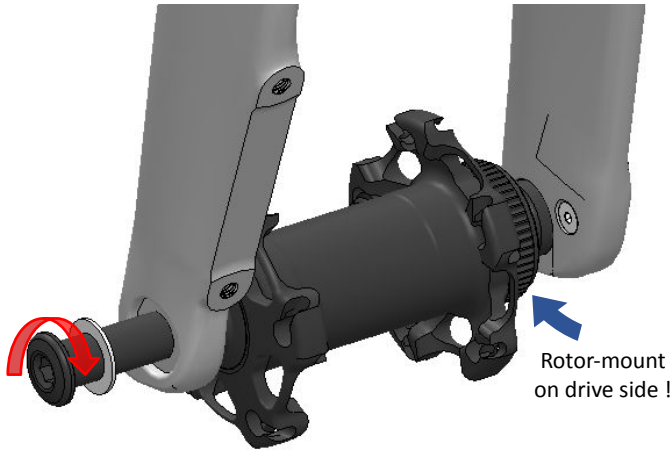


2025 ONE

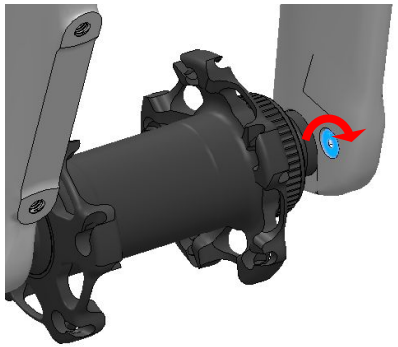


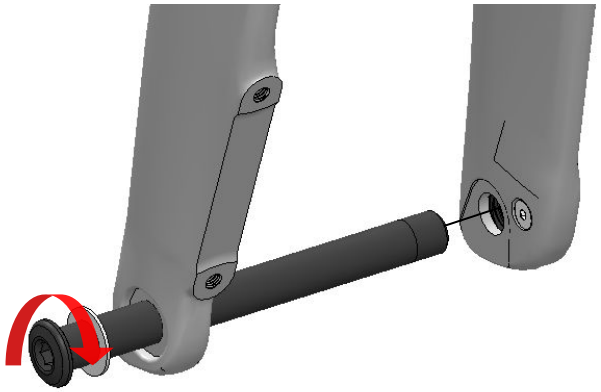
Apply Loctite 243 on bolt threads. Thread the bolt in but do not tighten, this will allow the insert to align when installing the axle

Install a front hub in the dropout with the free hub on non-drive side. This will allow better access for the next step. Install the thru-axle with the nylon washer and tighten to **10Nm**

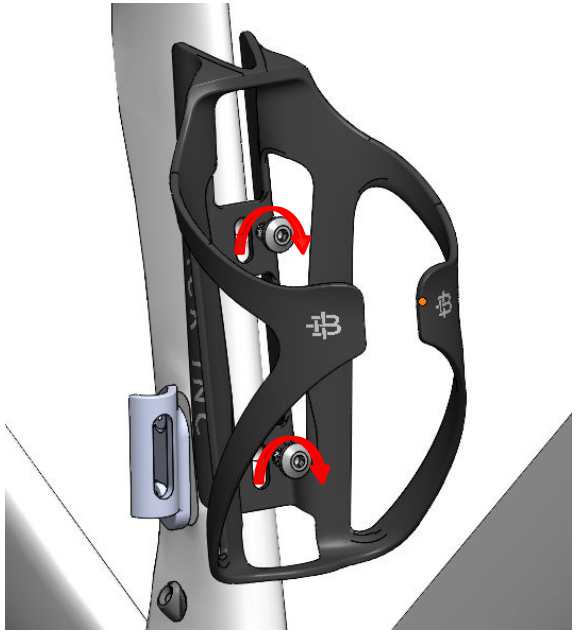


After ensuring the dropout insert is correctly aligned, tighten the dropout bolt to **1 Nm.**





Remove the thru-axle and remove the hub. Install front wheel and tighten the thru axle (with the nylon washer) to **10Nm.**



Install cages of your choice and tighten M5 bolts with a high quality 3mm Hex head to **2 Nm.**

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