

***FACTOR***

***FACTORBIKES.COM***

**2025 Monza 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](http://www.factorbikes.com) and register your product(s) within 15-days of purchase.

## WARRANTY

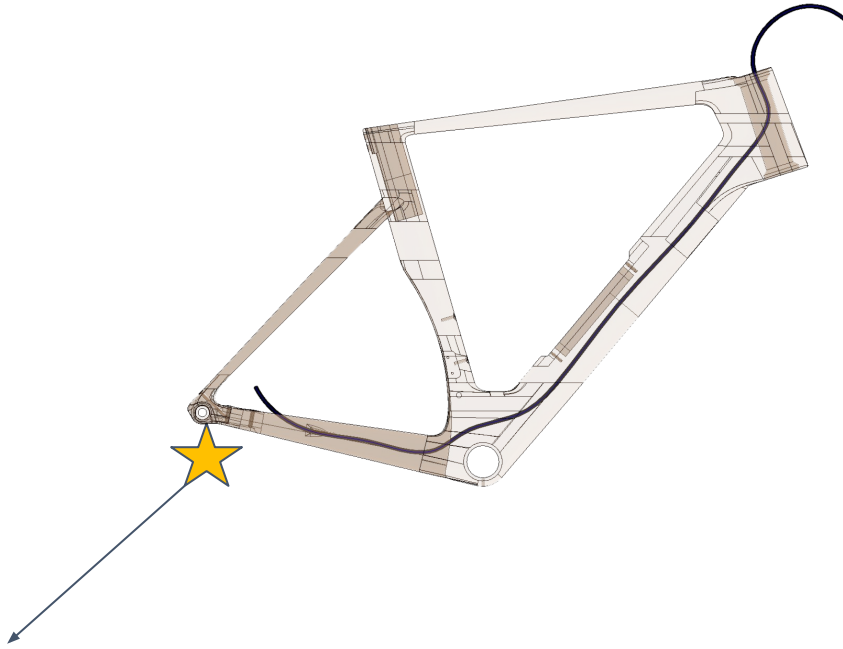


## PRODUCT REGISTRATION



## Hose routing

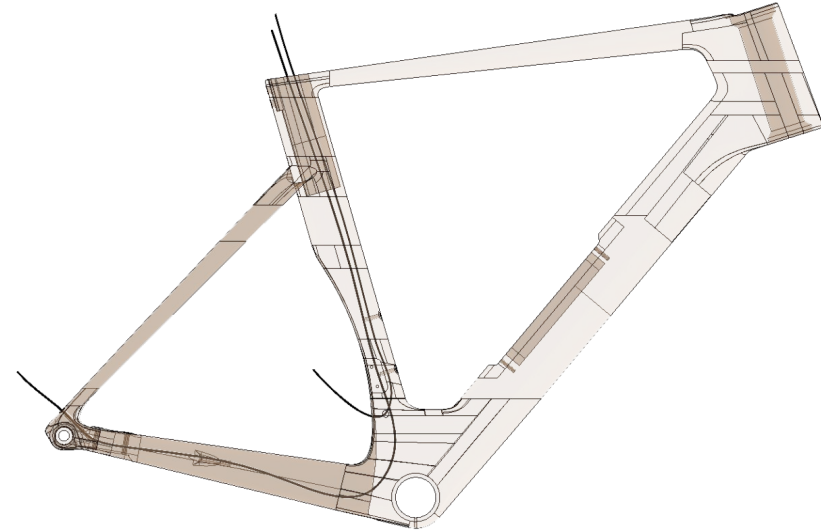
- Install rear brake and fish hose through the frame and out the head tube
- install the anti rattle rear brake hose foam sleeve
- Insure that the clear plastic anti wear guard portion of the anti rattle hose covering is adjacent to the head tube to shield the brake hose from the steerer rotation
- Loosely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



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

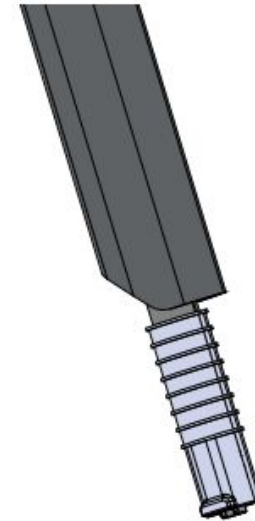
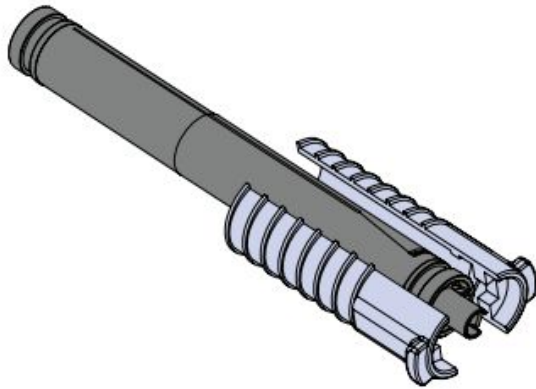
## Di2 routing

- Install the Front and rear derailleur Di2 wires as needed, out the respective ports in the frame, and out the top of the seat tube opening.

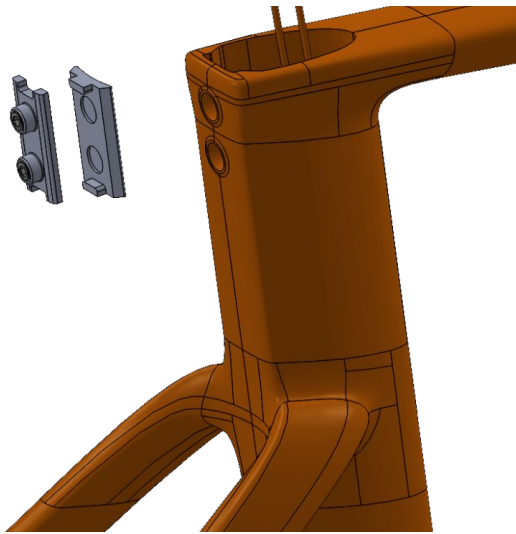


### Di2 Battery Installation

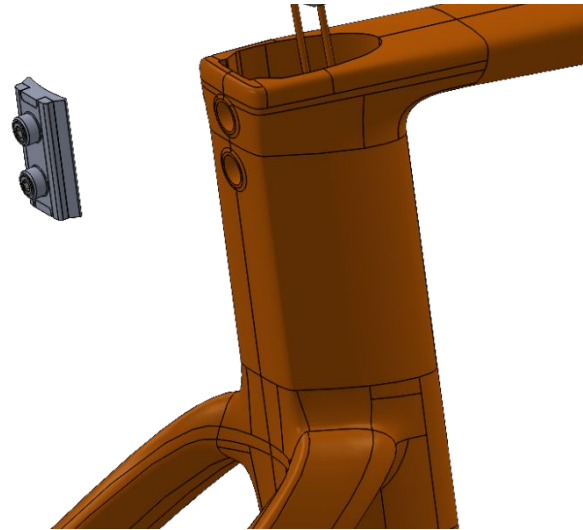
- Place the battery between the rubber clamshell battery sleeve
- Firmly install the battery and sleeve into the seatpost



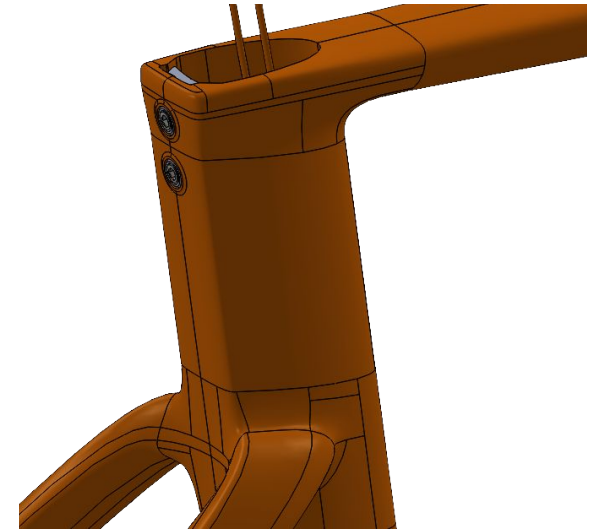
### Seatpost installation



Grease the area between the two plates to prevent corrosion

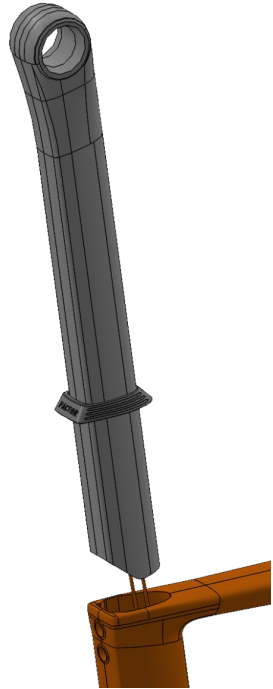


Apply a thick coat dielectric grease, or frame prep compound to the rear of the SP clamp assembly

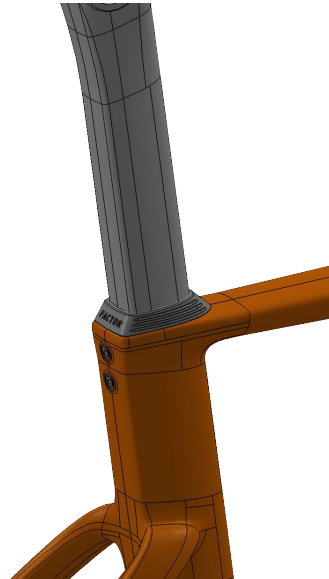


Install the clamp and firmly push it back into the recess in the rear of the SP pocket. The grease applied in the previous step will help the clamp stick to the frame, preventing it from falling into the frame. If this happens, turn the bike upside and shake the clamp out.

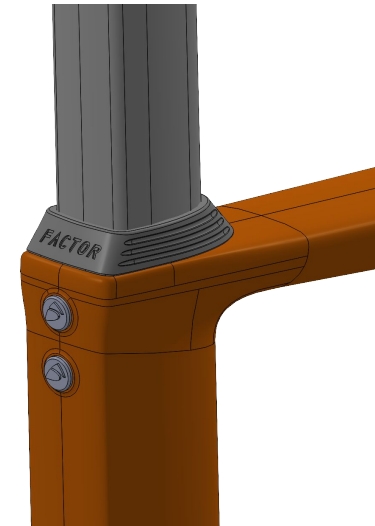
### SP installation



Install the SP gasket around the post. Once the gasket is on (not before) apply a generous coating of carbon assembly compound to the seat post.



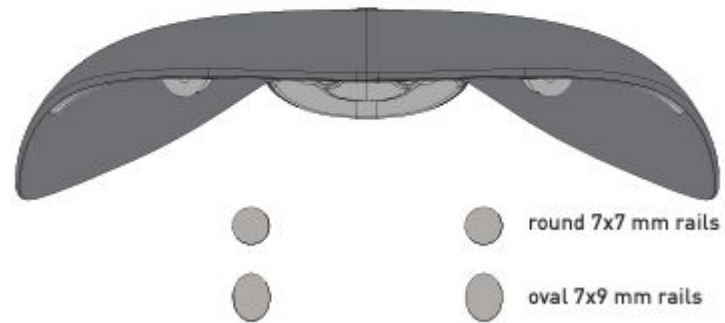
Install the SP into the frame. Tighten the grub screws using a high quality allen key to 4Nm, alternating between the bolts to bring the assembly up to tightness in a uniform fashion. Failure to alternate torque may result in frame or seat post cracking and void the warranty.



Install the grub screw plugs

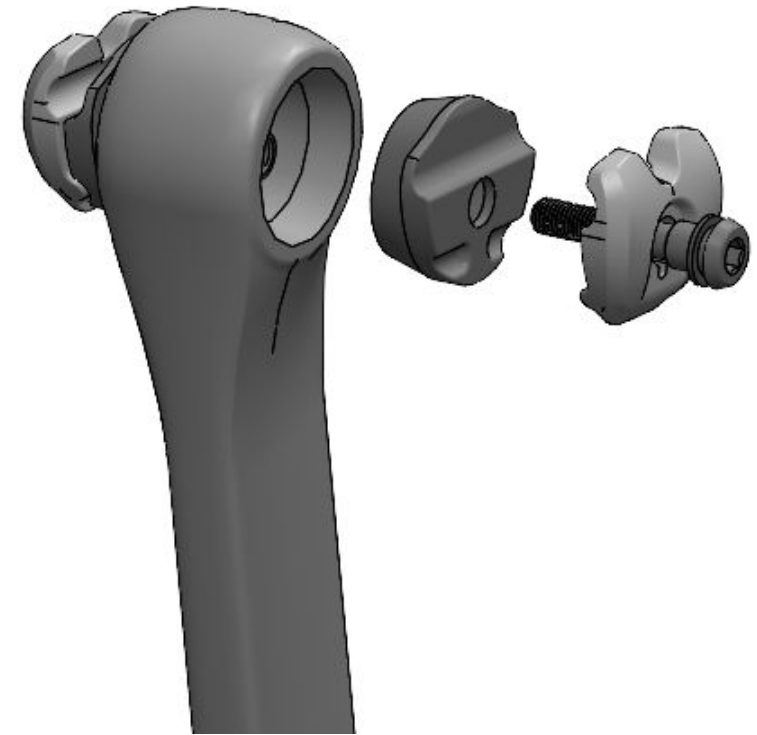
### Seat attachment

- 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.

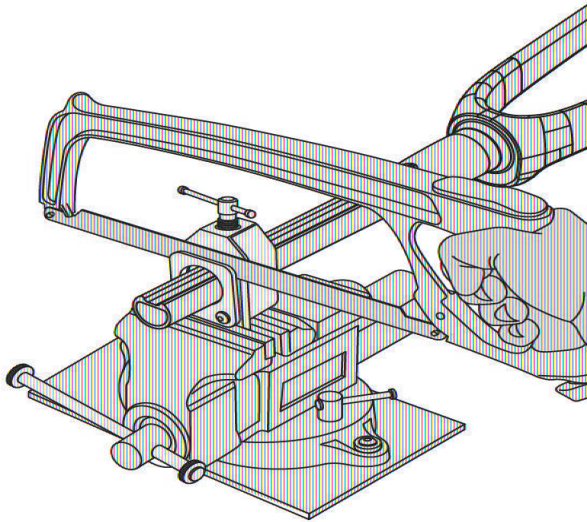
- Apply carbon paste liberally to the SP clamp assembly, assemble the seat post clamp, adjust saddle angle and seatback, and tighten to 12Nm.



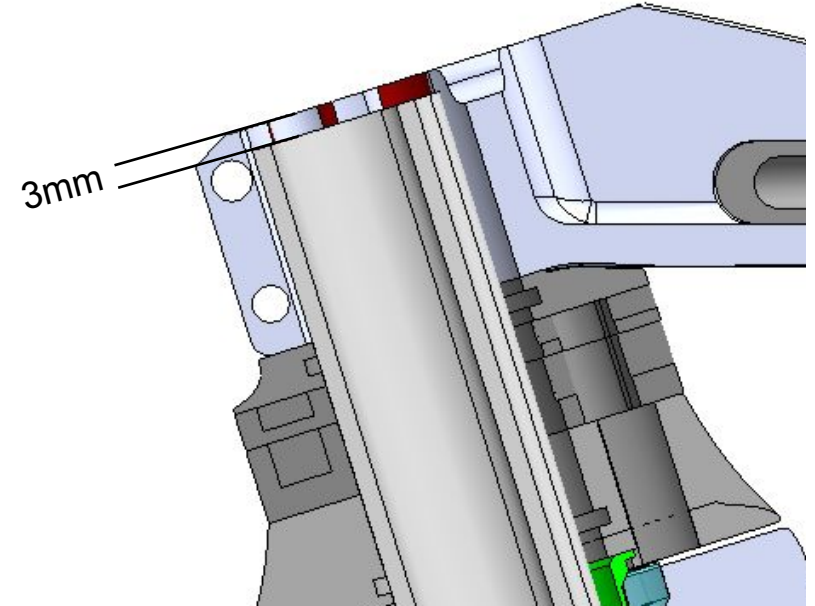


### Steerer

- Working with your mechanic determine the correct number of spacers, and cut the fork steerer tube as shown below

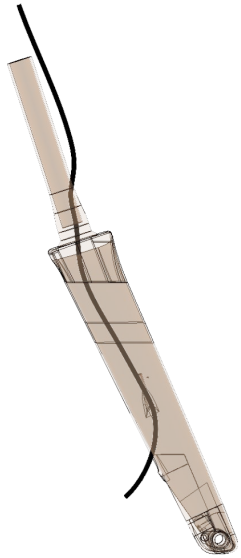


Pre-cut fork steerer making sure that it is cut 3mm below the top of the stem.

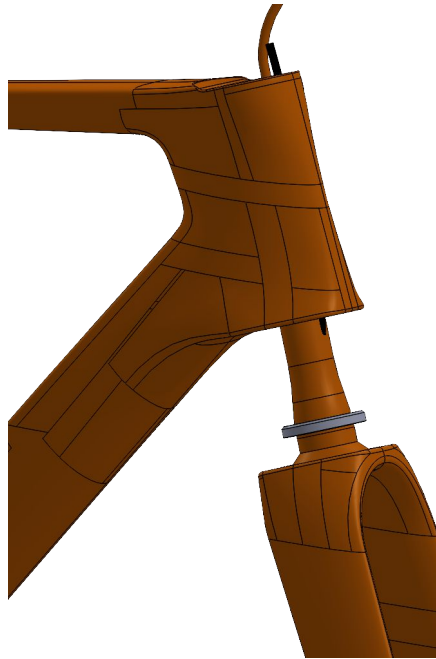


**WARNING!** Only use a maximum of 40mm of spacers (including tall headset cover) supplied with the frameset.

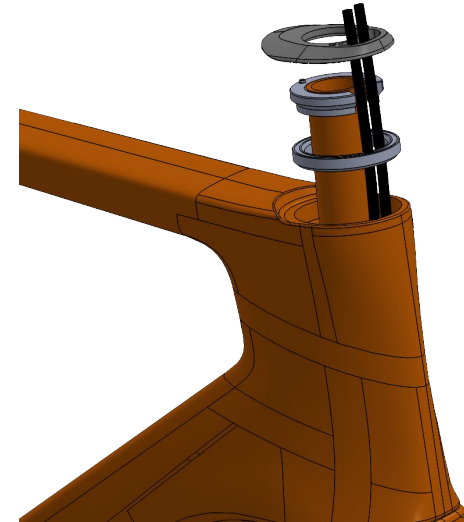
### Fork mounting



Pull brake hose through the fork and leave full length

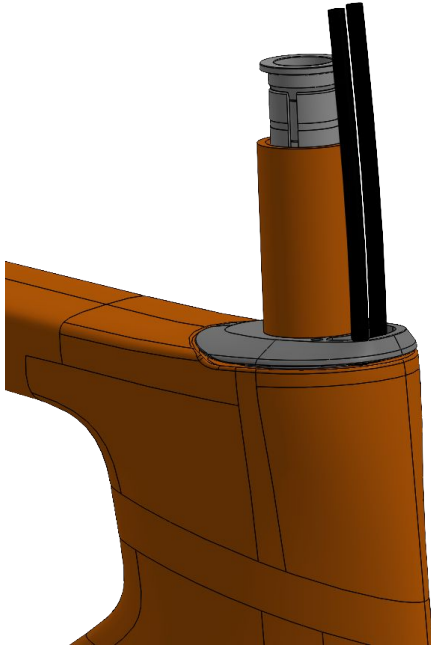


Pull the hose through the lower bearing, grease the lower bearing seat, and install the fork and bearing into the frame

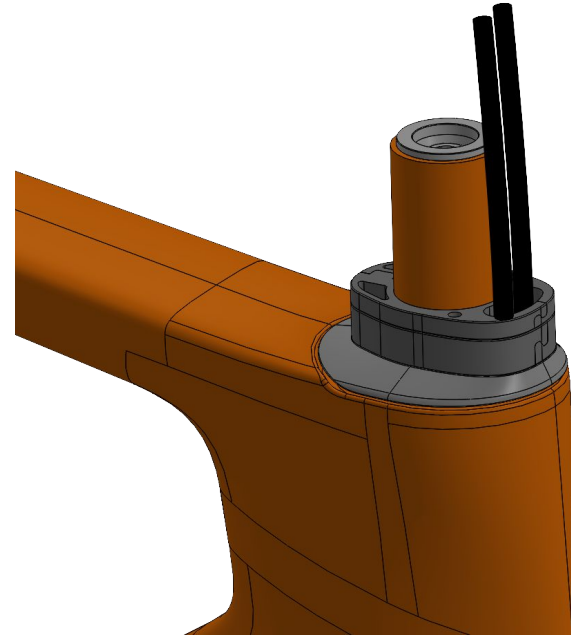


Grease and install the upper bearing, Split ring, and dust cap. Make sure the hoses go through the appropriate openings on the split ring and dust cover.

### Fork mounting

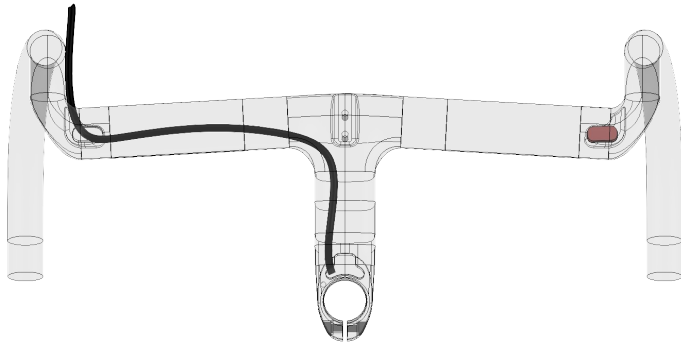


Apply carbon assembly paste to the compression plug, install in steerer, and tighten to 8Nm

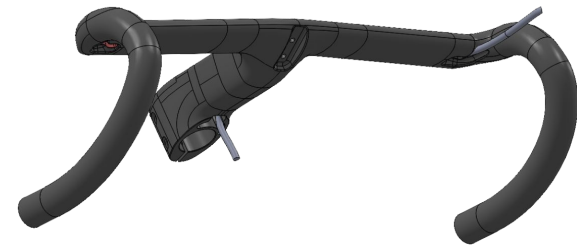


Install the relevant number of spacers.  
Note max spacer stack not to exceed 4cm

### Fork mounting



Snake hoses through the bar, respecting which is left and which is right and corresponding front/rear brakes



Pull excess hose through barstem, exiting on your desired side

### Fork mounting



Gently pull the hoses through the bar while starting to locate it over the steerer tube.



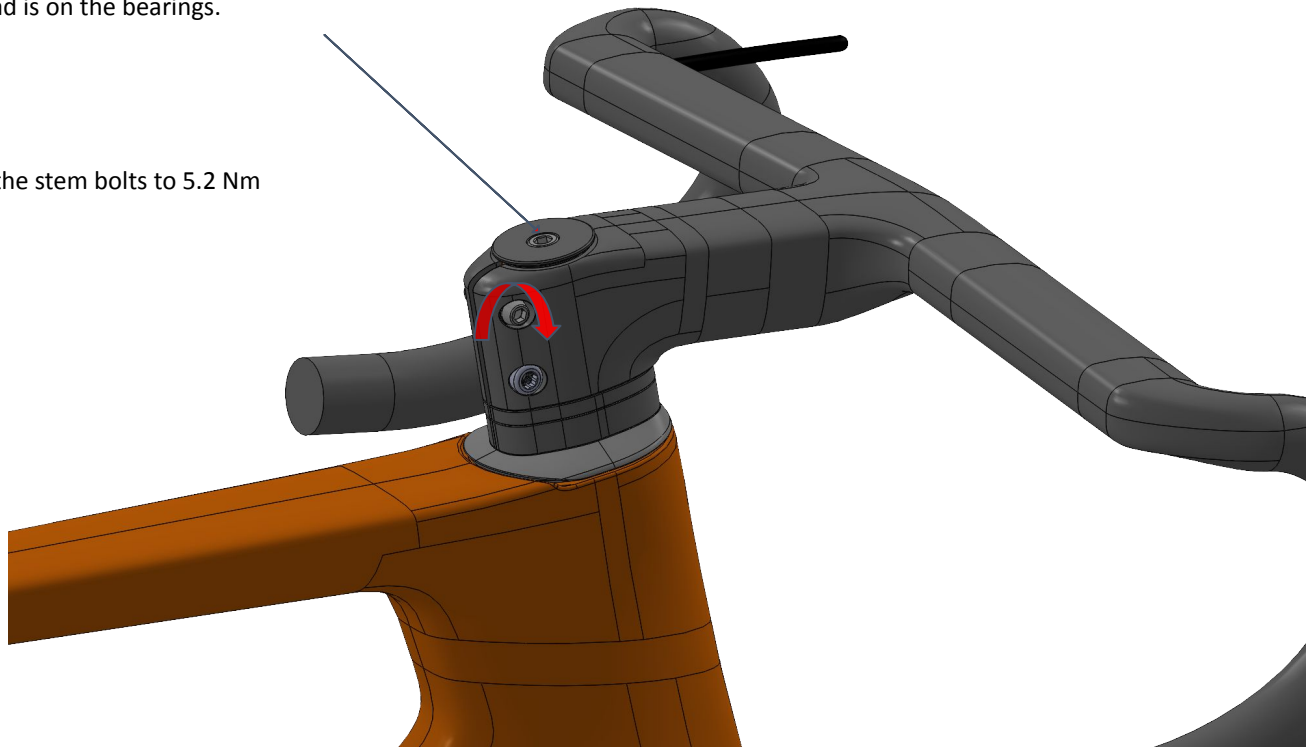
Alternating hoses and being sure to avoid kinking any lower it on the steerer tube until the bar sits atop the spacer stack

### Bar mounting

Center the bar on the bike's centerline prior to tightening. Ensure the spacer locating holes and mating features are aligned with the dust cap and the handlebar.

Tighten the compression top cap until sufficient preload is on the bearings.

Tighten the stem bolts to 5.2 Nm



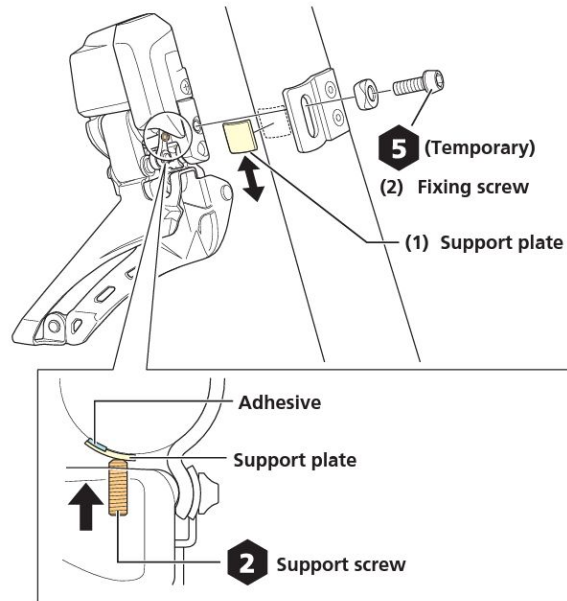
## FDM

- The 2025 Monza 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 Monza, 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.

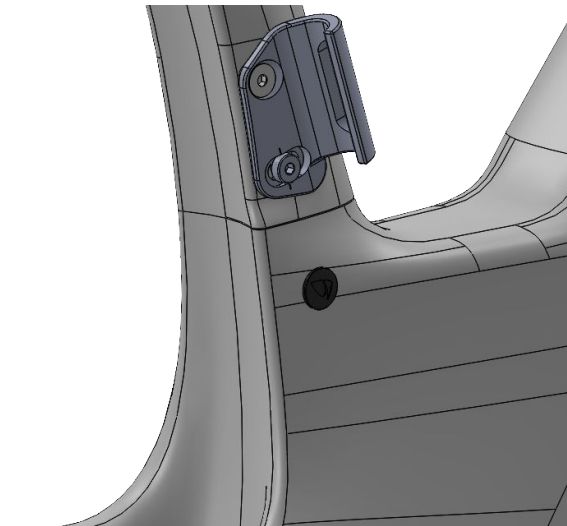
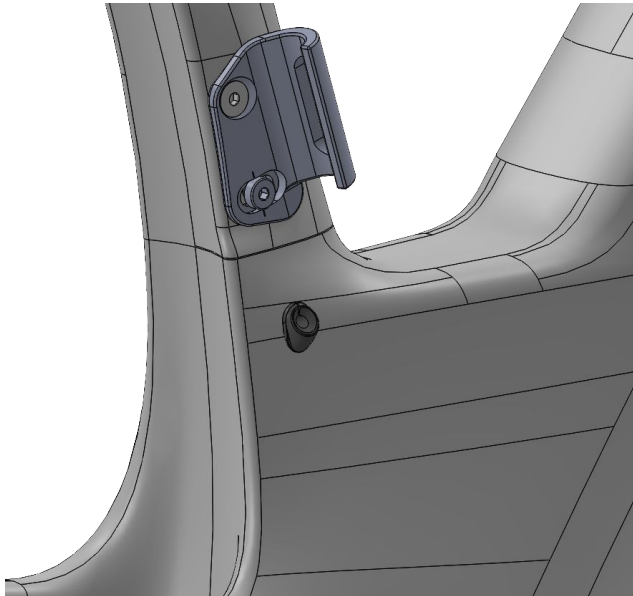
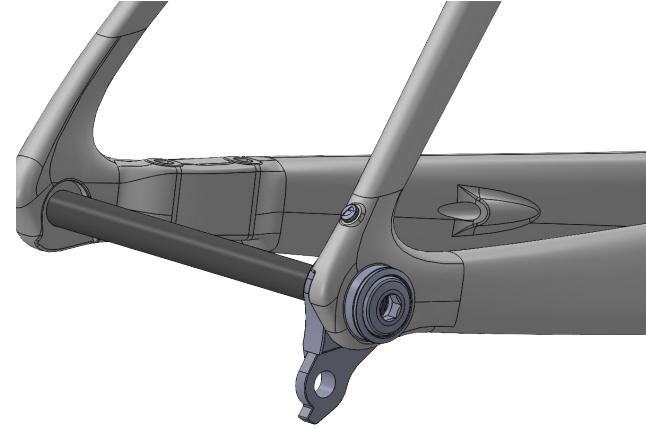
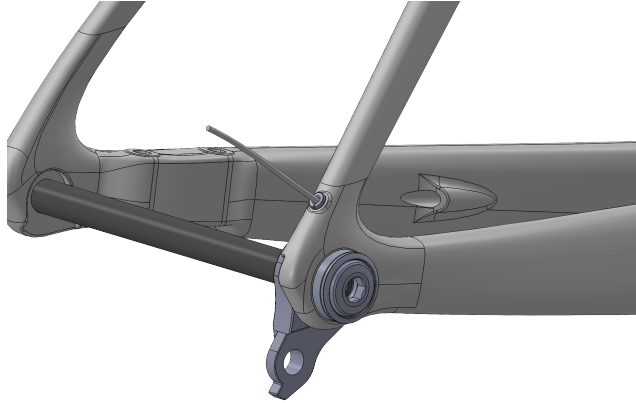
If the wedge is missing on a bike that came with an eTap AXS front derailleur, see your local dealer to ask for a free replacement. If you bought the derailleur to install on a bike, a selection of wedges was included in the original packaging. This is an important part of the front derailleur setup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



2 mm hex wrench

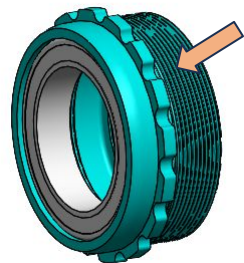
### Grommets

- Install the front and rear grommets, using either the Di2 passthrough style, or the E-Tap blanking style

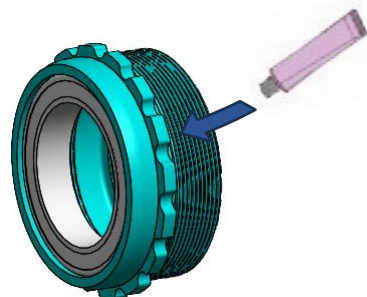




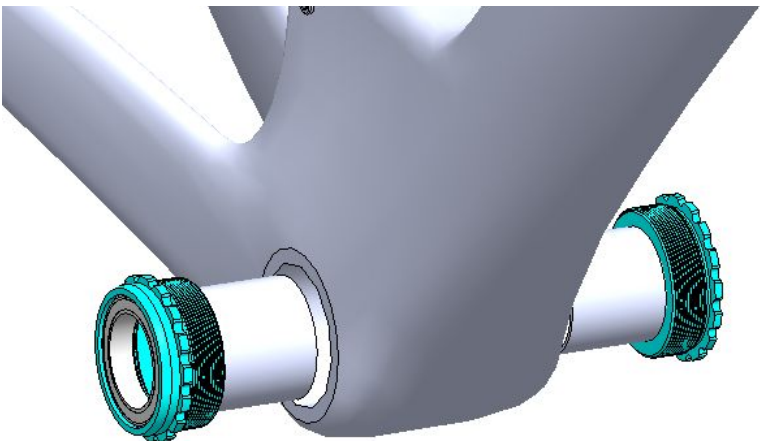
# 2025 Monza



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

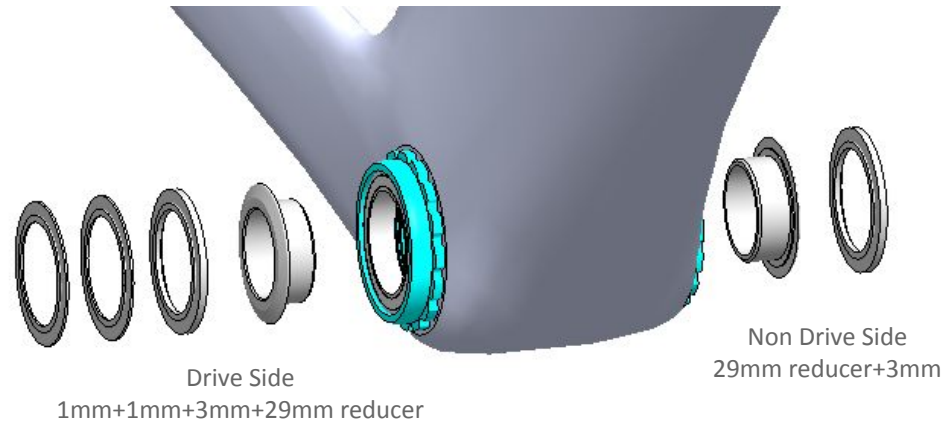


Apply a layer of good quality assembly paste to the threads of both bottom bracket cups. We recommend assembly paste from Morgan Blue (Aquaproof Paste) or r.s.p. (Creak Freak Assembling Paste).



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.



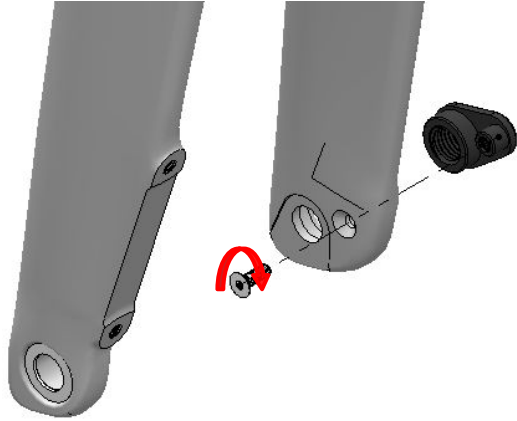
For Shimano Hollowtech II cranksets, install the included 24mm Wheels MFG reducers and spacer in the following sequence.

Drive Side  
24mm reducer

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

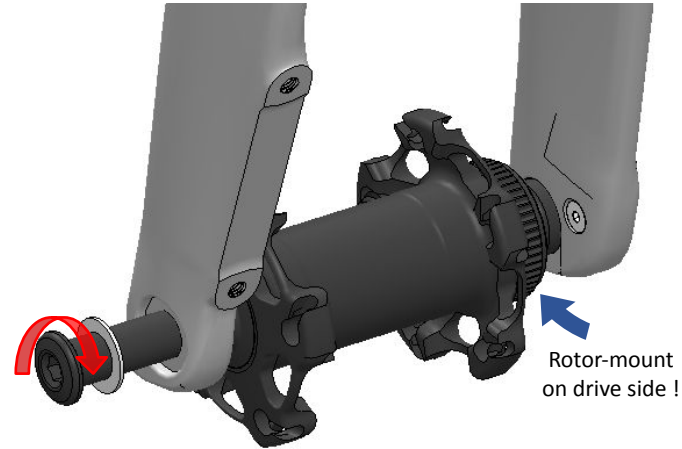
The Frame is fitted with a Mini-UDH interface. If you use the UDH hanger, or a Sram Full mount derailleur you must insure the 4.5mm spacer is in place.



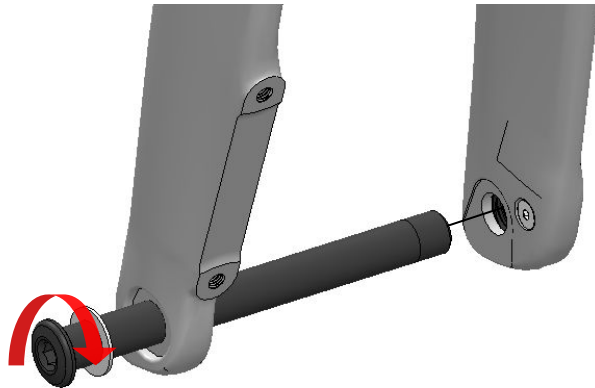
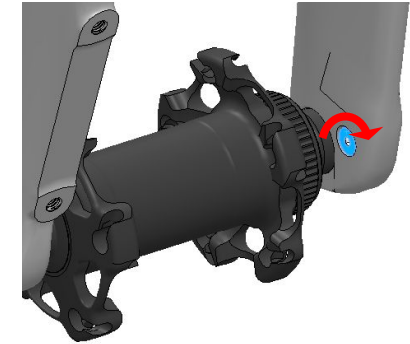


Apply Loctite 243 on bolt threads. Thread the bolt in but do not tighten, this will allow the insert to align when installing the axle

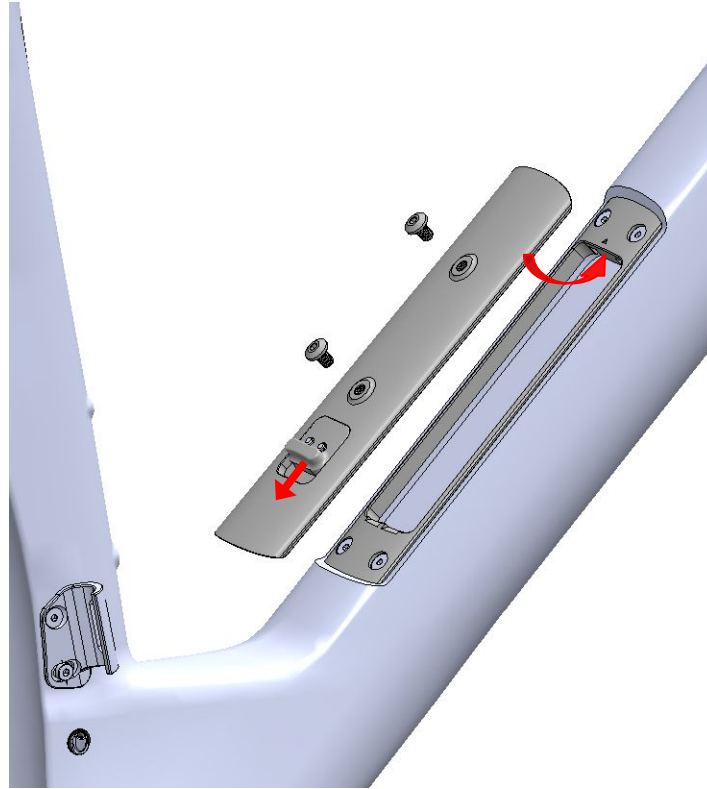
Install a front hub in the dropout with the free hub on non-drive side. This will allow better access for the next step. Install the thru-axle with the nylon washer and tighten to **12Nm**



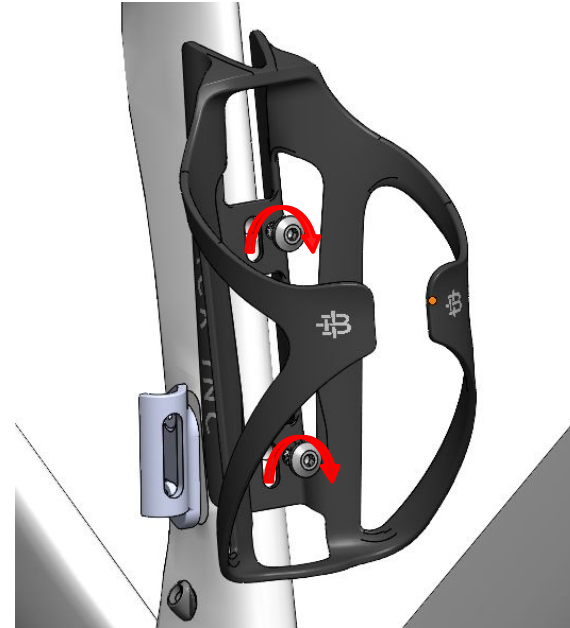
After ensuring the dropout insert is correctly aligned, tighten the dropout bolt to **1 Nm**.



Remove the thru-axle and remove the hub. Install front wheel and tighten the thru axle (with the nylon washer) to **12Nm**.



Insure that the factory installed bezel bolts are tightened (2Nm). Install cover and tighten M5 WB bolts with a high quality 3mm Hex head to **2 Nm**.



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

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