

# SERVICE INSTRUCTIONS

Before use, read these instructions carefully, and follow them for correct use.

## Rear Derailleur RD-7402



## DURA-ACE

### Capacity

- Front difference: 14 teeth or less
- Total capacity (front difference plus rear difference): 26 teeth or less
- Rear smallest sprocket: 12 teeth/Rear largest sprocket: 26 teeth

**Note:** The above capacity is the value when the B-tension adjustment bolt is completely tightened.

### System Components

The following products should be used together for the Shimano Index System (SIS) function.

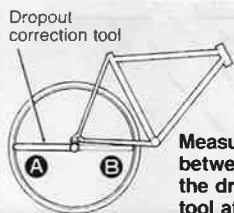
	8-speed	7-speed	6-speed
Shifting Lever	SL-7402	SL-7401	SL-7400
Rear Derailleur	RD-7402		
Freehub, Freewheel	FH-7402	FH-7400-7 MF-7400-7	FH-7400-6 MF-7400-6
Chain	Shimano UG chain narrow type		
Outer Cable	Shimano SIS cable		

### Note

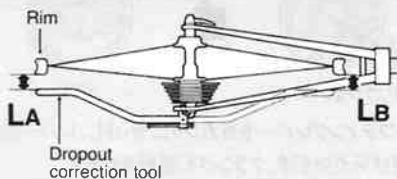
- Use a dropout alignment tool (TL-RD10) to adjust the part of the rear dropout where the derailleur is to be mounted to meet the dimensions shown here.

Distance between rim and tool  
 $LB - LA = +10mm \sim -5mm$

In other words, adjust so that the derailleur mounting is slightly open to the front when seen from the rear.



Measure the distances between the rim and the dropout correction tool at points A and B.



- Recommended rear dropout. Shimano made: Shimano EF  
Campagnolo made: Small 1010B

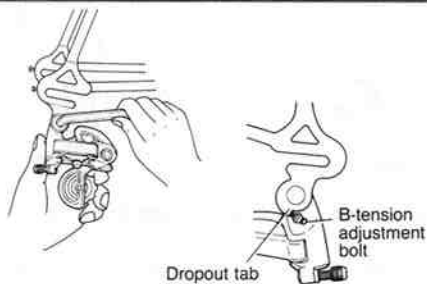
## Assembly and Adjustment

### 1. Assembly to Frame

Secure the bracket axle to the dropout with a 5mm hexagon wrench (TL-WR36).

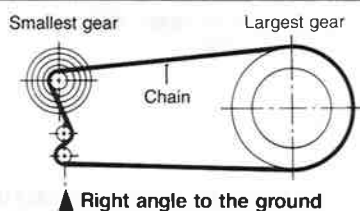
**Note:** When installing, be careful that the B-tension adjustment bolt is not deformed by coming into contact with the dropout tab.

**Bracket axle tightening torque:**  
80—100 kgfcm (70—85 in.lbs.)



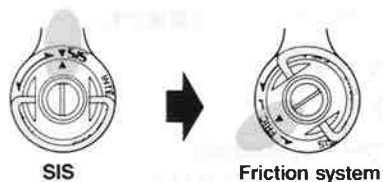
### 2. Chain Assembly

Put the chain on the smallest sprocket of the freewheel and on the largest sprocket of the front chainwheel. Adjust the length of the chain by checking that the center line connecting the rear derailleur guide pulley and the tension pulley is at right angles to the ground.



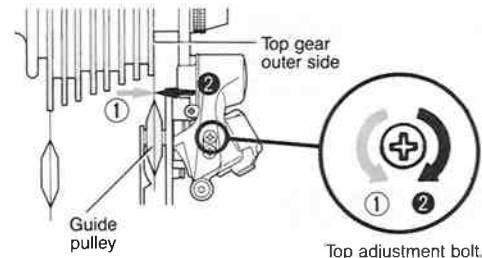
### 3. Stroke Adjustment and Cable Connection

Adjust with the lever at the friction position.



### 1. Top adjustment

Turn the top adjustment bolt to adjust so that, looking from the rear, the guide pulley is below the outer line of the top gear.



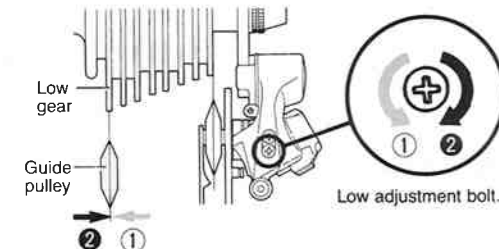
### 2. Inner cable connection

Connect the inner cable to the rear derailleur and, after the pre-stretch as shown in the figure, reset the cable to eliminate cable slack.



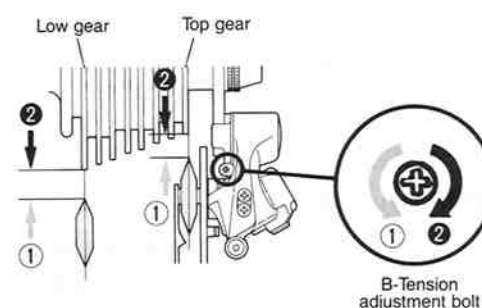
### 3. Low adjustment

Turn the low adjustment bolt to adjust so that the guide pulley moves to a position directly below the low gear.



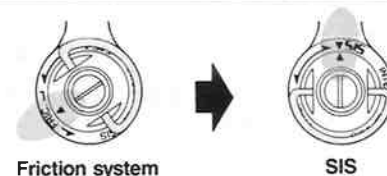
### 4. How to Use B-Tension Adjustment Bolt

Mount the chain on the smallest chainwheel gear and the largest freewheel gear, and turn the crank backwards. Turn the B tension adjustment bolt to adjust the guide pulley as close to the gear as possible but not so close that it touches. Next, set the freewheel to the smallest gear and repeat the above to make sure the pulley does not touch.



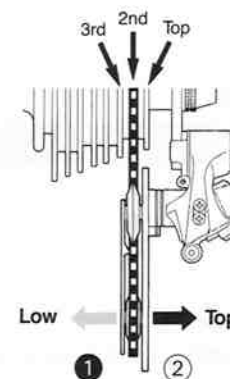
### 5. SIS Adjustment

1. Move the shifting lever from friction so SIS, and make the SIS adjustment.

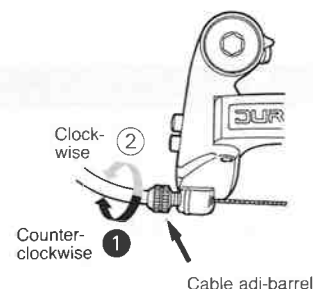


2. Operate the shifting lever to shift the chain from the top gear to the 2nd gear.

- If the chain will **not** move to the 2nd gear, turn the cable adjusting barrel to increase the tension.....① (counter clockwise)
- If the chain **moves past** the 2nd gear, decrease the tension.....② (clockwise)



3. Next with the chain on the 2nd gear, increase the inner cable tension while turning the crank forward. Stop turning the cable adjusting barrel **just before the chain makes noise against the 3rd gear**. This completes the adjustment.



Be sure to perform oil maintenance at each part of the derailleur mechanism.  
The optimum oil is dry molybdenum oil or the equivalent.



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