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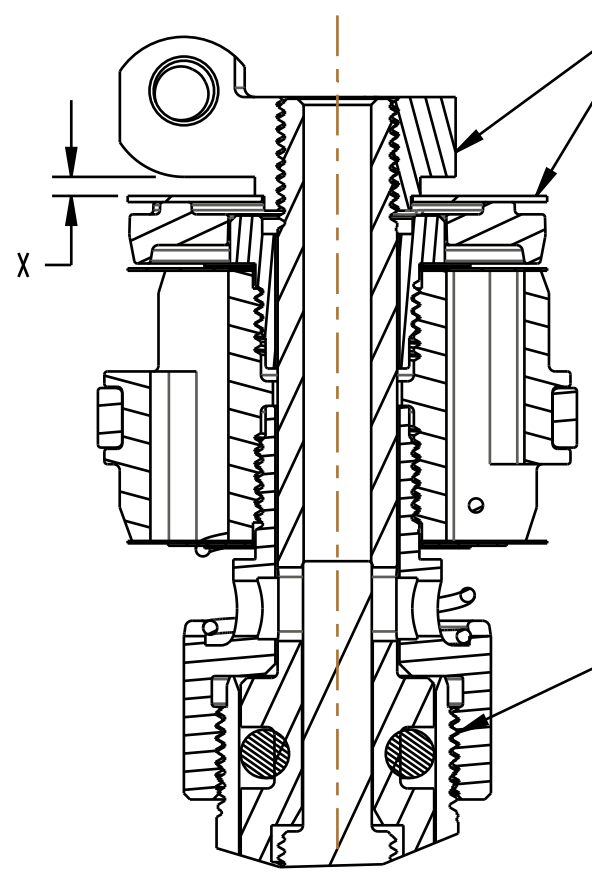
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***ASSEMBLY INSTRUCTIONS:**

- 1) ORIENT LEAF SPRING TO THE APPROX. CENTER OF ITS ADJUSTMENT RANGE
- 2) ENGAGE FLATS OF LEAF SPRING TO RBD NUT
- 3) PLACE .030 [0,76] THICK SHIM AT "X"
- 4) HOLD RBD NUT TO PISTON ASSY AND TORQUE HSR SHAFT TO 2±.5in-lb
- 5) ROTATE HSR SHAFT CCW 4 CLICKS (72°)
- 6) TORQUE M2 SHCS (019-01-141) TO SPECIFIED TORQUE



SECTION D-D

Fastener Standard (Metric): Screw [M2.5 X 6mm] Tapered Head Cap, Steel, Black

Fastener, Custom: Nut, HSR, Grip F-S

Spring, Leaf, HSR, Grip F-S, .010 THK

Plate, HSR, Grip F-S

REBOUND PISTON ASSEMBLIES:
 820-03-655-KIT: 2021 Grip2 VVC HSR / LSR Rebound Piston Assy Long Travel
 820-03-669-KIT: 2021 Grip2 VVC HSR / LSR Rebound Piston Assy Light

820-03-525-KIT
 2019 Grip2 Bearing Housing Assy

TORQUE: 8±.5in-lb
 Seals: O-Ring [4.0mm ID x 2.0mm CS] Metric, N-90 Static

Seals: O-Ring [3.0MM ID x 1.0MM CS] Metric, N-70, Static

Fastener, Custom: Screw [#8-32] SHCS

LOCTITE: RED 263
 1-2 DROPS

Spring: Detent [.138 TLG, 087 OD 48 lb/in]

TORQUE: 40±5 in-lb*

Spring: Detent [.138 TLG, 087 OD 48 lb/in]

LOCTITE: RED 263
 1-2 DROPS

IMPORTANT: INSTALL ONTO SHAFT FROM THIS END ONLY *

Seals: O-Ring [3.0MM ID x 1.5MM CS] Metric, N-70, Static

Adjuster, HSR, Grip F-S

Valve: Metric [8.00mm OD X 6mm ID X 0.10mm THK]

2-Piece HSR Shaft

Seals: O-Ring [13.0MM ID x 1.0MM CS] Metric, N-70, Static

Seals: O-Ring [9.0MM ID x 1.0MM CS] Metric, N-70, Static

Coupler, LSR, Grip F-S

Air Valve Parts: Ball [2.0mm OD], Grade 25 Steel, Chrome Plated

Base Stud, Grip F-S

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130 Hangar Way, Watsonville, CA 95076 USA		Fax 831-768-9312	
TITLE: 2021 34 150 VVC HSR/LSR DAMPER SHAFT ASSEMBLIES			
SIZE: C	DWG. NO.		
PLOT SCALE: 1:1		SHEET 1 OF 2	