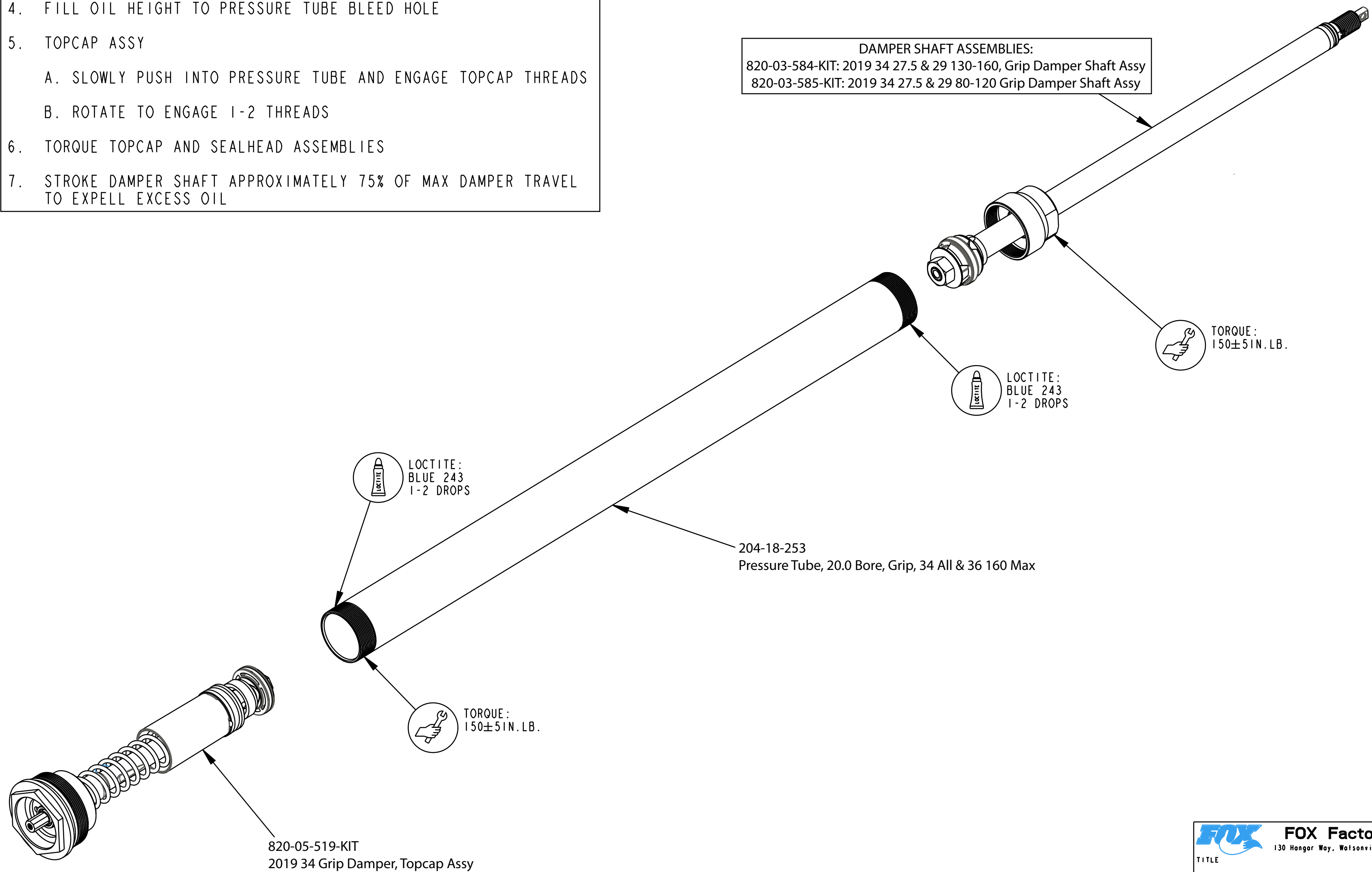


ASSEMBLY INSTRUCTIONS:

1. ASSEMBLE DAMPER SHAFT ASSEMBLY TO PRESSURE TUBE
2. FILL CARTRIDGE 1/2 FULL WITH OIL
3. STROKE DAMPER SHAFT 5X, THEN TOP OUT DAMPER SHAFT
4. FILL OIL HEIGHT TO PRESSURE TUBE BLEED HOLE
5. TOPCAP ASSY
  - A. SLOWLY PUSH INTO PRESSURE TUBE AND ENGAGE TOPCAP THREADS
  - B. ROTATE TO ENGAGE 1-2 THREADS
6. TORQUE TOPCAP AND SEALHEAD ASSEMBLIES
7. STROKE DAMPER SHAFT APPROXIMATELY 75% OF MAX DAMPER TRAVEL TO EXPELL EXCESS OIL

DAMPER SHAFT ASSEMBLIES:  
 820-03-584-KIT: 2019 34 27.5 & 29 130-160, Grip Damper Shaft Assy  
 820-03-585-KIT: 2019 34 27.5 & 29 80-120 Grip Damper Shaft Assy



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TITLE  
**2019 34 Grip Cartridge Assemblies**

SIZE DWG. NO.  
**C**  
 PLOT SCALE 0.75:1 SHEET 1 OF 1

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