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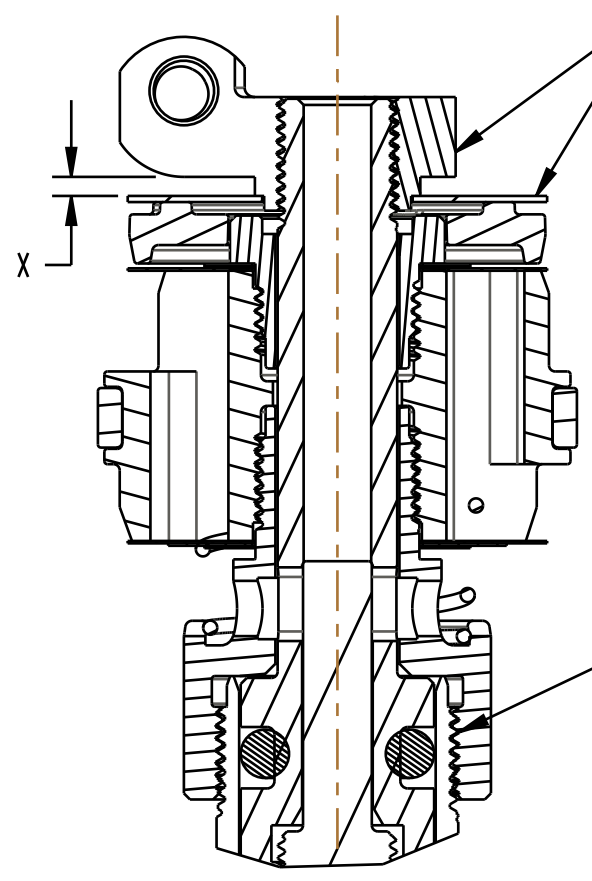
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**\*ASSEMBLY INSTRUCTIONS:**

- 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



TORQUE:  
40±5 in-lb\*

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

820-03-655-KIT  
2021 Grip2 VVC HSR / LSR Rebound Piston Assy Long Travel

TORQUE:  
8±.5 in-lb

Seals: O-Ring [4.0mm ID x 2.0mm CS] Metric, N-90 Static

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

IMPORTANT:  
INSTALL ONTO SHAFT FROM THIS END ONLY \*

LOCTITE:  
RED 263  
1-2 DROPS

TORQUE:  
40±5 in-lb\*

LOCTITE:  
RED 263  
1-2 DROPS

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

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

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

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

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

Base Stud, Grip F-S

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

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

Needle, LSR

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

Adjuster, HSR, Grip F-S

Damper Shaft

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**FOX Factory, Inc.**  
130 Hangar Way, Watsonville, CA 95076 USA  
Ph 831-768-1100 Fax 831-768-9312

TITLE  
**2021 40 203, Grip2 VVC HSR / LSR Damper Shaft Assy**

SIZE DWG. NO.  
**C 820-03-663-KIT**

PLOT SCALE 1:1 SHEET 1 OF 2