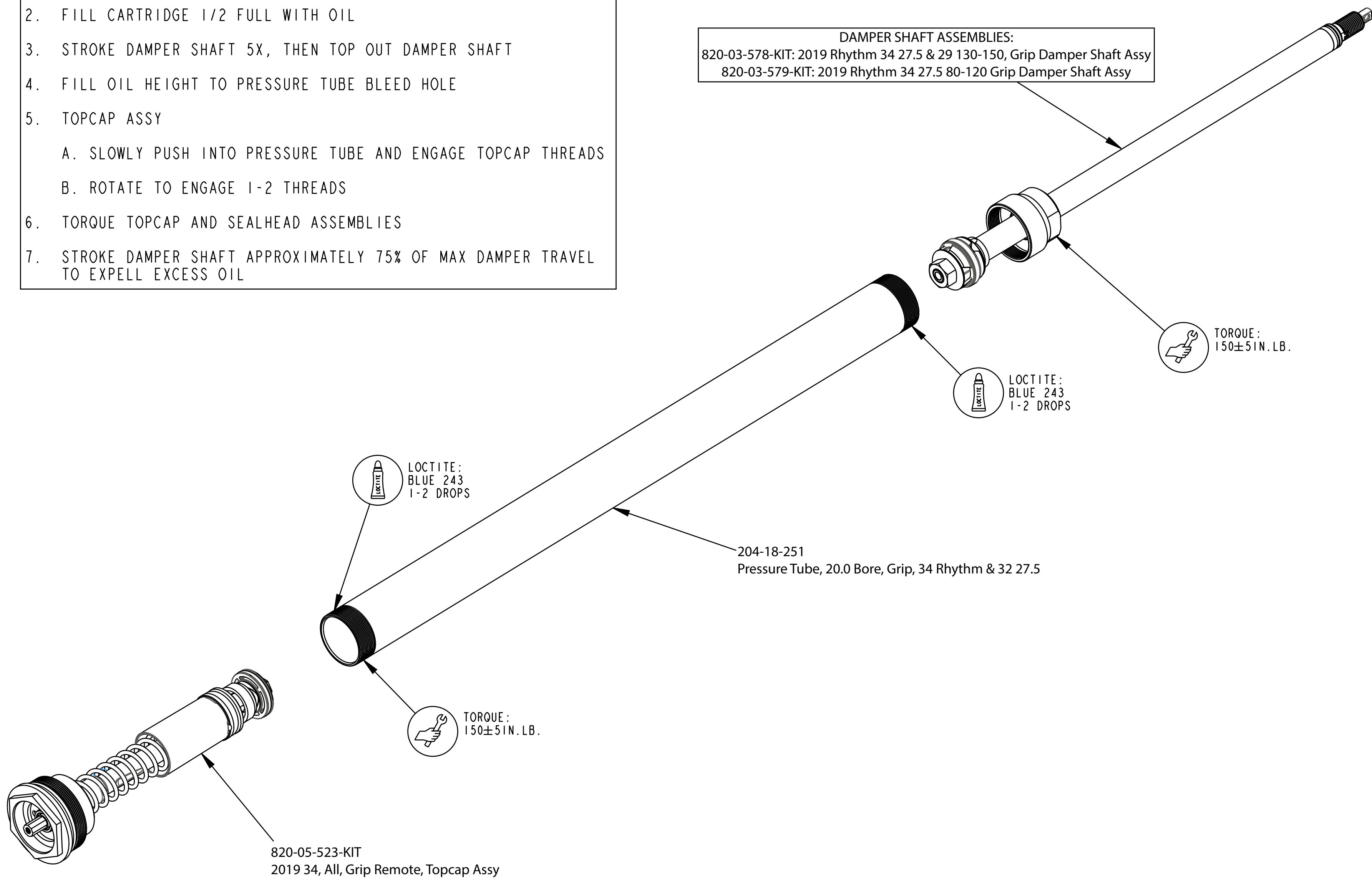


ASSEMBLY INSTRUCTIONS:

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:  
 820-03-578-KIT: 2019 Rhythm 34 27.5 & 29 130-150, Grip Damper Shaft Assy  
 820-03-579-KIT: 2019 Rhythm 34 27.5 80-120 Grip Damper Shaft Assy



LOCTITE:  
 BLUE 243  
 1-2 DROPS

TORQUE:  
 150±5 IN. LB.

LOCTITE:  
 BLUE 243  
 1-2 DROPS

TORQUE:  
 150±5 IN. LB.

204-18-251  
 Pressure Tube, 20.0 Bore, Grip, 34 Rhythm & 32 27.5

820-05-523-KIT  
 2019 34, All, Grip Remote, Topcap Assy

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TITLE **2019 34 Rhythm Grip Remote Cartridge Assemblies**

SIZE DWG. NO. **C**

PLOT SCALE 0.75:1 SHEET 1 OF 1