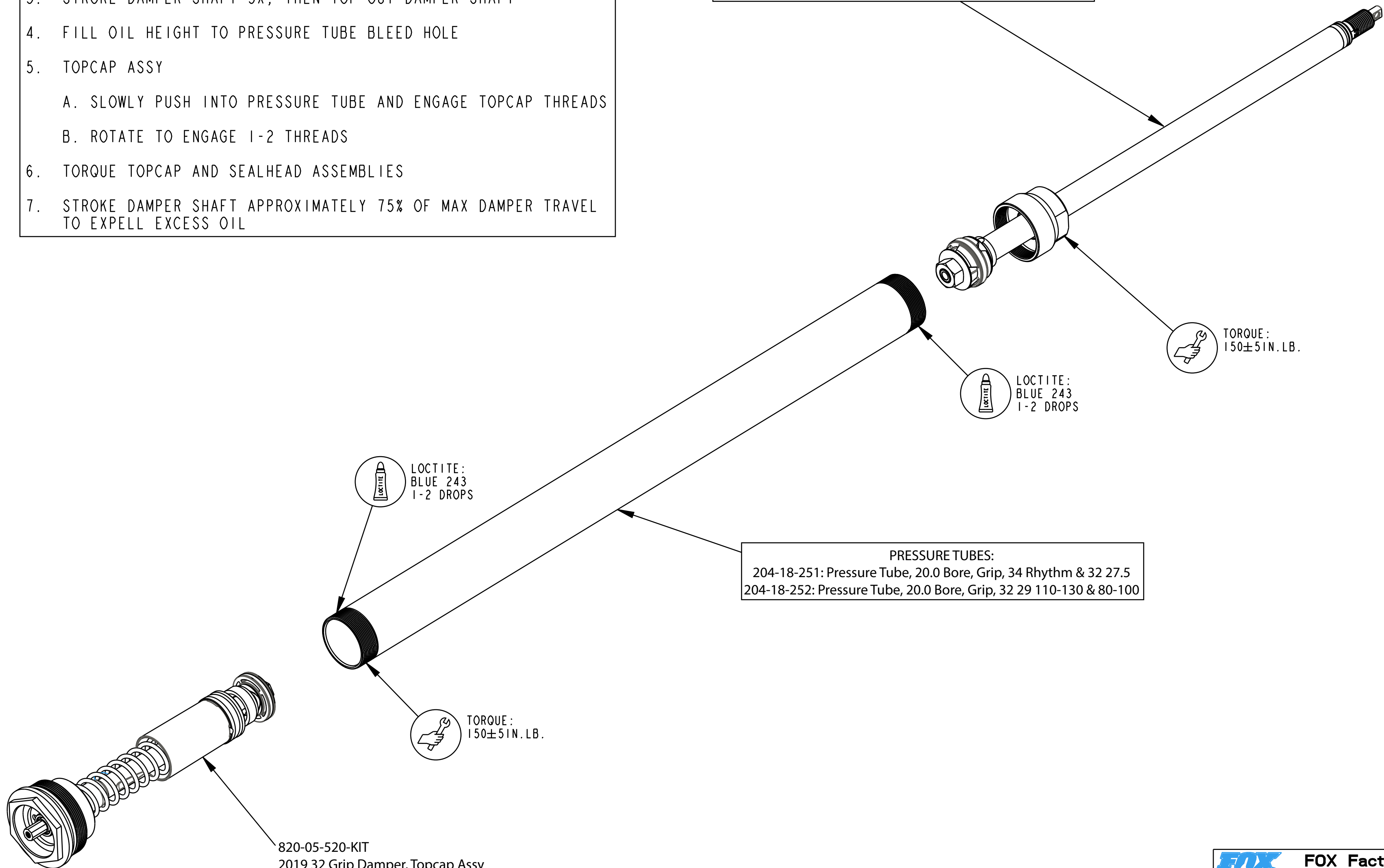


**ASSEMBLY INSTRUCTIONS:**

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:**  
 820-03-580-KIT: 2019 32 27.5 130-150, Grip Damper Shaft Assy  
 820-03-581-KIT: 2019 32 27.5 80-120 Grip Damper Shaft Assy  
 820-03-582-KIT: 2019 32 29 130, Grip Damper Shaft Assy  
 820-03-583-KIT: 2019 32 29 80-120 Grip Damper Shaft Assy

**PRESSURE TUBES:**  
 204-18-251: Pressure Tube, 20.0 Bore, Grip, 34 Rhythm & 32 27.5  
 204-18-252: Pressure Tube, 20.0 Bore, Grip, 32 29 110-130 & 80-100



820-05-520-KIT  
 2019 32 Grip Damper, Topcap Assy

LOCTITE:  
 BLUE 243  
 1-2 DROPS

TORQUE:  
 150±5 IN. LB.

LOCTITE:  
 BLUE 243  
 1-2 DROPS

TORQUE:  
 150±5 IN. LB.

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

TITLE  
**2019 32mm Grip Cartridge Assemblies**

SIZE DWG. NO.  
**C**

PLOT SCALE 0.75:1 | SHEET 1 OF 1