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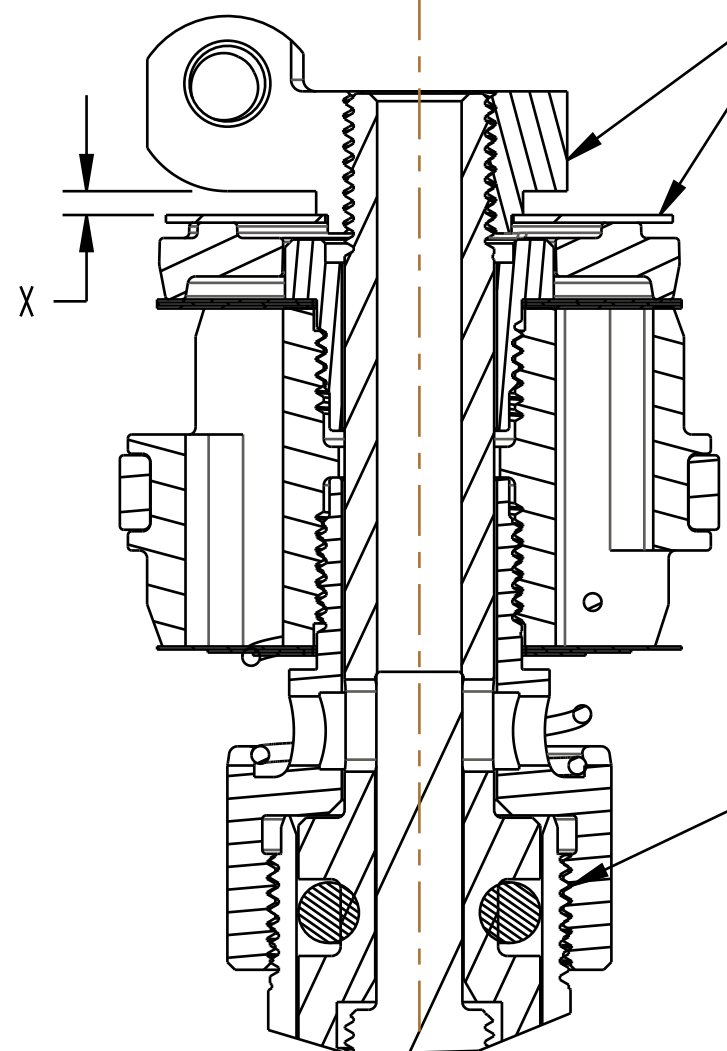
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ASSEMBLY INSTRUCTIONS:

- 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 $2 \pm .5$ in-lb
- 5) ROTATE HSR SHAFT CCW 4 CLICKS (72°)
- 6) TORQUE M2 SHCS (019-01-141) TO SPECIFIED TORQUE



TORQUE:
 40 ± 5 in-lb*

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

045-00-178: Valve: Metric
[8.00mm OD X 6mm ID X 0.10mm THK]

820-03-573-KIT
2019 36 180, Grip2 HSR, 2-Piece Damper Shaft Assy

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

LOCTITE:
RED 263
1-2 DROPS

241-02-120

029-08-047
Seals: O-Ring [13.0MM ID x 1.0MM CS]
Metric, N-70, Static

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

039-00-243
(010-01-016)

210-24-379
Base Stud, Grip F-S

019-01-141
Fastener Standard (Metric): Screw
[M2.5 X 6mm] Tapered Head Cap, Steel, Black

018-00-062
Fastener, Custom: Nut, HSR, Grip F-S

039-00-461
Spring, Leaf, HSR, Grip F-S, .010 THK

050-00-026
Plate, HSR, Grip F-S

820-03-528-KIT
2019 Grip2 HSR / LSR Rebound
Piston Assy Long Travel

TORQUE:
 40 ± 5 in-lb*

029-08-073
Seals: O-Ring [9.0MM ID x 1.0MM CS]
Metric, N-70, Static

210-24-391
Coupler, LSR, Grip F-S

229-10-670
Shaft, Damper, Grip F-S, 10mm, 36 180

(039-00-243)

010-01-016
Air Valve Parts: Ball [2.0mm OD], Grade 25
Steel, Chrome Plated

LOCTITE:
RED 263
1-2 DROPS

IMPORTANT:
INSTALL ONTO SHAFT
FROM THIS END ONLY *

210-24-400
Needle, LSR, Grip2, 36 180

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

029-08-068
Seals: O-Ring [3.0MM ID x 1.5MM CS]
Metric, N-70, Static

210-24-390
Adjuster, HSR, Grip F-S

TORQUE:
 $8 \pm .5$ in-lb

029-08-197
Seals: O-Ring [4.0mm ID
x 2.0mm CS] Metric,
N-90 Static

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		FOX Factory, Inc.		Ph 831-768-1100
130 Hongar Way, Watsonville, CA 95076 USA		Fax 831-768-9312		
TITLE 2019 36 180, Grip2				
HSR / LSR Damper Shaft Assy				
SIZE	DWG. NO.	820-03-529-KIT		
C				
PLOT SCALE	1:1	SHEET 1 OF 2		

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Pr oE ASSEM