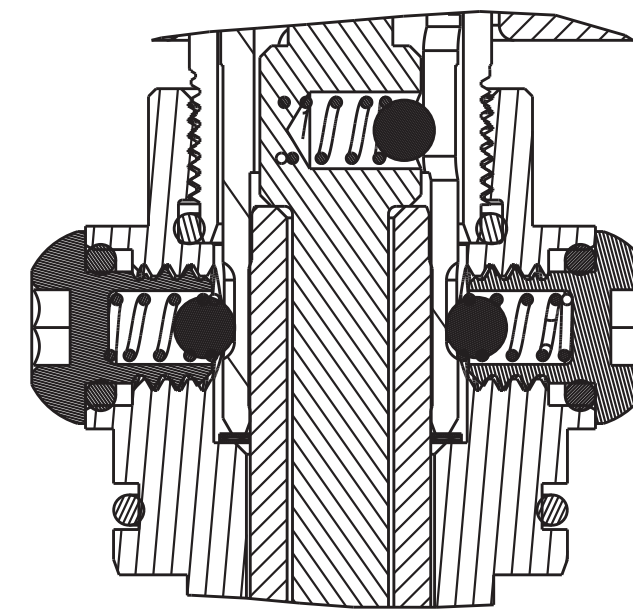


*ASSEMBLY INSTRUCTIONS:

- 1) TIGHTEN VVC NUT (241-00-067) UNTIL VVC LEAF SPRING (043-XX-650) MAKES CONTACT WITH POSTS ON VVC PLATE (050-00-XXX) AND ROTATION STOPS
- 2) ORIENT VVC LEAF SPRING TO THE APPROX. CENTER OF ITS ADJUSTMENT RANGE
- 3) PLACE .050 [1,27] THICK SHIM AT "X"
- 4) HOLD VVC NUT TO PISTON ASSY AND TORQUE HSR SHAFT TO $2 \pm .5$ in-lb
- 5) TORQUE M3 SHCS (019-01-095) TO SPECIFIED TORQUE

TORQUE:
 40 ± 5 IN. LB.

SECTION A-A
SCALE 4:1



SECTION A-A
SCALE 4:1

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

Valve: Metric [8mm OD X 6mm ID X 0.10mm THK]

Fastener, Custom: VVC Nut, HSR, GripX2

Valve Custom (T): VVC, HSR, GripX2, .010 THK

820-03-699-KIT
2025 Grip X2, Bearing Housing Assy

LOCTITE:
RED 263
1-2 Drops

IMPORTANT:
INSTALL ONTO SHAFT
FROM THIS END ONLY

820-03-744-KIT
2025 Grip X2 HSR / LSR
Rebound Piston Assy 38/40

TORQUE:
 10 ± 2 IN. LB.

TORQUE:
 15 ± 2 IN. LB.

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

Damping Adj Part: 2024 Grip3

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

Fastener, Standard (Metric): Screw [M3 X 6mm] SHCS, Patchlock

820-03-732-KIT
2025 Grip X2, Rebound Check Valve Assy

TORQUE:
 10 ± 2 IN. LB.

TORQUE:
 40 ± 5 IN. LB.

LOCTITE:
RED 263
1-2 Drops

Base Stud, GripX2

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

Air Valve Parts: Ball [2.0mm OD], Grade 25 Steel, Chrome Plated (X2)

Spring: Detent [.138 TLG, .087 OD, 48 lb/in] (X2)

Seals: O-Ring [3.5MM ID x 1.0MM CS] Metric, N-70, Static (X2)

Fastener, Custom: HSR Detent Screw, GripX2 (X2)

TORQUE:
 10 ± 2 IN. LB.

Coupler, LSR, GRIP F-S

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

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

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

Needle, LSR