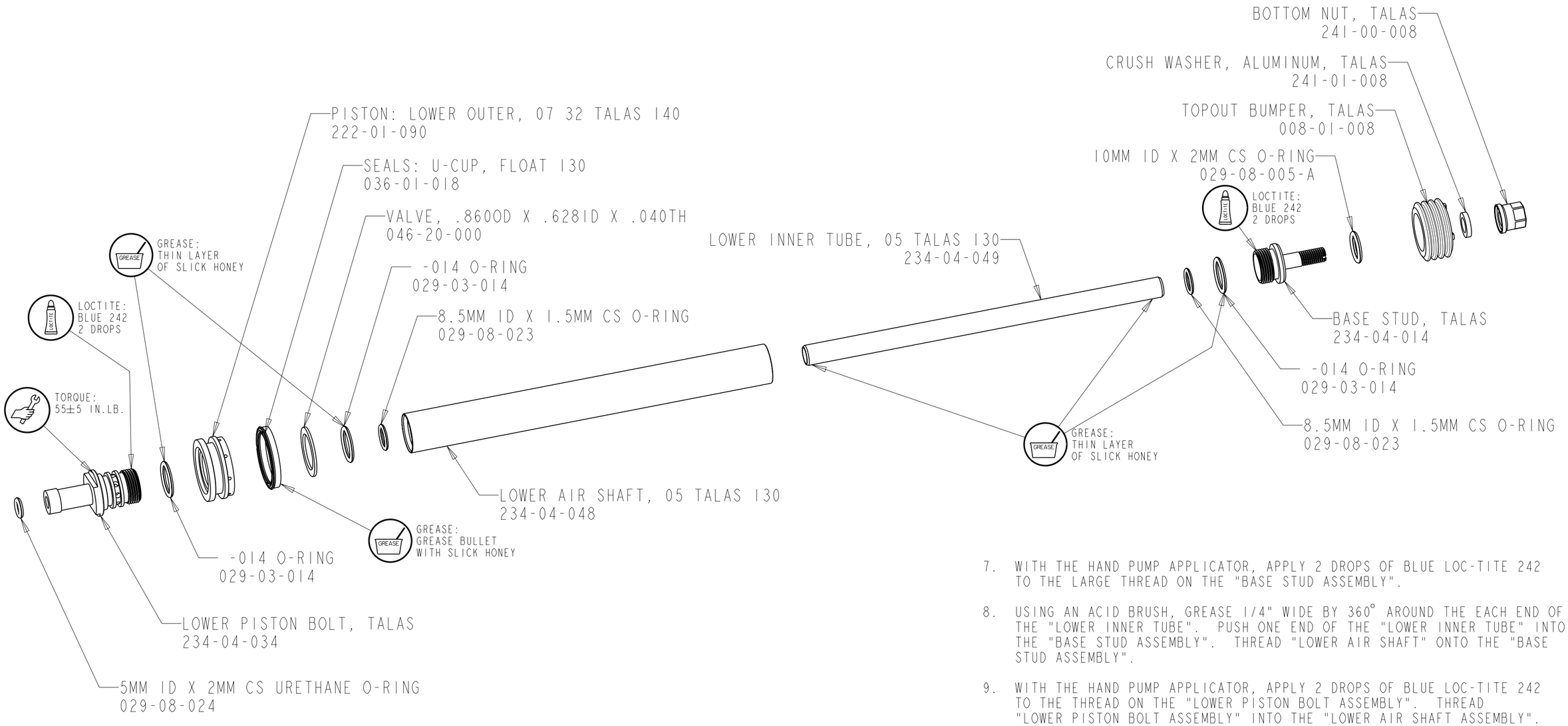
— PROPRIETARY —
THIS DOCUMENT CONTAINS CONFIDENTIAL, PROPRIETARY INFORMATION THAT IS FOX PROPERTY. DO NOT DISCLOSE TO OR DUPLICATE FOR OTHERS EXCEPT AS AUTHORIZED BY FOX.

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	A	RELEASE FOR PRODUCTION	07SEP06	



ASSEMBLY INSTRUCTIONS:

1. PLACE "LOWER PISTON BOLT" ON FIXTURE AND INSTALL "8.5MM ID X 1.5MM CS O-RING" INTO THE BOTTOM INNER GROOVE (THREADED SIDE). CHECK THAT O-RING IS FULLY INSTALLED INTO THE GLAND.

2. PLACE "LOWER PISTON BOLT" ON FIXTURE AND INSTALL "5MM ID X 2MM CS O-RING" INTO THE TOP INNER GROOVE. CHECK THAT O-RING IS FULLY INSTALLED INTO THE GLAND.

3. PLACE LONG SEAL BULLET ON THREADED SIDE OF "PISTON BOLT" AND INSTALL THE "-014 O-RING". INSPECT THAT O-RING IS NOT TWISTED AND FULLY IN GROOVE. USING AN ACID BRUSH, LIGHTLY GREASE THE OD OF THE "-014 O-RING".

4. INSTALL "LOWER OUTER PISTON" ONTO THE "LOWER PISTON BOLT" ORIENTED WITH THE SMALL C-BORE ON THE PISTON FACING TOWARDS THE SHOULDER OF THE BOLT.

5. INSTALL "VALVE .860 OD X .628 ID" ONTO THE "LOWER PISTON BOLT". PLACE SHORT SEAL BULLET ON THREADED SIDE OF "PISTON BOLT" AND INSTALL THE "-014 O-RING". INSPECT THAT O-RING IS NOT TWISTED AND FULLY IN GROOVE. USING AN ACID BRUSH, LIGHTLY GREASE THE OD OF THE "-014 O-RING".

6. INSTALL "8.5MM ID X 1.5MM CS O-RING" INTO THE BOTTOM INNER GLAND OF THE "BASE STUD. INSPECT THAT O-RING IS FULLY INSTALLED INTO THE GLAND. USING A SHORT SEAL BULLET, INSTALL THE "-014 O-RING" ONTO THE BASE STUD. INSPECT THAT O-RING IS NOT TWISTED AND FULLY IN GROOVE. USING AN ACID BRUSH, LIGHTLY GREASE THE OD OF THE "-014 O-RING".

7. WITH THE HAND PUMP APPLICATOR, APPLY 2 DROPS OF BLUE LOC-TITE 242 TO THE LARGE THREAD ON THE "BASE STUD ASSEMBLY".

8. USING AN ACID BRUSH, GREASE 1/4" WIDE BY 360° AROUND THE EACH END OF THE "LOWER INNER TUBE". PUSH ONE END OF THE "LOWER INNER TUBE" INTO THE "BASE STUD ASSEMBLY". THREAD "LOWER AIR SHAFT" ONTO THE "BASE STUD ASSEMBLY".

9. WITH THE HAND PUMP APPLICATOR, APPLY 2 DROPS OF BLUE LOC-TITE 242 TO THE THREAD ON THE "LOWER PISTON BOLT ASSEMBLY". THREAD "LOWER PISTON BOLT ASSEMBLY" INTO THE "LOWER AIR SHAFT ASSEMBLY". PLACE "LOWER AIR SHAFT ASSEMBLY" INTO FIXTURE AND TORQUE TO 55 IN-LB.

10. INSTALL "TOPOUT BUMPER" ONTO "LOWER AIR SHAFT ASSEMBLY" WITH THE 4 RIBS ON THE BUMPER FACING OPPOSITE OF THE "LOWER OUTER PISTON".

11. PRESS IN THE "10MM ID X 2MM CS O-RING" INTO THE BOTTOM GROOVE OF THE BASE STUD.

12. USING A GREASED SEAL BULLET, CAREFULLY INSTALL THE "FLOAT 130 U-CUP SEAL" ONTO THE GLAND OF THE "LOWER OUTER PISTON" WITH THE SEAL EDGE TOWARDS THE TOP OF THE ASSEMBLY.

13. REMAINING PARTS WILL BE ASSEMBLED DURING "MAIN ASSEMBLY".

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	MATERIAL SPEC

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES [MM]

TOLERANCES ARE:
DECIMALS .XX [.X] ± .01 [0,25] .XXX [.XX] ± .005 [0,13]
ANGLES ± 1°

THIRD ANGLE PROJECTION

PER ASME Y14.5M 1994

APPROVALS		DATE
DWN. BY	B. BECKER	07SEP06
CHK. BY	B. BECKER	07SEP06
ENG.	B. BECKER	07SEP06
MFG.		
ADD.		

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

SPRING SUB-GROUP:
07 32 TALAS 130 LOWER AIR SHAFT ASSY

SIZE C | PART NO. 820-02-032

PLOT SCALE0.75:1 | SHEET 1 OF 1