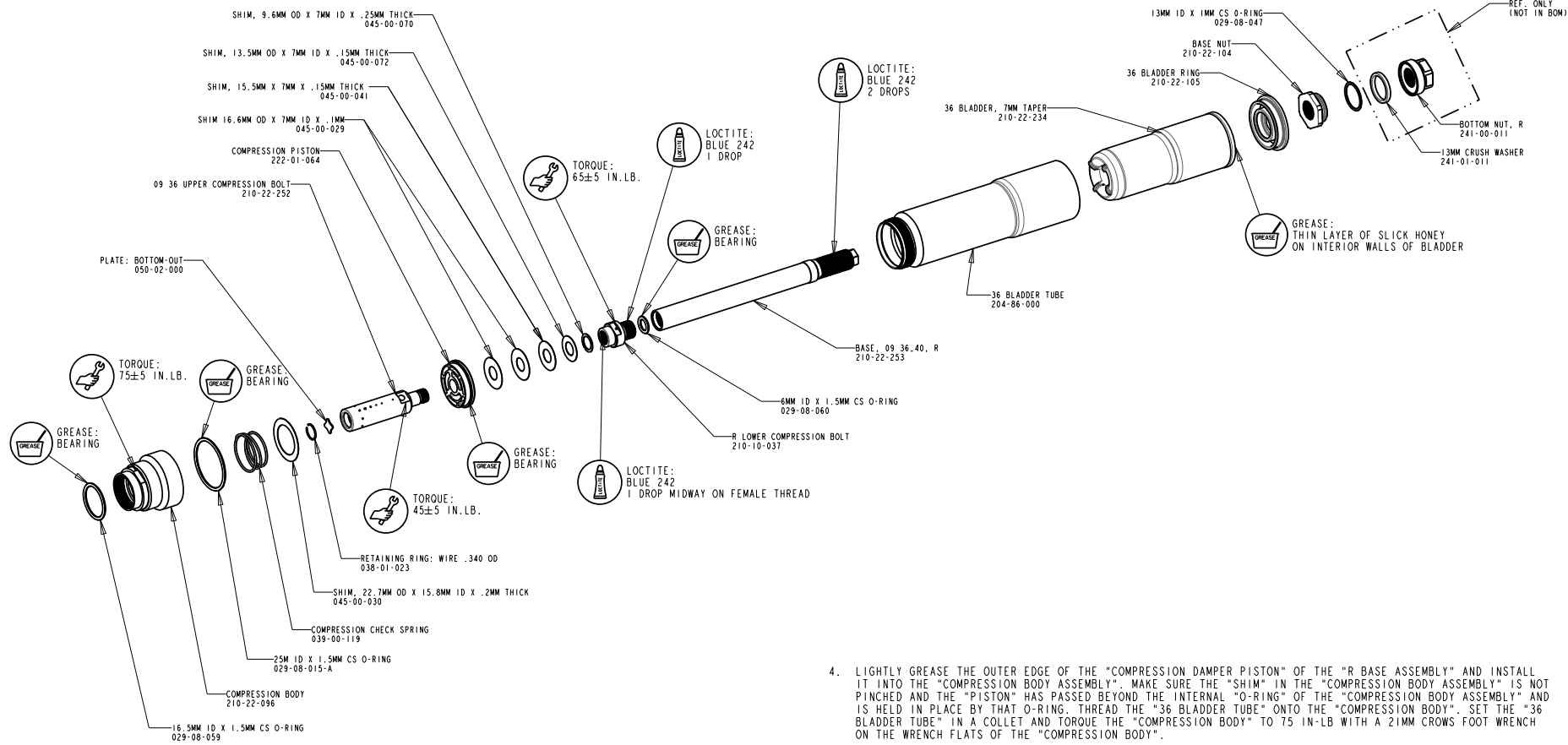


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REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
	A	RELEASE FOR PRODUCTION	21 FEB 08	



**ASSEMBLY INSTRUCTIONS:**

1. USING A BULLET TOOL, GREASE AND INSTALL THE EXTERNAL "6MM ID X 1.5MM CS O-RING" ONTO THE GROOVE OF THE "R LOWER COMPRESSION BOLT". THREAD THE "LOWER COMPRESSION BOLT ASSEMBLY" INTO THE "R BASE". TORQUE THE "LOWER COMPRESSION BOLT" TO 65 IN-LB WITH A 10MM CROWS FOOT WRENCH WHILE HOLDING THE LOWER END OF THE "R BASE" WITH AN 8MM 6 POINT WRENCH.
2. PLACE THE "BOTTOM OUT PLATE" INTO THE "36 UPPER COMPRESSION BOLT" AND CHECK TO MAKE SURE IT SEALS. INSTALL THE WIRE RETAINING RING INTO THE LOWER GROOVE OF THE "UPPER COMPRESSION BOLT" AND CHECK TO MAKE SURE IT IS FULLY ENGAGED IN THE GROOVE. SLIDE THE "COMPRESSION PISTON," SMALL SIDE FIRST ONTO THE THREADED END OF THE "36 UPPER COMPRESSION BOLT". WITH THE THREADED END OF THE "UPPER BOLT ASSEMBLY" FACING UPWARDS, INSTALL TWO "SHIM 16.6MM OD X 7MM ID X .1MM TH", ONE "SHIM 15.5MM OD X 7MM ID X .15MM TH", ONE "SHIM 13.5MM OD X 7MM ID X .15MM TH" AND ONE "SHIM 9.6MM OD X 7MM ID X .25MM TH". PUT ONE DROP OF BLUE LOCTITE 242 MIDWAY ON THE FEMALE THREAD OF THE "LOWER COMPRESSION BOLT." KEEP THE "UPPER BOLT ASSEMBLY" INVERTED AND THREAD ON THE "R BASE ASSEMBLY". CAREFULLY INSPECT THAT THE "SHIMS" ARE CENTERED ON THE "BOLT" AND CLAMPED PROPERLY ON THE "BASE ASSEMBLY". TORQUE THE "UPPER COMPRESSION BOLT ASSEMBLY" TO 45 IN-LB WITH A 10MM WRENCH WHILE HOLDING THE LOWER END OF THE "R BASE" WITH AN 8MM 6 POINT WRENCH.
3. USING A BULLET TOOL, GREASE AND INSTALL THE INTERNAL "16.5MM ID X 1.5MM CS O-RING" IN THE UPPER GROOVE ON THE "COMPRESSION BODY". GREASE AND INSTALL THE INTERNAL "25MM ID X 1.5MM CS O-RING" IN THE LOWER GROOVE ON THE "COMPRESSION BODY". INSTALL THE "COMPRESSION CHECK CONE SPRING INTO THE INSIDE OF THE "COMPRESSION BODY" WITH THE LARGE SIDE FIRST. PLACE THE "SHIM 22.7MM OD X 15.8MM ID X .2MM TH" INTO THE "COMPRESSION BODY" MAKING SURE IT SETS ON THE "CONE SPRING" AND NOT UNDER THE END WIRE OF THE "SPRING".

4. LIGHTLY GREASE THE OUTER EDGE OF THE "COMPRESSION DAMPER PISTON" OF THE "R BASE ASSEMBLY" AND INSTALL IT INTO THE "COMPRESSION BODY ASSEMBLY". MAKE SURE THE "SHIM" IN THE "COMPRESSION BODY ASSEMBLY" IS NOT PINCHED AND THE "PISTON" HAS PASSED BEYOND THE INTERNAL "O-RING" OF THE "COMPRESSION BODY ASSEMBLY" AND IS HELD IN PLACE BY THAT O-RING. THREAD THE "36 BLADDER TUBE" ONTO THE "COMPRESSION BODY". SET THE "36 BLADDER TUBE" IN A COLLET AND TORQUE THE "COMPRESSION BODY" TO 75 IN-LB WITH A 21MM CROWS FOOT WRENCH ON THE WRENCH FLATS OF THE "COMPRESSION BODY".
5. THESE NEXT STEPS WILL BE ASSEMBLED ONTO THE "R BASE VALVE ASSEMBLY" AFTER THE CARTRIDGE IS ASSEMBLED AND FILLED WITH OIL. LIGHTLY GREASE THE INSIDE SURFACES AS WELL AS THE OUTER AND INNER SEALING LIPS OF THE "36 BLADDER". INSTALL THE INNER SEALING LIP OF THE "BLADDER" ONTO THE INNER SEAL GROOVE OF THE "36 BLADDER RING" AND CAREFULLY SPIN TO MAKE SURE IT IS FULLY ENGAGED. PUSH FROM THE TOP OF THE "BLADDER" SO YOU DO NOT COMPRESS IT INWARD AND SLOWLY ROLL THE OUTER SEALING LIP OF THE "BLADDER ONTO THE "BLADDER RING". INSTALL THE EXTERNAL "13MM ID X 1MM CS O-RING" IN THE GROOVE ON THE "BASE NUT".

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	MATERIAL SPEC
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES (MM)			PER ASME Y14.5M 1994	
TOLERANCES ARE:			APPROVALS	DATE
DECIMALS .XX (.XX) ± .01 [0,25] ± 1°			DWN. BY S. PELOT	29 NOV 07
ANGLES .XXX (.XX) ± .005 [0,13]			CHK. BY B. BECKER	6 FEB 08
THIRD ANGLE PROJECTION			ENG. S. PELOT	29 NOV 07
MFG.				
ADD.				
SIZE C			PART NO. 820-03-110	
PLOT SCALE 0.65:1				SHEET 1 OF 2

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

09 36 VAN R BASE VALVE ASSY