ASSEMBLY PROCEDURE

IDA Head Assembly

P/N: 310 60041-XX

I. SPECIAL PRECAUTIONS

a. Be careful not to scratch or nick any sealing surfaces within the damper that would cause either internal or external leakage of the unit after assembly.

II. Tools, equipment, and supplies

a. O-ring Lubrication
b. Shock Vice – p/n: 310 30204
c. Piston Vice – p/n: 310 30329
d. Torque Wrench (minimum setting of 20 ft-lbs)
e. 9/16" socket
f. 11/16" Combination Wrench
g. 5/64" Allen Wrench

III. Components

a. (1) Piston Rod Assembly - p/n: 310 6005X-50
b. (1) Piston Assembly - p/n: 310 60006-XX
c. (1) Rod End Assembly - p/n: 310 60030-50
d. (1) Rod Guide Assembly - p/n: 310 30302
e. (1) Adjuster Knob - p/n: 310 60031
f. (1) Piston Rod Jam Nut - p/n: 310 30377
g. (1) Travel Indicator - p/n: 310 30218
h. (2) Disc Travel Limiter - p/n: 310 30396
i. (1) Piston Nut - p/n: 310 60013
j. (2) Adjuster Knob Set Screw- p/n: 310 60035
k. (1) Compression Valve Stack
l. (1) Rebound Valve Stack

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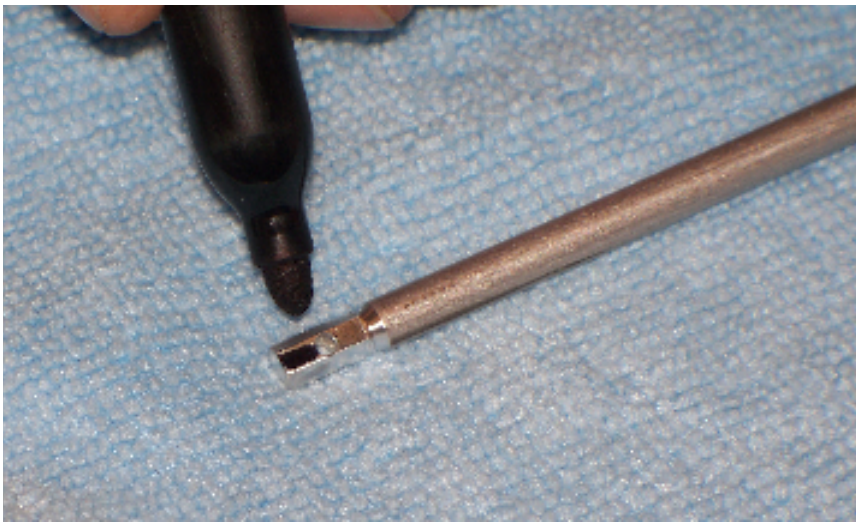
P/N: 310 60041-XX

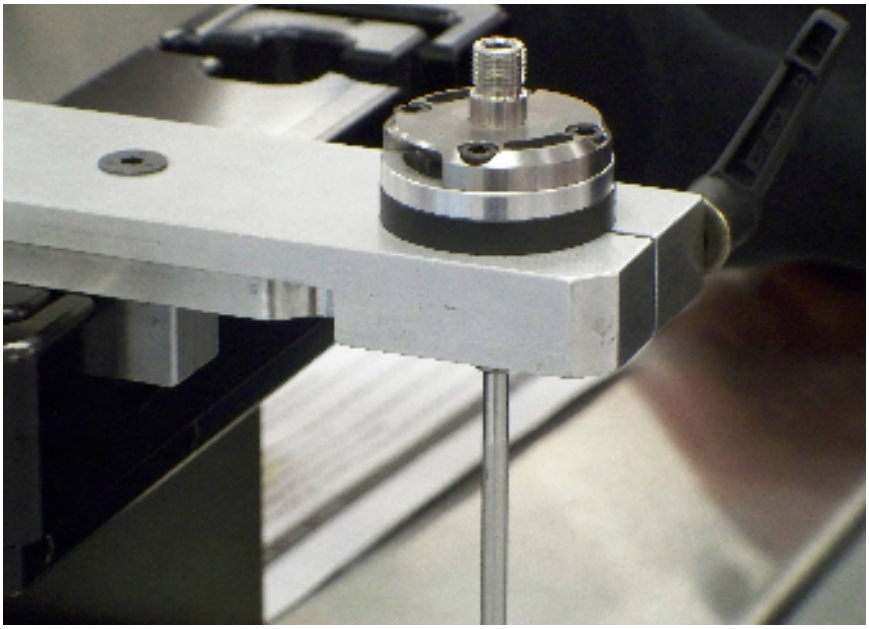
IV. Instructions

a. Layout rebound and compression valve disc stacks per necessary code.

b. Using a black marker place a mark on the adjuster rod hex above one of the set screw holes as shown.

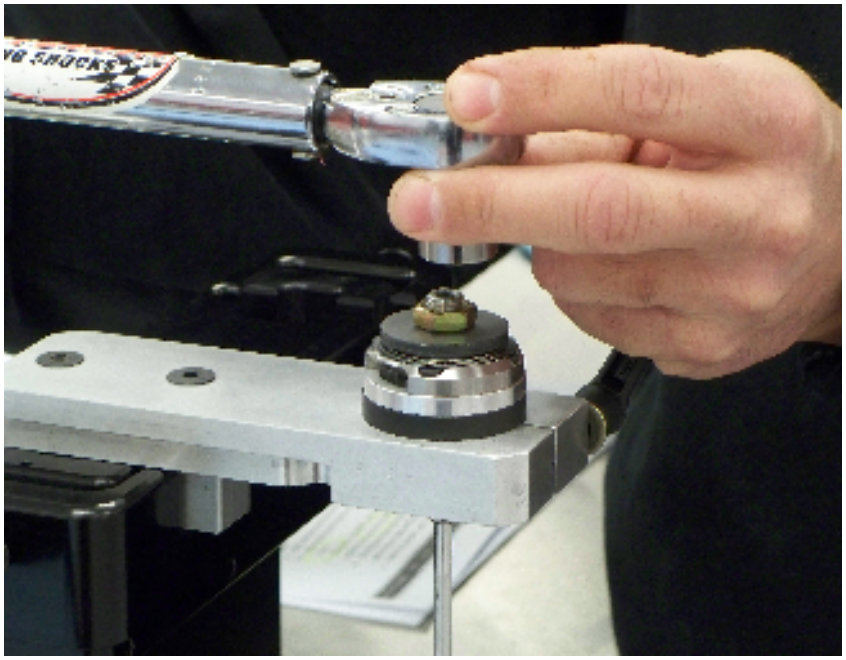


c. Place piston assembly - p/n: 310 60006-XX in piston vice with adjuster rod facing through bottom of vice (as shown) and tighten piston vice.



d. Place Rebound valve stack and disc travel limiter over rebound piston stud. Be sure any bleed ports in the disc align with the piston ports if applicable.

e. Screw the Piston Nut - p/n: 310 60013 onto rebound piston post and torque to 20 ft-lbs as shown. Be sure the ports on the bleed disc do not rotate during torqing.



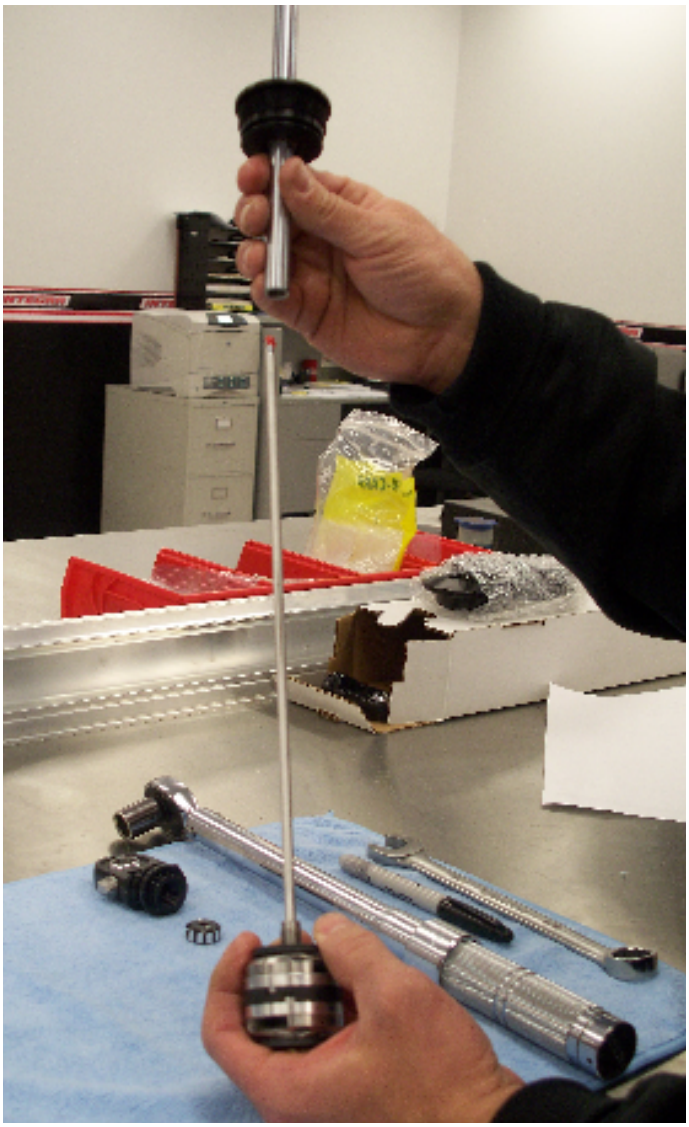
f. Slide the Travel Indicator - p/n: 310 30218 over the Piston Rod Assembly - p/n: 310 6005X-50 from the end of the piston rod without external threads.

g. Be sure there is adequate o-ring lubrication on the seal and wiper in the Rod Guide Assembly - p/n: 310 30302 and slide over the piston rod as shown.

h. Screw the Piston Rod Jam Nut - p/n: 310 30377 onto the piston rod until it is approximately (3) turns from bottoming.

i. Place the Compression valve stack and disc travel limiter over the adjuster rod. Be sure any bleed slots in the disc align with the piston ports if applicable.

j. While holding the disc stack, carefully slide the piston rod and rod guide assembly into place over the adjuster shaft as shown. Hand tighten the piston rod onto the compression piston post.



k. Screw the Rod End Assembly - p/n: 310 60030-50 onto the rod end until approximately .100" of the adjuster shaft shows into the window of the rod end. Be sure the selector shaft in the rod end is positioned in the rebound mode "R".

ASSEMBLY PROCEDURE

IDA Head Assembly

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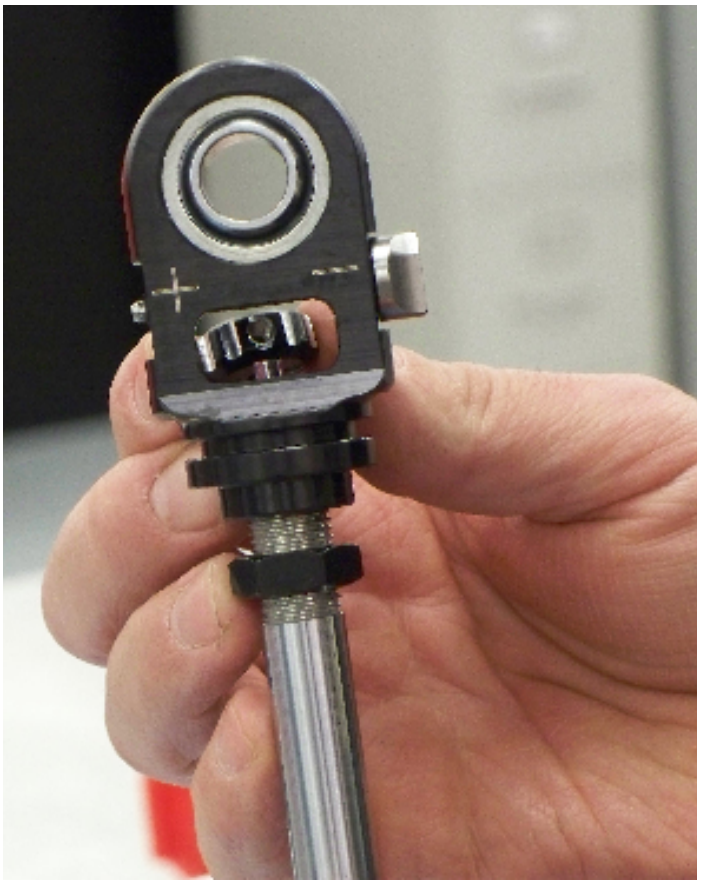
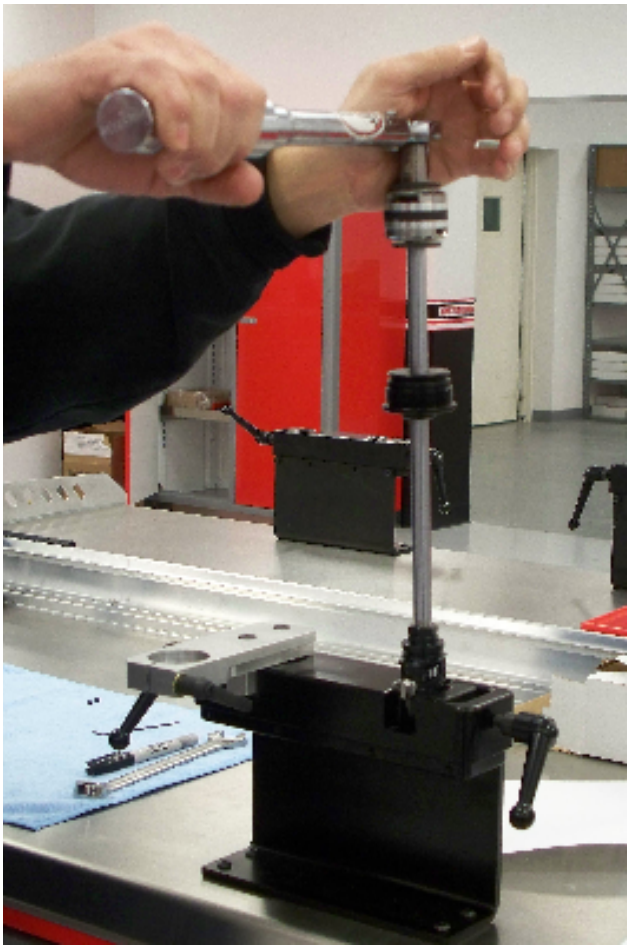
l. Place the Adjuster Knob - p/n: 310 60031 into the rod end window and over the adjuster shaft as shown. Be sure one of the set screw holes in the adjuster knob align with the black mark placed on the adjuster shaft in step “b”. Rotate the selector shaft to the compression mode “C”.



m. Continue tightening the rod end until it contacts the piston rod jam nut.

n. Place the rod end in the shock vice and tighten the piston rod jam nut to the rod end. Be sure there are approximately (3) threads showing on the shaft prior to tightening the jam nut. This will ensure that the rod end does not bind the adjuster shaft and cause failure of the internal adjusting components.

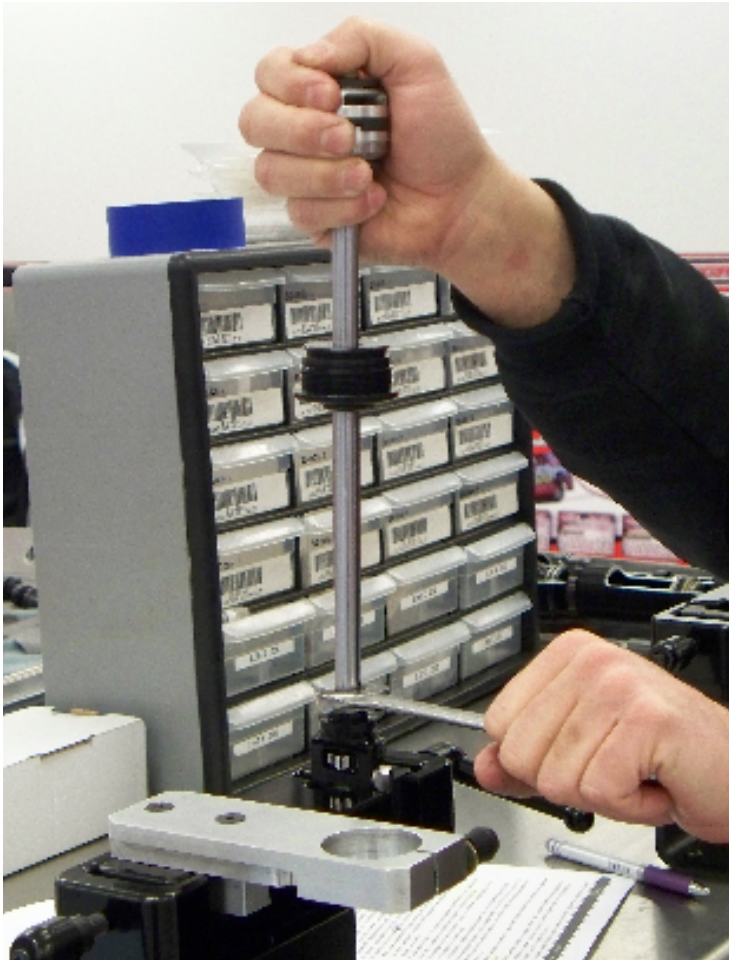
o. Torque the piston nut to 20 ft-lbs with the head assembly in the vice as shown. Be sure any bleed slots in the disc remain aligned with the ports in the piston if applicable.



p. Unlock the piston rod jam nut from the rod end and continue screwing the jam nut until it bottoms at the end of the threads.

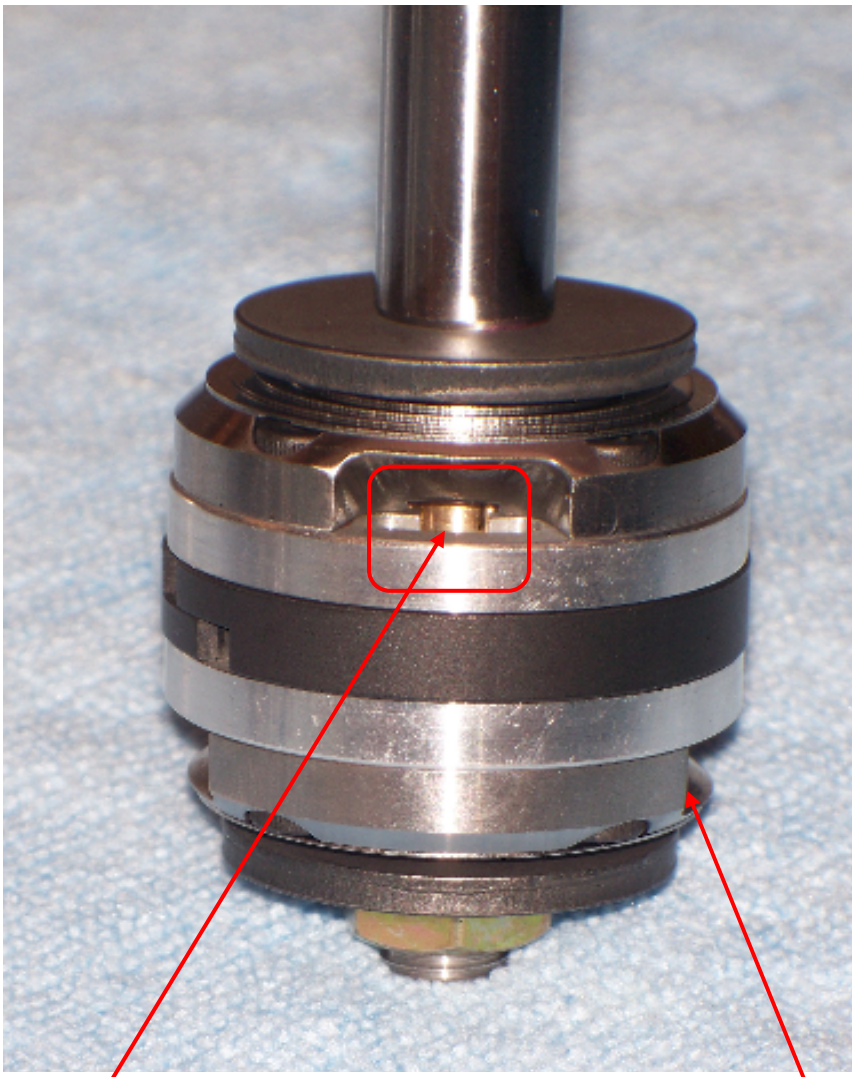
q. Slowly tighten the rod end until resistance is felt from the internal adjusting mechanism. Immediately stop tightening the rod end and back the rod end off ¼ turn from this point. Care must be made not to over-tighten the rod end or failure of the internal adjusting components may occur.

r. Tighten the piston rod jam nut to the rod end while holding the piston assembly from rotating as shown.



s. Check to see if the adjuster knob rotates freely with the selector shaft in the rebound and then the compression modes. If binding occurs in the compression mode, loosen the jam nut and back the rod end off an additional ¼ turn.

t. With the selector knob in the compression mode rotate the adjuster knob and check to see that the compression bleed plate is rotating and the rebound bleed plate is not rotating as indicated in the photo below.



Rebound bleed plate SHOULD NOT rotate

Compression bleed plate SHOULD rotate

u. Rotate the selector shaft to the rebound mode and check to see that the rebound bleed plate is rotating and the compression bleed plate is not rotating.