



ASSEMBLY PROCEDURE

Bladder Base Assembly

P/N: 310 60080-X

I. SPECIAL PRECAUTIONS

- a. Whenever working with the internals of a damper, be careful not to scratch the interior of the pressure tube. This could cause the damper to function improperly.
- b. Be careful not to scratch 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

III. Components

- a. (1) Base Valve Assembly - p/n: 310 60033-50
- b. (1) Rod Guide Primary Seal - p/n: 310 30211
- c. (1) Tube Assembly - p/n: 310 6007X-50
- d. (1) Bladder - p/n: 310 60080
- e. (2) Anti-Rotation Ball - p/n: 310 60038

IV. Instructions

- a. Inspect o-ring, 310 30211 for nicks or other irregularities. Replace if necessary.
- b. Thoroughly lubricate the o-ring and install onto the Base Valve Assembly - p/n: 310 60033-50. The o-ring should be installed into the groove that is furthest from the valve stack as shown below.





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- c. Use a small amount of grease in the side bores of the base valve assembly and place the Anti-Rotation Balls - p/n: 310 60038 into the side of the base valve.
- d. Lubricate the sealing ends and the exterior portion of the Bladder - p/n: 310 60080.
- e. Slide the bladder over the Tube Assembly - p/n: 310 6007X-50 as indicated in the photo. The sealing end should be positioned into the groove in the tube adapter.





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- f. Stand the tube assembly upright on a bench with the bladder facing up. Ensure that the small diameter sealing end of the bladder is located flat on the face and concentric with the bore of the pressure tube assembly as shown below.



BLADDER & PRESSURE TUBE BORE CONCENTRIC



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- g. Mark the side of the bladder corresponding to the location of the internal pressure tube anti-rotation grooves as indicated in the photo. This mark will be used to align the base valve anti-rotation balls and the corresponding pressure tube grooves during assembly in subsequent steps.



- h. Lubricate approximately a one inch length of the I.D. of the pressure tube at the bladder end. This will ease assembly of the base valve into the pressure tube.



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- i. Position the base valve assembly into the end of the tube assembly. Ensure the anti-rotation balls in the sides of base valve are aligned with the grease mark from step "g" as shown. Press the base valve body into the pressure tube using firm but steady pressure.





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- j. Ensure that the bladder sealing end is fully contained in the face groove located in the base valve body and that the base valve has seated correctly to the face of the pressure tube. The photo below shows proper and improper seating of the base valve body to the pressure tube.



CORRECT



INCORRECT