

PA Procedure (AS-75PIHV) 7500 Series Head-Valve

The procedure below is the recommended installation protocol for this assembly.

- 1.) Build head-valve using desired valve stack – Note that the base shim should be $\text{\O}1.350$ " on the compression side and the return shims should be $\text{\O}1.200$ "
- 2.) Use appropriate constants to prevent the nut (NT-04J) from bottoming on the thread
- 3.) Torque nut to screw (SC-75HV) with 160 in-lbs of torque – Do not use Loctite®
- 4.) Secure RR-06 within body groove (avoid scratching inner bore during operation)
- 5.) With OR-2029-B in place, insert PI-75HV into reservoir end of body
- 6.) Insert the collar (CO-75HV) into the opposite end of the body until threads meet
- 7.) Use the piston-engaging tool (TL-75HV) to tighten head-valve and collar-engaging tool (TL-75HV) to tighten collar – Torque these respective components to 25 ft-lbs – Do not use Loctite®
- 8.) Insert floating piston (PI-75HV-FP) according to the orientation seen below
- 9.) Secure body-cap and proceed to build shock in normal fashion

NOTE: When removing the floating piston during disassembly, use air pressure to force the piston out of its bore – cover the open reservoir end with one hand during operation.

