

# Work instruction

## WI3-01

### Assembly

**TRACTIVE**  
*suspension*

Revision 1

Rev. date 27-9-2011

Authorized quality  
manager

Before assembly, working area should be empty and clean.

All parts and subassemblies to be picked before the assembly order starts.

Assembly only by qualified personnel. Tractive tooling and qualified machines should be in good order.

Only components supplied/released by Tractive, may be assembled.

All loctite joints to be clean before Loctite application.

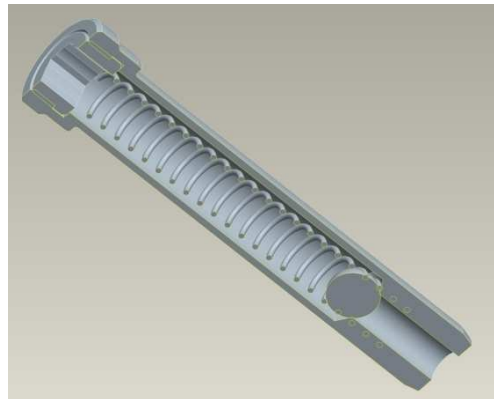
Follow part and setting list. In case of conflict with work instructions, please follow the part and setting list.

Pistonrod cpl.

Put the ball d3.5 46000169 and the checkvalve spring part no 46000092 in the needle seat d3 part no 46000089.

Lock the spring with the checkvalve bleed nut part no 46000094 using an allen key 3mm. Torque 3Nm and Loctite 2701.

Srew the needle seat into to pistonrod. Torque 3Nm without loctite. Deform the pistonrod on the top with a hamer. Do not damage the outer thread.



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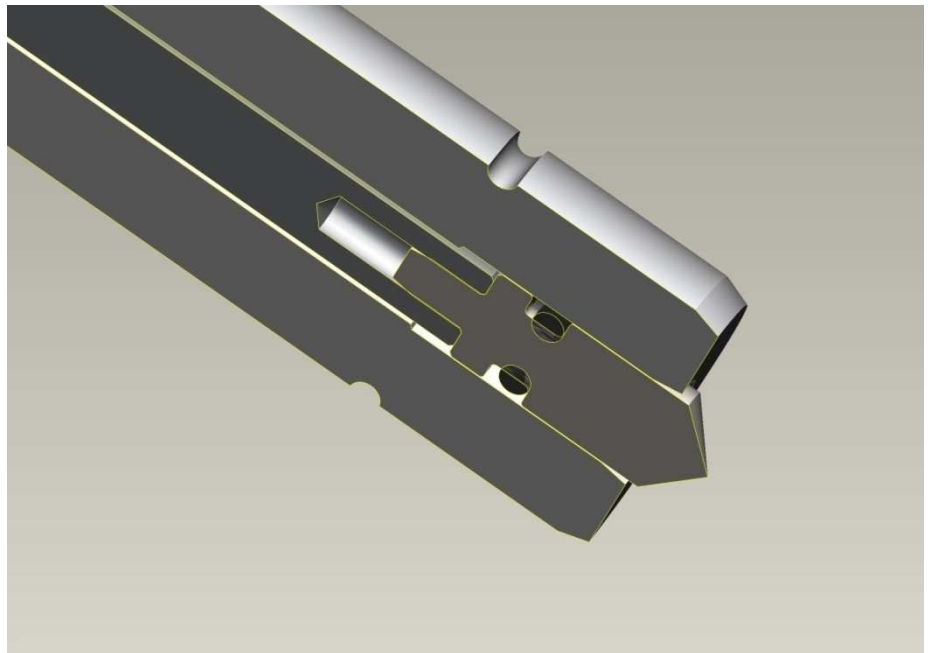
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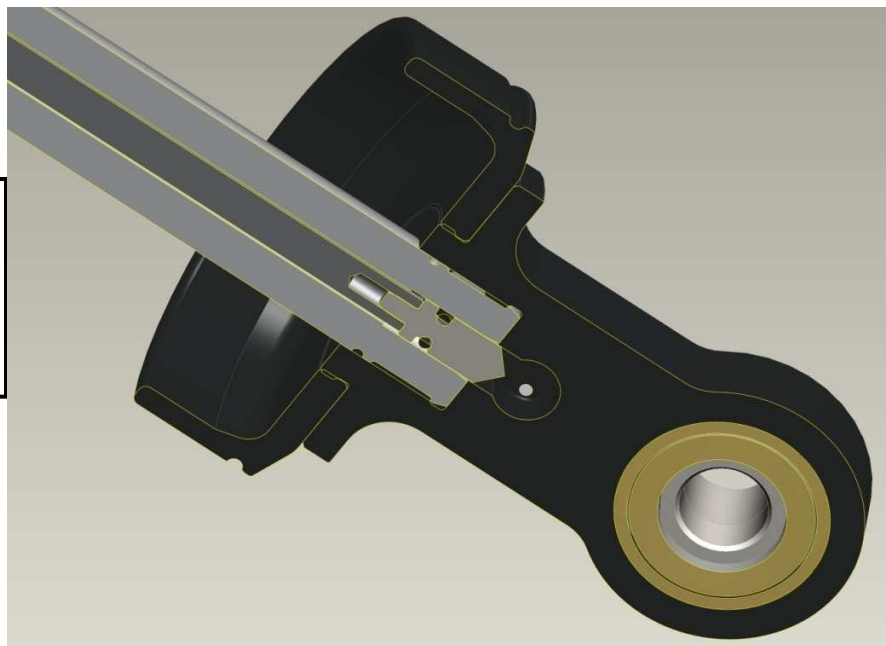
Piston rod cpl.

Put the needle subassey into the pistonrod. Check if the needle sticks out approx 3mm. measured from the point to the pistonrod surface

If it's less then 2mm or more the 4mm there is a mistake in the parts combination needle /pistonrod.



Mount the springretainer cup part no 46000040.



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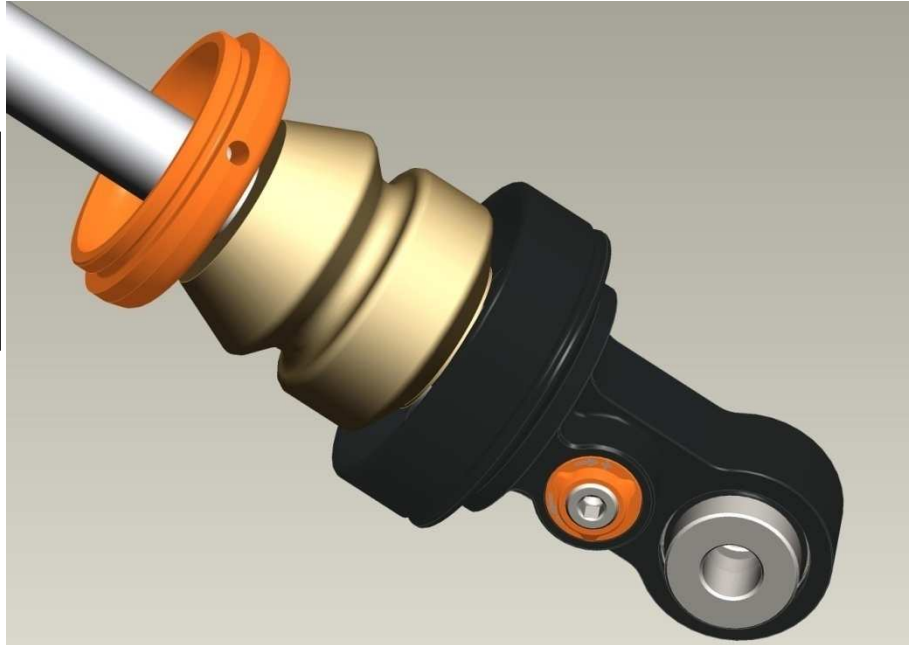
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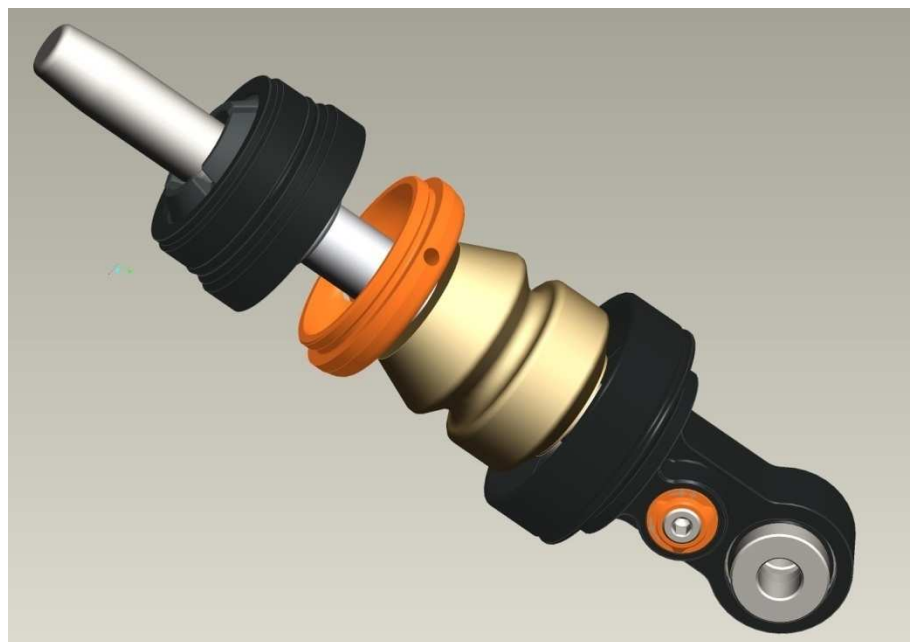
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Put on the bumprubber and the  
cover part no 46000049 over the  
piston rod



Put tool part no 90100039 over  
the pistonrod tap and mount the  
holder part no 46000050S1/2/3



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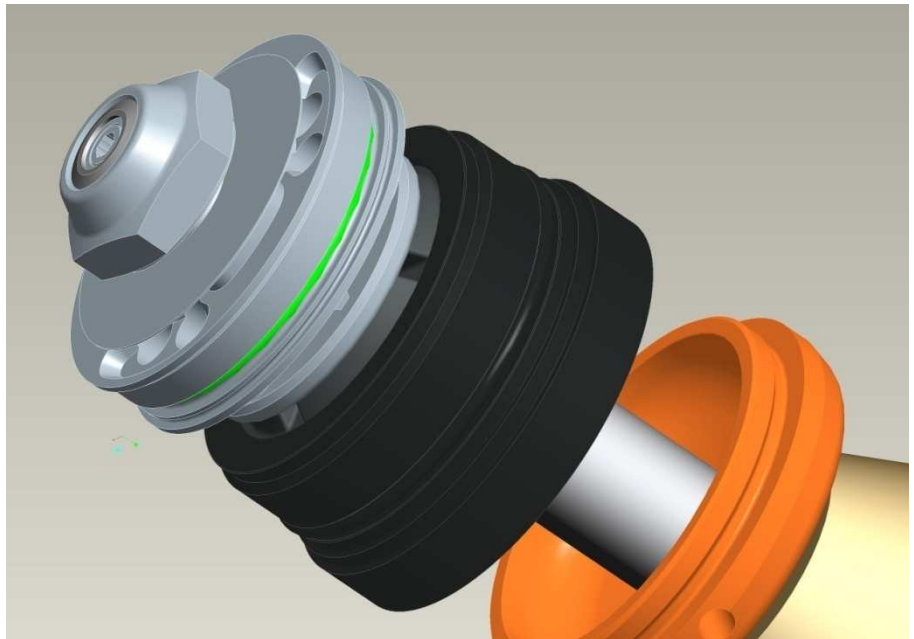
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Remove the tool and mount the rebounddisk, compression shimstack, piston, rebound shimstack, pistonrod nut part no 46000106.  
Torque: 30 Nm without loctite  
Mount O-ring 37.82x1.78 part no 46000087. No grease.



Mount the 2 O-rings 49x2 part no 46000095 around the tube body. For visible purpose in this picture red.  
After mounting grease them with PP300.



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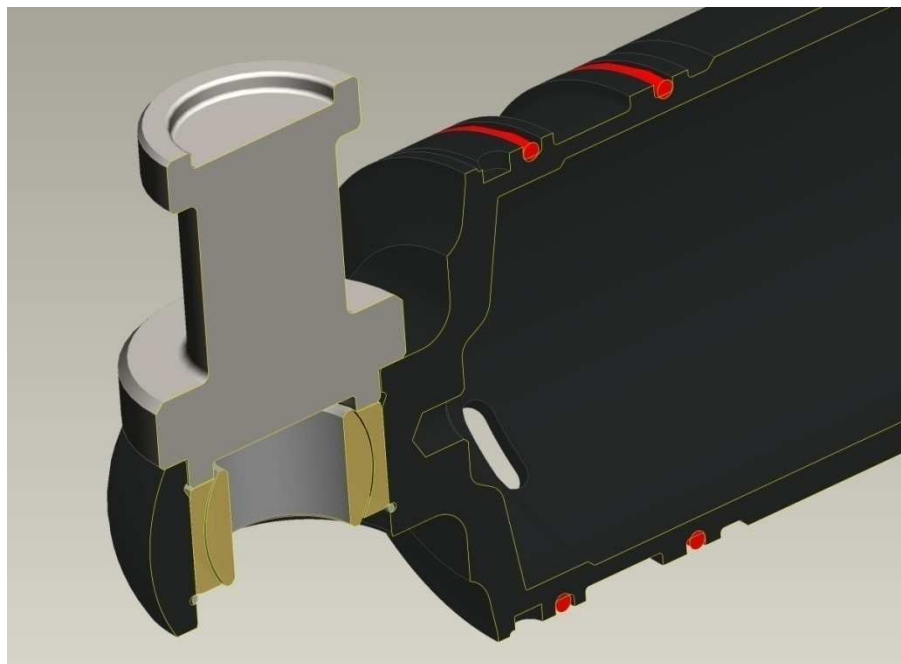
**TRACTIVE**  
*suspension*

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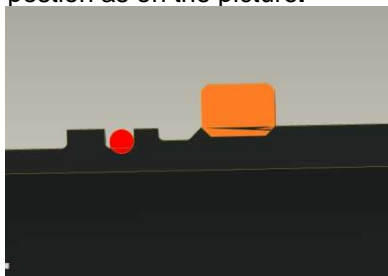
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Mount springring part no  
46000084.  
Press in the bearing part no  
46000044 with tool part no  
90200013  
Mount the second springring.



Mount the contranut to the  
postion as on the picture.



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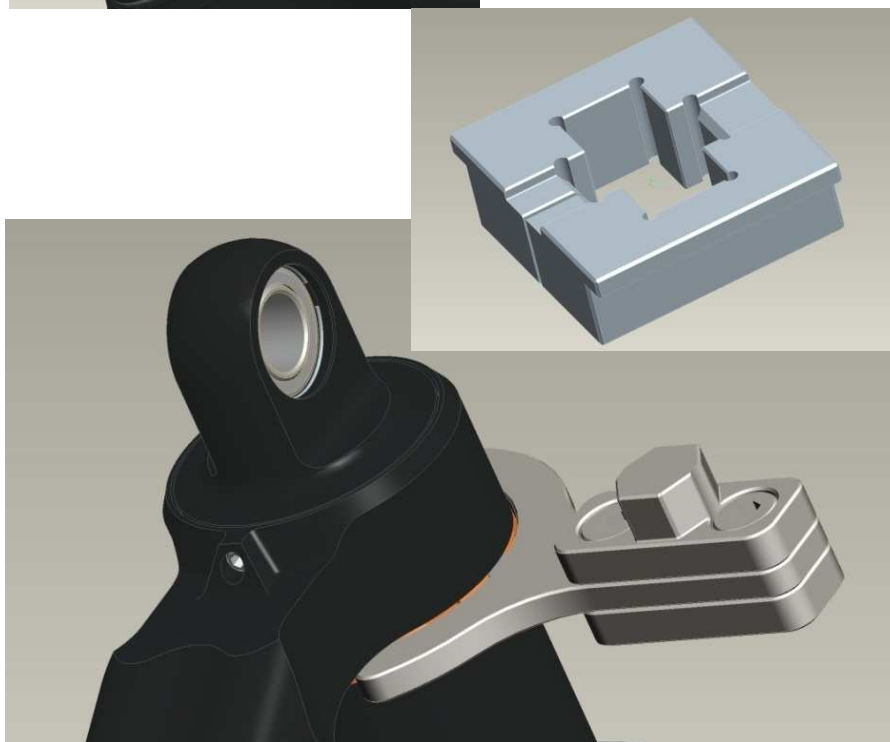
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Mount the springing part no  
46000097 in the groove with the  
opening located on the position  
needed for the locking bolt part  
no 46000120  
Torque: 3 Nm  
Loctite 2701



Place the shock tube in  
clamping block part no  
90100040 (See picture).  
Use tool part no 90100005S to  
tighten the contra nut.  
Torque: 75 Nm



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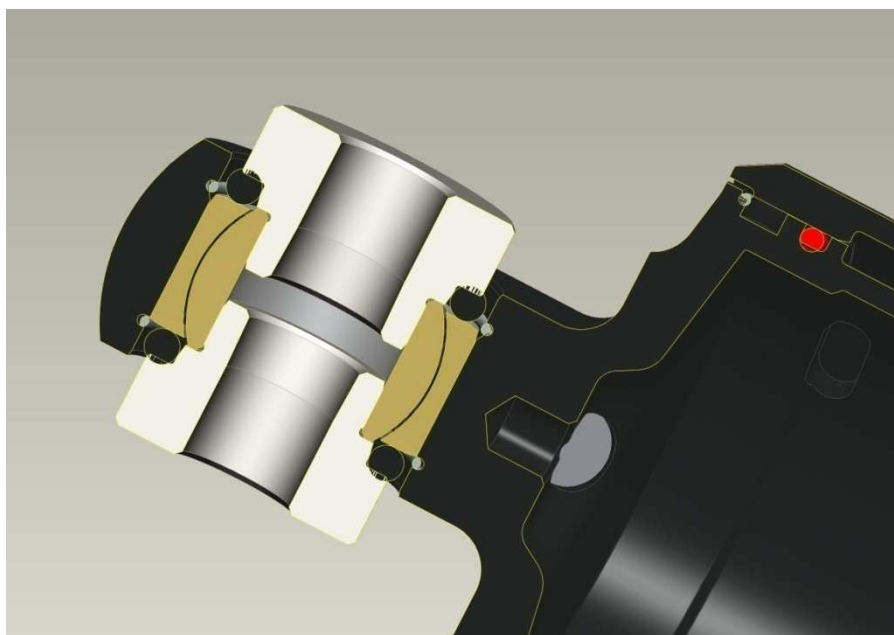
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*suspension*

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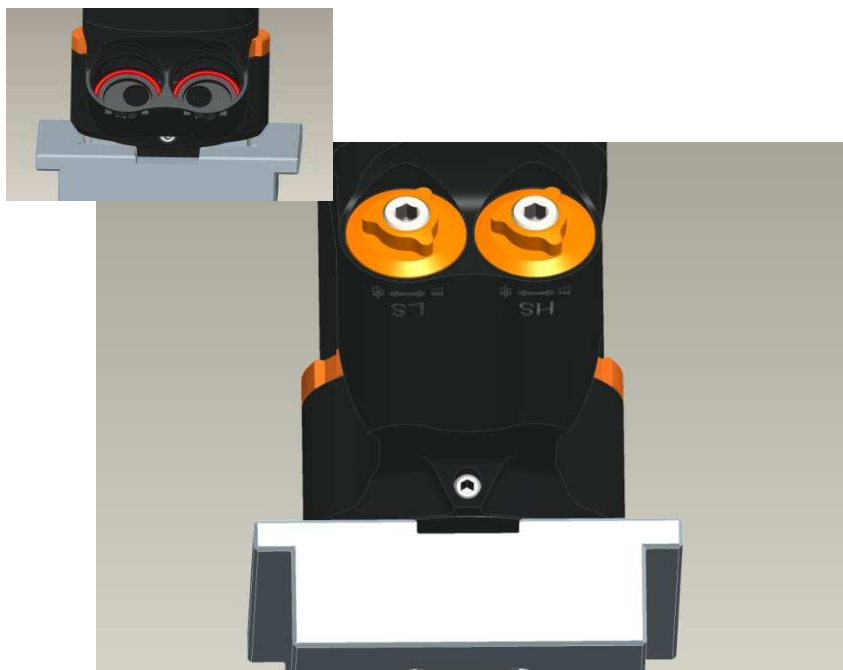
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Bearing bushes: Press in the required bearing bushes together with the seal.  
The seal can be an O-ring 18x3 part no 46000148 or a yellow seal part no 46000085



Mount the 2 O-rings 18x1.5 (red color on picture) with part no 46000101

Mount the low speed adjuster (left) and the high speed adjuster (right) with tool part no 90100002.  
Torque: 12 Nm



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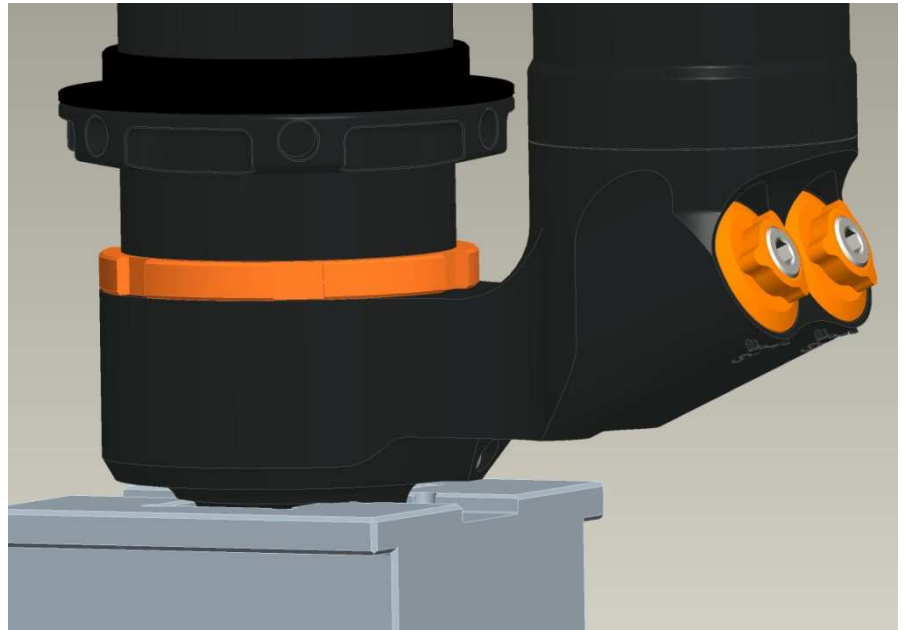
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Mount the springretainer screw  
M53x1.5 part no 46000042.  
Place the spacer part no  
46000107 on top of the  
springretainer.  
Mount the protection sleeve part  
over the tube.



Mount the piston rod assey in the  
tube.  
Put piston ring part no 46000088  
over the piston.  
Srew the holder into the tube with  
tool no 90100004S.



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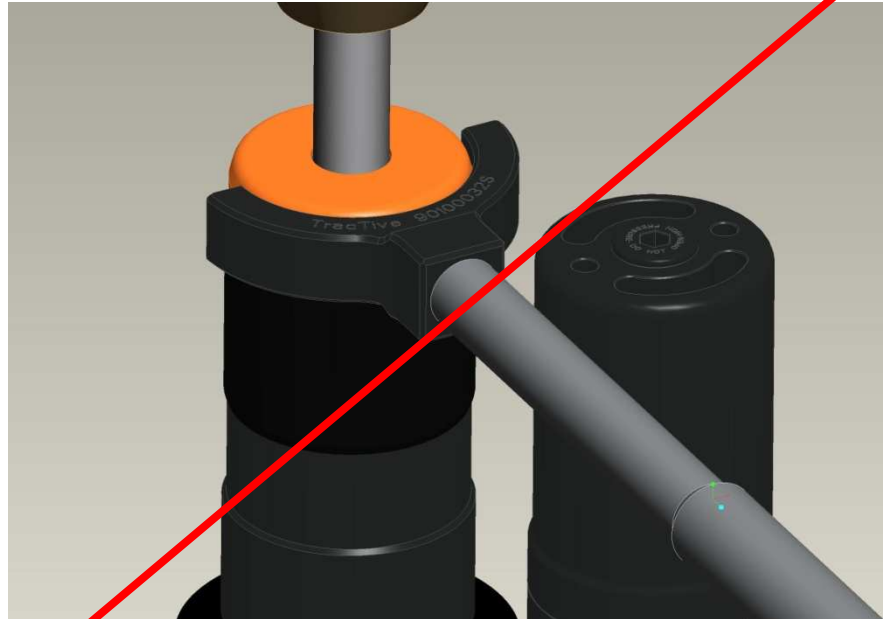
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Screw the cover part no  
46000049 into the holder and  
tighten it with tool part no  
90200032S



Tooling picture needs updating