

TK01 TUNING KIT TECHNICAL MANUAL
FOR 67/65/62/60/57/50/FC SERIES SHOCKS

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Parts included in the TK01 Tuning Kit:

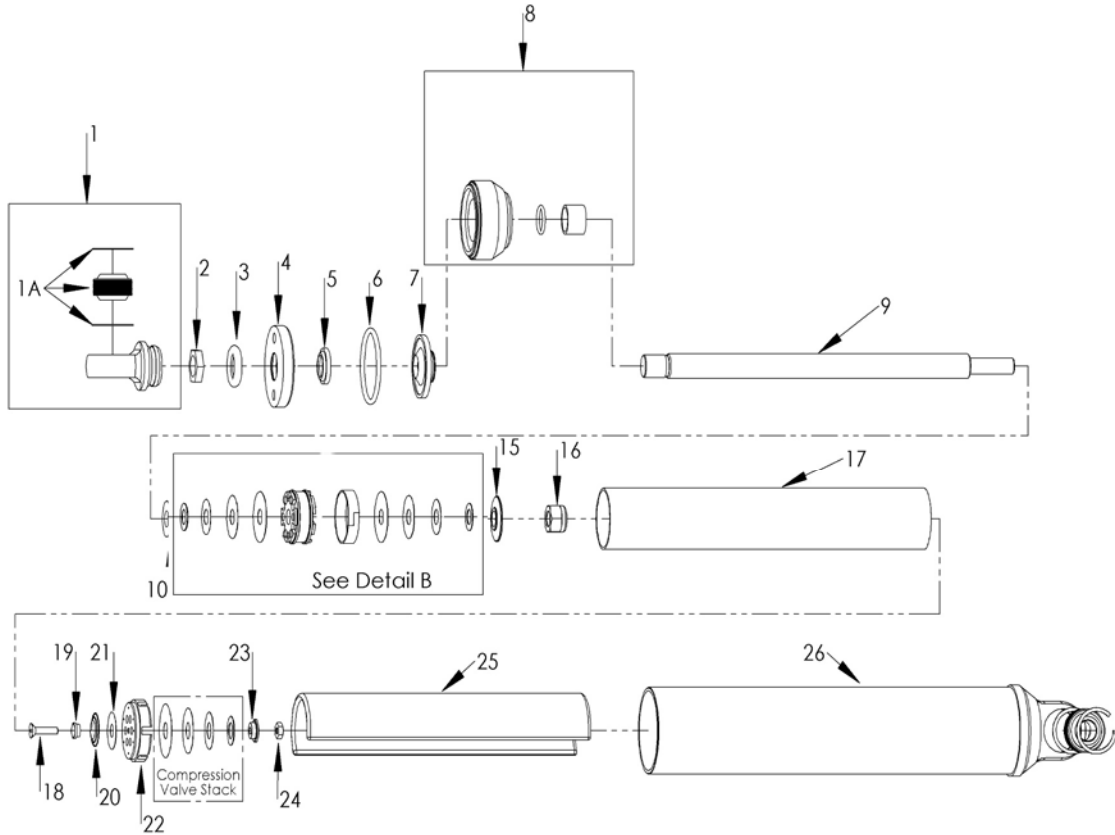
Item Number	Piece Part Number	Description	Qty
9042-126		Seal, Piston	2
9044-108		O-ring, Gland/Body 42x2.5	4
9044-117		O-ring, Gland/Body 44x3	4
7855-101	9055-104	Disc Valve .70 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
7855-102	9055-105	Disc Valve .90 x .006, 8 Pcs. / Kit	1 Kit / 8pcs
7855-103	9055-106	Disc Valve .90 x .008, 8 Pcs. / Kit	1 Kit / 8pcs
7855-104	9055-107	Disc Valve .90 x .010, 8 Pcs. / Kit	1 Kit / 8pcs
7855-105	9055-108	Disc Valve .90 x .012, 8 Pcs. / Kit	1 Kit / 8pcs
7855-106	9055-109	Disc Valve .90 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
7855-107	9055-110	Disc Valve 1.1 x .006, 8 Pcs. / Kit	1 Kit / 8pcs
7855-108	9055-111	Disc Valve 1.1 x .008, 8 Pcs. / Kit	1 Kit / 8pcs
7855-109	9055-112	Disc Valve 1.1 x .010, 8 Pcs. / Kit	1 Kit / 8pcs
7855-110	9055-113	Disc Valve 1.1 x .012, 8 Pcs. / Kit	1 Kit / 8pcs
7855-111	9055-114	Disc Valve 1.1 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
7855-178	9055-296	Disc Valve 1.3 x .004, 8 Pcs. / Kit	1 Kit / 8pcs
7855-112	9055-115	Disc Valve 1.3 x .006, 8 Pcs. / Kit	1 Kit / 8pcs
7855-113	9055-116	Disc Valve 1.3 x .008, 8 Pcs. / Kit	1 Kit / 8pcs
7855-114	9055-117	Disc Valve 1.3 x .010, 8 Pcs. / Kit	1 Kit / 8pcs
7855-115	9055-118	Disc Valve 1.3 x .012, 8 Pcs. / Kit	1 Kit / 8pcs
7855-116	9055-119	Disc Valve 1.3 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
9057-215		35mm Piston, No Bleed, Machined	2
9055-297		Base Valve, Body, Machined, No Bleed	1
9055-293		Base Valve Assy-Soft, Machined	1
9055-122		Base Valve Assy-Firm	1
9011-108		Drill Bit, 0.025" (#72)	1
9011-113		Drill Bit, 0.028" (#70)	1
9011-114		Drill Bit, 0.031" (#68)	1
9011-102		Drill Bit, 0.038" (#62)	1
9011-115		Drill Bit, 0.042" (#58)	1
9011-104		Drill Bit, 0.046" (#56)	1
9011-105		Drill Bit, 0.052" (#55)	1
9011-106		Drill Bit, 0.055" (#54)	1
9011-107		Drill Bit, 0.059" (#53)	1
9011-109		Drill Bit, 0.070" (#50)	1
9011-110		Drill Bit, 0.078" (#47)	1
9011-111		Drill Bit, 0.093" (#42)	1
7857-101	9002-104	Check Ball	1 Kit / 8pcs
7857-103	9035-142	Pin, Check Ball	1 Kit / 8pcs

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65 Series Parts List

Smooth Aluminum Large Body



Item	Part No.	DESCRIPTION
1	9036-104	Loop, Aluminum-Assy
1A	SIB8-101PK	Kit, Bearing (2 Bearings, 4 Snap Rings)
2	9014-113	Nut, Jam-9/16"-18
3	9044-107	O-ring, Rod (OR-207)
4	9014-404	Nut, Closure-M50x1.0
5	9046-101	Wiper, Piston Rod
6	9044-117	O-Ring, 44x3MM 70 Buna-N
7	9042-103	Seal, Piston Rod
8	9054-107	Assy, Gland Large Body Aluminum
9	9028-122	Rod, Piston - 6"
9	9028-118	Rod, Piston - 7"
9	9028-138	Rod, Piston - 8"
9	9028-114	Rod, Piston - 9"
10	9027-113	Plate, Valve Stack Compression
13	9057-215	Piston , 35mm Disk (Undrilled Bleed)
14	9042-126	Seal, Piston
15	9027-113	Plate, Valve Stack
16	9014-116	Nut, Lock-M10x1.25
17	9053-128	Tube, Compression Large Body 6"

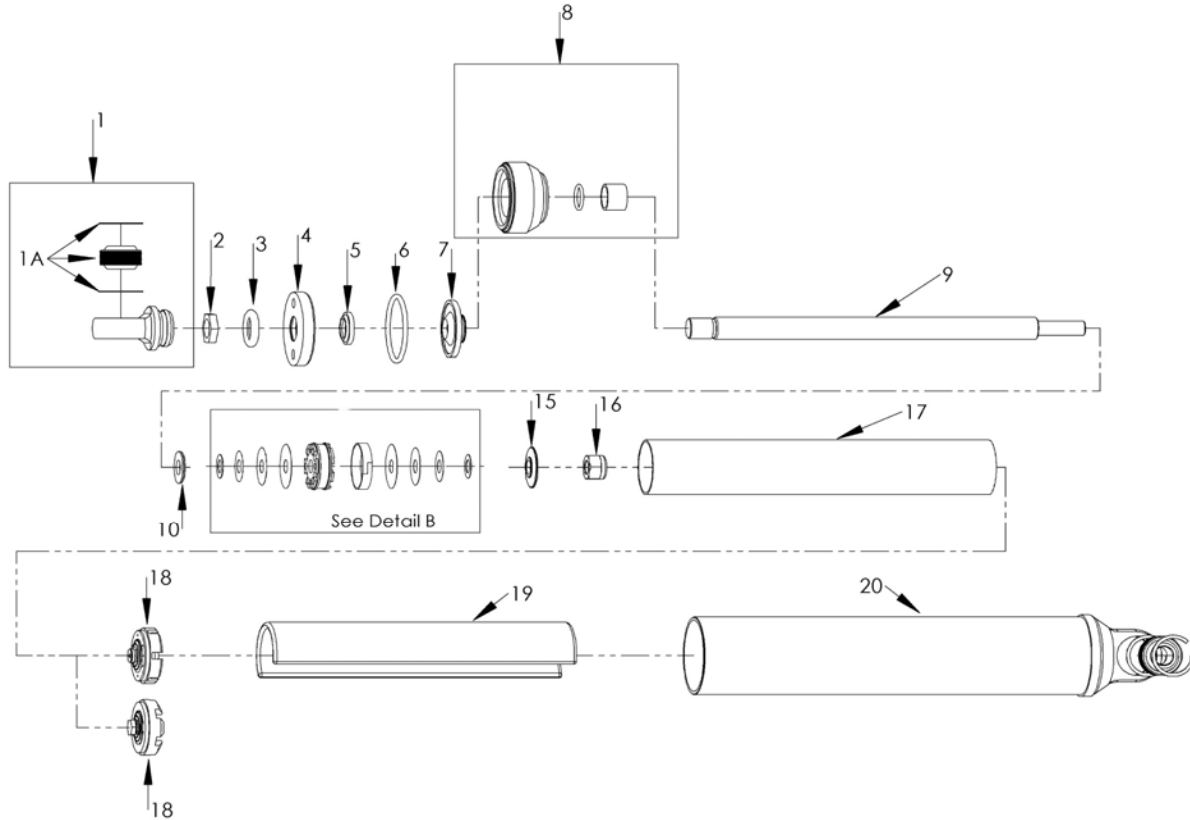
Item	Part No.	DESCRIPTION
17	9053-123	Tube, Compression Large Body 7"
17	9053-124	Tube, Compression Large Body 8"
17	9053-125	Tube, Compression Large Body 9"
18	9012-176	Bolt
19	9014-155	Seat, Bolt
20	9015-107	Spring, Disk, Replenish
21	9055-144	Disc, Replenish
22	9055-294	Base Valve, 028" Bleed
22	9055-297	Base Valve, No Bleed
23	9014-310	Seat, Valve Stack
24	9014-311	Nut, Nylock
25	9052-110	Bag, Gas 6" Large Body
25	9052-111	Bag, Gas 7" Large Body
25	9052-121	Bag, Gas 8" Large Body
25	9052-121	Bag, Gas 9" Large Body
26	9760-109	Body, Large Body 6" Smooth
26	9760-103	Body, Large Body 7" Smooth
26	9760-107	Body, Large Body 8" Smooth
26	9760-105	Body, Large Body 9" Smooth

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60 Series Parts List

Smooth Aluminum Large Body



Item	Part No.	DESCRIPTION
1	9036-104	Loop, Aluminum-Assy
1A	SIB8-101PK	Kit, Bearing (2 Bearings, 4 Snap Rings)
2	9014-113	Nut, Jam-9/16"-18
3	9044-107	O-ring, Rod (OR-207)
4	9014-404	Nut, Closure-M50x1.0
5	9046-101	Wiper, Piston Rod
6	9044-117	O-Ring, 44x3MM 70 Buna-N
7	9042-103	Seal, Piston Rod
8	9054-107	Assy, Gland Large Body Aluminum
9	9028-122	Rod, Piston - 6"
9	9028-118	Rod, Piston - 7"
9	9028-138	Rod, Piston - 8"
9	9028-114	Rod, Piston - 9"
10	9027-113	Plate, Valve Stack Compression
13	9057-215	Piston , 35mm Disk (Undrilled Bleed)
14	9042-126	Seal, Piston
15	9027-113	Plate, Valve Stack
16	9014-116	Nut, Lock-M10x1.25

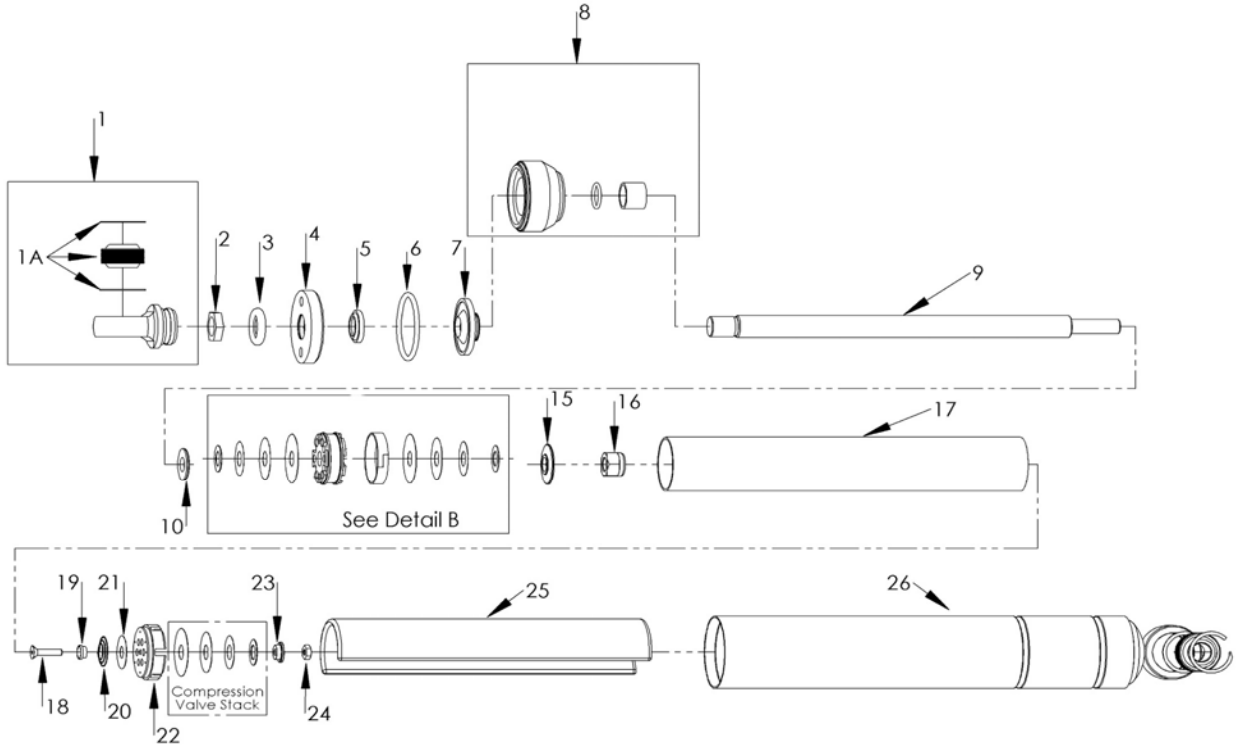
Item	Part No.	DESCRIPTION
17	9053-128	Tube, Compression Large Body 6"
17	9053-123	Tube, Compression Large Body 7"
17	9053-124	Tube, Compression Large Body 8"
17	9053-125	Tube, Compression Large Body 9"
18	9055-293	Base Valve Assy-Soft
18	9055-122	Base Valve Assy-Firm
19	9052-110	Bag, Gas 6" Large Body
19	9052-111	Bag, Gas 7" Large Body
19	9052-121	Bag, Gas 8" Large Body
19	9052-121	Bag, Gas 9" Large Body
20	9760-109	Body, Large Body 6" Smooth
20	9760-103	Body, Large Body 7" Smooth
20	9760-107	Body, Large Body 8" Smooth
20	9760-105	Body, Large Body 9" Smooth

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57 Series Parts List

Smooth Steel Large Body



Item	Part No.	DESCRIPTION
1	9036-103	Loop, Steel-Assy
1A	SIB8-101PK	Kit, Bearing (2 Bearings, 4 Snap Rings)
2	9014-113	Nut, Jam-9/16"-18
3	9044-107	O-ring, Rod (OR-207)
4	9014-332	Nut, Closure-M48x1.0
5	9046-101	Wiper, Piston Rod
6	9044-108	O-Ring, 42x2.5MM 70 Buna-N
7	9042-103	Seal, Piston Rod
8	9054-108	Assy, Gland Large Body Steel
9	9028-118	Rod, Piston - 7"
9	9028-114	Rod, Piston - 9"
10	9027-113	Plate, Valve Stack Compression
13	9057-215	Piston, 35mm Disk (Undrilled Bleed)
14	9042-126	Seal, Piston
15	9027-113	Plate, Valve Stack
16	9014-116	Nut, Lock-M10x1.25
17	9053-123	Tube, Compression Large Body 7"
17	9053-125	Tube, Compression Large Body 9"

Item	Part No.	DESCRIPTION
18	9012-176	Bolt
19	9014-155	Seat, Bolt
20	9015-107	Spring, Disk, Replenish
21	9055-144	Disk, Replenish
22	9055-294	Base Valve, 028" Bleed
22	9055-297	Base Valve, No Bleed
23	9014-310	Seat, Valve Stack
24	9014-311	Nut, Nylock
25	9052-111	Bag, Gas 7" Large Body
25	9052-121	Bag, Gas 9" Large Body
26	9750-101	Body, Large Body 7" Steel
26	9750-102	Body, Large Body 9" Steel

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IMPORTANT: Before rebuilding or revalving your QA1 67/65/62/60/57/50/FC shock absorbers, your work area must be clean. Shock absorber performance is greatly affected by any contamination (i.e. dirt, dust, rag lint, etc.).

TOOLS NEEDED FOR REBUILDING AND TUNING (REVALVING):

- Vise with soft jaws (aluminum or plastic)
- Closure nut wrench (available from QA1 / part #7791-104)
- Torque wrench with 17mm or 11/16" socket
- Pick set
- QA1 shock oil (part #SF01)
- QA1 rebuild kit and/or tuning kit (67/65/62/60 series rebuild kit part #RK01; 57/50/FC series rebuild kit part #RK02; revalving/tuning kit part #TK01)
- QA1 large body tool kit (optional; part #7891-106)
- Soft faced mallet
- Clean rags

DISASSEMBLY:

1. Check shock mount bearings for excessive play and replace as needed.
2. Clamp shock body eyelet in a vise with the shaft pointing up.
3. Fully extend the shock rod from the body.
4. Using a closure nut wrench, unscrew the shock closure nut. 67/65/62/60/57/50/FC series shocks are not pressurized.
5. Use a pick tool to remove the closure nut o-ring.
6. Remove the shock rod assembly, gland, and compression (inner) tube by pulling up on the shock rod.
7. Remove the gas bag from the shock and set it aside in area where it will not collect debris.
8. Over a drain pan, gently tap the gland and shaft assembly away from the compression tube with a QA1 separator tool or equivalent.
9. Pour the oil from the shock body and compression tube. Watch for any debris in the used oil and properly dispose of the oil if debris is present.
10. Clean the parts with mild solvent as necessary and set aside.
11. Clamp the piston rod eyelet (or stud top) in a vise with the piston pointing up.
12. Cover the gland with a rag, blow compressed air into the gland side-bleed hole to pop the piston rod seal out of the gland.
13. Remove the 17mm lock nut to access the piston valving. Remove the piston and the valving.
14. If not revalving, the rebound stack, piston, and compression stack need to be kept in their original order for re-assembly.
15. Remove the gland assembly, and the piston rod seal from the rod.

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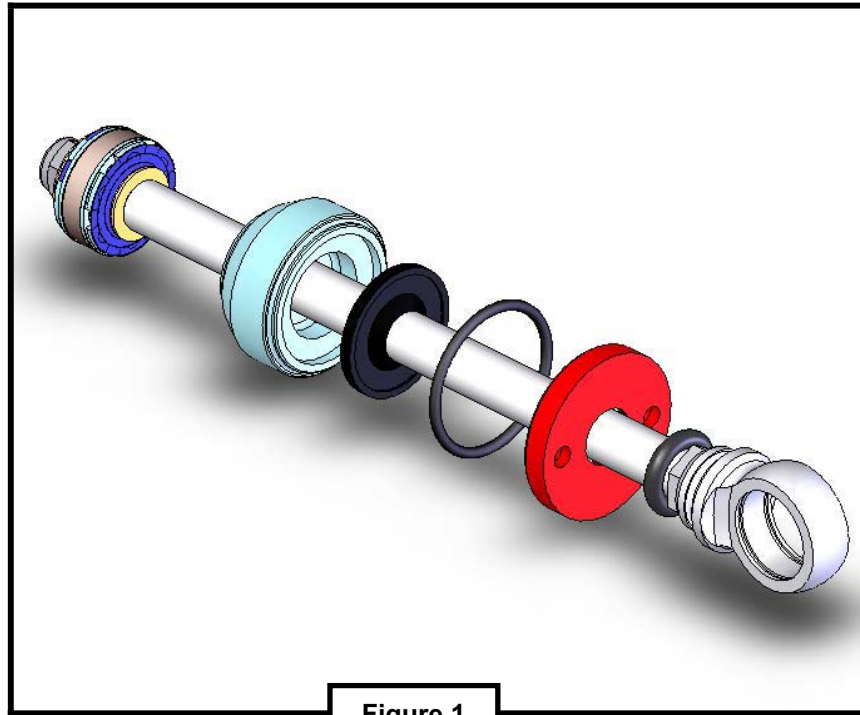


Figure 1

ASSEMBLY:

1. Inspect the bushing for wear, and replace the gland assembly if the bushing is loose on the shaft.
2. Reassemble the shaft with the travel indicator, closure nut with piston rod wiper installed, gland o-ring, piston rod seal, and gland assembly (see Figure 1).
3. If revalving, go to page 13 and read the revalving instruction section now.
4. Place the valve plate onto the shaft with the small side facing up.
5. With shaft still in the vise, assemble the compression valving, piston, and rebound valving. The compression valve stack is on the bottom of piston and the rebound valve stack on top. **IMPORTANT: The piston must be positioned with the rebound side facing up (see Detail B on page 17).**
6. Place the second valve plate onto the shaft with the small side down.
7. Torque the 17mm lock nut to 20 ft/lbs (240 in/lbs). Check the lock nut for any loose burrs and remove as necessary. Set the piston rod assembly aside. Place the shock body in the vise, holding it by the lower mount.
8. Pour ~1/4 cup of oil into the shock body.
9. Gently insert the compression tube and gas bag into the shock body, base valve first. Verify that the base valve has seated into base of the shock body properly.
10. **IMPORTANT: Do not tear the gas bag or pinch it under the base valve. Also be sure to keep the top of the gas bag below the top of the compression tube.**
11. Fill the shock body and compression tube with shock oil to just above (1/16") the top of the compression tube.
12. Move the compression tube around in a circular motion to free any trapped air bubbles.
13. Insert the piston rod assembly, with the piston wrap, into the compression tube.
14. With the piston assembly submerged approximately 1", tap the shock rod eyelet with a soft mallet. This opens the compression valve stack to release any air trapped inside the piston.

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15. Use your fingers to hold the compression tube down and raise the shock shaft until the piston is at the top of the compression tube.
16. Hold the shock shaft near the top of the compression tube and slide the gland into the shock body. Oil should come up through the gland's bleed hole. **NOTE:** Remember we are attempting to build a shock without any air trapped inside.
17. Holding the gland down, cycle the piston rod in short 1" strokes. Under full extension, the gland bleed hole should not be allowed to pull air back into the shock. Add more oil as necessary.
18. Keep the shock fully extended and slide the rod seal into the gland. Push the closure nut o-ring into the outer groove of the gland.
19. Install and tighten the closure nut.
20. Invert the shock and wipe off any oil over-flow.
21. Stroke the shock and check for smooth operation. Rough or jerky movement indicates that air is trapped inside - repeat the steps above.
22. If the piston rod "springs back" from full compression, the shock is over-filled with oil. Fully extend the piston rod, loosen the closure nut fully, compress the piston rod until oil overflows, and re-tighten the closure nut.

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REVALVE INSTRUCTIONS

Shock absorbers create dampening by flowing oil through restrictive paths - the more restricted the flow, the higher the dampening force. Nearly all shocks use a combination of “bleed passages” and “blow-off valves” to control the oil flow in both compression and rebound separately.

Bleed is typically controlled by the size of a small hole(s) or slit(s). The oil can flow easily at low shaft velocities, but as velocity increases, the resistance rises progressively. QA1 shocks use single and dual bleed hole(s) in the piston, which range from 0.025” to 0.093”. Smaller or larger bleed holes may be used to raise or lower low-speed dampening. Unless you have access to a shock dyno it is best to stay with the standard bleed.

Blow-off is typically controlled by either a spring pushing on a valve, or a set of disk valves covering a set of larger holes. Once the shaft reaches a certain velocity, the valves will open – allowing a linear or digressive dampening curve. QA1 shocks utilize three sets of disk valves, two for compression and one for rebound. One rebound valve stack and one compression valve stack are on either side of the piston; the other compression valve stack is in the base valve. For simplicity, on the **67/65/57 series** the base valve stack will use the same stack that is on your compression side of the piston; on the **62/60/50/FC series** there are two base valves used, one for compression valving 5 and below, and one for 6 and above. The following information will help you tune your QA1 large body shocks:

LOW SPEED (0~1 in/sec): The piston bleed hole size has the main effect. Larger bleed holes will lower the low-speed dampening and will delay the blow-off to occur at a higher velocity. Smaller bleed holes will raise the low-speed dampening – blow-off will tend to occur at lower velocities.

MEDIUM SPEED (1~10 in/sec): Valve stack begins to open. The disk closest to the piston (1.30” OD) will have the main effect. Valve stack thicknesses determine the blow-off velocity and the slope of the dampening curve. Bleed can affect the blow-off velocity, but the slope of the graph remains the same. The blow-off can be more or less distinct depending on the amount of bleed.

HIGH SPEED (>10 in/sec): The shape of the valve stack has main effect. Thickness, outside diameters, and number of disks determine the shape of the dampening curve. The smallest disk (0.700” OD) acts as the pivot disk. The pivot disk has a large affect on the higher speed portion of the dampening curve as it controls the diameter where the rest of the disks start to bend. Removing the 0.700” pivot disk will create a more digressive valve curve.

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Use the graphs on page 18 to aid in selecting the proper valving for your application. Once you have decided which valve code you would like to revalve to, use the tables on page 16 to determine the components needed for the revalving. Use the following guidelines:

1. For 62/60/50/FC series shocks:

- a. Using the tables on page 16, determine the base valve that corresponds to your desired compression valve code.
- b. Install the base valve.
- c. Using the tables on page 16, determine the disks needed for your desired compression valve code.
- d. Install the compression disk stack onto the piston rod starting with the smallest diameter disk and ending with the largest.

2. For 67/65/57 series shocks:

- a. Using the tables on page 16, determine the disks needed for your desired compression valve code.
- b. Separate the compression stacks - one for the base valve and one for the compression side of the piston. Remove the base valve to change the stack. When finished, torque the nut on the base valve to 17in-lbs.
- c. Install one of the disk stacks onto the base valve, starting with the largest diameter disk and ending with the smallest.
- d. Install the other disk stack onto the piston rod starting with the smallest diameter disk and ending with the largest.

For all 67/65/62/60/57/50/FC series shocks:

3. Drill bleed hole(s). The piston bleed required is determined by the specific valve code chosen for the shock. Use the tables to find the bleed size needed for compression and rebound.
 - a. **Straight valve shocks:** If the chosen shock is a straight valve (e.g. 4 compression / 4 rebound), only one bleed hole will be used. This bleed hole can be drilled on either the compression side or the rebound side of the piston, but only one hole will be drilled.
 - b. **Split valve shocks:** If the chosen shock is a split valve (e.g. 3 compression / 5 rebound), both bleed circuits **may** be used. The QA1 shock is capable of separating the compression bleed from the rebound bleed to maximize the performance of a split valve shock. When building a split valve shock refer to **Detail B** (page 17). After identifying the rebound and compression sides of the piston, carefully drill the proper size bleed holes on the appropriate sides. In order to keep the circuits independent of each other, a cross hole must be drilled through each bleed circuit (Refer to Detail B). A check ball (Item 12) needs to be installed into each bleed circuit followed by a dowel pin (Item 11) in each cross hole. Turn the piston over and complete the process on the other side. The cross pins are held in the piston by the piston band (Item 14). You may also choose to use only one bleed in split valve shock. If you choose this option, drill the piston bleed to match the higher valving of the shock. The hole can be drilled on either the compression side or the rebound side of the piston.

Note: Using check balls and pins will require regular maintenance on the piston. Be sure to regularly check the diameter of the bleed holes as they may decrease while the check balls seat into the piston.

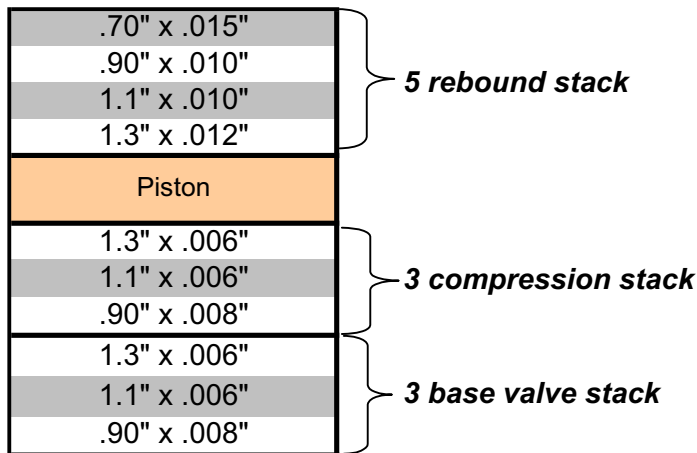
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5. Using the tables on page 16, determine the disks needed for your desired rebound valve code.
6. Install the rebound disks onto the piston rod starting with the largest diameter disk and ending with the smallest.

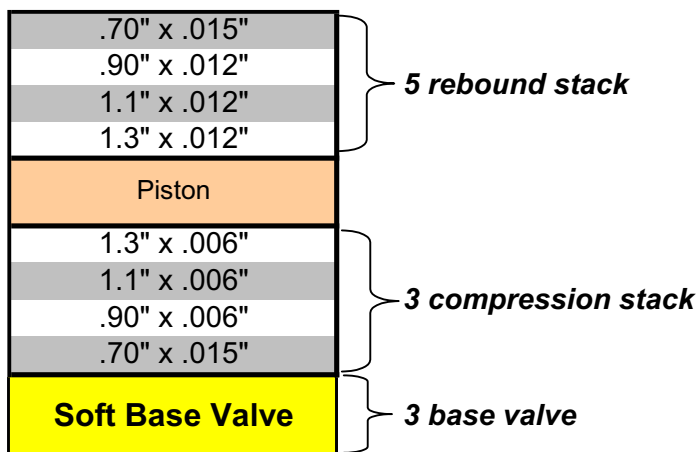
Examples:

Example 1: You want to build a 67 series 3-5 (3 compression / 5 rebound) valved shock. Follow these steps:

1. Using the tables on page 16, you would use the compression stack from the 3 column and the rebound stack from the 5 column.
2. You can choose to use the dual bleed for any split valve shocks. In this case, the 3 compression uses a 0.070" bleed and the 5 rebound uses a 0.055" bleed. If you choose to use just one bleed, use the compression 0.070" bleed.
3. The base valve stack is the same as your compression stack.
4. Therefore, the components used in a 67 series 3-5 valved shock will be as follows:



Example 2: By following the same steps, a 62 series 3-5 (3 compression / 5 rebound) valved shock would be as follows:

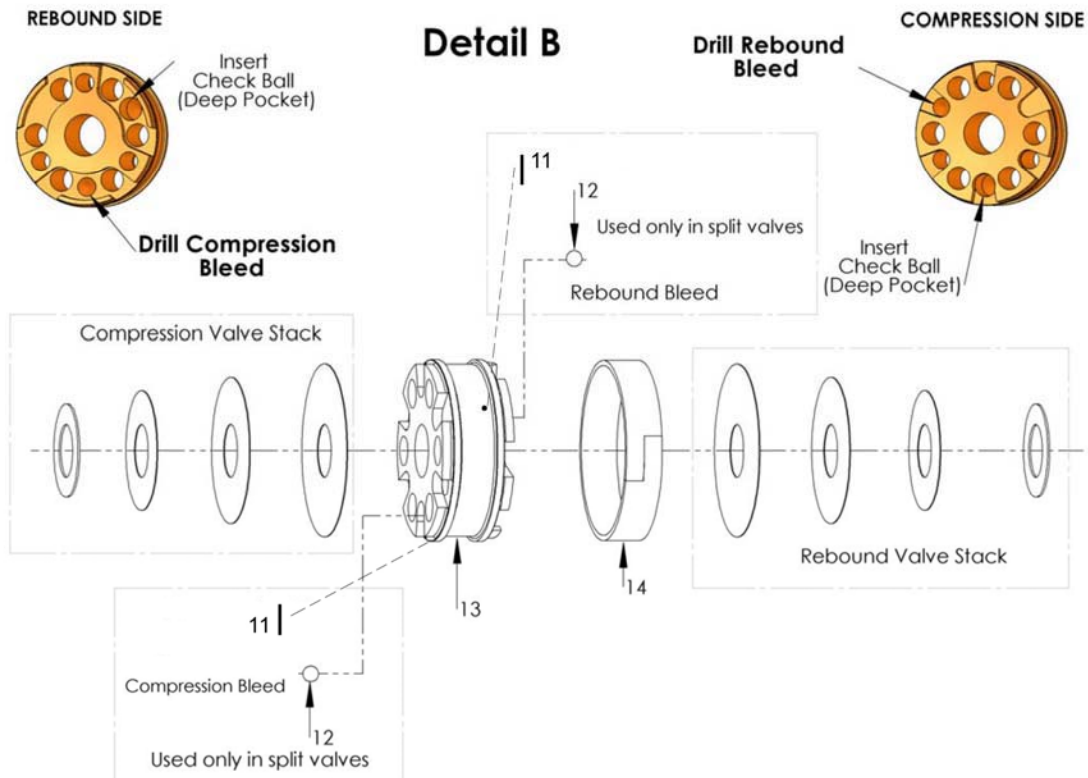


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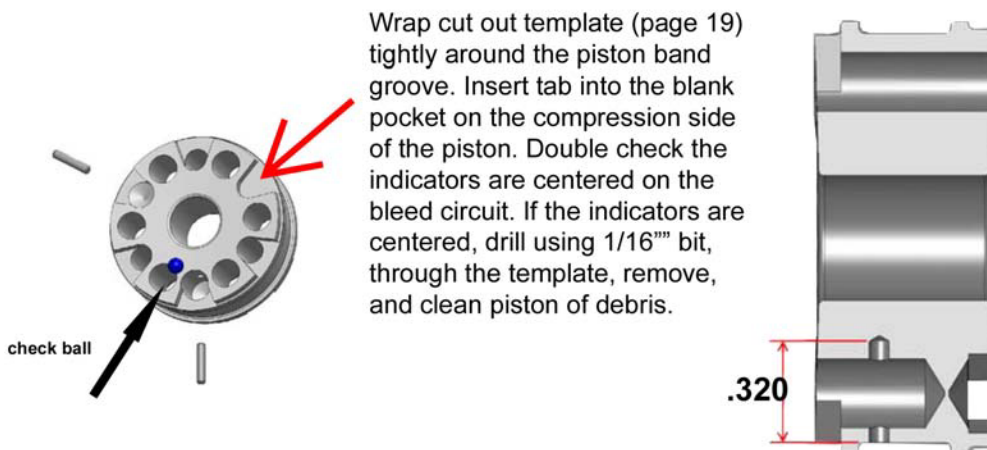
It is important to remember the following:

- The base valve stack or the base valve (depending on series) is determined by the compression valve code
- The piston compression stack goes on first
- The piston is installed rebound side up
- The piston rebound stack goes on last (closest to nut)

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**NOTE: THE COMPRESSION BLEED IS DRILLED FROM THE REBOUND SIDE
THE REBOUND BLEED IS DRILLED FROM THE COMPRESSION SIDE**

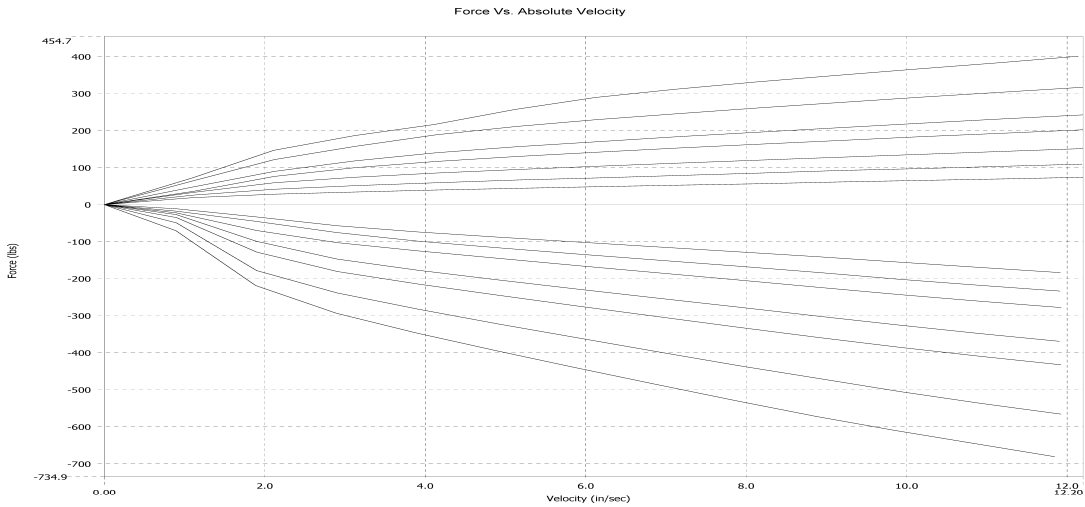


Wrap cut out template (page 19) tightly around the piston band groove. Insert tab into the blank pocket on the compression side of the piston. Double check the indicators are centered on the bleed circuit. If the indicators are centered, drill using 1/16" bit, through the template, remove, and clean piston of debris.

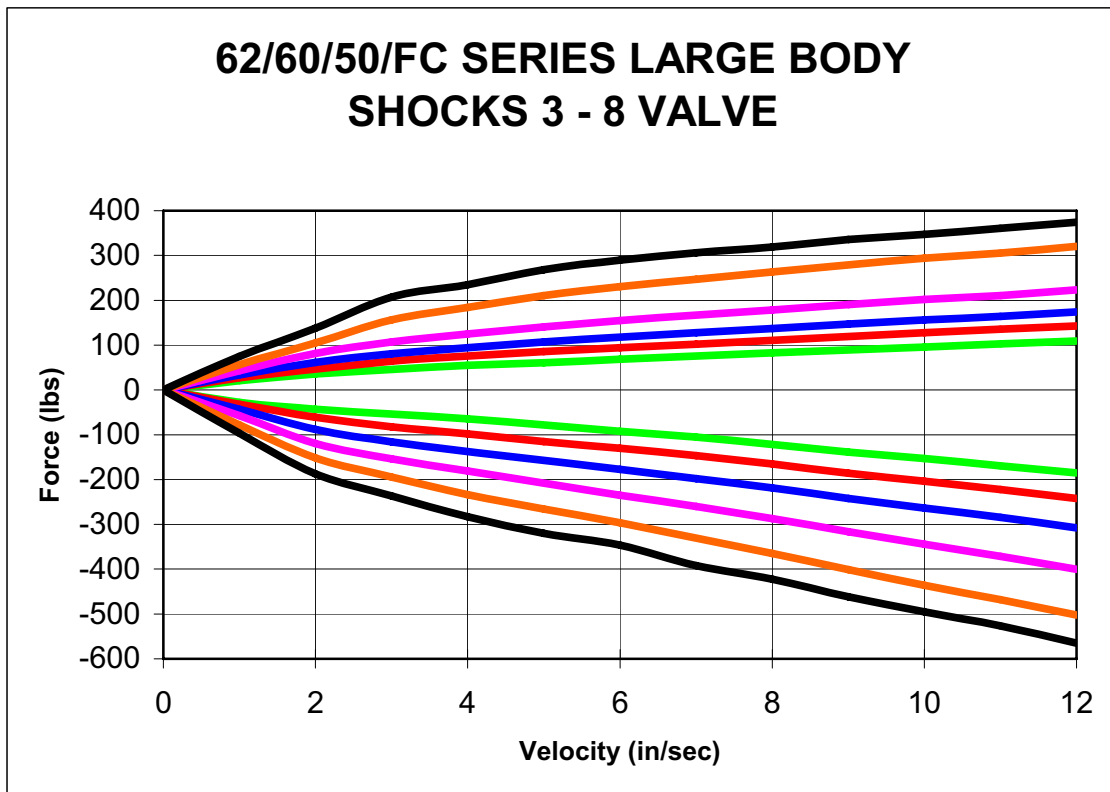
* Using check balls and pins will require regular maintenance *

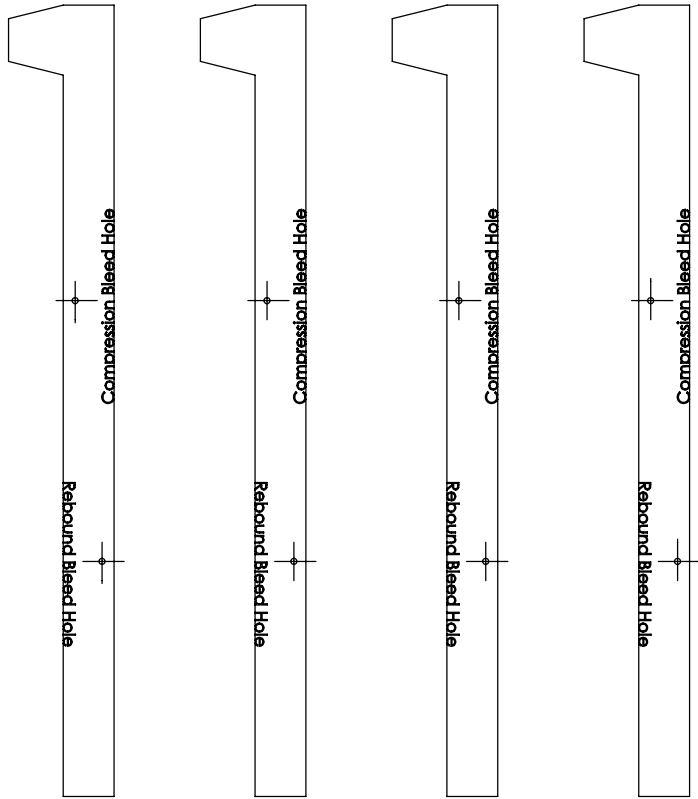
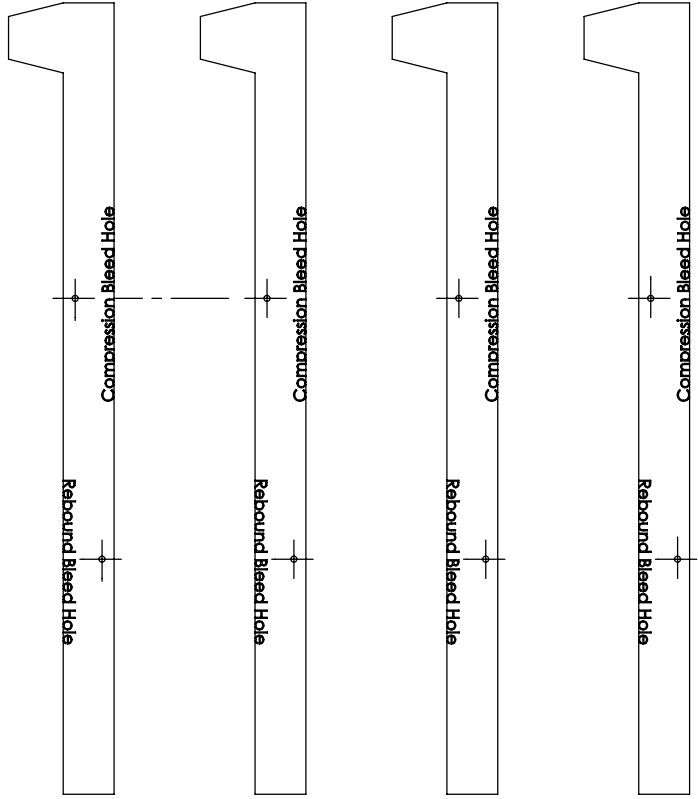
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67/65/57 SERIES LARGE BODY SHOCKS
3 – 9 VALVE



62/60/50/FC SERIES LARGE BODY SHOCKS
3 - 8 VALVE





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TERMS & CONDITIONS

All information contained herein is subject to change without notice.

BUYERS ACCEPTANCE OF DELIVERY OF THE PRODUCT CONSTITUTES BUYER'S ACCEPTANCE OF THE TERMS HEREIN. ANY ADDITIONAL OR DIFFERENT TERMS PROPOSED BY BUYER ARE HEREBY REJECTED IN THEIR ENTIRETY UNLESS EXPRESSLY ASSENTED TO IN WRITING BY SELLER'S AUTHORIZED AGENT.

PAYMENT TERMS

Prepaid, Visa, Mastercard. Net 30 days from invoice date terms are available after credit approval. Credit terms may be revoked at any time, including after acceptance of purchase order. Accounts with invoices past due will be placed on "Credit Hold". A finance charge of 1.5% per month will also be applied to all past due invoices, not to exceed the maximum charge permitted by law. All collection expenses will be the responsibility of the buyer. Accounts are considered paid in full upon QA1's receipt of the full invoice amount plus collection fees and expenses incurred, if any. NSF checks, stop payment checks, chargebacks on credit cards, etc. are charged a minimum \$25 fee. No deduction or credit may be taken for any reason unless a credit memo has been issued by QA1. Any unauthorized deduction will automatically put the account on credit hold. Special orders may require a 50% down payment. In the event of buyer using freight collect or 3rd party billing for freight, the buyer is ultimately liable for and agrees to pay all charges if said freight is billed back to QA1 for any reason.

DAMAGED SHIPMENTS / SHORTAGES

All QA1 shipments are F.O.B. our factory. Title passes from QA1 to the purchaser at the time of shipment. Carton shortages and damages must be claimed against the carrier at the time of delivery. To expedite processing of claims against the carriers, the customer must note damages on the bill of lading at the time of delivery, and promptly request an inspection by the carrier or its claims agent. If a shortage is found within the shipment it must be reported to QA1 in writing within five (5) business days of receipt of shipment. Claims should refer to the order number, invoice number, date of invoice, date of shipment, part number, description and carton count.

DROP SHIPMENTS & REFUSED PACKAGES

Drop shipments are charged a \$15 service charge. A 20% restocking fee and all shipping costs are charged to the ordering party if a package is refused. No international drop shipments.

RETURNS

QA1 will issue a R.G.A. number for every return. *Returns will not be accepted without the R.G.A. number.* All authorized returns must have the R.G.A. number on all cartons and shipping documents. Returned product must be shipped prepaid -- collect shipments will be refused. **Modified or used products are not eligible for return.** Returns made within 90 days after invoice date are subject to a 20% restocking charge. **No returns are accepted after 90 days.** Freight charges are not refundable unless the merchandise is defective as determined by QA1. **Special orders are not returnable.**

WARRANTY / DISCLAIMER

QA1 warrants that the products will be free from defects in material and workmanship for one year from date of sale to the original purchaser. QA1 makes no other warranty of any kind, express or implied. QA1 shall have no obligation under the foregoing warranty where the defect is the result of improper or abnormal use, your negligence, vehicle accident, improper or incorrect installation or maintenance, nor when the product has been repaired or altered in any way. QA1's liability in the case of defective products subject to the foregoing warranty shall be limited to the repair or replacement, at QA1's option, of the defective products. Consequential or incidental damages are not recoverable under this warranty. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. This warranty gives you specific legal rights, and you may also have other rights that vary from state to state.

In order to be eligible for service under this warranty, you must return the defective part to QA1 together with a R.G.A. number issued from QA1. Tag each item with the part number and the specific explanation of defect. We will inspect the part and determine: a) if it is eligible for repair or replacement; and, b) if so, whether to repair or replace it. All returns must be shipped prepaid to: QA1 Precision Products, Inc., RGA # _____, 21730 Hanover Avenue, Lakeville, MN 55044.

THE BUYER UNDERSTANDS AND EXPRESSLY RECOGNIZES that racing parts, specialized street rod equipment, rod end bearings, and ALL parts and services sold by QA1 are exposed to many and varied conditions due to the manner in which they are installed and used. BUYER ACKNOWLEDGES that QA1 does not have full knowledge of the intended use of the goods, and BUYER WILL DEFEND AND INDEMNIFY QA1 upon demand against all claims, actions, liability, loss and expense (including investigating expense and attorney fees incurred in litigation or because of threatened litigation) for any loss, damage or injury, either to a person or to property, resulting from the direct or indirect use of any QA1 products or inability by the buyer to determine proper use or application of QA1 products. With the exception of the limited liability warranty set forth above, QA1 SHALL NOT BE LIABLE FOR ANY CLAIMS, DEMANDS, INJURIES, DAMAGES, ACTIONS, OR CAUSES OF ACTION WHATSOEVER TO BUYER ARISING OUT OF OR CONNECTED WITH THE USE OF ANY QA1 PRODUCTS. MOTORSPORTS ARE DANGEROUS; AS SUCH, NO WARRANTY OR REPRESENTATION IS MADE AS TO THE PRODUCT'S ABILITY TO PROTECT THE USER FROM INJURY OR DEATH. THE USER ASSUMES THAT RISK.

For complete Terms and Conditions of Sale please see our website at www.qa1.net.

62/60/50/FC SERIES TUNING GUIDE																
REVISED 4/10/07																
VALVE CODE																
	0	1	2	3	4	4.5	5	6	7	8	9	10	11	12	13	
Base Valve	Soft: #9055-293							Firm: #9055-122								
Compression	--	--	--	--	--	--	--	--	--	--	--	--	--	--	.70" x .015"	
	--	--	--	--	--	--	--	--	--	--	--	--	--	.70" x .015"	.90" x .015"	
	--	--	--	--	--	--	--	--	--	--	--	--	--	.70" x .015"	.90" x .015"	
	--	--	--	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.90" x .015"	1.1" x .015"	1.1" x .015"
	--	--	.90" x .006"	.90" x .006"	.90" x .010"	.90" x .010"	.90" x .010"	.90" x .012"	.90" x .006"	.90" x .012"	.90" x .012"	.90" x .015"	.90" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"
	--	1.1" x .006"	1.1" x .006"	1.1" x .006"	1.1" x .008"	1.1" x .010"	1.1" x .010"	1.1" x .012"	1.1" x .008"	1.1" x .012"	1.1" x .012"	1.1" x .015"	1.1" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"
	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .008"	1.3" x .010"	1.3" x .010"	1.3" x .008"	1.3" x .012"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	
Piston	Bleed ϕ .059"	Bleed ϕ .059"	Bleed ϕ .059"	Bleed ϕ .059"	Bleed ϕ .055"	Bleed ϕ .052"	Bleed ϕ .052"	Bleed ϕ .046"	Bleed ϕ .040"	Bleed ϕ .038"	Bleed ϕ .033"	No Bleed	No Bleed	No Bleed	No Bleed	
Rebound	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .010"	1.3" x .012"	1.3" x .012"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	
	--	1.1" x .006"	1.1" x .006"	1.1" x .008"	1.1" x .010"	1.1" x .010"	1.1" x .012"	1.1" x .012"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	
	--	.90" x .006"	.90" x .008"	.90" x .008"	.90" x .010"	.90" x .010"	.90" x .012"	.90" x .010"	.90" x .012"	.90" x .015"	.90" x .015"	.90" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"	
	--	--	--	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.90" x .015"	1.1" x .015"	1.1" x .015"	
	--	--	--	--	--	--	--	--	--	--	--	--	.70" x .015"	.90" x .015"	.90" x .015"	
	--	--	--	--	--	--	--	--	--	--	--	--	--	.70" x .015"	.90" x .015"	.70" x .015"

67/65/57 SERIES TUNING GUIDE														
REVISED 4/10/07														
VALVE CODE														
	0	1	2	3	4	5	6	7	8	9	10	11	12	
Base Valve	.028 Bleed											No Bleed		
Compression	--	--	--	--	--	--	--	--	--	--	.70" x .015"	--	.70" x .015"	
	--	--	--	--	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.90" x .015"	.90" x .015"	
	--	--	--	.90" x .008"	.90" x .010"	.90" x .010"	.90" x .010"	.90" x .010"	.90" x .012"	.90" x .010"	.90" x .010"	.90" x .015"	.90" x .015"	1.1" x .010"
	--	--	1.1" x .006"	1.1" x .006"	1.1" x .006"	1.1" x .008"	1.1" x .010"	1.1" x .010"	1.1" x .010"	1.1" x .010"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"
	1.3" x .004"	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .008"	1.3" x .010"	1.3" x .012"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	
Piston	Bleed ϕ .093"	Bleed ϕ .093"	Bleed ϕ .078"	Bleed ϕ .070"	Bleed ϕ .059"	Bleed ϕ .055"	Bleed ϕ .052"	Bleed ϕ .046"	Bleed ϕ .042"	Bleed ϕ .038"	Bleed ϕ .038"	Bleed ϕ .031"	Bleed ϕ .025"	
Rebound	1.3" x .004"	1.3" x .006"	1.3" x .008"	1.3" x .010"	1.3" x .010"	1.3" x .012"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	1.3" x .015"	
	--	1.1" x .006"	1.1" x .008"	1.1" x .008"	1.1" x .010"	1.1" x .010"	1.1" x .010"	1.1" x .012"	1.1" x .015"	1.3" x .008"	1.3" x .015"	1.3" x .015"	1.3" x .015"	
	--	.90" x .006"	.90" x .008"	.90" x .008"	.90" x .010"	.90" x .010"	.90" x .008"	.90" x .012"	1.1" x .006"	1.1" x .015"	1.1" x .015"	1.3" x .015"	1.3" x .015"	
	--	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.90" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.3" x .015"	
	--	--	--	--	--	--	--	--	.70" x .015"	.90" x .015"	.90" x .015"	1.1" x .015"	1.1" x .015"	
	--	--	--	--	--	--	--	--	--	.70" x .015"	.70" x .015"	.90" x .015"	1.1" x .015"	.90" x .015"