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www.QA1.net

TK01 Tuning Kit Manual

Applicable for:

FC Series

50 Series

51 Series

53 Series

60 Series

62 Series

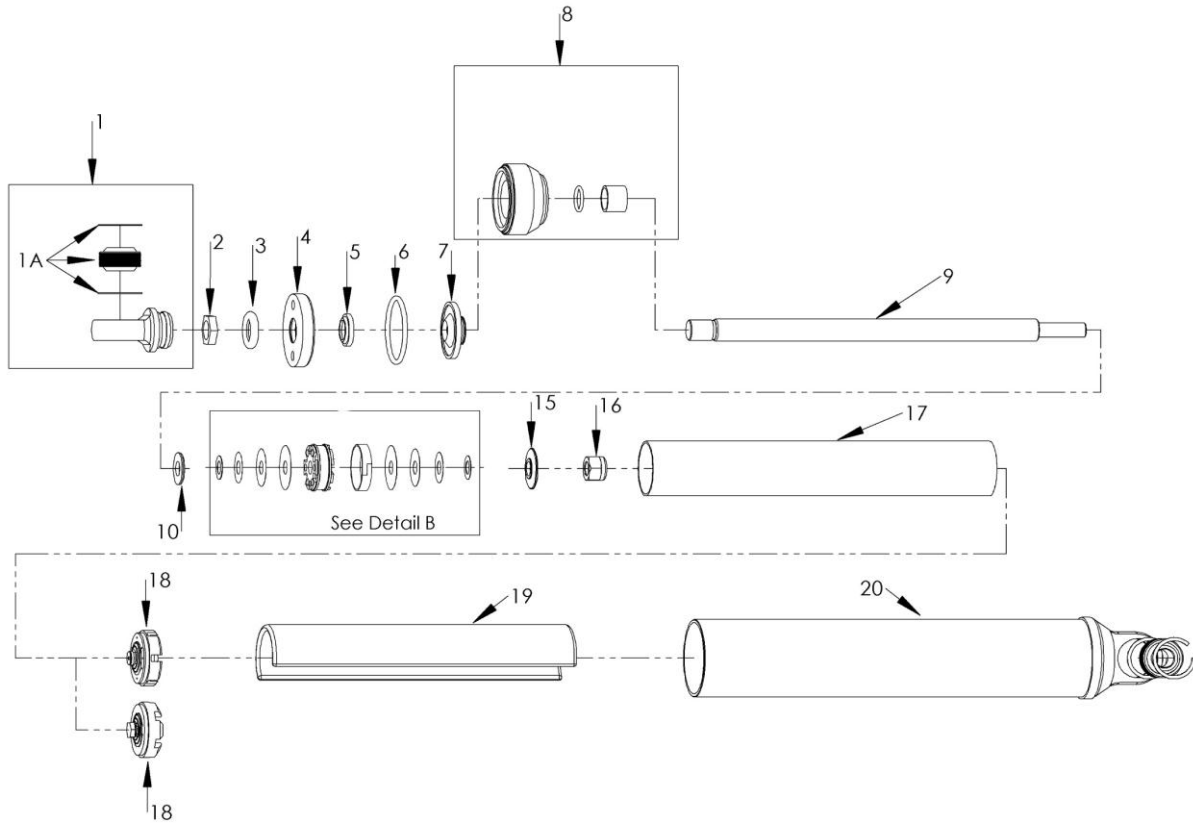
Revised 12/22/2014

Parts included in the TK01 Tuning Kit:

Item Number	Description	Qty
9042-126	Piston band	2
9044-108	O-ring, Gland/Body 42x2.5	4
9044-117	O-ring, Gland/Body 44x3	4
7855-101	Disc Valve .70 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
7855-102	Disc Valve .90 x .006, 8 Pcs. / Kit	1 Kit / 8pcs
7855-103	Disc Valve .90 x .008, 8 Pcs. / Kit	1 Kit / 8pcs
7855-104	Disc Valve .90 x .010, 8 Pcs. / Kit	1 Kit / 8pcs
7855-105	Disc Valve .90 x .012, 8 Pcs. / Kit	1 Kit / 8pcs
7855-106	Disc Valve .90 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
7855-107	Disc Valve 1.1 x .006, 8 Pcs. / Kit	1 Kit / 8pcs
7855-108	Disc Valve 1.1 x .008, 8 Pcs. / Kit	1 Kit / 8pcs
7855-109	Disc Valve 1.1 x .010, 8 Pcs. / Kit	1 Kit / 8pcs
7855-110	Disc Valve 1.1 x .012, 8 Pcs. / Kit	1 Kit / 8pcs
7855-111	Disc Valve 1.1 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
7855-178	Disc Valve 1.3 x .004, 8 Pcs. / Kit	1 Kit / 8pcs
7855-112	Disc Valve 1.3 x .006, 8 Pcs. / Kit	1 Kit / 8pcs
7855-113	Disc Valve 1.3 x .008, 8 Pcs. / Kit	1 Kit / 8pcs
7855-114	Disc Valve 1.3 x .010, 8 Pcs. / Kit	1 Kit / 8pcs
7855-115	Disc Valve 1.3 x .012, 8 Pcs. / Kit	1 Kit / 8pcs
7855-116	Disc Valve 1.3 x .015, 8 Pcs. / Kit	1 Kit / 8pcs
9057-221	35mm Piston, No Bleed	2
9055-293	Soft basevalve assembly	1
9055-324	Medium basevalve assembly	1
9055-325	Firm basevalve assembly	1
9011-101	Drill Bit, 0.033"	1
9011-102	Drill Bit, 0.038"	1
9011-103	Drill Bit, 0.040"	1
9011-104	Drill Bit, 0.046"	1
9011-105	Drill Bit, 0.052"	1
9011-106	Drill Bit, 0.055"	1
9011-107	Drill Bit, 0.059"	1
7857-101	Check ball kit	1 Kit / 8pcs
7857-103	Dowel pin kit	1 Kit / 8pcs

60 Series Parts List

Smooth Aluminum Large Body

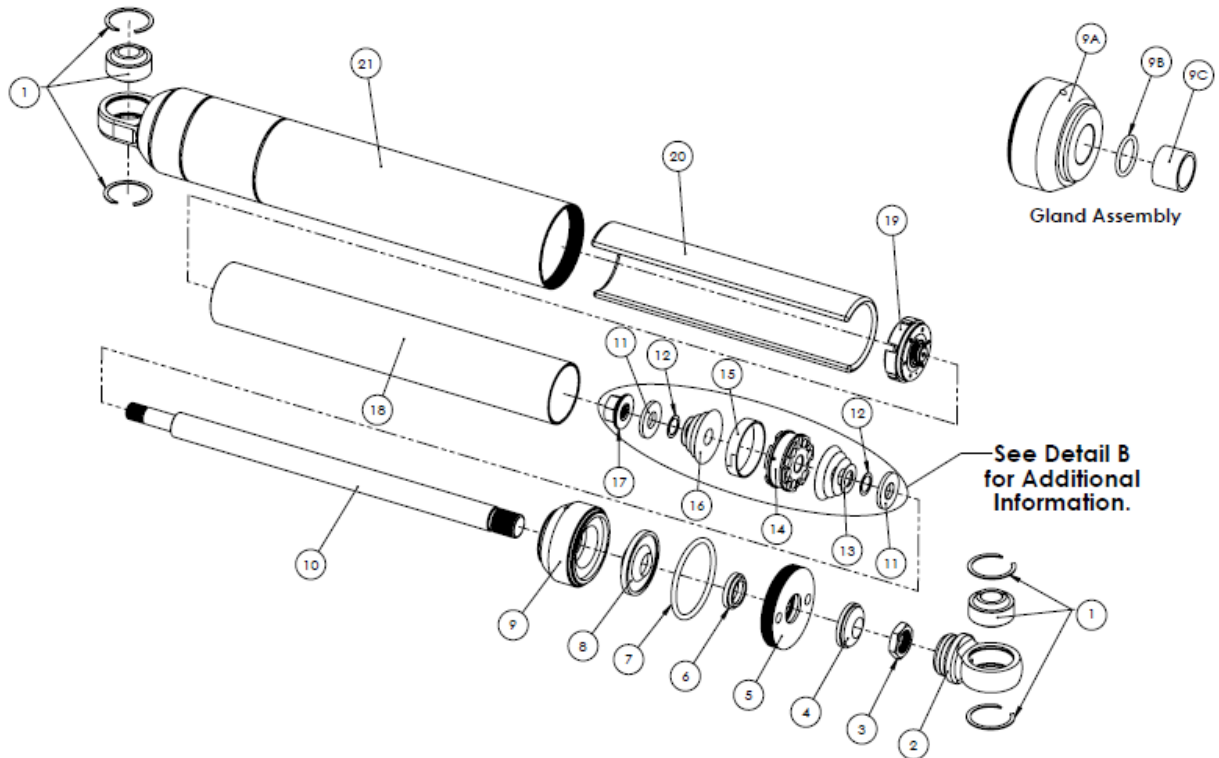


3	9042-121	New-style travel indicator
4	9014-115	Closure nut
5	9046-107	Wiper (blue)
5	9046-101	Wiper (black)
6	9044-108	O-ring, closure nut
7	9042-103	Piston rod seal
8	9054-107	Gland assembly, Large body aluminum
9	9028-122	6" piston rod
9	9028-118	7" piston rod
9	9028-138	8" piston rod
9	9028-114	9" piston rod
13	9057-221	Piston, no bleed
14	9042-126	Piston band

17	9053-123	7" large body compression tube
17	9053-125	9" large body compression tube
18	9055-293	Soft basevalve
18	9055-324	Medium basevalve
18	9055-325	Firm basevalve
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	9760-115	6" Aluminum smooth body
20	9760-114	7" Aluminum smooth body
20	9760-113	8" Aluminum smooth body
20	9760-112	9" Aluminum smooth body

51 Series Parts List

Smooth Large Body Steel

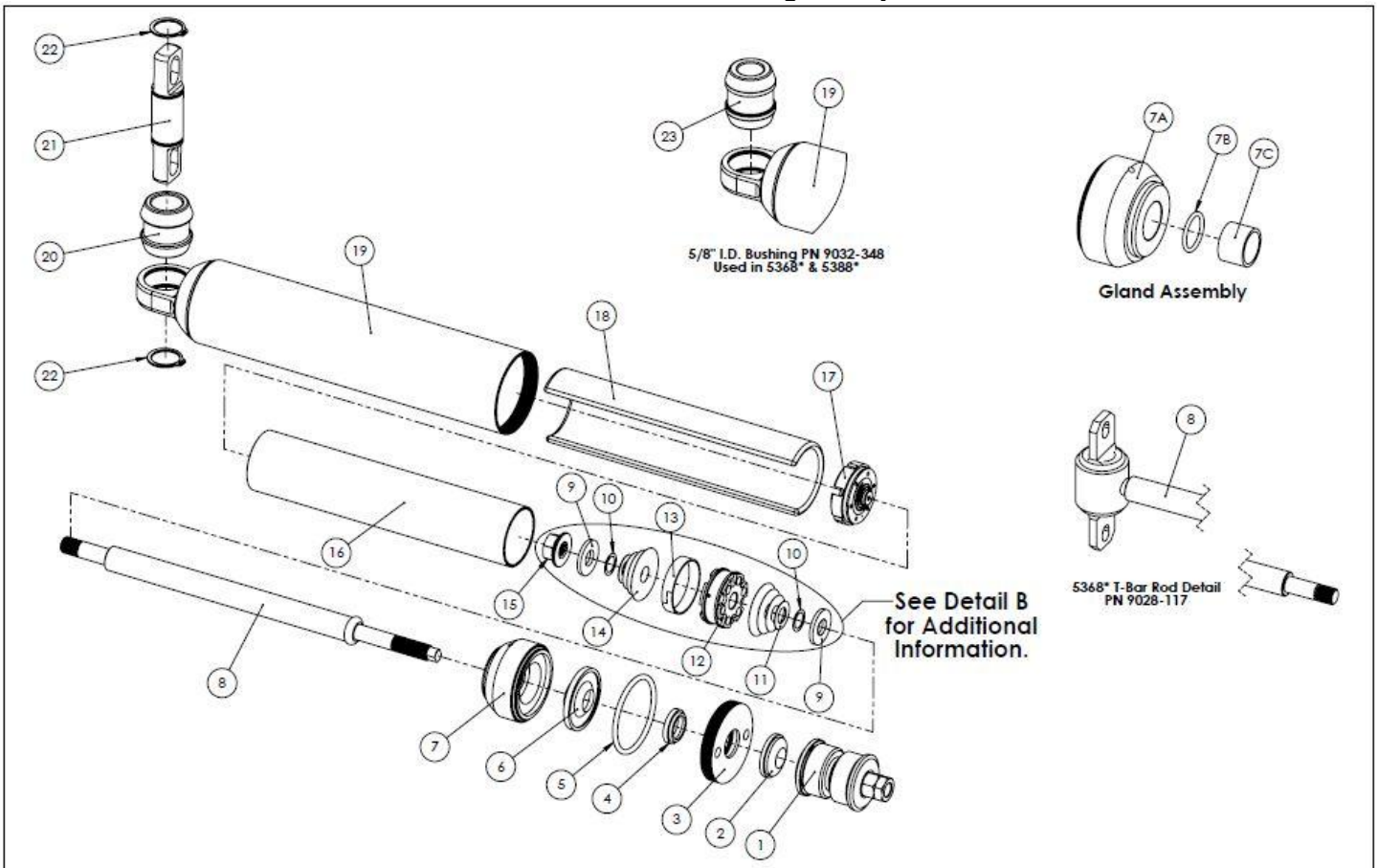


Item	Part No.	DESCRIPTION
1	SIB8-101PK	Kit, Bearing (2 Bearings, 4 Snap Rings)
2	9036-103	Steel loop assembly (with bearing)
3	9014-113	Jam nut, 9/16"-18
4	9042-121	New-style travel indicator
5	9014-115	Closure nut
6	9046-107	Wiper (blue)
6	9044-117	O-ring, closure nut
7	9042-103	Piston rod seal
8	9054-107	Gland assembly, aluminum
10	9028-118	7" piston rod
10	9028-114	9" piston rod
11	9005-237	Valve stack plate (2)
12	9005-238	Valve stack plate disc (2)
13	See Chart	Compression valve stack
14	9057-271	Piston, no bleed
15	9042-126	Piston band

Item	Part No.	DESCRIPTION
16	See Chart	Rebound valve stack
17	9014-420	Spirallock piston nut, M10-1.25
18	9053-123	7" large body compression tube
18	9053-125	9" large body compression tube
19	9055-293	Soft basevalve (0 - 5 compression)
19	9055-324	Medium basevalve (6 - 9 compression)
19	9055-325	Firm basevalve (10 - 13 compression)
20	9052-111	7" large body gas bag
20	9052-121	9" large body gas bag
21	9750-113	7" 51 series body (no bearing)
21	9750-137	7" 51 series body (w/bearing installed)
21	9750-114	9" 51 series body (no bearing)
21	9750-139	9" 51 series body (w/bearing installed)

53 Series Parts List

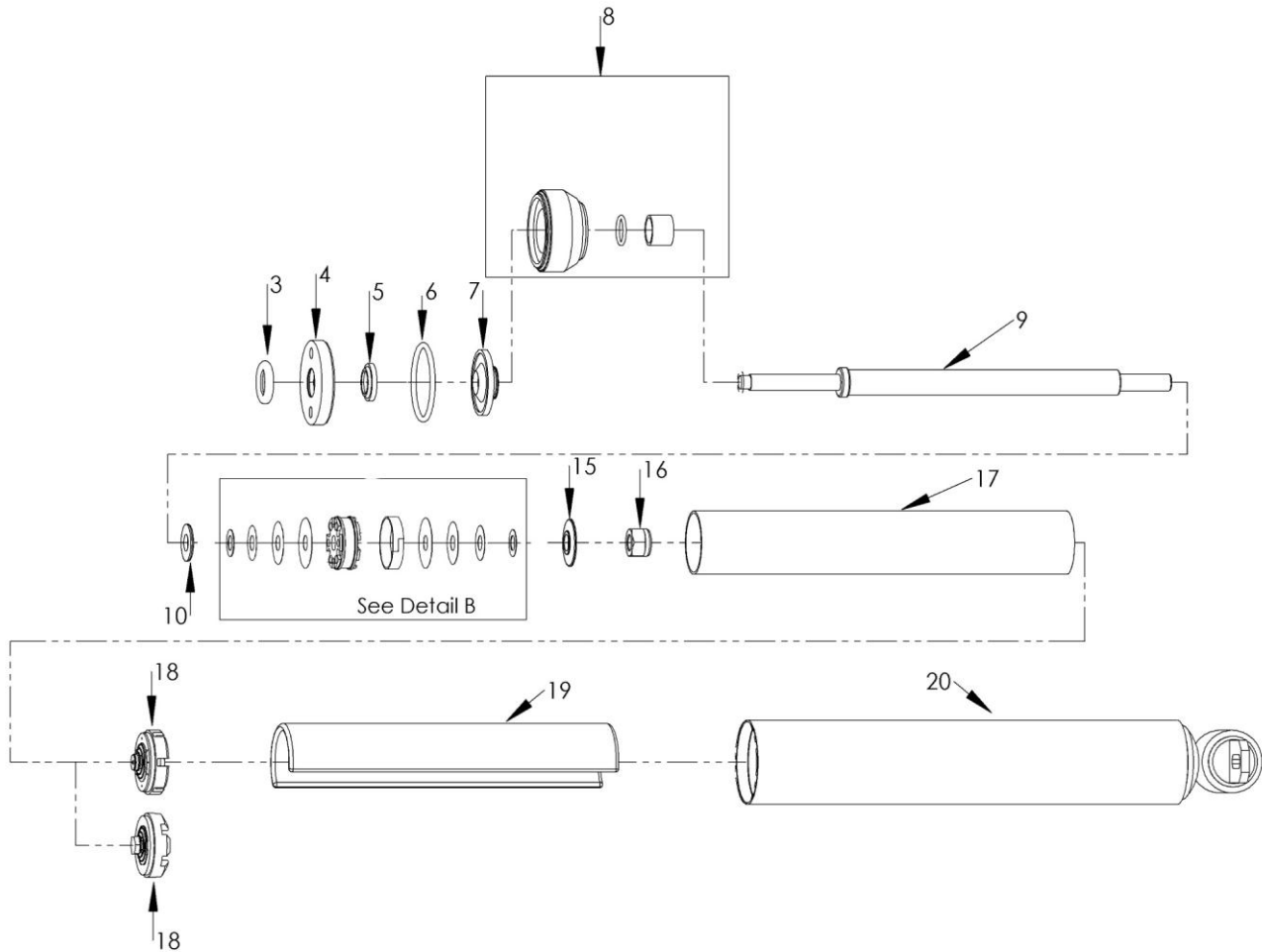
Stock Mount Steel Large Body



Item	Part No.	DESCRIPTION	Item	Part No.	DESCRIPTION
1	MK03	Stud top bushing kit	16	9053-187	Compression tube 5393x
2	9042-121	Travel indicator	16	9053-133	Compression tube 5394x
3	9014-115	Closure nut	16	9053-122	Compression tube 5395x
4	9046-107	Wiper	16	9053-124	Compression tube 5368x
6	9042-103	Piston rod seal	16	9053-124	Compression tube 5358x
7	9054-107	Gland assembly, Large Body Steel	16	9053-124	Compression tube 5388x
7A	9054-324	Gland, bare	17	9055-293	Soft basevalve
7B	9044-106	Internal gland o-ring	17	9055-324	Medium basevalve
7C	9032-107	Bushing, piston rod guide	17	9055-325	Firm basevalve
8	9028-244	Piston rod 5393x	18	9052-106	Gas bag 4" Large Body 5393x/5394x
8	9028-141	Piston rod 5394x	18	9052-109	Gas bag 5" Large Body 5395x
8	9028-115	Piston rod 5395x	18	9052-121	Gas bag 8" Large Body 5368x
8	9028-116	Piston rod 5388x	18	9052-121	Gas bag 8" Large Body 5358x
8	9028-117	Piston rod 5368x, 5358x	18	9052-121	Gas bag 8" Large Body 5388x
9	9005-237	Plate, valve stack (2 per shock)	19	9750-127	5393x body (body only)
10	9005-238	Disc, valve stack (2 per shock)	19	9750-120	5394x body (body only)
11	See Valve	Compression valve stack	19	9750-121	5395x body (body only)
12	9057-221	Piston, no bleed	19	9750-123	5368x, 5388x, 5358x body (body only)
13	9042-126	Piston seal	20	9032-150	One-piece bushing, .750" I.D.
14	See Valve	Rebound valve stack	20	9032-348	Two-piece bushing, .625" I.D.
15	9014-420	Spirallock piston nut, M10-1.25	21	BAR350K	T-bar kit
			22		

FC Series Parts List

Stock Mount Steel Large Body



Item	Part No.	DESCRIPTION
3	9042-121	New-style travel indicator
4	9014-320	Closure nut (aluminum)
5	9046-107	Wiper (blue)
5	9046-101	Wiper (black)
6	9044-108	O-ring, closure nut
7	9042-103	Piston rod seal
8	9054-108	Gland assembly, Large Body Steel
9	9028-141	Piston rod FC194xP
9	9028-115	Piston rod FC195xP
9	9028-116	Piston rod FC788xP
9	9028-117	Piston rod FC168xP, FC258xP
13	9057-221	Piston, no bleed
14	9042-126	Piston band
15	9005-237	Valve stack plate (2)
15	9005-238	Valve stack plate disc (2)
16	9014-420	Spirallock flange nut
17	9053-133	Compression tube FC194xP
17	9053-122	Compression tube FC195xP

Item	Part No.	DESCRIPTION
17	9053-124	Compression tube FC168xP
17	9053-124	Compression tube FC258xP
17	9053-124	Compression tube FC788xP
18	9055-293	Soft basevalve
18	9055-324	Medium basevalve
18	9055-325	Firm basevalve
19	9052-106	Gas bag 4" Large Body FC194xP
19	9052-109	Gas bag 5" Large Body FC195xP
19	9052-121	Gas bag 8" Large Body FC168xP
19	9052-121	Gas bag 8" Large Body FC258xP
19	9052-121	Gas bag 8" Large Body FC788xP
20	9730-105	FC194xP body
20	9730-101	FC195xP body
20	9750-115	FC168xP, FC788xP body
20	9731-101	FC258xP body

IMPORTANT: Before rebuilding or revalving your QA1 62/60/53/51/50/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 15mm or 17mm socket (depending on age of shock)
- Pick set
- QA1 shock oil (part #SF04)
- QA1 rebuild kit and/or tuning kit (62/60/53/51 series rebuild kit part #RK01; 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 or bushings 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. 62/60/53/51/50/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 soft faced mallet.
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.
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 side-bleed hole to pop the piston rod seal out of the gland.
13. Remove the 15/17mm 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.

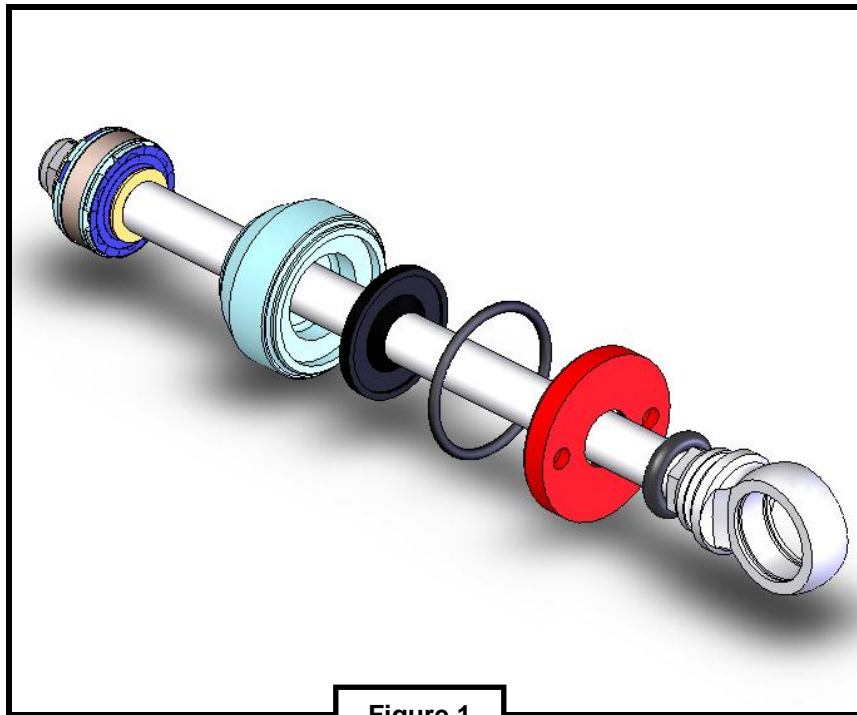


Figure 1

ASSEMBLY:

1. Inspect the gland 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 stack plate washer onto the piston rod. Then, place the small valve plate disc on top of the washer.
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 16).**
6. Place the second small valve plate disc on top of the rebound stack. Then, place the second valve stack plate washer on top of the disc.
7. Torque the 15/17mm 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 to seat 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 (1/8") 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 band, 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.

15. Use your thumb/fingers to hold the compression tube down with one hand and raise the shock shaft until the piston is at the top of the compression tube with the other.
16. Hold the shock shaft at the top of the compression tube and slide the gland into the shock body. Oil should come up through the gland bleed hole. **NOTE:** Remember we are attempting to build a shock without any air trapped inside.
17. 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.
18. Wipe away or soak up any oil that is now on top of the rod seal.
19. Install and tighten the closure nut.
20. Invert the shock and wipe off any excess oil.
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.
23. This could also be due to too soft of a basevalve compared to the valving on the piston. If the basevalve is softer than the compression stack on the piston, the rod will spring back after the shock is compressed. If this happens, double check the basevalve to make sure the proper one was used.

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 0.033” to 0.059”. 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. On the **62/60/53/51/50/FC series** there are three base valves used, one for compression valving 5 and below, one for 6 through 9 compression (1 dimple to identify), and one for 10 – 13 compression valving (2 dimples to identify). 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.

Use the graphs on page 17 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 62/60/53/51/50/FC series shocks:**

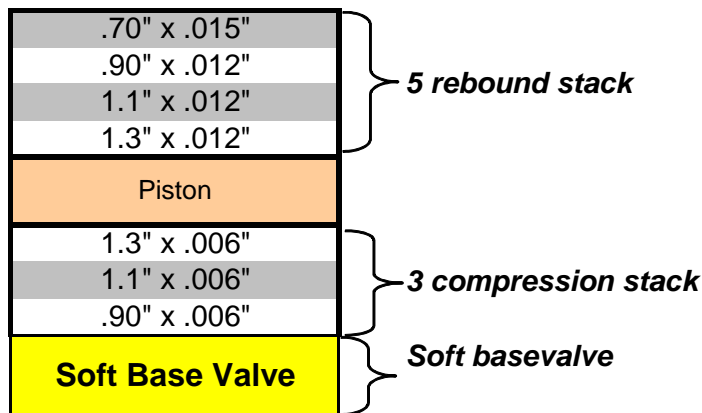
- a. Using the tables on page 17, determine the base valve that corresponds to your desired compression valve code.
 - b. Install the base valve.
 - c. Using the tables on page 17, determine the disks needed for your desired compression valve code.

 - d. 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 16). 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 (smaller of the two bleed holes). The hole can be drilled on either the compression side or the rebound side of the piston (at the factory, we drill from the rebound side).
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.
4. Using the tables on page 17, determine the disks needed for your desired compression valve code.
 5. Using the tables on page 17, 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.

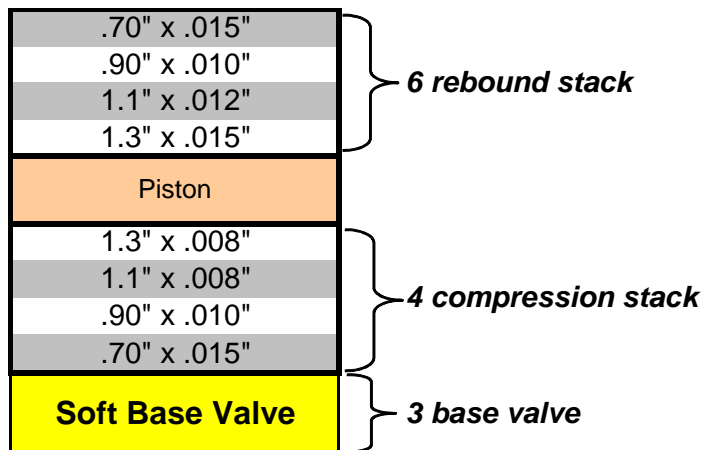
Examples:

Example 1: You want to build a 62 series 3-5 (3 compression / 5 rebound) valved shock. Follow these steps:

1. Using the tables on page 17, 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 0.059" bleed and the 5 rebound uses a 0.052" bleed. If you choose to use just one bleed, use the rebound 0.052" bleed.
3. Since the compression valve is less than a 6, use the soft base valve. (9055-293)
4. Therefore, the components used in a 62 series 3-5 valved shock will be as follows:

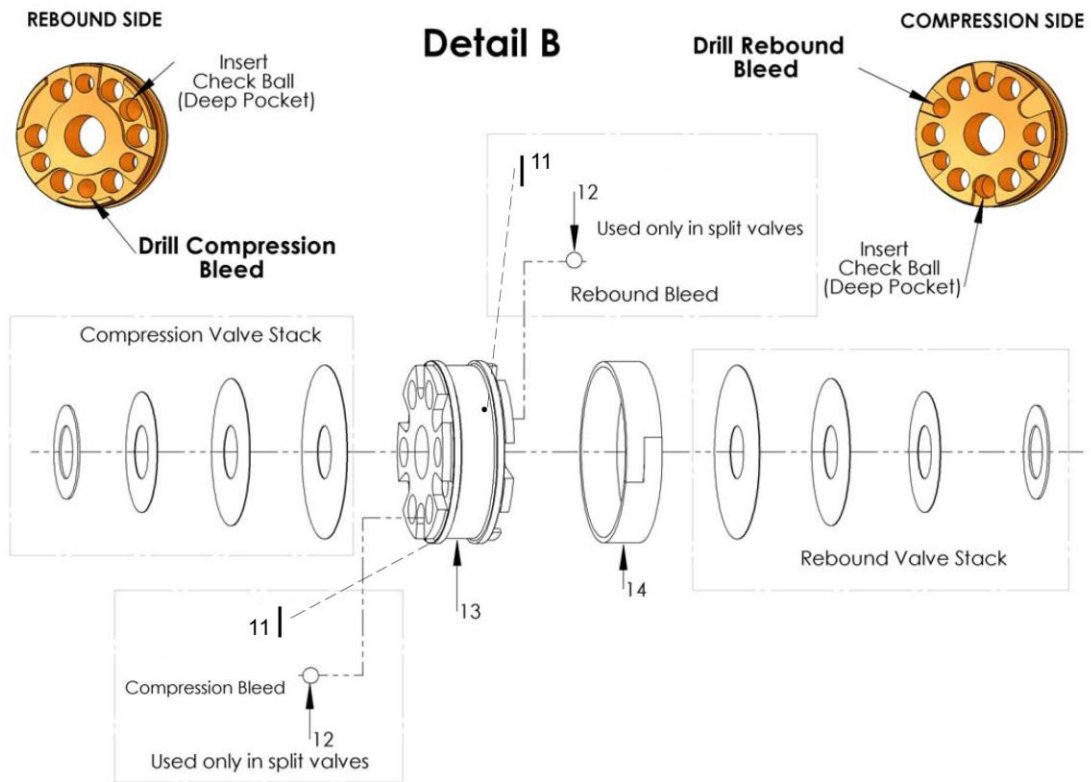


Example 2: By following the same steps, a 51 series 4-6 (4 compression / 6 rebound) valved shock would be as follows:

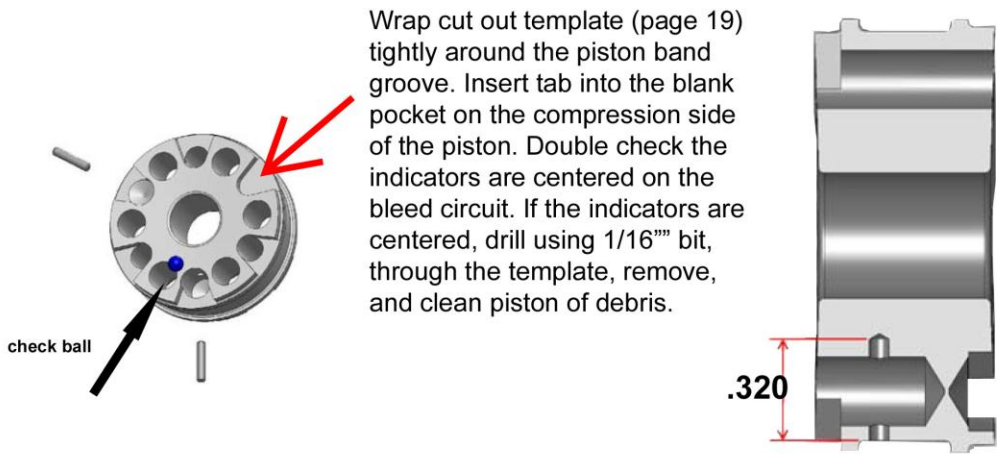


It is important to remember the following:

- The base valve 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)



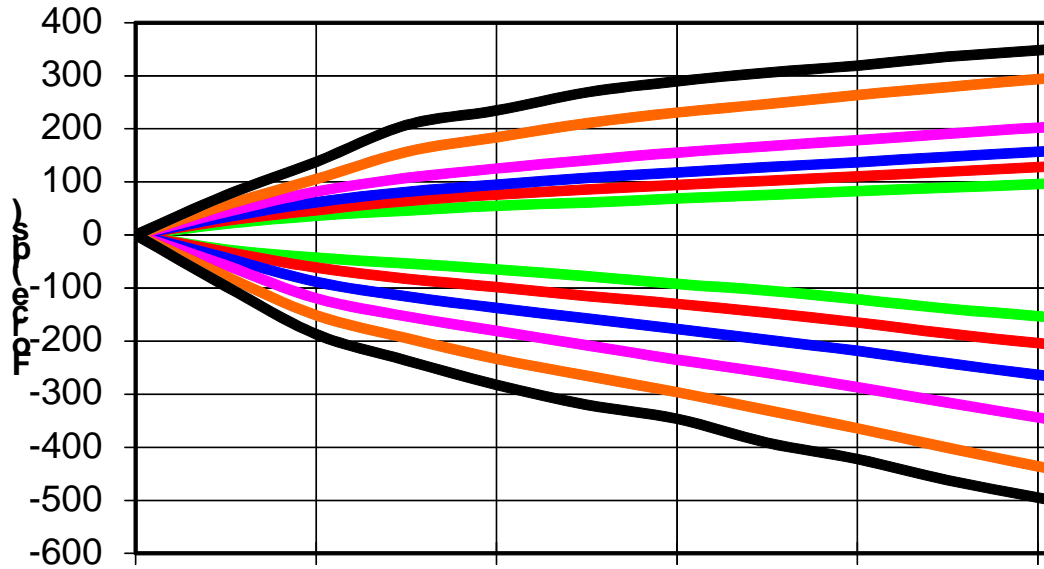
**NOTE: THE COMPRESSION BLEED IS DRILLED FROM THE REBOUND SIDE
THE REBOUND BLEED IS DRILLED FROM THE COMPRESSION SIDE**



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 *

62/60/51/50/FC SERIES LARGE BODY SHOCKS 3 - 8 VALVE



62/60/53/51/50/FC SERIES TUNING GUIDE														
REVISED 12/22/14														
VALVE CODE														
	0	1	2	3	4	5	6	7	8	9	10	11	12	13
Base Valve	Soft: #9055-293						Medium: #9055-324				Firm: #9055-325			
Compression	--	--	--	--	--	--	--	--	--	--	--	--	--	.70" x .015"
	--	--	--	--	--	--	--	--	--	--	--	--	--	.90" x .015"
	--	--	--	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.90" x .012"	.90" x .015"	.90" x .015"	.90" x .015"	.90" x .015"	1.1" x .015"
	--	--	.90" x .006"	.90" x .006"	.90" x .010"	.90" x .012"	.90" x .010"	.90" x .012"	.90" x .012"	.90" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"
Piston	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .006"	1.3" x .008"	1.3" x .012"	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"
	Bleed ϕ .059"	Bleed ϕ .059"	Bleed ϕ .059"	Bleed ϕ .059"	Bleed ϕ .055"	Bleed ϕ .052"	Bleed ϕ .046"	Bleed ϕ .040"	Bleed ϕ .038"	Bleed ϕ .033"	No Bleed	No Bleed	No Bleed	No Bleed
	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"	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 .012"	1.1" x .012"	1.1" x .012"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"	1.1" x .015"
Rebound	--	.90" x .006"	.90" x .008"	.90" x .008"	.90" x .010"	.90" x .012"	.90" x .010"	.90" x .015"	.90" x .010"	.90" x .015"	.90" x .010"	.90" x .015"	.90" x .015"	.90" 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 .015"	.90" x .015"	.90" x .015"	
	Use 2 VPs	--	--	--	--	--	--	--	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	.70" x .015"	
	--	--	--	--	--	--	--	--	--	--	--	--	--	

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. Shock components are not eligible for return.***

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.M.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., RMA # _____, 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.

