



112r2-230 Damper Kit

Build Guide
(25.05.25.01)

WARNING! DO NOT leave this kit, assembled or unassembled, in a hot motor vehicle or any other high temperature environment. This kit is 3D printed and high temperatures will harm or destroy the components.

CONTENTS:

PARTS

- ☐ 112r2-311 Plunger (2)
- ☐ 112r2-312 Cannon (2)

HARDWARE

- ☐ M3x25 SP (2)
- ☐ M3x8 BH (2)
- ☐ M3x5.5x7 TB (4)
- ☐ M3x5x5 SB (4)

WHERE / HOW USED

- ☐ M3x25 SP (2) - 1 per plunger
- ☐ M3x8 BH (2) - secure SP in plunger
- ☐ M3x5x5 SB (4) - 2 per cannon
- ☐ M3x5.5x7 TB (4) - 1 pressed into each cannon and plunger

HARDWARE KEY

BH = Button Head
TB = Threaded Ball
SP = Steel Pin
SB= Sleeve Bushing

Side Damper	
PARTS	1) Cannon 2) Plunger 3) M3x8 BH 4) M3x5x5 SB 5) M3x5x5 SB 6) M3x25 SP 7) M3x5.5x7 TB 8) M3x5.5x7 TB
Assembly STEPS	
1	Press SP (#6) into Plunger (#2) - 16-17mm should protrude when fully inserted
2	Thread BH (#3) from side as shown to secure SP. (MUST BE THE SIDE AS SHOWN)
3	Press 2 SB (#4 & #5) into Cannon (#1) to flush as shown
4	Press a TB (#7) into Plunger (#2) as shown
5	Press a TB (#8) into Cannon (#1) as shown
6	Partially fill cavity inside Cannon (#1) with 15k grease as damping
7	Slide the two halves together. Wipe away any excess grease.
8	Adjust amount of grease as needed to perform without popping, slack, or seal locking
9	Repeat steps 1-8 for second damper