

**Assembly**

Assemble the front fork in the reverse order of disassembly. Pay attention to the following points:

**⚠ CAUTION**

**The outer and inner tube's slide metals must be replaced along with the oil seal and dust seal when assembling the front fork.**

**Inner tube**

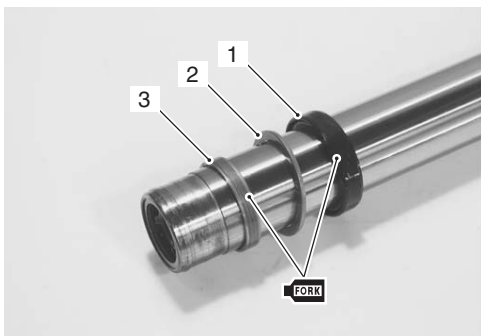
- Install the following parts onto the inner tube.
  - Oil seal (1)
  - Oil seal retainer (2)
  - Outer tube slide metal (3)

**⚠ CAUTION**

**When installing the oil seal to inner tube, be careful not to damage the oil seal lip.**

- Apply fork oil to the outer slide metal and oil seal lip.

**FORK**: Oil 99000-99001-SS8 (SUZUKI FORK OIL SS-08 or equivalent)



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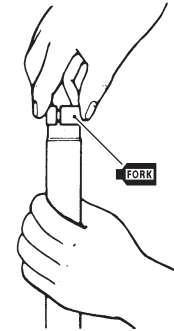
- Hold the inner tube vertically, clean the metal groove and install the inner tube slide metal by hand.

**⚠ CAUTION**

**Do not damage the Teflon coated surface of the inner tube's slide metal when mounting it.**

- Apply fork oil to the inner tube slide metal.

**FORK**: Oil 99000-99001-SS8 (SUZUKI FORK OIL SS-08 or equivalent)

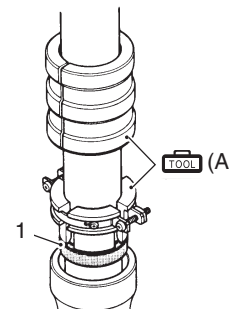


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- Insert the inner tube into the outer tube and install the oil seal (1) using the special tool.

**Special tool**

**TOOL (A)**: 09940-52861 (Front fork oil seal installer)



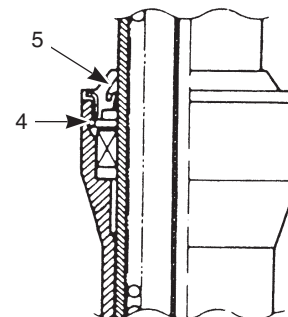
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- Install the oil seal stopper ring (4).

**⚠ CAUTION**

**Make sure that the oil seal stopper ring is fitted securely.**

- Install the dust seal (5).

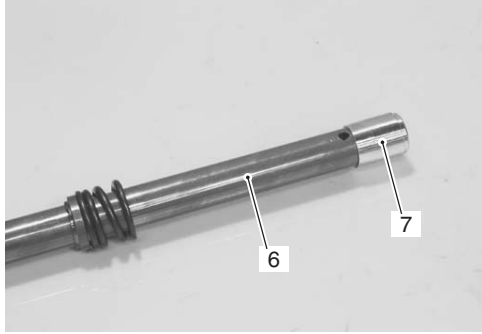


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## 2B-7 Front Suspension:

### Damper rod bolt

- Insert the inner rod/damper rod (cartridge) (6) and the oil lock piece (7) into the inner tube.



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- Apply thread lock to the damper rod bolt and tighten it to the specified torque with a 6-mm hexagon wrench and special tools.

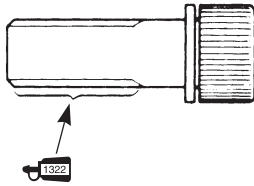
#### **CAUTION**

**Use a new gasket to prevent oil leakage.**

**1322** : Thread lock cement 99000-32110 (THREAD LOCK CEMENT SUPER 1322 or equivalent)

#### Tightening torque

Front fork damper rod bolt: 20 N·m (2.0 kgf-m, 14.5 lb-ft)



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### Fork oil

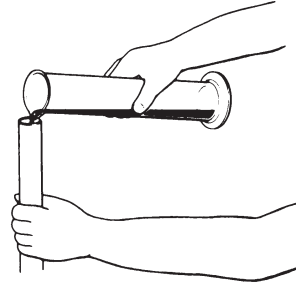
- Place the front fork vertically without spring.
- Compress it fully.
- Pour specified front fork oil up to the top level of the inner tube.

**FORK** : Oil 99000-99001-SS8 (SUZUKI FORK OIL SS-08 or equivalent)

#### Capacity (each leg)

GSF1250/A: 472 ml (16.0/16.6 US/Imp oz)

GSF1250S/SA: 471 ml (15.9/16.0 US/Imp oz)



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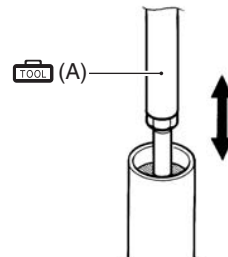
- Move the inner rod slowly with the special tool more than ten times until bubbles do not come out from the oil.

#### NOTE

**Refill front fork oil up to the top of the inner tube to find bubbles while bleeding air.**

#### Special tool

**TOOL (A)**: 09940-52841 (Inner rod holder)

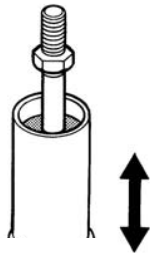


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- Refill specified front fork oil up to the top level of the inner tube again. Move the inner tube up and down several strokes until bubbles do not come out from the oil.
- Keep the front fork vertically and wait 5 – 6 minutes.

**NOTE**

- Always keep oil level over the cartridge top end, or air may enter the cartridge during this procedure.
- Take extreme attention to pump out air completely.



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- Hold the front fork vertically and adjust fork oil level with the special tool.

**NOTE**

When adjusting the fork oil level, remove the fork spring and compress the inner tube fully.

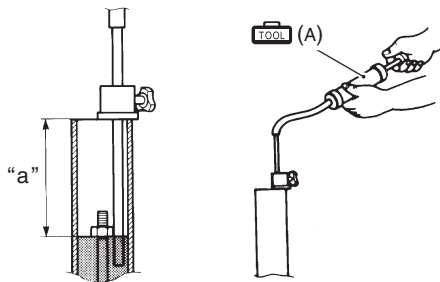
**Special tool**

**TOOL (A): 09943-74111 (Fork oil level gauge)**

**Fork oil level "a"**

GSF1250/A: 143 mm (5.6 in.)

GSF1250S/SA: 144 mm (5.7 in)



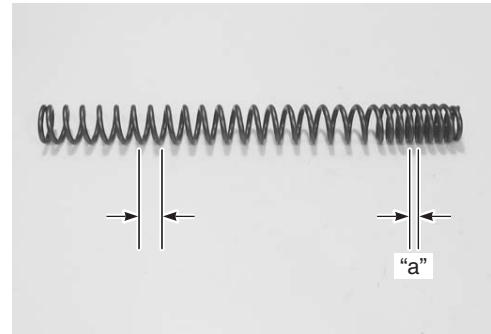
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**Fork spring**

- Install the fork spring as shown.

**NOTE**

The smaller pitch "a" should face to the bottom side of the front fork.



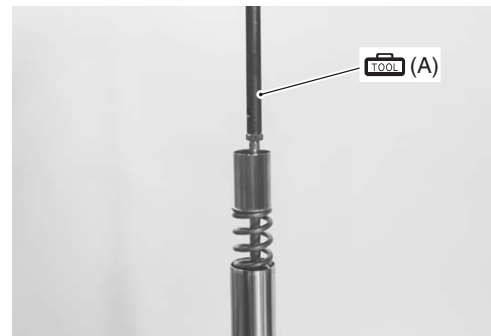
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**Inner rod and lock-nut**

- Install the special tool and pull up the inner rod.

**Special tool**

**TOOL (A): 09940-52841 (Inner rod holder)**



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## 2B-9 Front Suspension:

- Install the front fork cap (1).

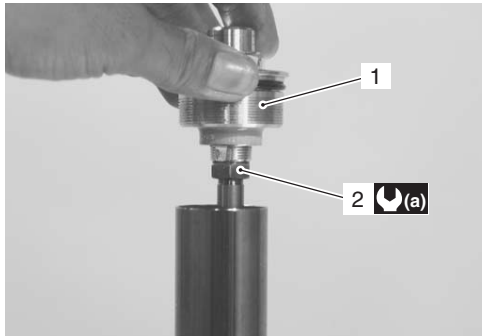
### NOTE

Before installing the front fork cap, turn the inner rod lock-nut (2) completely to the lower position as shown.

- Tighten the lock-nut (2) to the specified torque.

### Tightening torque

Inner rod lock-nut (a): 20 N·m (2.0 kgf-m, 14.5 lb-ft)



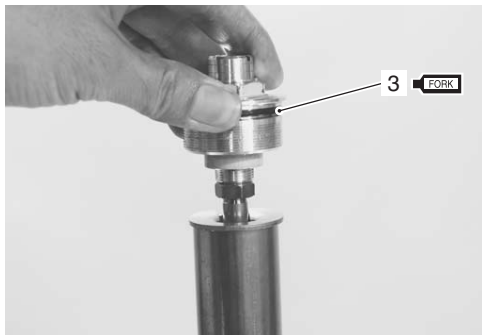
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- Apply fork oil lightly to the O-ring (3).

### CAUTION

Use a new O-ring (3) to prevent oil leakage.

**FORK** : Oil 99000-99001-SS8 (SUZUKI FORK OIL SS-08 or equivalent)



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- Install the front fork protector (4).

### NOTE

Fit the projection of the front fork protector to the depression of the front fork outer tube.



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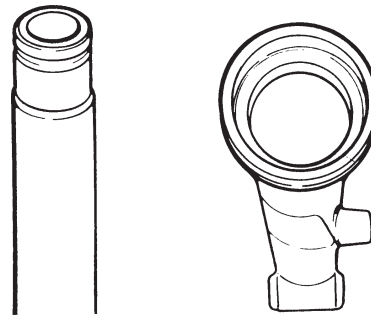
## Front Fork Parts Inspection

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Refer to "Front Fork Disassembly and Assembly (Page 2B-4)".

### Inner and Outer Tubes

Inspect the inner tube sliding surface and outer tube sliding surface for scuffing.



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