



Ecovent Vent Assembly Instructions

Revision: E

Issued: March 31th, 2016

Ecovent Vent Assembly Instructions



#	Revision	Description of Change	Created By	Approved By	Effective Date
1	-	Initial Release	M. DeLorenzo	M. DeLorenzo	12/05/2015
2	A	VA Assy for New Star	J. Pentecost	J. Pentecost	12/07/2015
3	B	Updates for GA	J. Pentecost	M. DeLorenzo	01/25/2016
4	C	Added Nylock Nut, Updated Vent Cover Shipping Instructions, Added Floor Vent Faceplate Installation Process	M. DeLorenzo	M. DeLorenzo	02/18/2016
5	D	Updated magnet installation instructions	T. Frey	T. Frey	03/24/16
6	E	Allow cleaning of hands with alcohol as alternative to wearing gloves	T. Frey	T. Frey	03/31/16

Ecovent Vent Assembly Instructions



Battery Pack Assembly

1. Snap Series Battery Connections, PN 601-00007, qty. 2 onto the Battery Pack Housing, PN 602-00060, qty. 1 as shown.

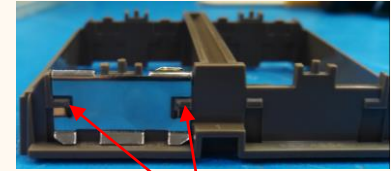
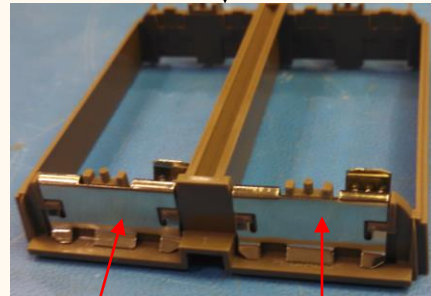
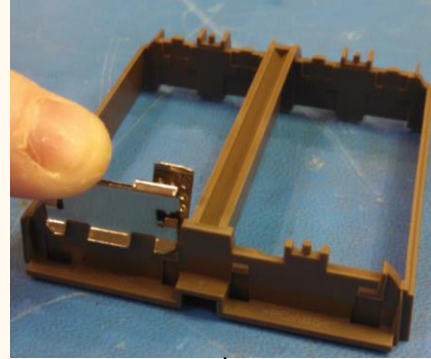


Battery Pack Housing
(PN 602-00060-BRO), qty. 1



Series Battery Connection
(PN 601-00007), qty. 2

THE FOLLOWING PARTS ARE USED BASED ON VENT CONFIGURATION:		
CONFIGURATION	BATTERY PACK HOUSING PART NUMBER	BATTERY PACK RIB PART NUMBER
WHITE	602-00060_F	602-00144_A
BROWN	602-00060-BRO_F	602-00144-BRO_A



Ensure Series Connections clip into Battery Pack Housing, 2 places.

Ecovent Vent Assembly Instructions



Battery Pack Assembly (continued)

2. Install Battery Pack Terminal, PN 602-00014, onto the Battery Pack Housing opposite negative spring.
3. Clip the Battery Spring Positive, PN 601-00016 over the Battery Pack Terminal. It should make a 'snap' sound when finished.
4. Repeat Step 2 & 3 for the second location



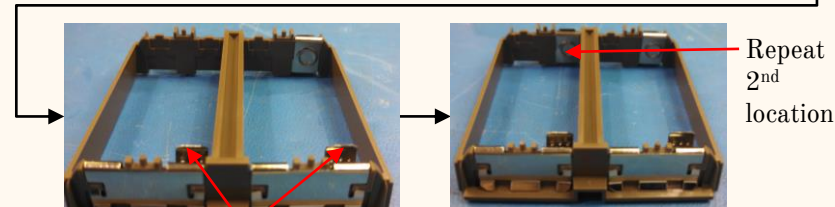
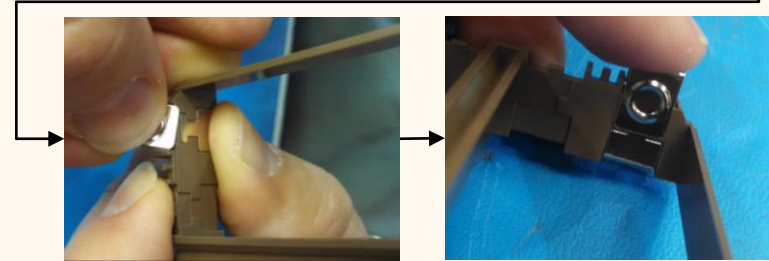
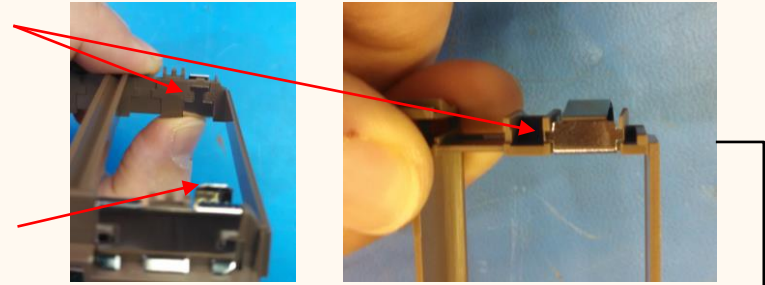
Battery Spring Positive
(PN 601-00016), qty. 2



Battery Pack Terminal
(PN 602-00014), qty. 2

Ensure the
Battery Pack
Terminal is fully
seated in the
housing

Note Negative
spring location



Note Negative spring locations

Ecovent Vent Assembly Instructions

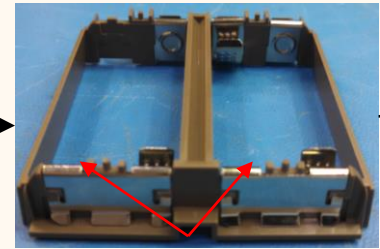
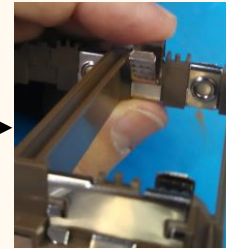
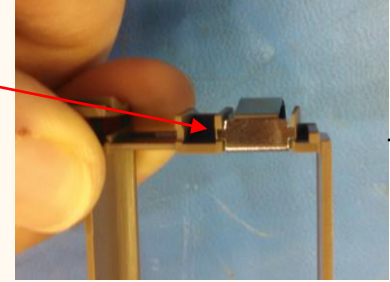
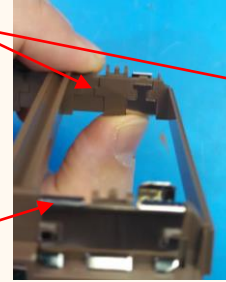


Battery Pack Assembly (continued)

5. Install Battery Pack Terminal, PN 602-00014, onto the Battery Pack Housing opposite positive spring.
6. Clip the Battery Spring Negative, PN 601-00010 over the Battery Pack Terminal. It should make a 'snap' sound when finished.
7. Repeat Step 5 & 6 for the second location

Ensure the Battery Pack Terminal is fully seated in the housing

Note Positive spring location



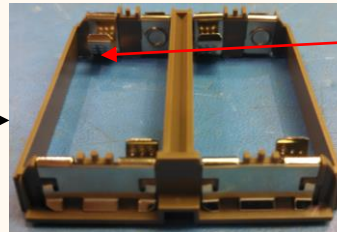
Note positive spring locations



Battery Spring Negative
(PN 601-00010), qty. 2



Battery Pack Terminal
(PN 602-00014), qty. 2



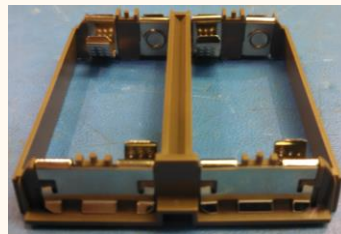
Repeat
2nd
location

Ecovent Vent Assembly Instructions

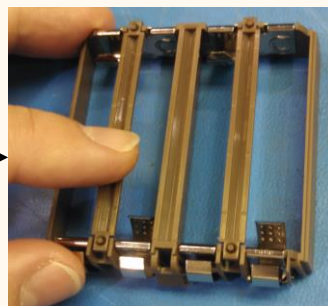
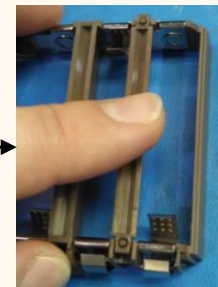


Battery Pack Assembly (continued)

8. Install Battery Pack Ribs, PN 602-00144 onto Battery Pack Housing, 2 places.
9. Heat stake Battery Pack Ribs onto Battery Pack Housing, 4 places using the indicated machine.
10. Visually inspect for proper appearance



+



Battery Pack Rib
(PN 602-000144-BRO), qty. 2

THE FOLLOWING PARTS ARE USED BASED ON VENT CONFIGURATION:		
CONFIGURATION	BATTERY PACK HOUSING PART NUMBER	BATTERY PACK RIB PART NUMBER
WHITE	602-00060_F	602-00144_A
BROWN	602-00060-BRO_F	602-00144-BRO_A



Ecovent Vent Assembly Instructions

Deflector Cover Steel Block Installation

- 1. Lightly sand flat face of Steel Block with 200-400 grit sandpaper.
- 2. Thoroughly clean hands with isopropyl alcohol. STEPS 3-5 MUST BE COMPLETED IN SUCCESSION.
- 3. Clean steel block with isopropyl alcohol
- 4. Clean application area with isopropyl alcohol
- 5. Ensure alcohol on steel block and application area is fully dry. Install qty. 4 Steel Blocks, PN 601-00017, into the Deflector Cover with sanded side towards plastic, using 2 drops Loctite 411, PN 604-00009, and dispensing tip for each location (4 places). Use press to ensure steel blocks are fully seated.
- 6. ALLOW 24 HOURS FULL CURE TIME BEFORE USING PART IN ANY OTHER ASSEMBLY



Steel Block
1/8 x 3/8 x 1/16
(PN 601-00017)

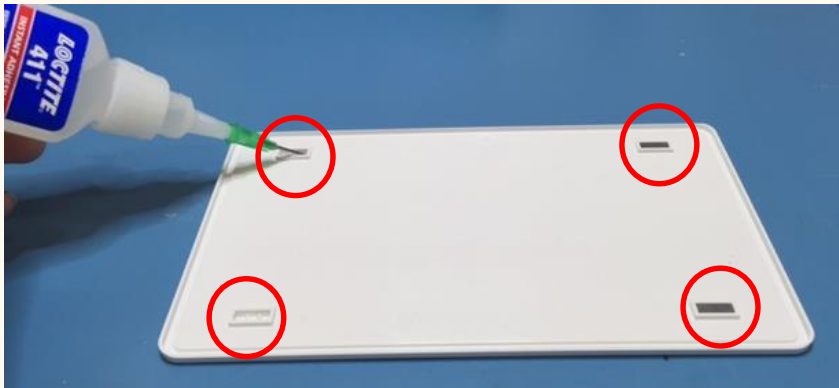


Loctite 411
(PN 604-00009)



Deflector Cover,
multiple PNs listed below

THIS ASSEMBLY PROCEDURE APPLIES TO THE FOLLOWING ASSEMBLIES:		
SIZE	CONFIGURATION	PART NUMBER
10X4	WALL	801-00061
	CEILING	801-00059
10X6	WALL	801-00063
	CEILING	801-00011
12X4	WALL	801-00062
	CEILING	801-00060
12X6	WALL	801-00024
	CEILING	801-00023





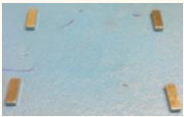
Ecovent Vent Assembly Instructions

Faceplate Extension Magnet Installation

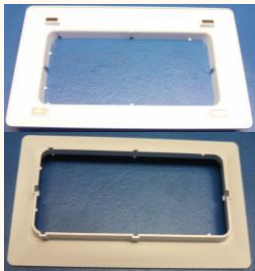
- 1. Lightly sand **SOUTH** side of magnet with 200-400 grit sandpaper.
- 2. Thoroughly clean hands with isopropyl alcohol. STEPS 3-5 MUST BE COMPLETED IN SUCCESSION.
- 3. Clean magnet with isopropyl alcohol
- 4. Clean application area with isopropyl alcohol
- 5. Ensure alcohol on steel block and application area is fully dry. Install qty. 4 Magnets, PN 603-00006, into the Faceplate Extension with sanded side towards plastic, using 2 drops Loctite 411, PN 604-00009, and dispensing tip for each location (4 places). Use press to ensure magnets are fully seated.
- 6. ALLOW 24 HOURS FULL CURE TIME BEFORE USING PART IN ANY OTHER ASSEMBLY



Loctite 411
(PN 604-00009)



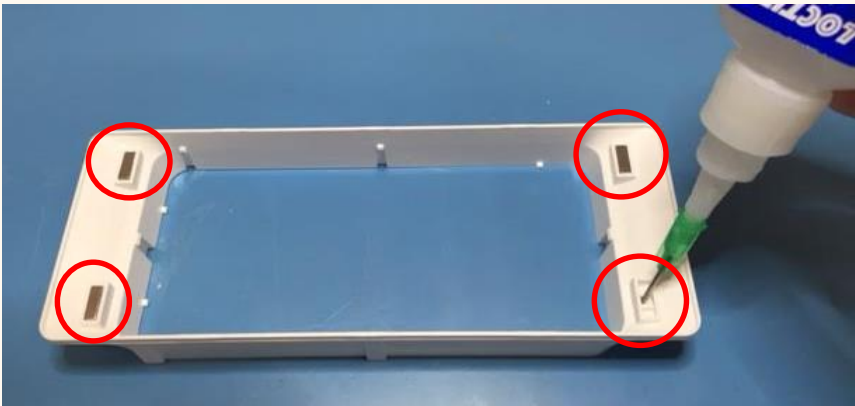
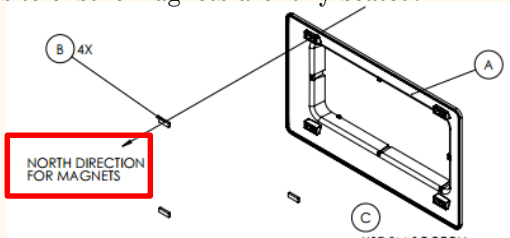
Magnet
3/8 x 1/8 x 1/16
(PN 603-00006)



Faceplate Extension
Applies to multiple PNs,
see table below

THE FOLLOWING PARTS ARE USED BASED ON VENT SIZE AND CONFIGURATION:

SIZE	CONFIGURATION	PART NUMBER
10X4	WALL	602-00137_E
	CEILING	602-00111_E
10X6	WALL	602-00139_E
	CEILING	602-00091_E
12X4	WALL	602-00138_E
	CEILING	602-00123_E
12X6	WALL	602-00140_E
	CEILING	602-00101_E





Ecovent Vent Assembly Instructions

Vent Frame Magnet Installation

- 1. Lightly sand **NORTH** side of magnet with 200-400 grit sandpaper.
- 2. Thoroughly clean hands with isopropyl alcohol. STEPS 3-5 MUST BE COMPLETED IN SUCCESSION.
- 3. Clean magnet with isopropyl alcohol
- 4. Clean application area with isopropyl alcohol
- 5. Ensure alcohol on steel block and application area is fully dry. Install qty. 4 Magnets, PN 603-00006, into the Frame with sanded side towards plastic, using 2 drops Loctite 411, PN 604-00009, and dispensing tip for each location (4 places). Use press to ensure magnets are fully seated.
- 6. ALLOW 24 HOURS FULL CURE TIME BEFORE USING PART IN ANY OTHER ASSEMBLY



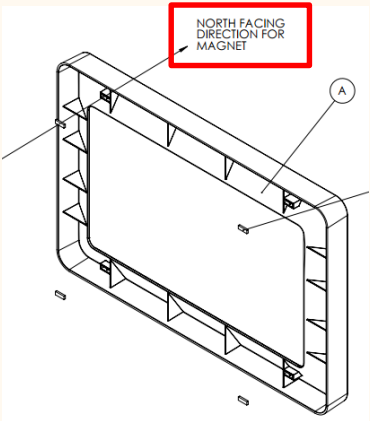
Loctite 411
(PN 604-00009)



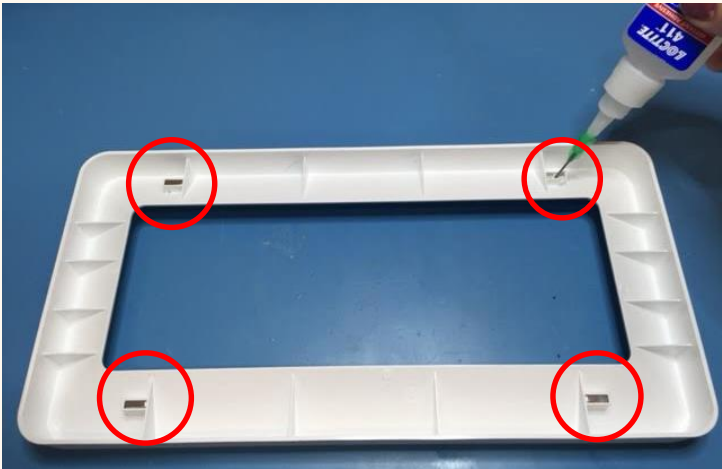
Magnet
3/8 x 1/8 x 1/16
(PN 603-00006)



Frame
Applies to multiple PN's, see
table below



THIS ASSEMBLY PROCEDURE APPLIES TO THE FOLLOWING ASSEMBLIES:	
SIZE	PART NUMBER
10X4	801-00019
10X6	801-00008
12X4	801-00018
12X6	801-00017





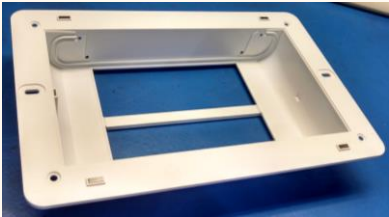
Ecovent Vent Assembly Instructions

Outer Box Magnet Installation

- 1. Lightly sand **SOUTH** side of magnet with 200-400 grit sandpaper.
- 2. Thoroughly clean hands with isopropyl alcohol. STEPS 3-5 MUST BE COMPLETED IN SUCCESSION.
- 3. Clean magnet with isopropyl alcohol
- 4. Clean application area with isopropyl alcohol
- 5. Ensure alcohol on steel block and application area is fully dry. Install qty. 4 Magnets, PN 603-00006, into the Outer Box with sanded side towards plastic, using 2 drops Loctite 411, PN 604-00009, and dispensing tip for each location (4 places). Use press to ensure magnets are fully seated.
- 6. ALLOW 24 HOURS FULL CURE TIME BEFORE USING PART IN ANY OTHER ASSEMBLY



Loctite 411
(PN 604-00009)

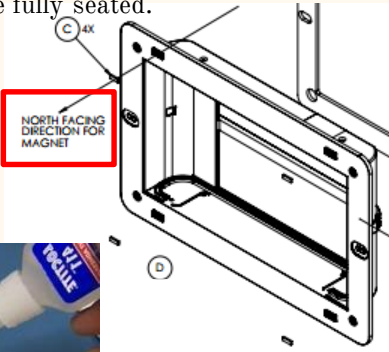
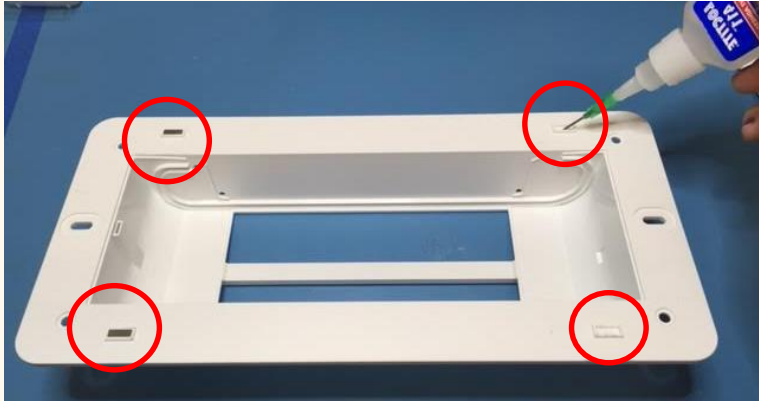


Outer Box,
Applies to multiple
PNs, see table below



Magnet
3/8 x 1/8 x 1/16
(PN 603-00006)

THE FOLLOWING PARTS ARE USED BASED ON VENT SIZE:		
SIZE	OUTER BOX PART NUMBER	SEAL PART NUMBER
10X4	602-00104_H	602-00105_A
10X6	602-00081_H	602-00089_A
12X4	602-00115_H	602-00116_A
12X6	602-00093_H	602-00095_A





Ecovent Vent Assembly Instructions

Floor Faceplate Magnet Installation

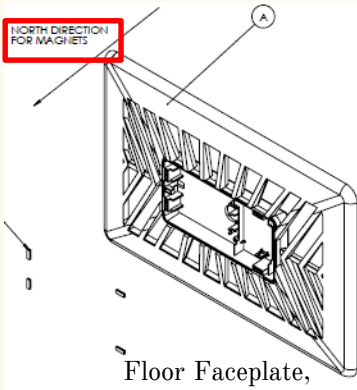
- 1. Lightly sand **SOUTH** side of magnet with 200-400 grit sandpaper.
- 2. Thoroughly clean hands with isopropyl alcohol. STEPS 3-5 MUST BE COMPLETED IN SUCCESSION.
- 3. Clean magnet with isopropyl alcohol
- 4. Clean application area with isopropyl alcohol
- 5. Ensure alcohol on steel block and application area is fully dry. Install qty. 4 Magnets, PN 603-00006, into the Floor Faceplate with sanded side towards plastic, using 2 drops Loctite 411, PN 604-00009, and dispensing tip for each location (4 places). Use press to ensure magnets are fully seated.
- 6. ALLOW 24 HOURS FULL CURE TIME BEFORE USING PART IN ANY OTHER ASSEMBLY



Loctite 411
(PN 604-00009)

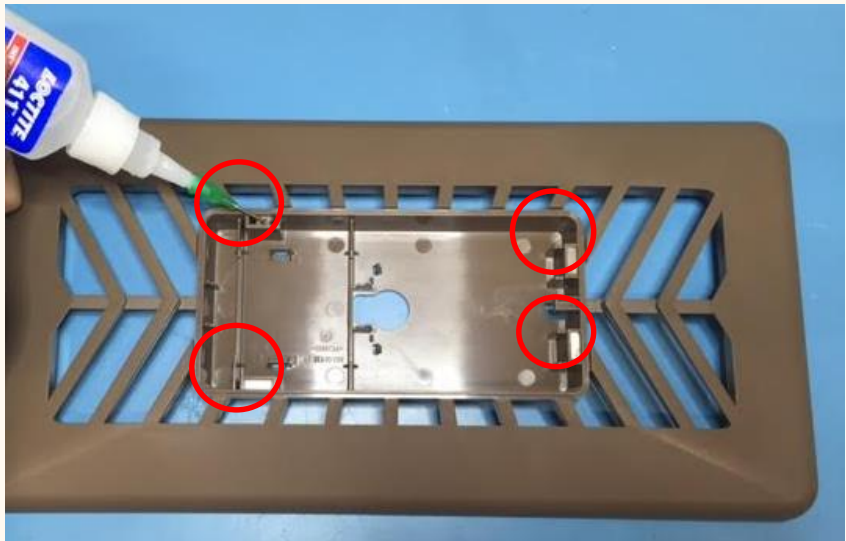


Magnet
3/8x1/8x1/16
(PN 603-00006)



Floor Faceplate,
Applies to multiple
PNs, see table below

THIS ASSEMBLY PROCEDURE APPLIES TO THE FOLLOWING ASSEMBLIES:	
SIZE	PART NUMBER
10X4	801-00043
10X6	801-00037
12X4	801-00048
12X6	801-00041





Ecovent Vent Assembly Instructions

Floor Faceplate Cover Steel Block Installation

- 1. Lightly sand flat side of Steel Block with 200-400 grit sandpaper.
- 2. Thoroughly clean hands with isopropyl alcohol. STEPS 3-5 MUST BE COMPLETED IN SUCCESSION.
- 3. Clean Steel Block with isopropyl alcohol
- 4. Clean application area with isopropyl alcohol
- 5. Ensure alcohol on steel block and application area is fully dry. Install qty. 4 Steel Blocks, PN 601-00017, into the Floor Faceplate Cover with sanded side towards plastic, using 2 drops Loctite 411, PN 604-00009, and dispensing tip for each location (4 places). Use press to ensure Steel Blocks are fully seated.
- 6. ALLOW 24 HOURS FULL CURE TIME BEFORE USING PART IN ANY OTHER ASSEMBLY



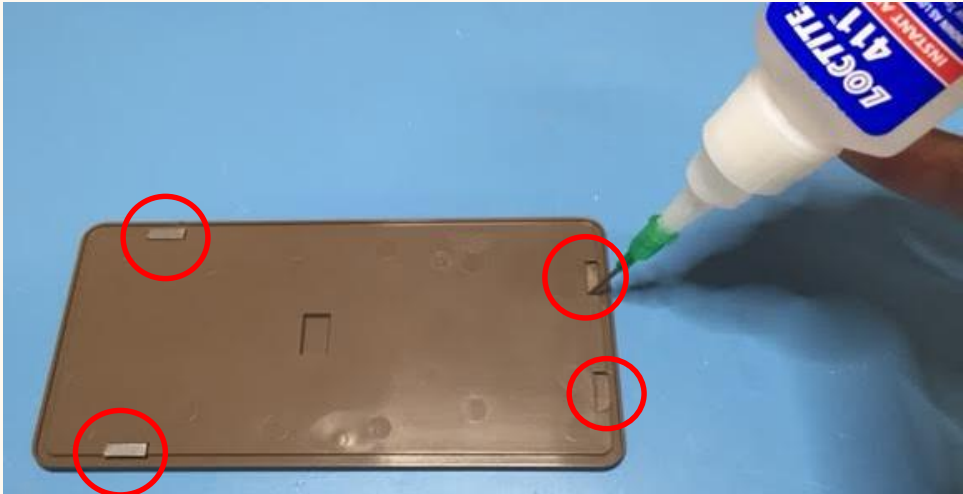
Loctite 411
(PN 604-00009)



STEEL BLOCK
1/8 x 3/8 x 1/16
(PN 601-00017)



Floor Faceplate Cover
(PN 602-00136)

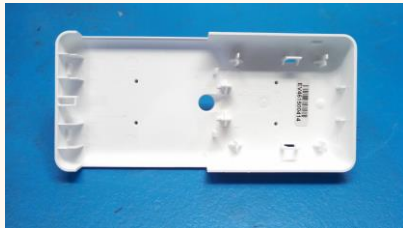
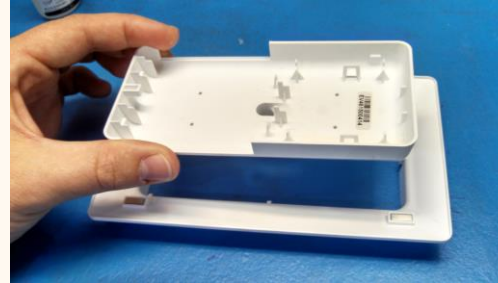


Ecovent Vent Assembly Instructions



Vent Assembly

1. Snap the Balljoint Faceplate Wall/Ceiling, PN 602-00076, into the Faceplate Extension. (Make sure that the magnets are already installed in the faceplate extension)
2. Snap the faceplate cover onto the assembly.



Balljoint Faceplate
Wall/Ceiling
(PN 602-00076)



See Faceplate Covers for
each assembly below

THIS ASSEMBLY PROCEDURE APPLIES TO THE FOLLOWING ASSEMBLIES:		
SIZE	CONFIGURATION	PART NUMBER
10X4	WALL	801-00061
	CEILING	801-00059
10X6	WALL	801-00063
	CEILING	801-00011
12X4	WALL	801-00062
	CEILING	801-00060
12X6	WALL	801-00024
	CEILING	801-00023

Description	Extension Part Number	Assembly Part Number
10x6 Ceiling	602-00091	801-00052
12x6 Ceiling	602-00101	801-00058
10x4 Ceiling	602-00111	801-00016
12x4 Ceiling	602-00123	801-00014
10x4 Wall	602-00137	801-00015
12x4 Wall	602-00138	801-00013
10x6 Wall	602-00139	801-00009
12x6 Wall	602-00140	801-00064

Ecovent Vent Assembly Instructions



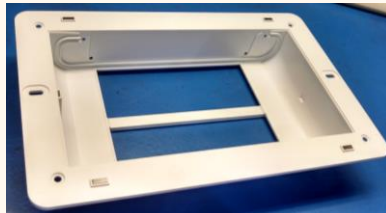
Vent Assembly

1. Install the Vent Seal onto the Outer Box.
Ensure all holes are aligned in the Seal and outer Box.

Part Description	Vent Seal Part Number	Outer Box Part Number
10x6 White	602-00089	602-00081 WHITE
12x6 White	602-00095	602-00093 WHITE
10x4 White	602-00105	602-00104 WHITE
12x4 White	602-00116	602-00115 WHITE
10x6 Black	602-00147	602-00081 BLACK
10x4 Black	602-00148	602-00093 BLACK
12x4 Black	602-00149	602-00104 BLACK
12x6 Black	602-00150	602-00115 BLACK



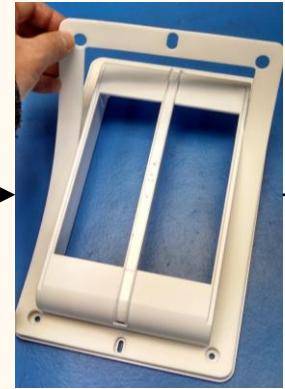
Vent Seal



Outer Box



Remove adhesive protective cover from Vent Seal



Apply Vent Seal adhesive side down



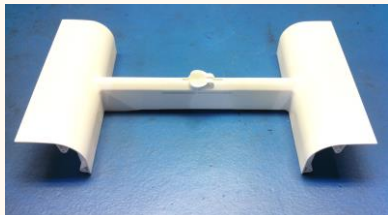
Set aside for later assembly

Ecovent Vent Assembly Instructions



Vent Assembly

1. Locate the following parts:



Diffuser Screw Cover



Note: Bushing Side of
Lead Screw



Note: Motor Side of
Lead Screw



Nut, Bushing Side | Nut, Motor Side
(PN 602-00073) | (PN 602-00085)

Description	Drive Train Assembly	Diffuser Screw Cover	Diffuser Screw Cover (Color)	Lead Screw
10x4 wall/ceiling	801-00022	602-00107	White	602-00053
10x4 floor	801-00027	602-00107	Black	602-00053
10x6 floor	801-00028	602-00083	Black	602-00053
12x4 floor	801-00029	602-00118	Black	602-00098
12x6 floor	801-00030	602-00097	Black	602-00098
10x6 wall/ceiling	801-00032	602-0008	White	602-00053
12x6 wall/ceiling	801-00038	602-00097	White	602-00098
12x4 wall/ceiling	801-00045	602-00118	White	602-00098



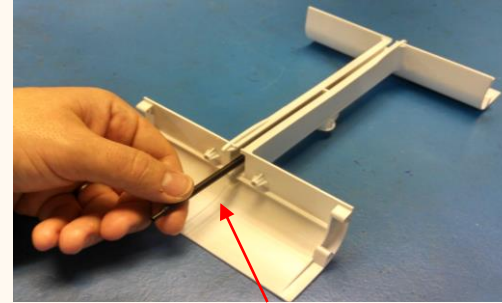
Lead Screw

Ecovent Vent Assembly Instructions



Vent Assembly

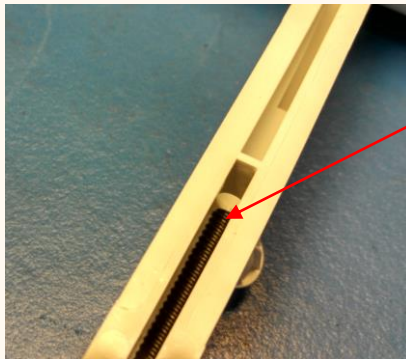
2. Install Lead Screw into the Diffuser Screw Cover
3. Ensure Bushing & Motor Side of the Diffuser Screw Cover matches the Bushing & Motor Sides of the Lead Screw



Note Bushing Side of the Diffuser Screw Cover has Pressure Sensor Wire Track in the Plastic



Bushing side of Lead Screw



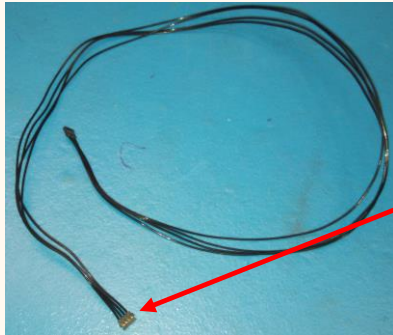
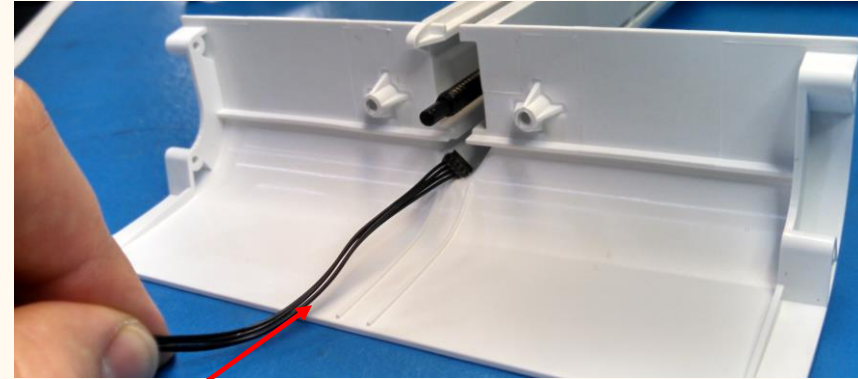
Slide the Lead Screw all the way through the Diffuser Screw Cover. Note the hole the screw must go through midway.

Ecovent Vent Assembly Instructions



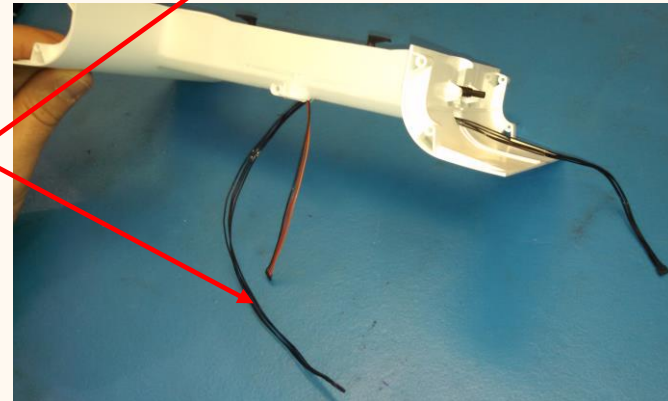
Vent Assembly

4. Thread the Cable, Vent Pressure Sensor, PN 801-00053 through the lower tunnel of the Diffuser Screw Cover from the Bushing End. See pictures showing the exit of the Vent Pressure Sensor Cable.



Cable, Vent Pressure Sensor
(PN 801-00053), qty. 1

Note: The color of the
cable wires may be all black
or multi-colored



Ecovent Vent Assembly Instructions



Vent Assembly

5. Thread the Nuts, PNs 602-00073 and 602-00085, qty. 1 each onto the Lead Screw.

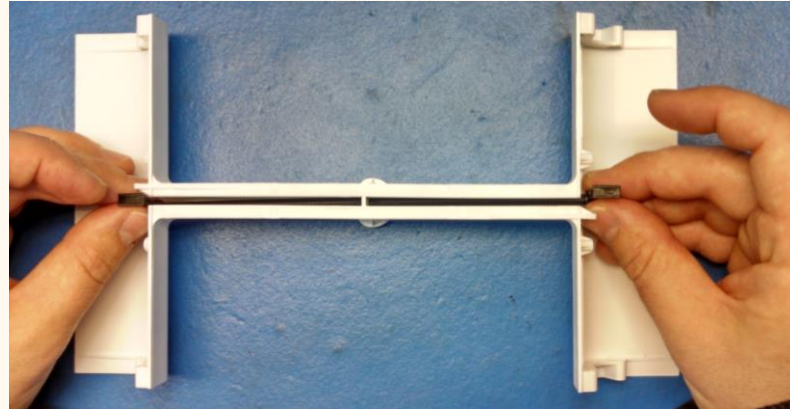
Note: PN 602-00073 is the Bushing Side Screw and PN 602-00085 is the Motor Side Screw.

Take care to thread the Nuts simultaneously so that they start on the same screw thread.

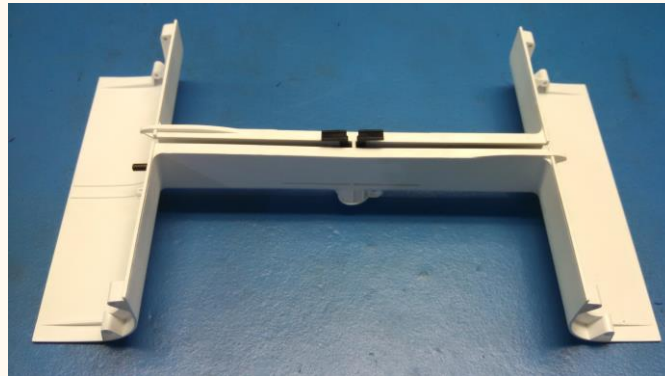


Nut, Bushing Side
(PN 602-00073)

Nut, Motor Side
(PN 602-00085)



Rotate the Lead Screw to thread Nuts onto the Screw



Thread the Nuts all the way to the middle of the screw to check alignment on the screw. The nuts should meet in the center at the same time.

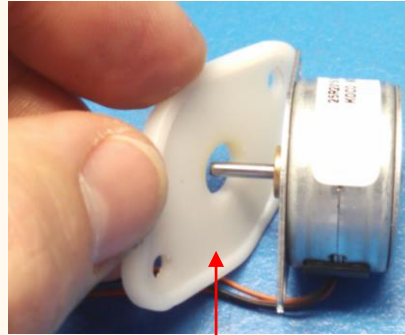
Ecovent Vent Assembly Instructions



Vent Assembly

6. Install Motor Cover Front, PN 602-00086 onto the Motor Stepper, PN 103-00045. Note the orientation. The grooved side of the Motor Cover Front mates flush with the Motor.

Place Rubber washers on screws and insert screws into the motor.



Motor Cover Front
Grooved Side



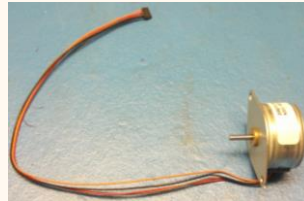
Washer M3 Rubber
(PN 603-00004)



Screw M3x8 Plastite
(PN 603-00005)



Motor Cover Front
(PN 602-00086)



Motor Stepper
(PN 103-00045)

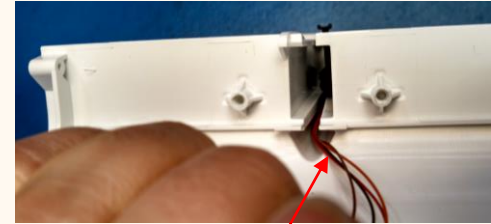
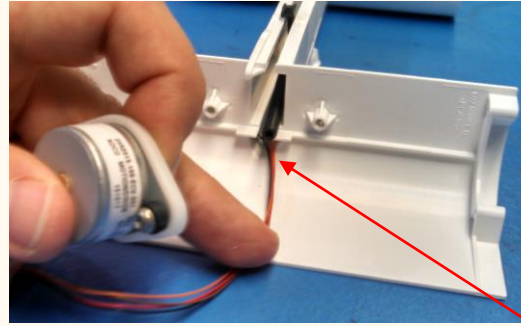


Ecovent Vent Assembly Instructions

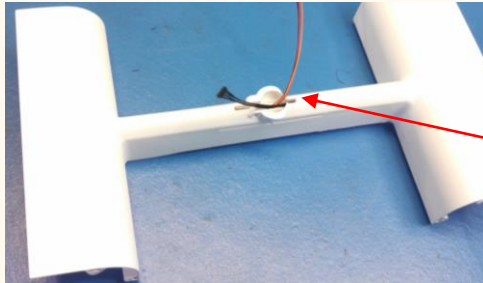


Vent Assembly

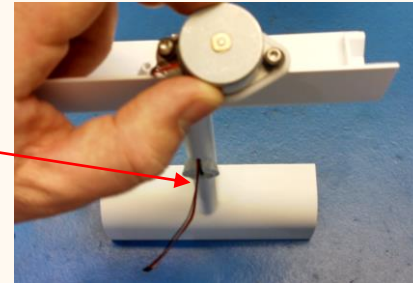
7. Thread the motor power wires through the lower tunnel of the Diffuser Screw Cover. See pictures showing the exit of the Motor Power Cable.



Lower Tunnel



Motor Power Cable Exit Port in
Diffuser Screw Cover

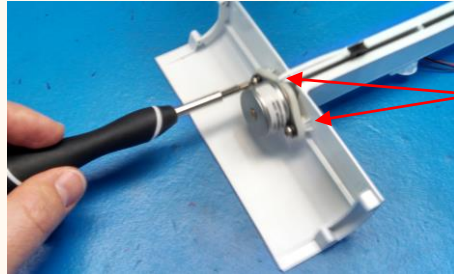
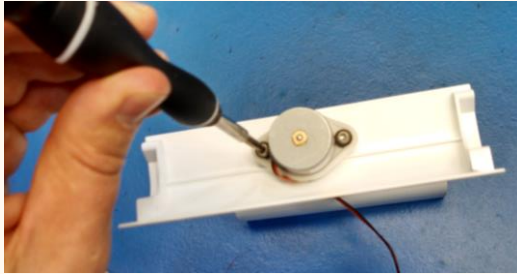


Ecovent Vent Assembly Instructions



Vent Assembly

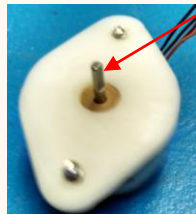
8. Locate the Motor Mount Standoffs on the Diffuser Screw Cover. Torque the Screws, M3x8 Plastite, PN 603-00005, to 45 in-oz (+/- 4 in-oz) with T10 torx driver, 2 places. Torque must be verified and recorded during setup. Refer to torque setup instructions. If the screw begins to rotate freely before the torque setting is met, stop production and contact engineering.



Motor Mount Standoffs on the Diffuser Screw Cover

9. While in the Diffuser Screw Cover, rotate the Lead Screw until it mates with the Key of the Motor Shaft.

Flat Keyed Surface of Motor Shaft



Internal feature in the Lead Screw is Keyed to Motor Shaft



Rotate Lead Screw to Seat on Motor Shaft



Ecovent Vent Assembly Instructions



Vent Assembly

10. Install Rubber Washers, PN 603-00004, qty. 4 and Screws M3x8, PN 603-00005, qty. 2 onto the Bushing PN 602-00055 as shown.



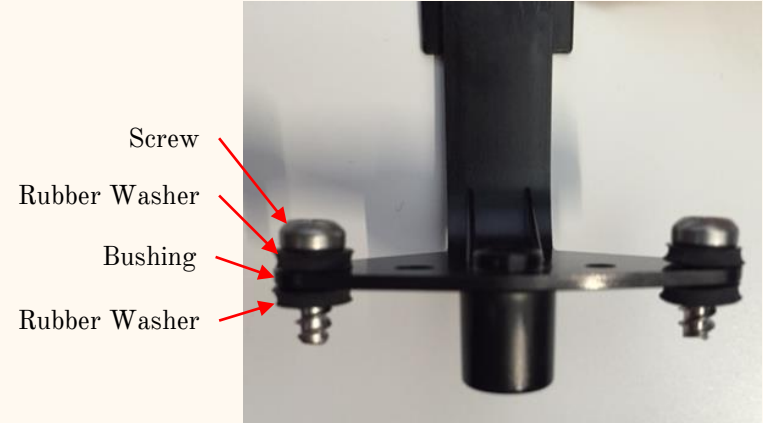
Bushing
(PN 602-00055),
qty. 1



Washer M3 Rubber
(PN 603-00004),
qty. 4



Screw M3x8 Plastite
(PN 603-00005),
qty. 2

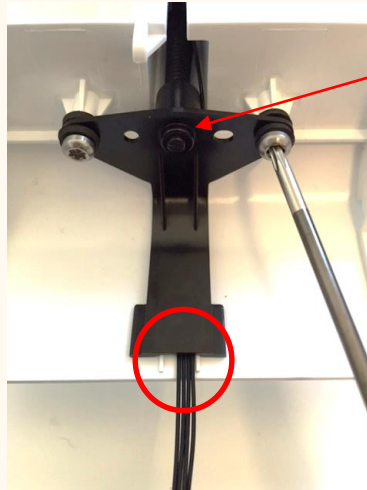


Ecovent Vent Assembly Instructions



Vent Assembly

11. Install the Bushing onto the Diffuser Screw Cover. Torque Screws to 40 in-oz (+/- 4 in-oz) with T10 torx driver, 2 Places. Torque must be verified during setup. Refer to torque setup instructions.
12. If the screw begins to rotate freely before the torque setting is met, stop production and contact engineering.



Note: lead screw should protrude past Bushing

Note: ensure that pressure sensor wires are inside routing tunnel.

Ecovent Vent Assembly Instructions

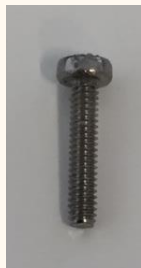


Vent Assembly

Wall & Ceiling Vents Only

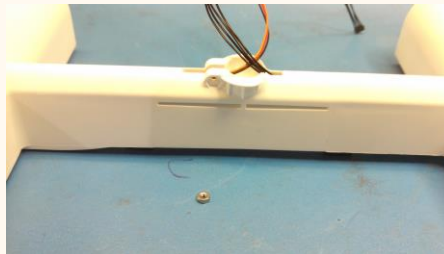
13. Install the Locknut M2 Hex Stainless Steel, PN 603-00018, and Screw M2x10, PN 603-00014 into the Diffuser Screw Cover.

Loosely Tighten the Screw onto the Nut. Ensure the Motor Cable is routed underneath the screw.



Screw M2x10 BH Machine
(PN 603-00014), qty. 1

Locknut M2 Hex Stainless Steel
(PN 603-00018), qty. 1



View from Nut Side
Note hexagonal cutout for Nut

Ecovent Vent Assembly Instructions



Vent Assembly

Wall & Ceiling Vents Only

Part Number	Description
900-00005	Wall Vent, 10x4
900-00011	Ceiling Vent, 10x4
900-00002	Wall Vent, 10x6
900-00008	Ceiling Vent, 10x6
900-00003	Wall Vent, 12x4
900-00013	Ceiling Vent, 12x4
900-00006	Wall Vent, 12x6
900-00015	Ceiling Vent, 12x6

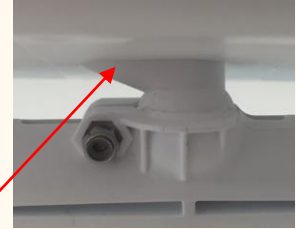
14. Pass the Motor Cable and Pressure Sensor Cable through the Balljoint Faceplate Wall/Ceiling & Faceplate Extension Assembly, as shown.
15. Snap the ball joint into place on the diffuser screw cover.
16. Torque the screw to 25 in-oz (+/- 5 in-oz) using #1 Phillips driver.



Balljoint Faceplate Wall/Ceiling & Faceplate Extension Assembly



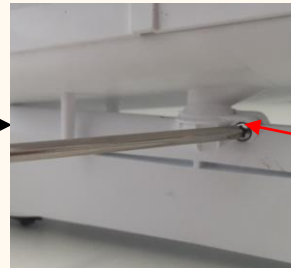
Feed the Motor Power Cable and Pressure Sensor Cable here. Battery PCBA will not be present.



Note: angled side of the mounting feature is oriented over the tightening screw on the Diffuser Screw Cover



Press down gently. The two assemblies will snap into place.



After the ball joint components have snapped together, torque the screw to 25 in-oz (+/- 5 in-oz) using #1 Phillips driver.

Ecovent Vent Assembly Instructions



Vent Assembly

17. Install the Flexible Doors into the Outer Box. Snap Balls at either end of the door into the track on the Outer Box.

Part Description	Door Part Number	Outer Box Part Number
10x6 White	602-00088 WHITE	602-00081 WHITE
12x6 White	602-00113 WHITE	602-00093 WHITE
10x4 White	602-00114 WHITE	602-00104 WHITE
12x4 White	602-00121 WHITE	602-00115 WHITE
10x6 Black	602-00088 BLACK	602-00081 BLACK
10x4 Black	602-00113 BLACK	602-00093 BLACK
12x4 Black	602-00114 BLACK	602-00104 BLACK
12x6 Black	602-00121 BLACK	602-00115 BLACK



Insert the door into the track and feed it in, ensuring all of the balls are in the track



Inspect the assembly to make sure the snap features are in the center and all balls are located in the track

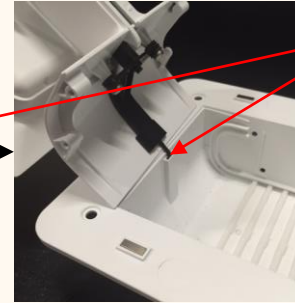
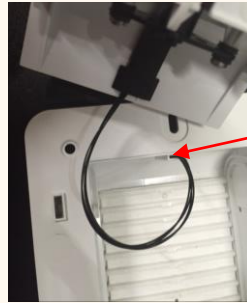
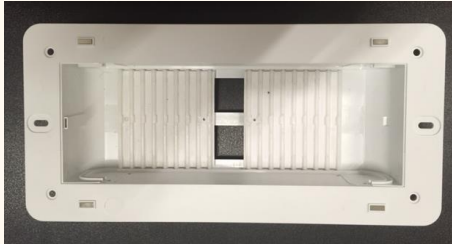


Ecovent Vent Assembly Instructions



Vent Assembly

18. Thread the Pressure Sensor Cable through the Outer Box Cable Way Pull through until Driveshaft edge and Outer Box are in contact.



Pressure Sensor
Cable Way

19. Move the Drive Train Assembly into the Outer Box. Take care not to damage the Pressure Sensor Cable. The Diffuser Screw Cover should seat flush with the Outer Box.



Surfaces must be flush all the way around

Ecovent Vent Assembly Instructions

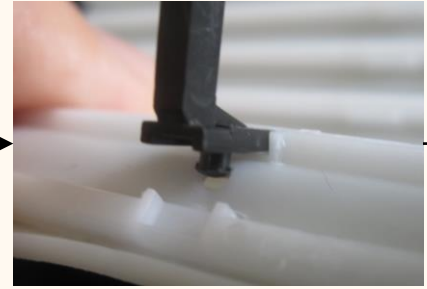


Vent Assembly

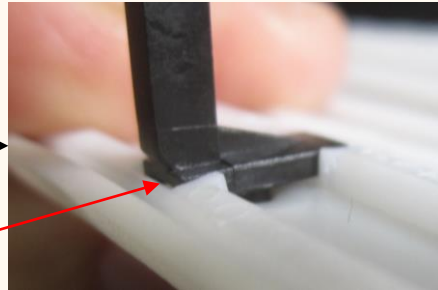
20. Snap the Motor & Bushing Nuts onto the Flexible Doors.

First, insert the Toe into the Nut Mounting feature and then snap in the heel of the Nut.

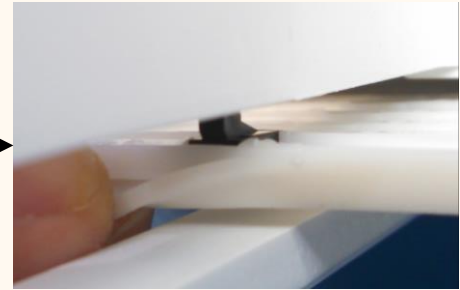
Repeat this operation for both doors.



Snap Nut Toe into the Door Mounting Feature



Snap Nut Heel into the Door Mounting Feature



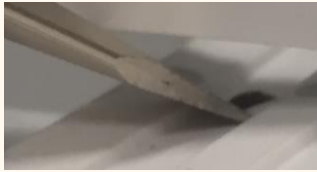
Ecovent Vent Assembly Instructions



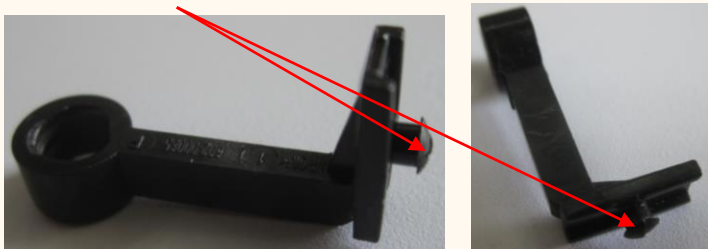
Vent Assembly

From the back side of the vent, make sure the Nut Mushroom is properly installed into the Flexible Door.

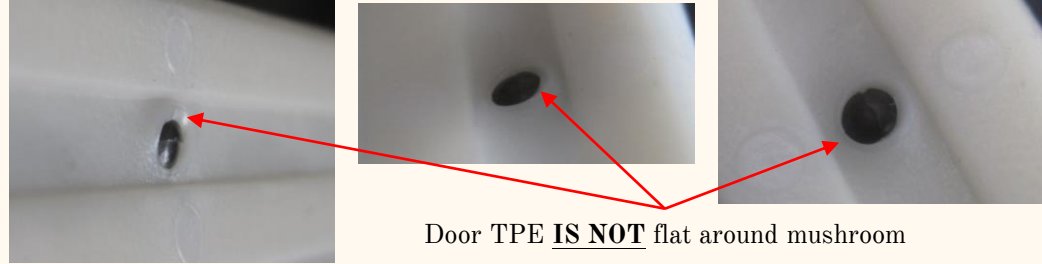
Fold door material around the mushroom feature using flathead screwdriver.



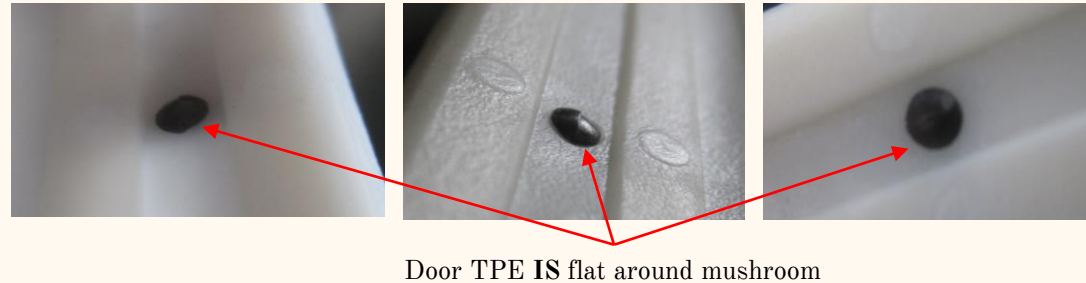
Nut “Mushroom” feature



Examples of Incorrectly Installed Nut “Mushroom” features



Examples of Correctly Installed Nut “Mushroom” features



Vent is ready for mechanical test.

Ecovent Vent Assembly Instructions



Vent Assembly

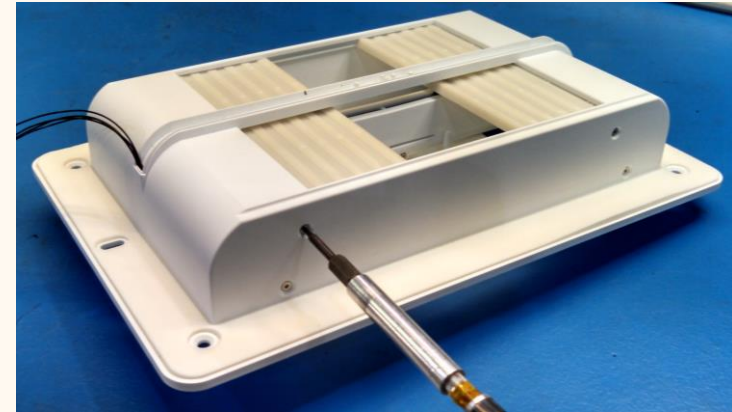
21. Install the side screws PN 603-00019 into the vent. (8 locations, 4 each side). Inspect to ensure that the screw head is fully seated.

Ensure that the screw bosses are aligned with the thru holes in the outer box.

Install the screws to the specified torque of 40 in-oz (+/- 4 in-oz) with T8 torx driver.

Note: If the screw begins to rotate freely before the torque setting is met, stop production and contact engineering.

22. **Mechanically Test the Vent according to the procedure provided. Record all results according to the Test Procedure.**



Ecovent Vent Assembly Instructions



Vent Assembly

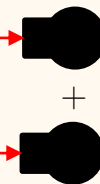
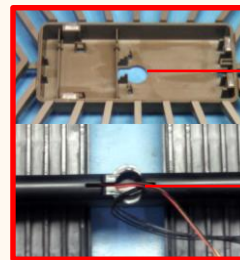
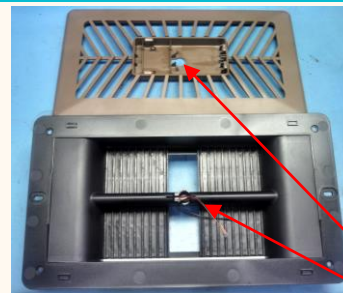
Floor Vents Only

Part Number	Description
900-00012	Floor Vent, 10x4
900-00007	Floor Vent, 10x6
900-00014	Floor Vent, 12x4
900-00009	Floor Vent, 12x6

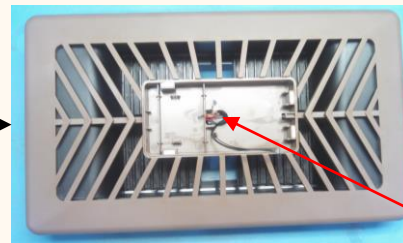
23. Pass the Motor Cable and Pressure Sensor Cable through the Faceplate Floor. Part Numbers provided below. Note the orientation of the drivetrain Balljoint feature to the feature in the Floor Faceplate.

Part Number	Description
602-00135	Faceplate Floor, 10x4
602-00112	Faceplate Floor, 10x6
602-00124	Faceplate Floor, 12x4
602-00103	Faceplate Floor, 12x6

24. Install PN 603-00017 - Screw #6-19x1/4" Thread Forming for Plastic, Qty. 4. Torque to 40 in-oz (+/- 4 in-oz) using T10 torx driver.



Place the Floor Faceplate on top of the Outer Box / Drive Train Assembly. Note the orientation of the features.



Pass the Motor Power Cable and Pressure Sensor Cable here.



Install PN 603-00017 - Screw #6-19x1/4" Thread Forming for Plastic, Qty. 4. Torque to 40 in-oz (+/- 4 in-oz) using T10 torx driver.

Ecovent Vent Assembly Instructions



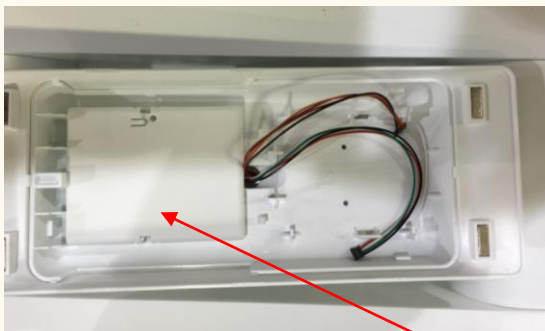
Vent Assembly

25. Place the PCA Cover, PN 602-00078, into the balljoint extension. This will be placed loose on the battery pack side of the assembly. See figures to the right.

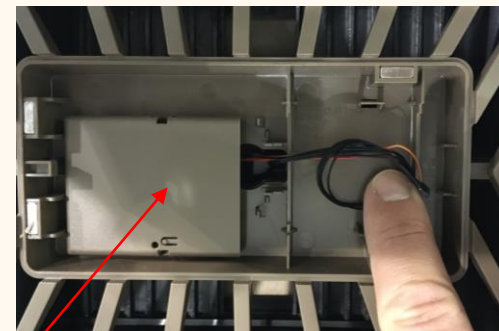


Vent PCB Cover
(PN 602-00078), qty. 1

Wall & Ceiling Vents - Only



Floor Vents - Only



Place Vent PCBA Cover loose in these locations.

Ecovent Vent Assembly Instructions

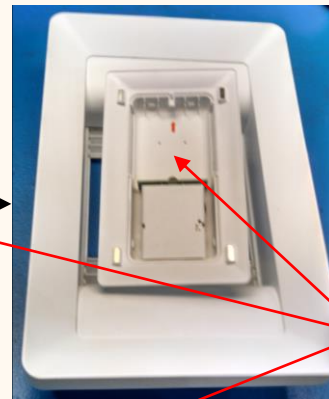
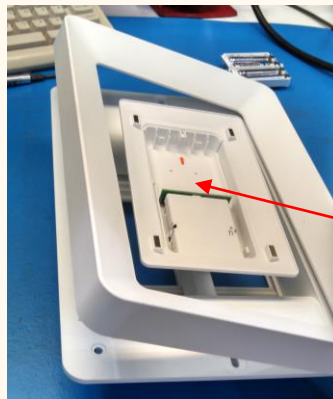


Vent Assembly

Wall & Ceiling Vents Only

26. Install Vent Frame and Faceplate Cover.

The magnetic force will hold these parts onto the vent.



Vent PCBA Cover will actually be placed loose in these locations. See previous page.



Install Faceplate Cover – All Vent Types

Ecovent Vent Assembly Instructions



Vent Assembly

27. Place the Vent Pressure Sensor Cover, PN 602-00082, onto the Outer Box.

Apply Tape, PN 604-00005 (Scotch Film Strapping Tape 8898), to hold the cover in place during shipment.

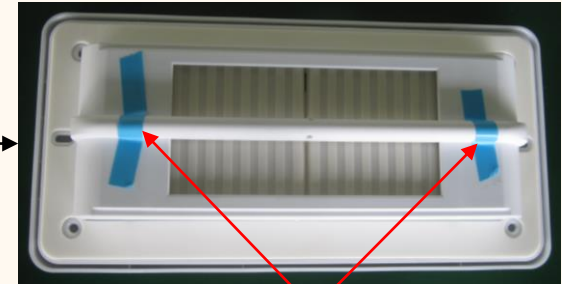
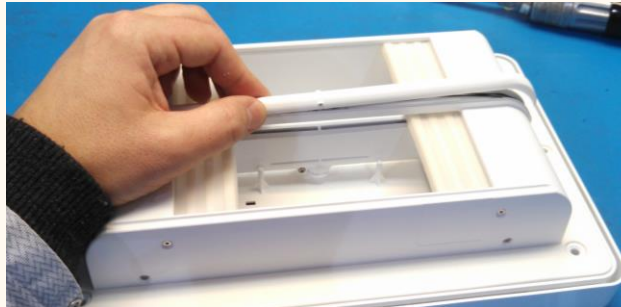
Vent Pressure Sensor Cover,
qty. 1

10 inch
(PN 602-00082)

12 inch
(PN 602-00094)



Vent is ready for packaging.



Apply Tape, 2 Places.

Ecovent Vent Assembly Instructions

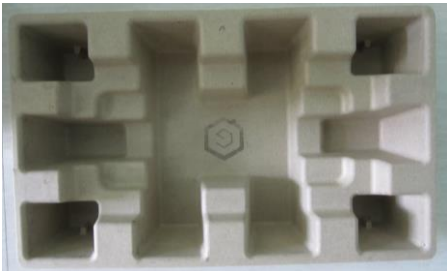


Vent Packaging

TOP



Vent Molded Pulp – Exterior

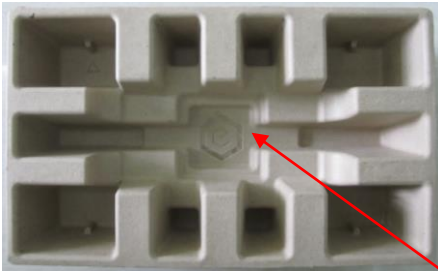


Vent Molded Pulp – Interior

BOTTOM



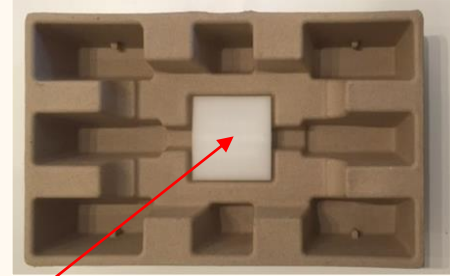
Vent Molded Pulp – Exterior



Vent Molded Pulp – Interior



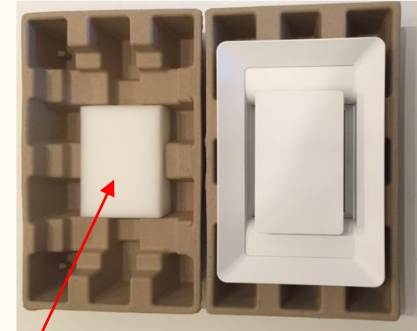
1. Place the Battery Pack in the Vent Molded Pulp – Bottom.



2. Place the Battery Pack Foam over the Battery Pack and press into the space in the Molded Pulp – Bottom



3. Place the Vent in the Vent Molded Pulp – Bottom.



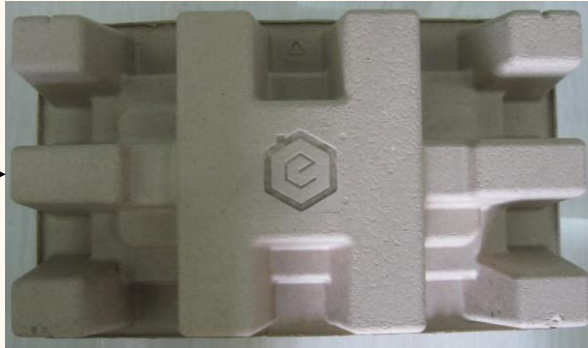
4. Place the vent foam into the Molded Pulp – Top. Make sure it is fully pressed into the packaging.

Note shape of the battery pack

Ecovent Vent Assembly Instructions



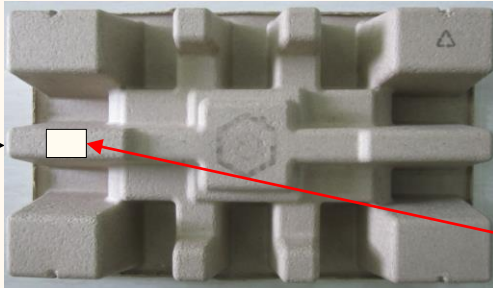
Vent Packaging



Pack this side up in the Master Carton.

5. Place the Molded Pulp – Top with foam onto the Molded Pulp – Bottom with Vent.

6. Apply quantity 2, Rubber Bands, as shown.



Place vent part number & size label here

Vent is Ready for Shipment. Pack 12 Vents to a Master Carton.