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|  | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | |
| Products applicable to | | | | | | | Page | Issue | Page | | Issue | Change History | | Updated |
| |  |  |  | | --- | --- | --- | | ***No*** | ***ITNBR*** | ***ITDSC*** | | 1 | BC3B7F732200 | iXH1220HTXSS 200-230V 50/60Hz SV4 | | 2 | BC4B7F732200 | iXH1820HTXSS 200-230V 50/60Hz SV4 | | 3 | BCDB7F732200 | iXH1220HTXSS 380-480V 50/60Hz SV4 | | 4 | BCEB7F732200 | iXH1820HTXSS 380-480V 50/60Hz SV4 | | 5 | BC4B7F732220 | iXH1820HTXSS 200-230V 50/60Hz SV4 HYX | | 6 | BC3B7H732210 | **iXH1220HTXS 200-230V 50/60Hz SV4 50025241** | | 7 | BC3B7F732202 | iXH1220HTXS XD+ MK2 LV SV3 | | 8 | BCDB7F732202 | iXH1220HTXS XD+ MK2 HV SV3 | | 9 | BC4B7F732202 | iXH1820HTXS XD+ MK2 LV SV3 | | 10 | BCEB7F732202 | iXH1820HTXS XD+ MK2 HV SV3 | | 11 | BC3B7F7322S2 | iXH1220HTXS XD+ MK2 LV SV3 KCCS-S | | 12 | BC4B7F7322S2 | iXH1820HTXS XD+ MK2 LV SV3 KCCS-S | | 13 | BC4B7F7322H2 | iXH1820HTXS XD+ MK2 LV SV3 KCCS-H |   **IMPORTANT**  **ESD WRIST BAND MUST BE WORN WHEN HANDLING GAS MODULE**  Service Note: For service rebuild, as the system is not required to be  stripped completely, please selectively use the ops within this SOP.  For replacement spares or service kit p/ns, please refer to parts  manuals. | | | | | | | **F1**  **H1**  **H2**  **R0**  **R1**  **R2**  **R3**  **R4**  **03**  **05**  **10**  **20**  **30**  **35**  **40**  **50**  **60**  **65**  **70**  **80**  **85**  **90**  **100**  **110**  **120**  **130**  **140**  **145**  **R12**  **R5**  **R6**  **R14**  **150**  **160**  **170**  **180**  **190**  **200**  **210**  **220**  **230** | **15**  **14**  **15**  **15**  **12**  **01**  **12**  **01**  **15**  **03**  **15**  **15**  **15**  **15**  **15**  **15**  **07**  **15**  **15**  **14**  **15**  **15**  **13**  **07**  **15**  **02**  **05**  **15**  **14**  **06**  **14**  **14**  **07**  **13**  **15**  **15**  **11**  **02**  **15**  **07**  **02** | **240**  **250**  **255**  **260**  **270**  **275**  **280**  **290**  **300**  **310**  **320**  **325**  **330**  **335**  **R7**  **R8**  **R9**  **R10**  **R11**  **R12**  **340**  **350**  **360**  **370**  **380**  **390**  **395**  **400**  **410**  **420**  **430**  **440**  **450**  **B1** | | **02**  **02**  **09**  **09**  **09**  **15**  **02**  **09**  **15**  **15**  **02**  **15**  **02**  **15**  **02**  **02**  **02**  **02**  **15**  **15**  **15**  **02**  **02**  **15**  **15**  **02**  **15**  **02**  **10**  **02**  **02**  **15**  **15**  **09** | **Issue 01**  Initial release  **Issue 02**  Except for R1~R5, B1 Page, All pages changed issue number from 1 to 2 due to added variants.  Added 1220 50025241 contents  Pages F1,F2- Modified Issue no. on .respective pages  Pages 10,20,30,40,100,110,130,140,160,180,190,250,280,340,350,370,380  – New parts added symbol for “MK2” contrasted with exsiting parts  (except for TMS & Gas pipe)  Page 30 - OP0050,added image and note  Page 40 – OP0070,changed image  Page 50 – OP0090, added TDK230025  Page 130 – OP0230,chaned image  Page 150 - OP0260,added image and note  Page 190 - OP0320,added HV power loom- K50000095  Page 190 - OP0330,added HV Inverter for DP & MB- D37496575 & D37496555  Page 210 - OP0360,added image for cable tie mounting base  Page 210 - OP0370,added part no.’s H03524846, H03530068, H03530073, M56691037 and H03551524, image and instruction.  Page 220 - OP0380,added image and instructions  Page 230 - OP0400,Removed part no. M66932054, M56691037, H03551524 and changed image.  Page 250 - OP0440,Added part no. M66932054, M56691037, H03551524 and changed image.  Page 280 – OP0470,Added note to check for TMS direction  Page 290 – OP0490,Removed part no.’s H03524846, H03530068, H03530073, M56691037, H03551524 and modified instruction.  Page R6,R7,R8,R9 - Added water system schematic  Page 390 – OP0670/OP0680,changing image.  Page 400 – OP0690, Added note:For 50025241, no ems loom  Page 410 – OP0700,Added & changing image | | 03-Jan-2019  Evan.Kim  27-Mar-2019  Evan.Kim |
| Page | **F1** | Issue | **15** | Approved | |  | | | | | | | SOP TEMPLATE – FRONT SHEET LANDSCAPE v7.doc | |

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|  | | | | | | SOP No. | **SOPKR1663** | | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | |
| Change History | | | | | | | | Updated | | Change History | | Updated |
| **Issue 03**  Page 05 - Added pre-assembly for fitting in heatsink pipes.  R5 – Added photo  R6 – Move photos from R5. / R6~R9 Contents changed R7~R8.  **Issue 04**  Page 30 – Replace screws which are used to assemble exh pipe to SEMS type.  **Issue 05**  F1 Updated to new template.  Replaced F2 with new History page H1.  Added R11 New Symbols template and symbols.  Page140 OP240 Removed high light for “S” added service not “service do not bake heaters”  Page100 OP180 Added I-mark for all 3 terminal block screws.  Page160 OP290 Added I-mark for all 3 terminal block screws.  Reviewed all pages and updated symbols where required to new versions made T symbols clearer where required.  **Issue 06**  Page 150 : OP270 \_ SEMS Screw updated.  Page R5 : Add note to make clear heater cartridge inserting direction  **Issue 07**  Page 60: Changed iteam H03524178 to H03541178  Page 80: Changed iteam H03524847 to H03543847  Page 110: Changed iteam H03524178 to H03541178  Page 210: Changed iteam H03524846 to H03543846  Page 220: Changed iteam H03524846 to H03543846  Page 290: Changed iteam H03524571 to 03543571  Page 150 : OP0270 – SEMS screw updated  **Issue 08**  Page 420: Update picture for cable arrangement  **Issue 09**  Page 180: Update the part number for 1200 & 1800 MB earth cable.  Page 190: Update the part number for 1200 & 1800 MB earth cable  Added page 255 OP0445 Service only added  ” FOR ¼” SS HAM-LET/SWAGELOCK FITTINGS FOR GAS PIPES-A 21Nm TORQUE MUST BE APPLIED TO ALL FITTINGS” | | | | | | | | 26-Jul-2019  Evan Kim  16th-Mar-2020  SooyoungSong  2020/04/21  R Prodger  15th-June-2020  SooyoungSong  2th-July-2020  Peniel  SooyoungSong  8th-Sep-2020  Peniel  22nd-Oct-2020  Eddie  R Prodger | | Page 260 OP450 Added symbols for service-21Nm and i-mark for gas pipes  Page 270 OP460 Added symbols for service-21Nm and i-mark for gas pipes  Page 290 OP500 Added symbols for service-21Nm and i-mark for gas pipes  B1 added 21Nm Torque Wrench-9/16” Spanner Attachment  **Issue 10**  Page 420 OP700 Added picure to clearify the calbe arrangement.  **Issue 11**  Page 180 OP0320: Update the part number for earth cable.  Page 180 OP0330: Update the torque value to 3.5Nm  Page 190 OP0340: Update the part number for earth cable.  **Issue 12**  Page R1 / R3: The colour of I-Mark has been changed from yellow to red.  Page 380 OP0650: The controller (with Cold-Fire Chip) has been introduced.  **Issue 13**  Page F1 / H1: Issue Updated  Page 100 OP0180: Torque value for motor block lid changed from 2.8 Nm to 2Nm.  Page 160 OP0290: Torque value for motor block lid changed from 2.8 Nm to 2Nm.  **Issue 14**  Added R12/R13 Heater block cable routing/  R6 updated for heater block routing  Page 80 Update sintered filter assembly & checks | | 2020/12/03  Eddie Yu  2021/01/21  Eddie Yu  2021/07/27  Darren Na  2021/08/19  Alfiya  2021/12/02  R prodger |
| Page | **H1** | Issue | **14** | Approved |  | | | | | | SOP TEMPLATE – HISTORY SHEET LANDSCAPE v7.doc | |

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|  | | | | | | SOP No. | **SOPKR1663** | | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | |
| Change History | | | | | | | | Updated | | Change History | | Updated |
| **Issue 15**  F1 : Added iXH1220/1820HTXS XD+ variants H2 : Added page for issue details  R0 : Changed from existing R11 page to R0 page  Page 03 : OP0003 : Added new OP used in iXH1220/1820HTXS XD+ variants(Pre fitting in TMS water pipes)  Page 10 : OP0010 : Added new base rail used in iXH1220/1820HTXS XD+ variants and OP0020 : Added new DP used in iXH1220/1820HTXS XD+ variants  Page20 : OP0030 : Added new water pipe used in iXH1220/1820HTXS XD+ variants and OP0040 : Added new insulation jacket used in iXH1220/1820HTXS XD+  Page30 : OP0050 : Added new exhaust pipe used in iXH1220/1820HTXS XD+ variants  Page35 : OP0070 : Moved OP0070 from page40 to page35. / Added new picture used in iXH1220/1820HTXS XD+ variants(Assembling DP thermistor loom)  Page40 : Moved OP0070 to page 35  Page50 : OP0090 : Added new pipe(M61920050) used in iXH1220/1820HTXS XD+ variant  Page65 : OP0120 : Moved OP0120 from page70 to page65. / Added new picture & new TMS water pipes used in iXH1220/1820HTXS XD+ variants  Page70 : Moved OP0120 to page 65  Page80 : OP0150 : Added material H02134000(BOM validation & correction)  Page85 : OP0160 : Moved OP0160 from page90 to page85. / Added new picture & new TMS water pipes used in iXH1220/1820HTXS XD+ variants  Page90 : Moved OP0160 to page 85  Page120 : OP0220 : Added Booster used in iXH1220/1820HTXS XD+ variant  Page 145 : OP0255 : Added new page for booster heatsink used in iXH1220/1820HTXS XD+ variant  Page170 : OP0310 : Added cap (H03524039) used in iXH1220/1820HTXS XD+ variant  Page180 : OP0320 : Add new Low Voltage power loom (K50000085) used in iXH1220/1820HTXS XD+ LV variants  Page210 : OP0370 : Added new pipe(M66932064) used in iXH1220/1820HTXS XD+ variant  Page275 : OP0465 : Added new gas pipes system used in iXH1220/1820HTXS XD+ variants  Page300 : OP0505 : Added new TMS water pipe used in iXH1220/1820HTXS XD+ variants  Page300 : OP0510 : Changed variants code to “1220HTXS 50025241”(SOP validation & correction)  Page310 : OP0530 : Added new TMS water pipe used in iXH1220/1820HTXS XD+ variants  Page325 : OP0545 : Added new TMS water pipe used in iXH1220/1820HTXS XD+ variants  Page335 : OP0563 & OP0567 : Added new TMS water pipe used in iXH1220/1820HTXS XD+ variants | | | | | | | | 2022/11/10  Evan Kim | | Page R11 & R12 : Added new TMS water system schematic used in iXH1220/1820HTXS XD+ variants  Page340 : OP0570 : Added new badge used in iXH1220/1820HTXS XD+  Page370 : OP0630 : Added new Heater module used in iXH1220/1820HTXS XD+  Page380 : OP0650 : Added new Controller used in iXH1220/1820HTXS XD+ variants  Page395 : OP0683 & OP0687 : Added Swivel Clips used in iXH1220/1820HTXS XD+ variants  Page440 : OP0750 : Added voltage label used in iXH1220/1820HTXS XD+ variants  Page450 : OP0770 : Added XCEDE logo used in iXH1220/1820HTXS XD+ variants | |  |
| Page | **H2** | Issue | **15** | Approved |  | | | | | | SOP TEMPLATE – HISTORY SHEET LANDSCAPE v7.doc | |

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|  | | | | | SOP No. | | **SOPKR1663** | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| **SYMBOLS** | | | | | | | | | | | | |
|  | Safety shoes required | | | | | | |  | | Indelibly mark | | |
|  | Check | | | | | | |  | | Loctite | | |
|  | Remove | | | | | | |  | | Turn clockwise | | |
|  | Hazard Heavy object | | | | | | |  | | Fomblin Grease | | |
|  | Hazard Hot surface | | | | | | |  | | Heat transfer compound (HEATSINK) | | |
|  | Hazard Finger trap | | | | | | |  | | Fomblin Oil | | |
|  | Coloured earth | | | | | | |  | | Torque to XXX Nm | | |
|  | Hand assembly/disassembly | | | | | | |  | | Check for damage | | |
|  | Push home | | | | | | |  | | Inspect | | |
|  | Hand tight by tool | | | | | | |  | |  | | |
|  | Correct | | | | | | |  | |  | | |
|  | Incorrect | | | | | | |  | |  | | |
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|  | | | | | | | SOP No. | | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| **M** | **S** | | **Instruction for bolts**  Refer to symbol for marking  심볼을 참조 하시오  **EXAMPLE**  **표기된 곳에만 아이마킹하시오.**  **Apply I-marking to mark**  **Spool과 brace 조립시 사용되는 모든 볼트에 아이마킹하시오.**  **Apply I-marking to all bolts assembled with the Brace and spool.**  **Apply “I” Marking after checking bolts or nuts tightened using hands as shown.**  **볼트나 너트가 잘 조여졌는지 손으로 확인하고 “I” 마킹을 하시오.**    **Apply “I” Markings to 1 point of each stage after checking the tighten component.**  **조임 확인 후 각 부분의 한곳에만 “I” marking을 하시오.**    SERVICE ONLY  PRODUCTION ONLY  **볼트와 결합된 부분에 이어지게 마킹**  **I-Mark the parts assembled with bolts.** | | | | | | | | | |
|  | | | | | | | | | | | | |
| Instruction:   * **Red colour use in Production, Blue colour use in Service.** * **붉은색은 생산, 파란색은 서비스에서 사용.** * **I mark on 1 point of each stage except Spool and brace** * **각 부위 별로 1곳에 마킹(스풀, 브레이스는 제외)** | | | | | | | | | | | | |
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|  | | | | | | | SOP No. | | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| **M** | **S** | | **Instruction for fitting assembly** | | | | | | | | | |
|  | | | | | | | | | | | | |
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|  | | | | | | | SOP No. | | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| **M** | **S** | | **Instruction for N2 fitting and Hybrid water connection** | | | | | | | | | |
| **Use an appropriate No Go gauge to check fittings gap.**  알맞은 No Go 게이지를 사용하여 피팅 틈새를 체크하시오. | | | | | | | | | | | | |
| Instruction:   * **Apply I-markings on fittings after checking gap using No Go gauge as shown.** * **그림과 같이 No Go 게이지를 이용하여 틈새를 확인한 후 “I” 마킹을 적용하시오.** | | | | | | | | | | | | |
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|  | | | | | | | SOP No. | | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| **M** | **S** | | **Instruction for earth looms assembly** | | | | | | | | | |
| **TERMINAL**  **PLAIN WASHER**  **PLAIN WASHER**  **NUT KEPS**  **NUT KEPS**  **NUT KEPS** | | | | | | | | | | | | |
| Instruction:   * **: Apply this instruction to the all operations in which earth looms should be assembled.** * **: 접지 선이 연결 되는 모든 공정에 이 방법을 적용 하시오.** | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | **SOPKR1663** | | | | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0003** | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
|  | | M61920054 | | | |  | | | PIPE ASSY - LOWER HEATSINK | | | | | | 1 |  | H03551520 | |  | | STRAIGHT UNION 8MM-8MM(NORMAL) | | | | 1 |
|  | | M61920052 | | | |  | | | PIPE ASSY - LWR STATOR COOLING | | | | | | 1 |  | H03551524 | |  | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | 1 |
|  | | M61920056 | | | |  | | | PPE ASSY - UPPER HEATSINK | | | | | | 1 |  | H03551523 | |  | | UNION ELBOW 8MM-8MM(NORMAL) | | | | 5 |
|  | | M61920058 | | | |  | | | PIPE ASSY - 3RD STATOR UPPER HS | | | | | | 1 |  |  | |  | |  | | | |  |
|  | | M56451036 | | | |  | | | SINGLE COOLING BLOK SWG | | | | | | 1 |  |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | |  | | |  | |  | |  | |  | |  | |  | |
| Instruction:  : Assemble fitting parts onto ferrule.**(그림과 같이 피팅류를 페럴에 조립하시오.)** | | | | | | | |  | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | **SOPKR1663** | | | | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0005** | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
|  | | M56451030 | | | |  | | | PIPE SWG-PUMP STATOR FEED HYB | | | | | | 1 |  | M57571054 | |  | | PIPE SWG-UPR TO LWR HSINK | | | | 2 |
|  | | M56451034 | | | |  | | | LOWER STATOR COOLING SWG | | | | | | 1 |  | H03551523 | |  | | BODY-UNION ELBOW 8MM-8MM | | | | 6 |
|  | | M56451036 | | | |  | | | SINGLE COOLING BLOCK SWG | | | | | | 1 |  | H03551520 | |  | | BODY-STRAIGHT UNION 8MM-8MM | | | | 2 |
|  | | M56451032 | | | |  | | | UPPER HEATSINK SWG | | | | | | 1 |  |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | |  | | |  | |  | |  | |  | |  | |  | |
| Instruction:  : Assemble fitting parts onto ferrule.**(그림과 같이 피팅류를 페럴에 조립하시오.)** | | | | | | | |  | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0010** | | | | | | | | | | | | | **M** | **S** | | **OP0020** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| **Non XD** | | M66930025 | | | |  | | | BASE RAIL ASSY RHS - 200H | | | | | | 1 | **LV**  **(Non XD)** | | A41261958 | | |  | | G4 200HP S PUMP 7.5KW LV WB | | | | 1 |
| **Non XD** | | M66930026 | | | |  | | | BASE RAIL ASSY LHS - 200H | | | | | | 1 | **HV**  **(Non XD)** | | A41261959 | | |  | | G4 200HP S PUMP 7.5KW HV WB | | | | 1 |
|  | | 218681017 | | | |  | | | M8 X 20 SOC HD SEMS ENP GR12.9 | | | | | | 8 | **LV XD+** | | A41672958 | | |  | | NB G4 200HP S XD PUMP 7.5KW LV WB | | | | 1 |
| **(XD+)** | | M61920025 | | | |  | | | BASE RAIL ASSY RHS - 200H S | | | | | | 1 | **HV XD+** | | A41672959 | | |  | | NB G4 200HP S XD PUMP 7.5KW HV WB | | | | 1 |
| **(XD+)** | | M61920026 | | | |  | | | BASE RAIL ASSY LHS - 200H S | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **TDS01777 사용**  **: 가조립** | | | | | | | | | | | | | | | | **Ensure to check “S” onto the HV & 2nd stators.**  **: HV & 2nd 단Stator의 S를 확인 하시오.** | | | | | | | | | | | |
| Instruction:  : Put Bases onto the blocks of build trolley and adjust level feet.  **: 베이스 레일을 빌드 트롤리에 안착 시킨 후 레벨 풋을 조정하시오.**  : Pre-assemble SEMS bolt onto the bases.**(샘스 볼트를 베이스에 가조립 하시오.)** | | | | | | | | | | | | | | | | Instruction:  : Lift DP module using crane.  **: 크레인을 사용하여DP 를 들어 올리시오.**  Service Note: Service uses standard crane and slings to assist this operation; pump Cartridge Weight 240Kg. | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0030** | | | | | | | | | | | | | **M** | **S** | | **OP0040** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1**(Non XD)** | | M56451030 | | | |  | | | PIPE SWG-PUMP STATOR FEED HYB | | | | | | 1 | **Non XD** | | M66930048 | | |  | | G4 200 DP INSULATION JACKET | | | | 1 |
| 2**(Non XD)** | | M56451034 | | | |  | | | LOWER STATOR COOLING SWG | | | | | | 1 | **XD+** | | M61920062 | | |  | | G4 200HP DP INSULATION JACKET | | | | 1 |
| **(Non XD)** | | H03551520 | | | |  | | | BODY-STRAIGHT UNION 8MM-8MM | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **(Non XD)** | | H03551523 | | | |  | | | UNION ELBOW 8MM-8MM(NORMAL) | | | | | | 3 |  | |  | | |  | |  | | | |  |
| 3**(XD+)** | | M61920052 | | | |  | | | PIPE ASSY - LWR STATOR COOLING | | | | | |  |  | |  | | |  | |  | | | |  |
| 4**(XD+)** | | M61920054 | | | |  | | | PIPE ASSY - LOWER HEATSINK | | | | | |  |  | |  | | |  | |  | | | |  |
|  | | 218681016 | | | |  | | | M6X25 SOC HD SEMS | | | | | | 16 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **17Nm**  **3**  **4**  MK2 XD+  MK2 Non XD+  **1**  **2** | | | | | | | | | | | | | | | | Non XD  XD+ | | | | | | | | | | | |
| Instruction:  : Assemble pipe onto the DP.(17Nm)  **: 파이프를 DP에 조립 하시오.(17Nm)**  : Assemble ferrule onto the pipes if there is no ferrule assembly on the pipes**(패럴이 파이프에 안물려져 있으면 물리시오.)**  : Assemble fitting parts onto ferrule.**(그림과 같이 피팅류를 페럴에 조립하시오.)** | | | | | | | | | | | | | | | | Instruction:  : Fit DP Insulation jacket as shown.  **: 그림과 같이 자켓을 씌우시오.** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0050** | | | | | | | | | | | | | **M** | **S** | | **OP0060** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| **STD** | | **M66934040** | | | |  | | | **EXH SYS SPLIT HEAT ASSY** | | | | | | 1 |  | | A24801037 | | |  | | AV MOUNT - ELASTOMER | | | | 4 |
| **HYNIX** | | **M66933040** | | | |  | | | **EXH SYS SPLIT HEATED S ASSY HYX** | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **50025241** | | **M64924040** | | | |  | | | **EXH SYS HEATED S ASSY 50025241** | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **XD+** | | M61924040 | | | |  | | | EXH ASSY 200DP S XD PLAIN | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **XD+ Hynix** | | M66933040 | | | |  | | | EXH SYS SPLIT HEATED S ASSY HYX | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | H02115009 | | | |  | | | METAL O'RING 31.85ID X 2.38SEC | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218681016 | | | |  | | | M6X25 SOC HD SEMS ENP GR12.9 | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218681015 | | | |  | | | M8 X 30 SOC HD SEMS ENP GR12.9 | | | | | | 4 |  | |  | | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| TDS017755 사용  **17Nm**  **Ensure to assemble loom for MK2 exhaust pipe.**  **룸이 조립되었는지 확인**  **30Nm**  **17Nm** | | | | | | | | | | | | | | | | **20Nm** | | | | | | | | | | | |
| Instruction:  : Fit Metal O’ring into the groove and assemble Exh pipe.(30Nm)  **: 메탈 오링을 끼운 후 Exh 파이프를 조립 하시오.(30Nm)**  :Assemble Exh pipe bracket using TDS017755.(17Nm)  **: TDS017755를 사용하여 Exh 파이프 브라켓을 조립하시오.(17Nm)** | | | | | | | | | | | | | | | | Instruction:  : After applying loctite 222 to AV Mount thread, assemble AV mount onto the DP  as shown.(20Nm)  **: 록타이트222를 적용한 뒤 그림과 같이 AV mount를 DP 에 20Nm로 조립 하시오.** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0070** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
|  | | K50003003 | | | |  | | | LOOM TMS DP 3 THERMISTOR 6W RECEPT AMP | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | 218231288 | | | |  | | | M4X10 SOC HD SCR | | | | | | 2 |  | |  | |  | |  | | | |  |
|  | | 218986607 | | | |  | | | WASHER SP INT SS M4 | | | | | | 2 |  | |  | |  | |  | | | |  |
|  | | 218231328 | | | |  | | | M5X10 S/K H/D CAP SCREW SS | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | 218984008 | | | |  | | | WASHER SP INT MS NI M5 | | | | | | 1 |  | |  | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | | End cover | |  | |  | | |  | |  | |  | |  | |
| Instruction:  : Fit S/P washer to all screws. **(S/P 와셔를 모든 스크류에 끼우시오.)**  : Apply HTC onto the threads of each screws. **(HTC를 스크류에 적용 하시오.)**  : Assemble Thermistor loom to the assigned points as shown.  **:그림과 같이 써미스터 룸을 지정 된 위치에 조립 하시오.** | | | | | | | | End cover    Common    MK2 Non XD+  MK2 XD+  Common | | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0000** | | | | | | | | | | | | | **M** | **S** | | **OP0080** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | |  | | | | | |  | 1 | | 218960211 | | |  | | NUT FULL MS NI M10 | | | | 4 |
|  | |  | | | |  | | |  | | | | | |  | 2 | | 218982811 | | |  | | WASHER SPRING NI M6 | | | | 4 |
|  | |  | | | |  | | |  | | | | | |  | 3 | | 218980211 | | |  | | WASHER PLAIN MS NI M10 | | | | 4 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **BLANK** | | | | | | | | | | | | | | | | **Ensure to tighten Nut with No.2 / 3 washers on the 4 points**  **: 조립 시 반드시 No.1/2/3을 함께 사용 하시오.** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction:  :Download DP onto baserail.**( DP를 baserail에 내리시오)**  : Fit the DP onto the Bases and tighten nuts.(20Nm)  **: DP를 베이스레일에 올린 후 너트를 20Nm로 조이시오.** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0090** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | H03537450 | | | |  | | | NUT&FERRULE SET 8M TUBE SS | | | | | | 6 |  | |  | |  | |  | | | |  |
| 2 | | H03551523 | | | |  | | | UNION ELBOW 8MM-8MM(NORMAL) | | | | | | 3 |  | |  | |  | |  | | | |  |
| 3 | | H03551520 | | | |  | | | STRAIGHT UNION 8MM-8MM(NORMAL) | | | | | | 2 |  | |  | |  | |  | | | |  |
| 4 | | M66932060 | | | |  | | | PIPE SWG- DP MOTOR FEED | | | | | | 1 |  | |  | |  | |  | | | |  |
| **5**  **(Non XD)** | | M66932058 | | | |  | | | PIPE SWG-200H DP EC - GB OUT | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | |  | |  | |  | | | |  |
| **6(XD+)** | | M61920050 | | | |  | | | PIPE SWG-200H DP EC - GB OUT | | | | | | 1 |  | |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| Instruction:  : Swage stubs with nut & ferrules (Modules-DP)  **: DP의 스터브를 스웨징 하시오.**  : Pre-swage 6 stubs come from DP.  : **DP의 파이프를 그림과 같이 스웨징 하시오.**  : Assemble fitting parts onto ferrule.  :**그림과 같이 피팅류를 페럴에 조립하시오.**  :Assemble pipe(M66932060) using TDK230025.  **: TDK230025를 사용하여 파이프(M66932060)를 조립하시오.** | | | | | | | | **TDK230025 사용/**  **Use TDK230025**  **2**    **1**  **4**    **5/6**  **A. TMS pipe를 가조립하고 JIG를 댄다.**  **(After pre-assemblying TMS pipe, put JIG on the pipe.)**  **B. JIG를 모터 eyebolt체결하는 부분에 맞추고 너브볼트를 체결한다.**  **(Adjust this JIG on eyebolt point. And, assemble the nerve bolt.)**  **C. 클립을 그림과 같이 체결하고 TMS pipe를 완조립한다.**  **(After assembly clip as shown, complete TMS pipe assembly**  **1**  **2**  **3**  **1** | | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0100** | | | | | | | | | | | | | **M** | **S** | | **OP0110** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | H03541178 | | | |  | | | M CONN 1/4 TUBE-1/8BSPT BODY | | | | | | 5 | **DP** | | H11312030 | | |  | | FOMBLIN DRYNERT 25/6 250KG | | | |  |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **1**  **5**  **4**  **3**  **1** | | | | | | | | | | | | | | | | **1) PRIME MOTOR 300ml (Fill Slowly)**  **GEAR COVER**  **155ml (approx)**  **END COVER**  **GEAR COVER (LV)**  **FILL TO MAX LEVEL:**  **525ml (approx)** | | | | | | | | | | | |
| Instruction:  : Apply PTFE onto the thread of each fittings and fit them to the stators.  **: 피팅에 PTFE 테이프 적용 후 스테이터에 조립 하시오.** | | | | | | | | | | | | | | | | Instruction:  : Remove oil plugs from gear and end cover.  : Fill oil until oil level is at Max on sight glass and fix oil plugs by 30Nm.  **: 오일플러그 제거한 뒤 그림과 같이 오일을 MAX까지 보충하고 30Nm의 토크로 오일 플러그를 조립하시오. (300ml 부분은 천천히 주입하시오)** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0120** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1**(Non XD)** | | M56451036 | | | |  | | | SINGLE COOLING BLOCK SWG | | | | | | 1 | 3**(XD+)** | | M56451036 | |  | | SINGLE COOLING BLOK SWG | | | |  |
| 2**(Non XD)** | | M56451032 | | | |  | | | UPPER HEATSINK SWG | | | | | | 1 | 4**(XD+)** | | M61920058  M61920056 | |  | | PIPE ASSY - 3RD STATOR UPPER HS | | | |  |
| **(Non XD)** | | H03551523 | | | |  | | | UNION ELBOW 8MM-8MM(NORMAL) | | | | | | 1 | 5(**XD+)** | | M61920056 | |  | | PPE ASSY - UPPER HEATSINK | | | |  |
| **(Non XD)** | | H03551520 | | | |  | | | STRAIGHT UNION 8MM-8MM(NORMAL) | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | 218681016 | | | |  | | | M6X25 SOC HD SEMS ENP GR12.9 | | | | | | 12 |  | |  | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| Instruction:  : Assemble Heatsink assy onto the DP as 17Nm. **(히트싱크를 DP위에 17Nm로 조립 하시오.)**  : Assemble fitting parts onto ferrule.**(그림과 같이 피팅류를 페럴에 조립하시오.)** | | | | | | | | MK2 XD+  MK2 Non XD+  **4**  **5**  **1**  **2**    **3**  **17Nm** | | | | | | | | | | | | | | | | | | |
| Page | | **65** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0000** | | | | | | | | | | | | | **M** | **S** | | **OP0130** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **BLANK** | | | | | | | | | | | | | | | | **Re-use the Screws: Screw 재사용 할 것.** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction:  : Remove Cover and Filter from DP. **(커버 와 필터를 제거 하시오.)**  : Do not dispose of Screws which will be used in the next operation.  **: 다음 공정에서 사용 되기 때문에 스크류는 버리지 마시오.** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0140** | | | | | | | | | | | | | **M** | **S** | | **OP0150** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | H03543847 | | | |  | | | 1-4" BSPP BODY BDY ONLY | | | | | | 1 | 1 | | H02134000 | | |  | | O-RING FKM HP 44.5ID X 2.4SEC | | | | 1 |
| 2 | | H02104032 | | | |  | | | DOWTY BONDED SEAL | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 3 | | M56205044 | | | |  | | | FILTER COVER PLATE 100C | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 4 | | H02122037 | | | |  | | | O RING E1M80 E2M80 | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 5 | | M56205043 | | | |  | | | FILTER HOLDER 100C | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 6 | | H02122033 | | | |  | | | O’RING VIT 11.6IDX2.4 | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 7 | | A22305002 | | | |  | | | SINTERED FILTER 6.6 DIA | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **1**  **2**  **7**  **6**  **5**  **4**  **3** | | | | | | | | | | | | | | | | **1** | | | | | | | | | | | |
| Instruction:  : Assemble No.1~7 parts together.  **: 1~7번 파트를 그림과 같이 함께 조립 하시오.**  : Apply grease on part 6.  **: 부품 6에 그리스를 바릅니다.** | | | | | | | | | | | | | | | | Instruction:  : Fit O’ring into the groove of module. (오링을 DP 홈에 끼우시오.)  : Fit the Filter assy which was assemble in the OP0130 into the headplate and tighten 4 screws.(10Nm)  : OP0130에서 조립 된 필터를 헤드플레이트에 끼워 넣은 후 4개의 스크류를 10Nm로 조이시오. | | | | | | | | | | | |
| Page | | **80** | | Issue | | **14** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0160** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1**(Non XD)** | | M57571054 | | | |  | | | PIPE SWG-UPR TO LWR HSINK | | | | | | 2 | 2**(XD+)** | | M61920060 | |  | | PIPE - 3 RD UPR TO OUT | | | | 1 |
| **(Non XD)** | | H03551523 | | | |  | | | BODY-UNION ELBOW 8MM-8MM | | | | | | 2 |  | |  | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| Instruction:  : Assemble the TMS Pipe as shown.  **: 파이프를 그림과 같이 조립 하시오.**  : Assemble fitting parts onto ferrule.  **: 그림과 같이 피팅류를 페럴에 조립하시오.** | | | | | | | | MK2 Non XD+  MK2 XD+    **1**  **1**  **2** | | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0000** | | | | | | | | | | | | | **M** | **S** | | **OP0170** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | |  | | | | | |  |  | | A27903026 | | |  | | THERMAL SNAP SWITCH | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  |  | | 218430257 | | |  | | M3 X 4 SELF TAPPING SCR | | | | 2 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **BLANK** | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction:  : Apply HTC onto the Thermal sanp switch and assemble it onto the DP motor.  **: 스위치에 HTC적용 후 DP모터에 조립 하시오.** | | | | | | | | | | | |
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| **M** | **S** | | **OP0180** | | | | | | | | | | | | | **M** | **S** | | **OP0000** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | K50000170 | | | |  | | | LOOM DP 3PH MOTOR/INVERTER G4 | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | A25908414 | | | |  | | | CONN MOTOR BLOCK LID | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218680023 | | | |  | | | M5X12 POZI HD SEMS | | | | | | 6 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **2 Nm**  **MK2**  **Ensure that wires are held in the grooves as shown.**  그림과 같이 전선이 홈에 정확히 고정되었는지 확인하시오. | | | | | | | | | | | | | | | | **BLANK** | | | | | | | | | | | |
| Instruction:  : Assemble Loom to the DP motor block. (2.8Nm) / **DP모터 블록에 룸을 2.8Nm로 조립 하시오.**  : Assemble the Lid to the motor block. (2Nm) / **커버를 2 Nm로 조립 하시오.** | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Page | | **100** | | Issue | | **13** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0190** | | | | | | | | | | | | | **M** | **S** | | **OP0200** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| **1820** | | M56430088 | | | |  | | | 1820HP SUPPORT SPOOL Assembly PK1 | | | | | | 1 |  | | M66930085 | | |  | | SUPPORT BRACE PAINTED MACHINED | | | | 1 |
| **1220** | | M56420088 | | | |  | | | 1220HP SUPPORT SPOOL ASSY | | | | | | 1 |  | | 218181578 | | |  | | M16x50 HE HD SCREW | | | | 2 |
|  | | H02134012 | | | |  | | | ORING VIT9830 80.0ID X 2.4SEC | | | | | | 1 |  | | 218980214 | | |  | | M16 PLAIN WASHER | | | | 2 |
|  | | 218681018 | | | |  | | | M10X30 SOC HD SEMS ENP GR12.9 | | | | | | 4 |  | | 218982814 | | |  | | M16 SPRING WASHER | | | | 2 |
|  | | H03541178 | | | |  | | | M CONN 1/4 TUBE-1/8BSPT BODY | | | | | | 1 |  | | M66930039 | | |  | | SUPPORT BRACE BRACKET | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  |  | | 218681015 | | |  | | M8 X 30 SOC HD SEMS ENP GR12.9 | | | | 2 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| H03541178  8 | | | | | | | | | | | | | | | | **MK2**  **MK2** | | | | | | | | | | | |
| Instruction:  : Assemble spool onto the DP.(30Nm)  **: 스풀을 그림과 같이 DP에 30Nm로 조립하시오.**  : Apply PTFE onto the thread of fitting and fit it to the spool.  **: 피팅에 PTFE 테이프 적용 후 스풀에 조립 하시오** | | | | | | | | | | | | | | | | Instruction:  : Assemble bracket onto the brace.(30Nm)  **: 브라켓을 그림과 같이 브레이스에 30Nm로 조립하시오.**  : Assemble Brace onto the DP.( 30Nm)  **: 브레이스를 그림과 같이 DP에 30Nm로 조립 하시오.** | | | | | | | | | | | |
| Page | | **110** | | Issue | | **07** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0210** | | | | | | | | | | | | | **M** | **S** | | **OP0220** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | A22304116 | | | | A22304716 | | | STATIC FILTER ASSY 100 CRS G4 | | | | | | 2 | **LV** | | A42620958 | | |  | | NB G4 1200 BOOSTER 4.5KW LV WB | | | | 1 |
|  | | A41200054 | | | | A41200054 | | | STATIC FILTER COVER PLATE Pk.1 | | | | | | 2 | **LV** | | A42621958 | | |  | | NB G4 1800 BOOSTER 4.5KW LV WB | | | | 1 |
|  | | H02134000 | | | | A41200816 | | | O-RING FKM HP 44.5ID X 2.4SEC | | | | | | 2 | **HV** | | A42620959 | | |  | | NB G4 1200 BOOSTER 4.5KW HV WB | | | | 1 |
|  | | 27522-046 | | | |  | | | M6X16SOC HD CAP SCREW ENP. 100C | | | | | | 8 | **HV** | | A42621959 | | |  | | NB G4 1800 BOOSTER 4.5KW HV WB | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **1**  **2**  **x4**  **3** (HV head plate) | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Assemble Static Filter & O-Ring and Cover Plate on Booster Pump.  **: 부스터 펌프에 스테틱 필터와 오링 및 커버 플레이트를 조립하시오** | | | | | | | | | | | | | | | | Instruction:  : Lift MB module using crane.  **: 크레인을 사용하여MB 를 들어 올리시오.** | | | | | | | | | | | |
| Page | | **120** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0230** | | | | | | | | | | | | | **M** | **S** | | **OP0000** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | K50003002 | | | |  | | | LOOM TMS MB 2 THERMISTOR 4W RECEPT AMP | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218231288 | | | |  | | | M4 X 10 SOC HD CAP ST.STL. | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218986607 | | | |  | | | WASHER SP INT SS M4 | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218231328 | | | |  | | | M5X10 SOC HD SCREW | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218984008 | | | |  | | | WASHER SP INT MS NI M5 | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **MK2**  **MK2**  참조(Reference)  **Ensure to fit S/P washers to each screws.**  **: 반드시 S/P 와셔를 적용 하시오.** | | | | | | | | | | | | | | | | **BLANK** | | | | | | | | | | | |
| Instruction:  : Assemble Thermistor loom to the MB.  **: 써미스터 룸을 부스터에 조립 하시오.** | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **130** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0240** | | | | | | | | | | | | | **M** | **S** | | **OP0250** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| **1820** | | M66932078 | | | |  | | | HEATSINK SWG-1800MB SS | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1820** | | M66932079 | | | |  | | | iXH1820HTXSS HEATED BOOSTER ASSY | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1220** | | M66922060 | | | |  | | | HEATSINK SWG-1200MB SS | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1220** | | M66922079 | | | |  | | | 1200 HEATED BOOSTER HT KIT | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| Block  **MK2**  Baked 1 hours  Gasket  Heatsink | | | | | | | | | | | | | | | | **1820**  **1220**  **Block**  **모양 및 방향확인**  **Check these block for shape and direction** | | | | | | | | | | | |
| Instruction:  : Use heated booster kit before baked 1hours and ready for parts like below picture.  **: heated booster kit는 1시간 구운 것을 사용 하시고, 위 그림과 같이 파트를 준비하시오.**  **:Service Note: Service not required to Bake Heaters** | | | | | | | | | | | | | | | | Instruction:  : Assemble Heated MB Kit and Heatsink Assy onto the MB referring to R5 page.  **: R2 페이지를 참고하여 부스터 히터 키트와 히트싱크를 17Nm로 조립하시오..** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0255** | | | | | | | | | | | | | **M** | **S** | | **OP0000** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | M60920068 | | | |  | | | HEATSINK ASSY-MB ECOVER | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | H03551523 | | | |  | | | UNION ELBOW 8MM-8MM(NORMAL) | | | | | | 2 |  | |  | | |  | |  | | | |  |
|  | | 218681016 | | | |  | | | M6X25 SOC HD SEMS | | | | | | 2 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | | | | | | | | | | | | | **BLANK** | | | | | | | | | | | |
| Instruction:  : Assemble Heatsink assy onto the MB as 17Nm. **(히트싱크를MB위에 17Nm로 조립 하시오.)**  : Assemble fitting parts onto ferrule.**(그림과 같이 피팅류를 페럴에 조립하시오.)** | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **145** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | SOP No. | | **SOPKR1663** | | Title: | | **iXH1220 & 1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | |
| **M** | **S** | | **Instruction for Heated booster cable routing** | | | | | | | | | | | | | | | | | | |
|  | | | | |  | | |  | | |  | |  | |  | |  |  |  | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS XD+ | | 1820HTXS XD+ | 1220HTXS XD+ | 1820HTXS XD+ | | 1820HTXS XD+ Hynix |
|  | | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * **Ensure Heater cables are routed down the side of the MB and under. Cables must not be routed over the top of the MB.** * **히터 케이블을 MB 옆으로 빼서 밑으로 가도록 작업 하세요. 케이블이 MB 위로 지나가지 않도록 유의 하세요.** | | | | | | | | | | | | | | | | | | | | | |
| Page | | **R12** | | Issue | | **14** | Approved | |  | | | | | | | | | | | SOP TEMPLATE – SINGLE LANSCAPE v6.doc | |

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|  | | | | | | SOP No. | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| 히터 조립방향  왼쪽 도면은 히터모듈과 히터 카트리지 배선 방법을 보여주기 위한 것 입니다.  케이블은 엔드커버 쪽으로 빼서 정리 하십시오.  4  1  3  2  Heated Thermistor  Loom  4  3  2  1  Heated Exhaust  Loom  Heater Module  Loom  Booster Drive  Loom  Booster Drive  Loom  PL1  PL2  Exhaust  Exhaust  PL1  PL2 | | | | | | | | | | |
| Page | **R5** | Issue | **06** | Approved |  | | | | | SOP TEMPLATE – BLANK LANDSCAPE v4.doc |

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|  | | | | | | SOP No. | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| **1220HTXS**  Exhaust  PL1  PL2 | | | | | | | | | | |
| Page | **R6** | Issue | **14** | Approved |  | | | | | SOP TEMPLATE – BLANK LANDSCAPE v4.doc |

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|  | | | | | | SOP No. | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| **1820HTXS**  Exhaust  PL1  PL2 | | | | | | | | | | |
| Page | **R14** | Issue | **14** | Approved |  | | | | | SOP TEMPLATE – BLANK LANDSCAPE v4.doc |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0260** | | | | | | | | | | | | | **M** | **S** | | **OP0270** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| **1820** | | M56363025 | | | |  | | | G4 1800 BOOSTER STATOR JACKET Pk1 | | | | | | 1 |  | | H02134113 | | |  | | ORING VIT9830 110.5ID X 5.3SEC | | | | 1 |
| **1220** | | M56253025 | | | |  | | | G4 1200 BOOSTER STATOR JACKET Pk1 | | | | | | 1 |  | | 218681057 | | |  | | SCR SHCS SEMS M10X45 Ni G12.9 | | | | 2 |
|  | |  | | | |  | | |  | | | | | |  | **1820** | | 218681015 | | |  | | M8 X 30 SOC HD SEMS ENP GR12.9 | | | | 8 |
|  | |  | | | |  | | |  | | | | | |  | **1220** | | 218681015 | | |  | | M8 X 30 SOC HD SEMS ENP GR12.9 | | | | 6 |
|  | |  | | | |  | | |  | | | | | |  | **1220** | | 218681056 | | |  | | SCR HEX HD SEMS M8X30 Ni G8.8 | | | | 2 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **1820**  **1220**  **Snap Switch Location**  **스냅스위치 방향**  **Heated Booster Kit Loom Location**  **히티드 부스터 킷 룸 방향** | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Fit Insulation Jacket onto the MB.  **: 부스터에 자켓을 그림과 같이 조립 하시오.** | | | | | | | | | | | | | | | | Instruction:  :Fit the O’ring into the groove of support spool.  **:스풀의 홈에 오링을 끼우시오.**  : Assemble the MB onto the spool and brace. (30Nm)  **: 스풀과 브레이스위에 부스터를 30Nm로 조립 하시오.** | | | | | | | | | | | |
| Page | | **150** | | Issue | | **07** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0280** | | | | | | | | | | | | | **M** | **S** | | **OP0290** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | A27903026 | | | |  | | | THERMAL SNAP SWITCH | | | | | | 1 |  | | K50000180 | | |  | | LOOM MB 3PH MOTOR/INVERTER G4 Pk1 | | | | 1 |
|  | | 218430257 | | | |  | | | M3 X 4 SELF TAPPING SCR | | | | | | 2 |  | | A25908414 | | |  | | CONN MOTOR BLOCK LID | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  |  | | 218680023 | | |  | | M5X12 POZI HD SEMS | | | | 6 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | | | | | | | | | | | | | **2 Nm**  **MK2**  **Ensure that wires are held in the grooves as shown.**  그림과 같이 전선이 홈에 정확히 고정되었는지 확인하시오. | | | | | | | | | | | |
| Instruction:  : Apply HTC onto the Thermal sanp switch and assemble it onto the MB motor.  **: 스위치에 HTC적용 후 MB모터에 조립 하시오.** | | | | | | | | | | | | | | | | Instruction:  : Assemble Loom to the MB motor block (2.8Nm) .  : **MB 모터 블록에 룸을 2.8Nm로 조립 하시오.**  : Assemble the Lid to the motor block (2Nm) .  : **커버를 2Nm로 조립 하시오.** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0300** | | | | | | | | | | | | | **M** | **S** | | **OP0310** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| **MB** | | H11312021 | | | |  | | | FOMBLIN DRYNERT 25/6 | | | | | | 1 |  | | H03537450 | | |  | | NUT&FERRULE SET 8M TUBE SS | | | | 6 |
|  | |  | | | |  | | |  | | | | | |  | **(Non XD)** | | H03551523 | | |  | | UNION ELBOW 8MM-8MM(NORMAL) | | | | 4 |
|  | |  | | | |  | | |  | | | | | |  | **(Non XD)** | | H03551520 | | |  | | STRAIGHT UNION 8MM-8MM(NORMAL) | | | | 2 |
|  | |  | | | |  | | |  | | | | | |  | **1220** | | H02134113 | | |  | | ORING VIT9830 110.5ID X 5.3SEC | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | **1820** | | H02134010 | | |  | | ORING VIT9830 158.1ID X 5.3SEC | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | **(XD+)** | | H03524039 | | |  | | CAP 8MM TUBE | | | | 2 |
|  | |  | | | |  | | |  | | | | | |  | **(XD+)** | | H03551523 | | |  | | UNION ELBOW 8MM-8MM(NORMAL) | | | | 3 |
|  | |  | | | |  | | |  | | | | | |  | **(XD+)** | | H03551520 | | |  | | STRAIGHT UNION 8MM-8MM(NORMAL) | | | | 1 |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **155ml (approx)**  **END COVER**  **1) PRIME MOTOR 300ml (Fill Slowly)**  **GEAR COVER**  **GEAR COVER (LV)**  **FILL TO MAX LEVEL:**  **525ml (approx)** | | | | | | | | | | | | | | | | MK2 Non XD+      MK2 XD+ | | | | | | | | | | | |
| Instruction:  : Remove oil plugs from gear and end cover.  : Fill oil until oil level is at Max on sight glass and fix oil plugs by 30Nm.  **: 오일플러그 제거한 뒤 그림과 같이 오일을 MAX까지 보충하고 30Nm의**  **토크로 오일 플러그를 조립하시오. (300ml 부분은 천천히 주입하시오)** | | | | | | | | | | | | | | | | Instruction:  : Swage stubs with nut & ferrules (Modules-MB).**(부스터의 스터브를 스웨징 하시오.)**  : Assemble fitting parts onto ferrule.**(그림과 같이 피팅류를 페럴에 조립하시오.)**  : Clean O-ring groove and put O-ring on the groove.**(O링 홈을 깨끗이 한 후 O링을 홈에 넣으시오.)**  : Put flange as shown.(**그림과 같이 플랜지를 올려놓으시오.)** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0320** | | | | | | | | | | | | | **M** | **S** | | **OP0330** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | K50000075 | | | |  | | | LOOM PWR INLET S/ASSY **LV**, IXH | | | | | | 1 |  | | M56110041 | | |  | | EMC DRIVE COVER | | | | 2 |
|  | | K50000095 | | | |  | | | LOOM PWR INLET S/ASSY **HV**, IXH | | | | | | 1 | **DP LV** | | D37481975 | | |  | | MTR CNTRLR 7KW5 **LV** M/PACK(X12) | | | | 1 |
| XD+ LV | | K50000085 | | | |  | | | LOOM PWR INLET S/ASSY LV XD+ | | | | | | 1 | **MB LV** | | D37481955 | | |  | | MTR CNTRLR 5KW5 **LV** M/PACK(X12) | | | | 1 |
|  | | 218980208 | | | |  | | | M5 PLAIN WASHER | | | | | | 2 | **DP HV** | | D37496575 | | |  | | MTR CNTRLR 7KW5 **HV** G4 MK2 | | | | 1 |
|  | | 218820004 | | | |  | | | M5 KEPS NUT | | | | | | 3 | **MB HV** | | D37496555 | | |  | | MTR CNTRLR 5KW5 **HV** G4 MK2 | | | | 1 |
|  | | 218680150 | | | |  | | | SCREW SEM M4X16 POZZI | | | | | | 4 |  | | 218820004 | | |  | | M5 KEPS NUT | | | | 6 |
|  | | D37480160 | | | |  | | | LATCH ANTY TAMPER MAINS CONN | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218680014 | | | |  | | | SCREW SEM M4X12 PZZN+CPAS !P! | | | | | | 2 |  | |  | | |  | |  | | | |  |
| 1 | | M66930030 | | | |  | | | REAR BULKHD 390 WD COMBI ASSY | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 2 | | A53382030 | | | |  | | | RF EARTHING BRAID 1375 LG | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218820006 | | | |  | | | M6 KEPS NUT | | | | | | 3 |  | |  | | |  | |  | | | |  |
|  | | 218980209 | | | |  | | | M6 PLAIN WASHER | | | | | | 2 |  | |  | | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **MK2**  **2**  **1** | | | | | | | | | | | | | | | | **3.5Nm** | | | | | | | | | | | |
| Instruction:  : Assemble Loom Power onto the RR bulkhead. **(리어 벌크헤드에 파워 룸을 조립 하시오.)**  : Assemble Loom Earth comes from Loom Power onto the RR bulkhead.(7Nm)  **: 파워룸에서 나오는 접지선을 리어 벌크헤드에 7Nm로 조립 하시오.**  : Pre-assemble Latch onto the RR bulkhead. **(리어 벌크헤드에 래치를 가조립 하시오.)**  : Assemble RF Earthing Loom onto the RR bulkhead. (7Nm)  **: 룸을 리어 벌크헤드에 7Nm로 조립 하시오.** | | | | | | | | | | | | | | | | Instruction:  : Fit EMC Cover onto the RR bulkhead.  : **리어 벌크헤드에 EMC커버를 끼우시오.**  : Assemble the Drives onto the EMC cover.(4.5Nm)  **: 드라이브를 EMC커버위에 4.5Nm로 조립 하시오.** | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0340** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
|  | | D37480119 | | | |  | | | BRKT KIT,RA 100CT | | | | | | 1 |  | | | 218680150 | |  | | SCREW SEM M4X16 POZZI | | | | 4 |
|  | | D37480047 | | | |  | | | WIRE 10MM2 G/Y 300 LG | | | | | | 1 |  | | |  | |  | |  | | | |  |
|  | | D37480093 | | | |  | | | WIRE 10MM2 G/Y 240LG | | | | | | 1 |  | | |  | |  | |  | | | |  |
|  | | K50000001 | | | |  | | | LOOM PWR INLET S/ASSY LV, IXH | | | | | | 1 |  | | |  | |  | |  | | | |  |
|  | | 218680014 | | | |  | | | M4x12 Pozi Sems | | | | | | 6 |  | | |  | |  | |  | | | |  |
|  | | 218980208 | | | |  | | | M5 PLAIN WASHER | | | | | | 6 |  | | |  | |  | |  | | | |  |
|  | | 218820004 | | | |  | | | M5 KEPS NUT | | | | | | 9 |  | | |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | | | |  | |  | |  | |  | |  | |
| Instruction:  :Assemble Bracket as shown.  **:그림과 같이 브라켓을 조립하시오.**  :Secure Earth Wire by 7Nm on Bracket.  **:브라켓에 접지선을 7Nm 토크로 고정하시오.**  :Loosely fix Power Assy(K50000001).  **:파워를(K50000001)**  **느슨하게 고정하시오.**  :Secure Earth Wire by 7Nm on Bracket Cover.  **:브라켓커버에 접지선을 7Nm 토크로 고정하시오.**  :Fully secure Bracket Cover and Power Assy.  **:브라켓커버와**  **파워를 단단히 고정하시오.**  :Secure 2-off Earth Wires by 7Nm as shown.  **:그림과 같이 2개의 접지선을 고정하시오.** | | | | | | | | **3**  **D37480047**  **2**  **1**  **D37480119**  **218680014**  **D37480093**  **D37480119**  **4**  **5**  **6**  **Power loom**  **K50000001**  **D37480093**  **218680150**  **MK2** | | | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0000** | | | | | | | | | | | | | **M** | **S** | | **OP0350** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | |  | | | | | |  |  | | 218980208 | | |  | | M5 PLAIN WASHER | | | | 4 |
|  | |  | | | |  | | |  | | | | | |  |  | | 218820004 | | |  | | M5 KEPS NUT | | | | 6 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
|  | | | | |  | | |  | | | |  | |  | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
|  | | | | |  | | |  | | | |  | |  | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **BLANK** | | | | | | | | | | | | | | | | **BOOSTER**  **D37480047**  **MOTOR**  **DRIVE**  **PUMP**  **MOTOR**  **DRIVE** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction:  : Fix Earth wires by 7Nm as shown.  **: 접지선을 그림과 같이 7Nm 토크로 고정하시오.** | | | | | | | | | | | |
| Page | | **200** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0360** | | | | | | | | | | | | | **M** | **S** | | **OP0370** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | D37480092 | | | |  | | | 530LG EARTH WIRE | | | | | | 2 | 1 | | H03543846 | | |  | | BULKHEAD CONN 8MM X 3/8BSPT BDY ONLY | | | | 1 |
| 2 | | D37480093 | | | |  | | | WIRE 10MM2 G/Y 240LG M5/M5 G4 | | | | | | 2 | 2 | | H03530068 | | |  | | 3/8 BSP SS QUICK CONNECT-SOCT | | | | 1 |
|  | | 218820004 | | | |  | | | M5 KEPS NUT | | | | | | 6 | 3 | | H03530073 | | |  | | DUST PLUG (EAGLE) 3/8 PLAS | | | | 1 |
|  | | 218820004 | | | |  | | | M5 KEPS NUT | | | | | | 6 | 4**(Non XD)** | | M56691037 | | |  | | PIPE SWG-CONNECTING STUB SS | | | | 2 |
|  | | 218980208 | | | |  | | | M5 PLAIN WASHER | | | | | | 8 | 5**(XD+)** | | M66932064 | | |  | | PIPE SWG-200H DP MTR OUT-CROSS | | | | 1 |
|  | | B21924015 | | | |  | | | CABLE TIE MOUNTING BASE | | | | | | 1 | 6**(XD+)** | | M56691037 | | |  | | PIPE SWG-CONNECTING STUB SS | | | | 1 |
|  | | B21924150 | | | |  | | | CABLE TIE REF 543 412 | | | | | |  | 7 | | H03551524 | | |  | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | 1 |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **1**  **2**  **2**  **1** | | | | | | | | | | | | | | | | MK2 Non XD+  MK2 XD+  **3**  **3**  **2**  **6**  **1**  **4**  **7**  **4**  **1**  **2**  **5**  **7** | | | | | | | | | | | |
| Instruction:  : Assemble Earth Looms onto the RR bulkhead. (7Nm)  **: 접지선을 리어 벌크헤드에 7Nm로 조립 하시오.** | | | | | | | | | | | | | | | | Instruction:  : Apply Loctite577 on the thread of bulkhead conn and assemble Quick conn onto it.  (**록타이트 577을 적용 후 퀵 커넥터를 조립 하시오.)**  : Assemble Bulkhead conn onto the RR bulkhead. **(벌크헤드 커넥터를 조립 하시오.)**  : Fit Dust Plug to the bulkhead conn. **(더스트 플러그를 끼우시오.)** | | | | | | | | | | | |
| Page | | **210** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0380** | | | | | | | | | | | | | **M** | **S** | | **OP0390** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | H03524264 | | | |  | | | FEMALE CONN 3/8"TUBE - 3/8"BSPT | | | | | | 1 |  | | H03537450 | | |  | | NUT&FERRULE SET 8M TUBE SS | | | | 4 |
| 2 | | H03524265 | | | |  | | | MALE ELBOW 3/8"TUBE - 3/8"BSPT | | | | | | 1 |  | | H03551520 | | |  | | STRAIGHT UNION 8MM-8MM(NORMAL) | | | | 3 |
| 3 | | H03530068 | | | |  | | | 3/8 BSP SS QUICK CONNEC-SOCT | | | | | | 1 | 1 | | A60034016 | | |  | | 2 PORT SOLENOID TMS VALVE | | | | 1 |
| 4 | | H03530073 | | | |  | | | DUST PLUG (EAGLE) 3/8 PLAS | | | | | | 1 | 2 | | M66932065 | | |  | | PIPE SWG- SINGLE VALVE FEED | | | | 1 |
| 5 | | H03543846 | | | |  | | | BULKHEAD CONN 8MM X 3/8BSPT BDY ONLY | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 6 | | M56691037 | | | |  | | | PIPE SWG-CONNECTING STUB SS | | | | | | 2 |  | |  | | |  | |  | | | |  |
| 7 | | H03551524 | | | |  | | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **4**  **3**  **1**  **5**  **2**  **6**  **7**  **6** | | | | | | | | | | | | | | | | ↑90도  **2**  **1** | | | | | | | | | | | |
| Instruction:  : Apply Loctite577 on the thread of bulkhead conn and assemble Quick conn onto it.(**록타이트 577을 적용 후 퀵 커넥터를 조립 하시오.)**  : Assemble Bulkhead conn onto the RR bulkhead. **(벌크헤드 커넥터를 조립 하시오.)**  : Fit Dust Plug to the bulkhead conn. **(더스트 플러그를 끼우시오.)** | | | | | | | | | | | | | | | | Instruction:  : Swage stubs with nut & ferrules in Drive**(드라이브의 스터브를 스웨징 하시오)**  : Assemble Strainght fitting parts onto ferrule.**(표시된 곳에 스트레이트 피팅류를 페럴에 조립하시오.)**  : Assemble the TMS Pipes as shown.**(그림과 같이 파이프를 조립 하시오)**  : Ensure direction of part 2.**(파트 2의 방향을 확인하십시오)** | | | | | | | | | | | |
| Page | | **220** | | Issue | | **07** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0400** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | M66932071 | | | |  | | | PIPE SWG-MB DRIVE FEED | | | | | | 1 |  | |  | |  | |  | | | |  |
| 2 | | D37480171 | | | |  | | | LOOM DP DRIVE ANTICONDENS'N G4 Pk1 | | | | | | 1 |  | |  | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| Instruction:  : Assemble the TMS Pipes in sequence as shown.  **: 그림과 같이 순서대로 파이프를 조립 하시오**  : Assemble loom to Solenoid TMS valve.  **: Loom을 솔레노이드 벨브에**  **조립하시오** | | | | | | | | D37480171  **1**  **2**  **순서대로**  **Pipe 조립하시오.** | | | | | | | | | | | | | | | | | | |
| Page | | **230** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v4.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0410** | | | | | | | | | | | | | **M** | **S** | | **OP0420** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | 218681017 | | | |  | | | M8x20 SOC HD SEMS | | | | | | 4 |  | | 218681028 | | |  | | SCREW SEM SOC HD HEX M5X12 ENP | | | | 2 |
|  | | 218984010 | | | |  | | | WASHER SP INT MS NI M8 | | | | | | 4 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **3**  **2**  **1** | | | | | | | | | | | | | | | | **기존 MK1에서 사용하던 볼트와 다르니 주의하시오.** | | | | | | | | | | | |
| Instruction:  : Pre-assemble RR bulkhead onto the bases.  **: 리어 벌크헤드를 베이스에 가조립 하시오.**  : Assemble Drive loom onto DP snap switch as shown.  **: 드라이브 룸을 보이는 것과 같이 DP 스냅스위치에 조립하시오.** | | | | | | | | | | | | | | | | Instruction:  : Assemble Loom Earths onto the motors of DP, MB. (3.5Nm)  **: 접지선을 모듈 모터에 3.5Nm로 조립 하시오.** | | | | | | | | | | | |
| Page | | **240** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0430** | | | | | | | | | | | | | **M** | **S** | | **OP0440** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| **STD,HYX** | | H06202030 | | | |  | | | GAS MODULE-VARIMODE+INLET PURGE | | | | | | 1 | 1 | | M66932054 | | |  | | PIPE SWG-MB MOTOR IN SS | | | | 1 |
| **INTEL** | | **H06202040** | | | |  | | | **GAS MODULE-VARIMODE NO EXH** | | | | | | 1 | 2 | | M56691037 | | |  | | PIPE SWG-CONNECTING STUB SS | | | | 1 |
|  | | 218681017 | | | |  | | | M8 X 20 SOCKET HD SEMS | | | | | | 3 |  | | H03551524 | | |  | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | 1 |
|  | | M56110039 | | | |  | | | DRIP DEFLECTOR | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | 218680023 | | | |  | | | M5X12 POZI HD SEMS | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | H03524278 | | | |  | | | MALE CONN. 1/4"TUBE-1/4BSPT | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **3**  H03524278  **MK2**  **2** | | | | | | | | | | | | | | | | **2**  **1** | | | | | | | | | | | |
| Instruction:  : Assemble the Gas Module ontot the RR bulkhead.(20Nm)  **: 가스모듈을 리어 벌크헤드에 20Nm으로 조립하시오.**  : Assemble the Drip deflector to the GM.  : **가스 모듈에 드립디플렉터를 조립 하시오.**  : Apply PTFE onto the thread of Male conn and assemble it to the GM.  : **커넥터에 PTFE를 감은 후 모듈에 조립하시오.** | | | | | | | | | | | | | | | | Instruction:  : Assemble the TMS Pipes in sequence as shown.  **: 그림과 같이 순서대로 파이프를 조립 하시오** | | | | | | | | | | | |
| Page | | **250** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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| **M** | **S** | | **OP0445** | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0450** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | M56405027 | | | |  | | | GAS PIPEINLET STG - 200HP Pk1 | | | | | | 1 |  | | H02134019 | |  | | ORING VIT9830 9.1ID X 1.6SEC | | | | 6 |
| 2 | | M56105024 | | | |  | | | GAS PIPE LV STG - 100LP Pk1 | | | | | | 1 |  | | H03524256 | |  | | UNION 1/4" TUBE ST. STL | | | | 1 |
| 3 | | M56405026 | | | |  | | | GAS PIPE 4TH STG - 200HP Pk1 | | | | | | 1 |  | |  | |  | |  | | | |  |
| 4 | | M56105025 | | | |  | | | GAS PIPE EXHAUST STG - 100LP Pk1 | | | | | | 1 |  | |  | |  | |  | | | |  |
| 5 | | M56105023 | | | |  | | | GAS PIPE SHAFT SEAL - 100LP Pk1 | | | | | | 1 |  | |  | |  | |  | | | |  |
| 6 | | M56405041 | | | |  | | | GAS PIPE FRONT 2-3 | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | H03524467 | | | |  | | | UNION TEE\_1-4-INCH | | | | | | 1 |  | |  | |  | |  | | | |  |
| 7 | | M56205031 | | | |  | | | GAS PIPE REAR 2-3 1220 | | | | | | 1 |  | |  | |  | |  | | | |  |
| 8 | | M56205033 | | | |  | | | GAS LINK PIPE | | | | | | 1 |  | |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| Instruction:  : Fit O’rings onto the grooves of each Gas pipes.  : 오링을 가스파이프에 끼우시오.  : Assemble all Gas pipes as shown.  : 그림과 같이 모든 가스 파이프를 조립 하시오. | | | | | | | | **5**  **8**  **7**  **6**  **4**  **3**  **2**  **1** | | | | | | | | | | | | | | | | | | |
| Page | | **260** | | Issue | | **09** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v4.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0460** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | M56405027 | | | |  | | | GAS PIPEINLET STG - 200HP Pk1 | | | | | | 1 | 10 | | M56405041 | |  | | GAS PIPE FRONT 2-3 | | | | 1 |
| 2 | | M56105024 | | | |  | | | GAS PIPE LV STG - 100LP Pk1 | | | | | | 1 | 11 | | M56205033 | |  | | GAS LINK PIPE | | | | 1 |
| 3 | | M56405026 | | | |  | | | GAS PIPE 4TH STG - 200HP Pk1 | | | | | | 1 |  | | H03524467 | |  | | UNION TEE\_1-4-INCH | | | | 1 |
| 4 | | M64925082 | | | |  | | | MFM GAS PIPE IN | | | | | | 1 |  | | H02134019 | |  | | ORING VIT9830 9.1ID X 1.6SEC | | | | 6 |
| 5 | | M54105016 | | | |  | | | LINK GAS PIPE INTEL | | | | | | 2 |  | | H03524256 | |  | | UNION 1/4" TUBE ST. STL | | | | 5 |
| 6 | | M64925081 | | | |  | | | MFM GAS PIPE IN | | | | | | 1 |  | |  | |  | |  | | | |  |
| 7 | | M64925083 | | | |  | | | MFM GAS PIPE IN THIRD STG | | | | | | 1 |  | |  | |  | |  | | | |  |
| 8 | | M64925084 | | | |  | | | MFM GAS PIPE OUT THIRD STG | | | | | | 1 |  | |  | |  | |  | | | |  |
| 9 | | M56105023 | | | |  | | | GAS PIPE SHAFT SEAL | | | | | | 1 |  | |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| Instruction:  : Fit O’rings onto the grooves of each Gas pipes.  : 오링을 가스파이프에 끼우시오.  : Assemble all Gas pipes as shown.  : 그림과 같이 모든 가스 파이프를 조립 하시오. | | | | | | | | **9**  **10**  **11**  **8**  **7**  **6**  **5**  **4**  **3**  **2**  **1** | | | | | | | | | | | | | | | | | | |
| Page | | **270** | | Issue | | **09** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v4.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0465** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | M56105025 | | | |  | | | GAS PIPE EXHAUST STG - 100LP | | | | | | 1 | 10 | | M6K436090 | |  | | DUAL PURGE LINK PIPE CENTER | | | | 1 |
| 2 | | M56105023 | | | |  | | | GAS PIPE SHAFT SEAL - 100LP Pk1 | | | | | | 1 | **1220** | | M56425017 | |  | | COVER PLATE ASSY RH | | | | 1 |
| 3 | | M56105024 | | | |  | | | GAS PIPE LV STG - 100LP Pk1 | | | | | | 1 | **1820** | | M6K436091 | |  | | COVER PLATE ASSY RH | | | | 1 |
| 4 | | M56205031 | | | |  | | | GAS PIPE REAR 2-3 1220 | | | | | | 1 | 11 | | M56425018 | |  | | COVER PLATE ASSY LH | | | | 1 |
| 5 | | M56405026 | | | |  | | | GAS PIPE 4TH STG - 200HP Pk1 | | | | | | 1 |  | | 27522-046 | |  | | M6X16 SOC HD CAP SCREW ENP CO | | | | 8 |
| 6 | | M56405027 | | | |  | | | GAS PIPEINLET STG - 200HP Pk1 | | | | | | 1 | 12 | | H02134000 | |  | | O-RING FKM HP 44.5ID X 2.4SEC | | | | 2 |
| 7 | | M56405041 | | | |  | | | GAS PIPE FRONT 2-3 | | | | | | 1 | 13 | | H02120037 | |  | | O-Ring NIT 15.6ID x 2.4SEC | | | | 2 |
|  | | H02134019 | | | |  | | | O-RING FKM HP 9.1ID X 1.6SEC | | | | | | 6 | 14 | | M56205043 | |  | | FILTER HOLDER 100CTR | | | | 2 |
|  | | H03524467 | | | |  | | | Union Tee 1/4 Tube (H03524132) MPK5 | | | | | | 3 | 15 | | H02122033 | |  | | O-RING FKM GP 11.6ID X 2.4SEC | | | | 2 |
| 8 | | M61920090 | | | |  | | | LOWER GAS LINK PIPE RIGHT | | | | | | 1 | 16 | | A22305002 | |  | | SINTERED FILTER 6.6 DIA X 7 LG | | | | 2 |
| 9 | | M56425023 | | | |  | | | LOWER LINK PIPE LH | | | | | | 1 |  | |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| Instruction:  : Fit O’rings onto the grooves of each Gas pipes.  : 오링을 가스파이프에 끼우시오.  : Assemble all Gas pipes as shown.  : 그림과 같이 모든 가스 파이프를 조립 하시오.  **1820/1220** | | | | | | | | **6**  **4**  **8**  **10**  **9**  **2**  **5**  P  **11**  P  P  **12**  **13**  **1**  **3**  **16**  **15**  **14**  **7** | | | | | | | | | | | | | | | | | | |
| Page | | **275** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v4.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | | |
| **M** | **S** | | **OP0470** | | | | | | | | | | | | | **M** | **S** | | **OP0480** | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. | |
| 1 | | M57282071 | | | |  | | | TMS MANIFOLD 5V-2R-HF SS IXH | | | | | | 1 |  | | H03530069 | | |  | | 3-8 BSP SS QUICK CONNECT-PLUG | | | | 1 | |
|  | | 218681017 | | | |  | | | M8x20 SOC HD SEMS | | | | | | 2 |  | | H03530074 | | |  | | DUST CAP (EAGLE) 3/8 PLAS | | | | 1 | |
| 2 | | H03524669 | | | |  | | | INLET\_BULKHEAD\_3-8\_M\_FACE\_SEAL | | | | | | 1 |  | |  | | |  | |  | | | |  | |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  | |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | |
| **MK2**  Check for TMS Manifold direction.  TMS Manifold 방향을 확인하시오  **1**  **3**  **2** | | | | | | | | | | | | | | | | **H03530069**  **H03530074** | | | | | | | | | | | | |
| Instruction:  : Assemble the TMS Manofold to the RR bulkhead.(20Nm)  **: 매니폴드를 리어 벌크 헤드에 20Nm로 조립 하시오.**  : Assemble Bulkhead seal to the manifold.(10Nm)  **: 벌크헤드 실을 매니폴드에 10Nm로 조립 하시오.** | | | | | | | | | | | | | | | | Instruction:  : Apply Loctite 577  **: 록타이트 577을 적용하시오.**  : Assemble Q.Conn with Dust Cap as shown.  **: 그림과 같이 퀵컨넥터를 먼지캡과 함께 조립하시오.** | | | | | | | | | | | | |
| Page | | **280** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | | |
| **M** | **S** | | **OP0490** | | | | | | | | | | | | | **M** | **S** | | **OP0500** | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. | |
| 1 | | M56401043 | | | |  | | | PIPE SWG-OUTLET LINK SS | | | | | | 1 |  | | M54120024 | | |  | | GAS QC SUPPORT BRACKET | | | | 1 | |
| 2 | | M66932074 | | | |  | | | PIPE SWG-TEE CONNECT OUT | | | | | | 1 |  | | 218680023 | | |  | | M5X12 POZI SEMS | | | | 2 | |
|  | | H03551524 | | | |  | | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | | | 2 |  | | M64925080 | | |  | | GAS SWG PIPE SUPPLY FROM QC | | | | 1 | |
|  | |  | | | |  | | |  | | | | | |  |  | | H03543571 | | |  | | QC BULKHEAD MALE 1/4 SS BDY ONLY | | | | 1 | |
|  | |  | | | |  | | |  | | | | | |  |  | | H03524572 | | |  | | FEMALE BULKHEAD QC ¼“ SS | | | | 1 | |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  | |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | |
| **1**  **2**  **1**  **3**  **2** | | | | | | | | | | | | | | | | **8Nm**  **M64925080**  **M54120024**  **218680023**  **H03524572**  **H03543571** | | | | | | | | | | | | |
| Instruction:  : Assemble Bulkhead conn onto the RR bulkhead. **(벌크헤드 커넥터를 조립 하시오.)**  : Apply Loctite577 onth the thread of bulkhead conn and assemble Quick conn onto it.  **: 록타이트 577을 적용 후 퀵 커넥터를 조립 하시오.**  : Fit Dust Plug to the bulkhead conn. **(더스트 플러그를 끼우시오.)**  : Assembly these TMS pipe as shown. **(보이는것처럼 TMS 파이프를 조립하시오.)** | | | | | | | | | | | | | | | | Instruction:  : Assemble fittings to Gas Module as shown.  **: 그림과같이 연결부품을 가스모듈에 조립하시오.** | | | | | | | | | | | | |
| Page | | **290** | | Issue | | **09** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | | |
| **M** | **S** | | **OP0505** | | | | | | | | | | | | | **M** | **S** | | **OP0510** | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. | |
| 1 | | M56401043 | | | |  | | | PIPE SWG-OUTLET LINK SS | | | | | | 1 |  | | H03524264 | | |  | | FEMALE CONN 3/8"TUBE - 3/8"BSPT | | | | 1 | |
| 2 | | M61920064 | | | |  | | | PIPE SWG-200H DP MTR OUT | | | | | | 1 |  | | H03524265 | | |  | | MALE ELBOW 3/8"TUBE - 3/8"BSPT | | | | 1 | |
| 3 | | M66932061 | | | |  | | | PIPE SWG-200H DP GB OUT | | | | | | 1 |  | | H03530069 | | |  | | 3/8 BSP SS QUICK CONNEC-PLUS | | | | 1 | |
|  | | H03541754 | | | |  | | | UNION CROSS 8MM BODY | | | | | | 1 |  | | H03530074 | | |  | | DUST CAP (EAGLE) 3/8 PLAS | | | | 1 | |
|  | | H03551524 | | | |  | | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | | | 1 |  | |  | | |  | |  | | | |  | |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | |
| **2**  **3**  **1**  **H03524265 x\1**  **H03524264**  **H03530069**  **H03530074**  **1**  **3**  **2** | | | | | | | | | | | | | | | |  | | | | | | | | | | | | |
| Instruction:  : Apply Loctite 577 on 4 positions as shown.  **: 그림과 같이 록타이트 577을 적용하시오.**  : Assemble each fitting and Quick connector with Dust Cap as shown.  **그림과 같이 각각의 연결부품과 퀵 컨넥터를 먼지캡과 함께 고정하시오.** | | | | | | | | | | | | | | | | Instruction:  : Apply Loctite 577 on 4 positions as shown.  **: 그림과 같이 록타이트 577을 적용하시오.**  : Assemble each fitting and Quick connector with Dust Cap as shown.  **그림과 같이 각각의 연결부품과 퀵 컨넥터를 먼지캡과 함께 고정하시오.** | | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | | |
| **M** | **S** | | **OP0520** | | | | | | | | | | | | | **M** | **S** | | **OP0530** | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. | |
| 1 | | M66932064 | | | |  | | | PIPE SWG- 200H DP MOTOR OUT-CROSS | | | | | | 1 | **(Non XD)** | | M66932063 | | |  | | PIPE SWG-MB CONNECTION OUT SS | | | | 1 | |
|  | | H03551524 | | | |  | | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | | | 1 | **(XD+)** | | M61920065 | | |  | | PIPE SWG-MB CONNECTION OUT SS | | | | 1 | |
| 2 | | M66932061 | | | |  | | | PIPE SWG-200H DP GB OUT | | | | | | 1 |  | | H03551524 | | |  | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | 1 | |
|  | | H03551520 | | | |  | | | STRAIGHT UNION 8MM-8MM(NORMAL) | | | | | | 1 | 1 | | M66932052 | | |  | | PIPE SWG-MB MOTOR OUT SS | | | | 1 | |
|  | |  | | | |  | | |  | | | | | |  | 2 | | M56482035 | | |  | | PIPE SWG-MB DRIVE RTN SS | | | | 1 | |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | |
| **2**  **1**  **1**  **3**  **2** | | | | | | | | | | | | | | | | **2**  **Non XD/XD+**  **1** | | | | | | | | | | | | |
| Instruction:  : Assemble all TMS Pipes as shown.  **: 그림과 같이 모든 파이프를 조립 하시오.** | | | | | | | | | | | | | | | | Instruction:  : Assemble all TMS Pipes as shown.  **: 그림과 같이 모든 파이프를 조립 하시오.** | | | | | | | | | | | | |
| Page | | **310** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0540** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | H06201023 | | | |  | | | CHECK VALVE SS 160PSI B/ONLY | | | | | | 1 |  | |  | |  | |  | | | |  |
| 2 | | M56101073 | | | |  | | | PIPE SWG-TMS EXPANSION VOL SS | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | H03524039 | | | |  | | | CAP 8MM TUBE | | | | | | 1 |  | |  | |  | |  | | | |  |
| 3 | | M56401035 | | | |  | | | PIPE SWG-ECOVER RETURN SS | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | H03551524 | | | |  | | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | | | 1 |  | |  | |  | |  | | | |  |
| 4 | | M66932055 | | | |  | | | PIPE SWG-200H DP HV STAGE OUT | | | | | | 1 |  | |  | |  | |  | | | |  |
| 5 | | M66932062 | | | |  | | | PIPE SWG-MB DP CENTER CONNECTION OUT | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | H03541754 | | | |  | | | UNION CROSS 8MM BODY | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | |  | | | |  | | |  | | | | | |  |  | |  | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| Instruction:  : Assemble all TMS Pipes as shown.  : 그림과 같이 모든 파이프를 조립 하시오. | | | | | | | | **5**  **4**  **2**  **3**  **1**  **Ensure the direction of check valve** | | | | | | | | | | | | | | | | | | |
| Page | | **320** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v4.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0545** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | H06201023 | | | |  | | | CHECK VALVE SS 160PSI B/ONLY | | | | | | 1 |  | |  | |  | |  | | | |  |
| 2 | | M61920067 | | | |  | | | PIPE SWG-TMS EXPANSION VOL SS | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | H03524039 | | | |  | | | CAP 8MM TUBE | | | | | | 1 |  | |  | |  | |  | | | |  |
| 3 | | M61920063 | | | |  | | | PIPE SWG-MB GB DP HS OUT SS | | | | | | 1 |  | |  | |  | |  | | | |  |
|  | | H03541754 | | | |  | | | UNION CROSS 8MM BODY | | | | | | 1 |  | |  | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| Instruction:  : Assemble all TMS Pipes as shown.  : 그림과 같이 모든 파이프를 조립 하시오. | | | | | | | | **3**  **2**  **1**  **Ensure the direction of check valve** | | | | | | | | | | | | | | | | | | |
| Page | | **325** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v4.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0550** | | | | | | | | | | | | | **M** | **S** | | **OP0560** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | M66932072 | | | |  | | | PIPE SWG-UPR HEATSINK FEED SS | | | | | | 1 | 1 | | M66932077 | | |  | | PIPE SWG-MB GC OUT SS1 | | | | 1 |
| **(Non XD)** | | M66932075 | | | |  | | | PIPE SWG-DP EC FEED SS | | | | | | 1 | 2 | | M56401041 | | |  | | PIPE SWG-STATOR RETURN SS | | | | 1 |
| 2 | | M56482023 | | | |  | | | PIPE SWG-PUMP STATOR FEED SS | | | | | | 1 | **1220** | | M66922057 | | |  | | PIPE SWG-MB GB - MB EC | | | | 1 |
| 3 | | M56431047 | | | |  | | | PIPE SWG-BSTR STATOR FEED SS | | | | | | 1 | **1820** | | M66932057 | | |  | | PIPE SWG-MB GB - MB EC | | | | 1 |
|  | | H03551523 | | | |  | | | UNION ELBOW 8MM-8MM(NORMAL) | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1220** | | M66922062 | | | |  | | | PIPE SWG-MB EC FEED SS | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1820** | | M66932076 | | | |  | | | PIPE SWG-MB EC FEED SS | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **3**  **1220/1820**  **Non XD**  **2**  **1** | | | | | | | | | | | | | | | | **1220/1820**  **2**  **1** | | | | | | | | | | | |
| Instruction:  : Assemble all TMS Pipes as shown.  : 그림과 같이 모든 파이프를 조립 하시오. | | | | | | | | | | | | | | | | Instruction:  : Assemble all TMS Pipes as shown.  : 그림과 같이 모든 파이프를 조립 하시오. | | | | | | | | | | | |
| Page | | **330** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0563** | | | | | | | | | | | | | **M** | **S** | | **OP0567** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | M66932072 | | | |  | | | PIPE SWG-UPR HEATSINK FEED SS | | | | | | 1 | 1 | | M66932077 | | |  | | PIPE SWG-MB GC OUT SS1 | | | | 1 |
| **(XD+)** | | M61920051 | | | |  | | | PIPE SWG-DP EC FEED SS | | | | | | 1 | 2 | | M56401041 | | |  | | PIPE SWG-STATOR RETURN SS | | | | 1 |
| 2 | | M56482023 | | | |  | | | PIPE SWG-PUMP STATOR FEED SS | | | | | | 1 | **1220** | | M60920071 | | |  | | PIPE SWG-MB GB - MB EC | | | | 1 |
| 3 | | M56431047 | | | |  | | | PIPE SWG-BSTR STATOR FEED SS | | | | | | 1 | **1820** | | M61930051 | | |  | | PIPE ASSY - LWR STATOR COOLING | | | | 1 |
|  | | H03551523 | | | |  | | | UNION ELBOW 8MM-8MM(NORMAL) | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1220** | | M60920070 | | | |  | | | PIPE ASSY - LWR STATOR COOLING | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1820** | | M61930050 | | | |  | | | PIPE SWG-MB GB - MB EC | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | | H03551524 | | | |  | | | UNION TEE 8MM-8MM-8MM(NORMAL) | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **1220/1820**  **3**  **1**  **2**  **XD+** | | | | | | | | | | | | | | | | **1820/1220**  **1**  **2** | | | | | | | | | | | |
| Instruction:  : Assemble all TMS Pipes as shown.  : 그림과 같이 모든 파이프를 조립 하시오. | | | | | | | | | | | | | | | | Instruction:  : Assemble all TMS Pipes as shown.  : 그림과 같이 모든 파이프를 조립 하시오. | | | | | | | | | | | |
| Page | | **335** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | SOP No. | | **SOPKR1663** | | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | |
| **M** | **S** | | **WATER SYSTEM SCHEMATIC – 1220HTXS STD, 1220HTXS INTEL** | | | | | | | | | | | | | | | | | |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | 1220HTXS XD+ | | 1820HTXS XD+ | 1220HTXS XD+ | 1820HTXS XD+ | | 1820HTXS XD+ Hynix |
|  | | | | |  | | |  | | |  | |  |  | |  |  |  | |  |
| **Please refer to TMS Pipe Assembly in details on behind pages.**  **상세한 TMS Pipe 조립은 뒷페이지를 참조하십시오.**  **Parts Required**  1. **2 off** – M56691037\_PIPE SWG-CONNECTING STUB SS  2. 1 off - M56691037\_PIPE SWG-CONNECTING STUB SS  3. 1 off - M56401043\_PIPE SWG-OUTLET LINK SS  4. 1 off - M66932074\_PIPE SWG-TEE CONNECT OUT  5. 1 off - M66932063\_PIPE SWG-MB CONNECTION OUT SS  6. 1 off - M66932064\_PIPE SWG-200H DP MTR OUT-CROSS  7. 1 off - M66932061\_PIPE SWG-200H DP GB OUT  8. 1 off - M56401035\_PIPE SWG-ECOVER RETURN SS  9. 1 off - M66932058\_PIPE SWG-200H DP EC - GB OUT  10. 1 off - M66932055\_PIPE SWG-200H DP HV STAGE OUT  11. 1 off - M56451030\_PIPE SWG-PUMP STATOR FEED HYB  12. 1 off - M56451034\_LOWER STATOR COOLING SWG  13. 1 off - M57282071\_TMS MANIFOLD 5V-2R-HF SS IXH  14. 1 off - M56482019\_PIPE SWG-UPR HEATSINK FEED SS  15. 1 off - M66932075\_PIPE SWG-DP EC FEED SS  16. 1 off - M56482023\_PIPE SWG-PUMP STATOR FEED SS  17. 1 off - M56431047\_PIPE SWG-BSTR STATOR FEED SS  18. 1 off - M66922062\_PIPE SWG-MB EC FEED SS  19. 1 off - M66932077\_PIPE SWG-MB GC OUT SS  20. 1 off - M66932062\_PIPE SWG-MB DP CENTER CONNECTION OUT  21. 1 off - M66922060\_HEATSINK SWG-1200MB SS  22. 1 off – M66922057\_PIPE SWG-MB GB - MB EC  23. 1 off – M56451032\_ UPPER HEATSINK SWG  24. 1 off – M56451036\_ SINGLE COOLING BLOK SWG | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * Push fit pipes following procedure as shown. * **그림과 같이 파이프를 순서에 맞게 조립하시오.** | | | | | | | | | | | | | | | | | | | | |
| Page | | **R7** | | Issue | | **02** | Approved | |  | | | | | | | | | | SOP TEMPLATE – SINGLE LANSCAPE v4.doc | |

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|  | | | | | | | | | | SOP No. | | **SOPKR1663** | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | |
| **M** | **S** | | **WATER SYSTEM SCHEMATIC – 1220HTXS STD, 1220HTXS INTEL** | | | | | | | | | | | | | | | | | | |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS XD+ | | 1820HTXS XD+ | 1220HTXS XD+ | 1820HTXS XD+ | | 1820HTXS XD+ Hynix |
|  | | | | |  | | |  | | |  | |  |  | | |  |  |  | |  |
| 11  **Please refer to TMS Pipe Assembly in details on behind pags.**  **상세한 TMS Pipe 조립은 뒷페이지를 참조하십시오.**  **Parts Required**  1. **2 off** – M57571054\_PIPE SWG-UPR TO LWR HSINK  2. 1 off – M56401041\_PIPE SWG-STATOR RETURN SS  3. 1 off – M66932065\_PIPE SWG- SINGLE VALVE FEED  4. 1 off – M56691037\_PIPE SWG-CONNECTING STUB SS  5. 1 off – M66932060\_PIPE SWG- DP MOTOR FEED  6. 1 off –M66932054\_PIPE SWG-MB MOTOR IN SS  7. 1 off – M66932071\_PIPE SWG-MB DRIVE FEED  8. 1 off – M56482035\_PIPE SWG-MB DRIVE RTN SS  9. 1 off –M66932052\_PIPE SWG-MB MOTOR OUT SS  10. 1 off – A60034016\_2 PORT SOLENOID TMS VALVE  11. 1 off - H06201023\_CHECK VALVE SS 160PSI B/ONLY | | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * Push fit pipes following procedure as shown. * **그림과 같이 파이프를 순서에 맞게 조립하시오.** | | | | | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | SOP No. | | **SOPKR1663** | | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | |
| **M** | **S** | | **WATER SYSTEM SCHEMATIC – 1820HTXS STD, 1820HTXS HYX** | | | | | | | | | | | | | | | | | |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | 1220HTXS XD+ | | 1820HTXS XD+ | 1220HTXS XD+ | 1820HTXS XD+ | | 1820HTXS XD+ Hynix |
|  | | | | |  | | |  | | |  | |  |  | |  |  |  | |  |
| **Please refer to TMS Pipe Assembly in details on behind pags.**  **상세한 TMS Pipe 조립은 뒷페이지를 참조하십시오.**  **Parts Required**  1. **2 off** – M56691037\_PIPE SWG-CONNECTING STUB SS  2. 1 off - M56691037\_PIPE SWG-CONNECTING STUB SS  3. 1 off - M56401043\_PIPE SWG-OUTLET LINK SS  4. 1 off - M66932074\_PIPE SWG-TEE CONNECT OUT  5. 1 off - M66932063\_PIPE SWG-MB CONNECTION OUT SS  6. 1 off - M66932064\_PIPE SWG-200H DP MTR OUT-CROSS  7. 1 off - M66932061\_PIPE SWG-200H DP GB OUT  8. 1 off - M56401035\_PIPE SWG-ECOVER RETURN SS  9. 1 off - M66932055\_PIPE SWG-200H DP HV STAGE OUT  10. 1 off – M66932062\_PIPE SWG-MB DP CENTER CONNECTION OUT  11. 1 off – M66932058\_PIPE SWG-200H DP EC - GB OUT  12. 1 off – M57282071\_TMS MANIFOLD 5V-2R-HF SS IXH  13. 1 off – M66932072\_ PIPE SWG-UPR HEATSINK FEED SS  14. 1 off – M66932075\_ PIPE SWG-DP EC FEED SS  15. 1 off – M56431047\_ PIPE SWG-BSTR STATOR FEED SS  16. 1 off – M66932076\_ PIPE SWG-MB EC FEED SS  17. 1 off – M66932077\_ PIPE SWG-MB GC OUT SS  18. 1 off – M66932078\_ HEATSINK SWG-1800MB SS  19. 1 off – M66932057\_ PIPE SWG-MB GB - MB EC | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * Push fit pipes following procedure as shown. * **그림과 같이 파이프를 순서에 맞게 조립하시오.** | | | | | | | | | | | | | | | | | | | | |
| Page | | **R9** | | Issue | | **02** | Approved | |  | | | | | | | | | | SOP TEMPLATE – SINGLE LANSCAPE v4.doc | |

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|  | | | | | | | | | | SOP No. | | **SOPKR1663** | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | |
| **M** | **S** | | **WATER SYSTEM SCHEMATIC – 1820HTXS STD, 1820HTXS HYX** | | | | | | | | | | | | | | | | | | |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS XD+ | | 1820HTXS XD+ | 1220HTXS XD+ | 1820HTXS XD+ | | 1820HTXS XD+ Hynix |
|  | | | | |  | | |  | | |  | |  |  | | |  |  |  | |  |
| **Please refer to TMS Pipe Assembly in details on behind pags.**  **상세한 TMS Pipe 조립은 뒷페이지를 참조하십시오.**  **Parts Required**  1. **2 off** – M57571054\_PIPE SWG-UPR TO LWR HSINK  2. 1 off – M56451034\_LOWER STATOR COOLING SWG  3. 1 off – M56451030\_PIPE SWG-PUMP STATOR FEED HYB  4. 1 off – M56482023\_PIPE SWG-PUMP STATOR FEED SS  5. 1 off – M56451036\_SINGLE COOLING BLOK SWG  6. 1 off – M56451032\_UPPER HEATSINK SWG  7. 1 off – M56401041\_PIPE SWG-STATOR RETURN SS  8. 1 off – M66932061\_PIPE SWG-200H DP GB OUT  9. 1 off – A60034016\_2 PORT SOLENOID TMS VALVE  10. 1 off –M66932065\_PIPE SWG- SINGLE VALVE FEED  11. 1 off – M56691037\_PIPE SWG-CONNECTING STUB SS  12. 1 off – M66932060\_PIPE SWG- DP MOTOR FEED  13. 1 off – M66932054\_PIPE SWG-MB MOTOR IN SS  14. 1 off – M66932071\_PIPE SWG-MB DRIVE FEED  15. 1 off –M56482035\_PIPE SWG-MB DRIVE RTN SS  16. 1 off –M66932052\_PIPE SWG-MB MOTOR OUT SS | | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * Push fit pipes following procedure as shown. * **그림과 같이 파이프를 순서에 맞게 조립하시오.** | | | | | | | | | | | | | | | | | | | | | |
| Page | | **R10** | | Issue | | **02** | Approved | |  | | | | | | | | | | | SOP TEMPLATE – SINGLE LANSCAPE v4.doc | |

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|  | | | | | | | | | | SOP No. | | **SOPKR1663** | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | |
| **M** | **S** | | **WATER SYSTEM SCHEMATIC – 1220/1820HTXS XD+** | | | | | | | | | | | | | | | | | | |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS XD+ | | 1820HTXS XD+ | 1220HTXS XD+ | 1820HTXS XD+ | | 1820HTXS XD+ Hynix |
|  | | | | |  | | |  | | |  | |  |  | | |  |  |  | |  |
| **Parts Required**  1. 1 off - M66932064\_PIPE SWG-200H DP MTR OUT-CROSS  2. 1 off - M56691037\_PIPE SWG-CONNECTING STUB SS  3. 1 off - M56401043\_PIPE SWG-OUTLET LINK SS  4. 1 off - M61920064\_PIPE SWG-200H DP MTR OUT  5. 1 off - M61920065\_PIPE SWG-MB CONNECTION OUT SS  6. 1 off - M61920063\_PIPE SWG-MB GB DP HS OUT SS  7. 1 off - M66932061\_PIPE SWG-200H DP GB OUT  8. 1 off - M61920067\_PIPE SWG-TMS EXPANSION VOL SS  9. 1 off - M61920050\_PIPE SWG-200H DP EC - GB OUT  10. 1 off - M66932072\_PIPE SWG-UPR HEATSINK FEED SS  11. 1 off - M61920051\_PIPE SWG-DP EC FEED SS  12. 1 off - M56482023\_PIPE SWG-PUMP STATOR FEED SS  13. 1 off - M56431047\_PIPE SWG-BSTR STATOR FEED SS  14. 1 off - M60920070\_PIPE ASSY - LWR STATOR COOLING (1220)  M61930050\_PIPE SWG-MB GB - MB EC (1820)  15. 1 off - M60920071\_PIPE SWG-MB GB - MB EC (1220)  M61930051\_PIPE ASSY - LWR STATOR COOLING (1820)  16. 1 off - M66932077\_PIPE SWG-MB GC OUT SS  17. 1 off - M66922060\_HEATSINK SWG-1200MB SS (1220)  M66932078\_HEATSINK SWG-1800MB SS (1820)  18. 1 off - M60920068\_HEATSINK ASSY-MB ECOVER  19. 1 off - H06201023\_CHECK VALVE SS 160PSI B/ONLY  20. 1 off - H03524039\_CAP 8MM TUBE  **Please refer to TMS Pipe Assembly in details on behind pags.**  **상세한 TMS Pipe 조립은 뒷페이지를 참조하십시오.**  13  20  19  12  16  9  18  17  14  11  10  7  6  8  1  2  3  4  5  15 | | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * Push fit pipes following procedure as shown. * **그림과 같이 파이프를 순서에 맞게 조립하시오.** | | | | | | | | | | | | | | | | | | | | | |
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|  | | | | | | | | | | SOP No. | | **SOPKR1663** | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | |
| **M** | **S** | | **WATER SYSTEM SCHEMATIC – 1220/1820HTXS XD+** | | | | | | | | | | | | | | | | | | |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS XD+ | | 1820HTXS XD+ | 1220HTXS XD+ | 1820HTXS XD+ | | 1820HTXS XD+ Hynix |
|  | | | | |  | | |  | | |  | |  |  | | |  |  |  | |  |
| 15  5  10  6  4  13  8  14  12  11  9  7  3  2  11  **Parts Required**  1. 1 off - M61920052\_PIPE ASSY - LWR STATOR COOLING  2. 1 off - M61920054\_PIPE ASSY - LOWER HEATSINK  3. 1 off - M56451036\_SINGLE COOLING BLOK SWG  4. 1 off - M61920058\_PIPE ASSY - 3RD STATOR UPPER HS  5. 1 off - M61920056\_PIPE SWG- DP MOTOR FEED  6. 1 off - M61920060\_PIPE - 3 RD UPR TO OUT  7. 1 off - M66932060\_PIPE SWG- DP MOTOR FEED  8. 1 off - A60034016\_2 PORT SOLENOID TMS VALVE  9. 1 off - M66932065\_PIPE SWG- SINGLE VALVE FEED  10.1 off - M66932071\_PIPE SWG-MB DRIVE FEED  11.1 off - M66932052\_PIPE SWG-MB MOTOR OUT SS  12.1 off - M66932054\_PIPE SWG-MB MOTOR IN SS  13.1 off - M56691037\_PIPE SWG-CONNECTING STUB SS  14.1 off - M56482035\_PIPE SWG-MB DRIVE RTN SS  15.1 off - M56401041\_PIPE SWG-STATOR RETURN SS  **Please refer to TMS Pipe Assembly in details on behind pags.**  **상세한 TMS Pipe 조립은 뒷페이지를 참조하십시오.** | | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * Push fit pipes following procedure as shown. * **그림과 같이 파이프를 순서에 맞게 조립하시오.** | | | | | | | | | | | | | | | | | | | | | |
| Page | | **R12** | | Issue | | **15** | Approved | |  | | | | | | | | | | | SOP TEMPLATE – SINGLE LANSCAPE v4.doc | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0570** | | | | | | | | | | | | | **M** | **S** | | **OP0580** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | M66930016 | | | |  | | | FRONT BULKHEAD 390MM WIDE | | | | | | 1 |  | | D37510900 | | |  | | DASHBOARD ASSY MK2 | | | | 1 |
| **1220** | | A20008802 | | | |  | | | BADGE - IXH1220HTXSS SPLIT DASH | | | | | | 1 |  | | D37510905 | | |  | | EMS ASSY MK2 | | | | 1 |
| **INTEL** | | A20008806 | | | |  | | | BADGE-IXH1220HTXS NO CU | | | | | | 1 |  | | 218680014 | | |  | | M4 X 12 POZI HD SEMS | | | | 6 |
| **1220 XD+** | | M61920031 | | | |  | | | BADGE - IXH1220HTXS XD+ DASH | | | | | | 1 |  | | 218980208 | | |  | | M5 PLAIN WASHER | | | | 2 |
| **1820** | | A20008803 | | | |  | | | BADGE - IXH1820HTXSS SPLIT DASH | | | | | | 1 |  | | 218820004 | | |  | | M5 KEPS NUT | | | | 3 |
| **HYX** | | A20008803 | | | |  | | | BADGE - IXH1820HTXSS SPLIT DASH | | | | | | 1 |  | |  | | |  | |  | | | |  |
| **1820 XD+** | | M61920032 | | | |  | | | BADGE - IXH1820HTXS XD+ DASH | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **MK2**  **1820 STD**  **1820 HYX**  **MK2**  **MK2**  **MK2**  **1220 STD**  **1220 INTEL**  **1220 XD+**  **MK2**  **MK2**  **1820 XD+**  **1820 XD+ HYX** | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Clean the surface of the Frt bulkhead and attach the adapt Badge onto it as referring variants.  : 벌크헤드 표면 세척 후 배지를 부착 하시오. | | | | | | | | | | | | | | | | Instruction:  : Assemble Dashboard and EMS Assy to the Frt bulkhead. (2Nm)  : 대시보드와 EMS 를 2Nm로 조립 하시오.  : Assemble Loom Earth comes from dashboard to the Frt bulkhead.(3.5Nm)  : 대시보드의 접지선을 벌크헤드에 3.5Nm로 조립 하시오. | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0590** | | | | | | | | | | | | | **M** | **S** | | **OP0600** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | D37510900 | | | |  | | | DASHBOARD ASSY MK2 | | | | | | 1 |  | | 218984010 | | |  | | M8 S/PROOF WASHER | | | | 4 |
|  | | 218680014 | | | |  | | | M4 X 12 POZI HD SEMS | | | | | | 4 |  | | 218681017 | | |  | | M8x20 SOC HD SEMS | | | | 4 |
|  | | 218980208 | | | |  | | | M5 PLAIN WASHER | | | | | | 2 |  | |  | | |  | |  | | | |  |
|  | | 218820004 | | | |  | | | M5 KEPS NUT | | | | | | 3 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **MK2** | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Assemble Dashboard Assy to the Frt bulkhead. (2Nm)  : 대시보드를 2Nm로 조립 하시오.  : Assemble Loom Earth comes from dashboard to the Frt bulkhead.(3.5Nm)  : 대시보드의 접지선을 벌크헤드에 3.5Nm로 조립 하시오. | | | | | | | | | | | | | | | | Instruction:  : Pre-assemble FRT bulkhead onto the bases.  : 프런트 벌크헤드를 베이스에 가조립 하시오. | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0610** | | | | | | | | | | | | | **M** | **S** | | **OP0620** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | K50000180 | | | |  | | | LOOM MB 3PH MOTOR/INVERTER G4 Pk1 | | | | | | 0 |  | | D37480090 | | |  | | LOOM INVERTER POWER MB MK2 G4 Pk1 | | | | 0 |
|  | | 218980208 | | | |  | | | M5 PLAIN WASHER | | | | | | 6 |  | | K50000170 | | |  | | LOOM DP 3PH MOTOR/INVERTER G4 | | | | 0 |
|  | | 218820004 | | | |  | | | M5 KEPS NUT | | | | | | 6 |  | | 218980208 | | |  | | M5 PLAIN WASHER | | | | 6 |
|  | | D37480090 | | | |  | | | LOOM INVERTER POWER MB MK2 G4 Pk1 | | | | | | 1 |  | | 218820004 | | |  | | M5 KEPS NUT | | | | 6 |
|  | | Blue loom | | | |  | | | Heated module loom | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **3**  **2**  **1**  **3**  **2**  **1**  **BLUE LOOM**  **MB DRIVE** | | | | | | | | | | | | | | | | **w**  **V**  **U**  **DP DRIVE** | | | | | | | | | | | |
| Instruction:  : Assemble Loom comes form MB motor to the MB drive.(3.5Nm)  : 부스터 모터에서 나오는 룸을 부스터 드라이브에 3.5Nm로 조립 하시오.  : Assemble Loom Link and Heated M Loom together to the MB drive.(3.5Nm)  : 링크 룸과 히티드 모듈룸을 함께 부스터 드라이브에 3.5Nm로 조립 하시오. | | | | | | | | | | | | | | | | Instruction:  : Assemble Loom comes form DP motor to the DP drive.(3.5Nm)  : DP 모터에서 나오는 룸을 DP 드라이브에 3.5Nm로 조립 하시오.  : Assemble Loom Link and Loom Power together to the DP drive.(3.5Nm)  : 링크 룸과 파워 룸을 함께 DP 드라이브에 3.5Nm로 조립 하시오. | | | | | | | | | | | |
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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0630** | | | | | | | | | | | | | **M** | **S** | | **OP0640** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1 | | D37480920 | | | |  | | | HEATER MOD LV M/PACK (X20) IXH | | | | | | 1 |  | | D37481050 | | |  | | MLD COVER | | | | 1 |
|  | | 218680014 | | | |  | | | M4 X 12 POZI HD SEMS | | | | | | 4 |  | | 218680014 | | |  | | M4 X 12 POZI HD SEMS | | | | 6 |
| 2 | | K50002002 | | | |  | | | LOOM SIG 8W HEATER, AMP, 600V, 575LG IXH | | | | | | 1 |  | |  | | |  | |  | | | |  |
| XD+ LV | | K50005610 | | | |  | | | HEATER MODULE LV G5 | | | | | | 1 |  | |  | | |  | |  | | | |  |
| XD+ HV | | K50005620 | | | |  | | | HEATER MODULE HV G5 | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| K50002002  **MK2**  **1**  **2** | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Assemble the Heater MOD onto the MB drive.(3.5Nm)(히터 모듈을 부스터 드라이브에 3.5Nm로 조립 하시오.)  : Fit Loom SIG which belongs to the bag of heater mod.(히터 모듈 백에 함께 동봉 된 SIG 룸을 조립 하시오.)  : Fit all Looms to the heater mod. (모든 룸을 히터 모듈에 연결 하시오.)  : Assemble Heated MB Kit onto the MB referring to R5~R6 page.  : R5~R6 페이지를 참고하여 부스터 히터 키트를 17Nm로 조립하시오.. | | | | | | | | | | | | | | | | Instruction:  : Assemble the MLD and Heater Mod Covers.  : 몰드, 히터 모듈 커버를 조립 하시오.  : Assemble Drive loom onto MB snap switch as shown.  **: 드라이브 룸을 보이는 것과 같이 MB 스냅스위치에 조립하시오.** | | | | | | | | | | | |
| Page | | **370** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0650** | | | | | | | | | | | | | **M** | **S** | | **OP0660** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | D37517000 | | | |  | | | T170 CONTROLLER | | | | | | 1 |  | | K50003005 | | |  | | LOOM TMS 5X WATER COOLING AMP, 600V, IXH | | | | 1 |
|  | | 218680014 | | | |  | | | SCREW SEM M4X12 PZZN+CPAS !P! | | | | | | 4 |  | |  | | |  | |  | | | |  |
| 1 | | D37480105 | | | |  | | | SPRING RFI G4 DRIVE/CNTER | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| **MK2** | | | | | | | | | | | | | | | | **회색**  **흰색**  **노란색**  **빨간색**  **보라색**  **K50003005** | | | | | | | | | | | |
| Instruction:  : Assemble T170 Controller as shown. (3.5Nm)  : T170 컨트롤러를 3.5Nm로 조립하시오.  : Assemble Spring RFI onto the DP drive.  : 스프링을 DP 드라이브에 조립 하시오. | | | | | | | | | | | | | | | | Instruction:  : Fit TMS Loom to the counter parts as shown.  : 그림과 같이 TMS 룸을 연결 하시오. | | | | | | | | | | | |
| Page | | **380** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0670** | | | | | | | | | | | | | **M** | **S** | | **OP0680** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | A55645047 | | | |  | | | SWIVEL CLIP ASSY | | | | | | 3 |  | | A55645047 | | |  | | SWIVEL CLIP ASSY | | | | 12 |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Fit clip to the TMS Pipes as shown.  : 그림과 같이 클립을 파이프에 조립하시오. | | | | | | | | | | | | | | | | Instruction:  : Fit clip to the TMS Pipes as shown.  : 그림과 같이 클립을 파이프에 조립하시오. | | | | | | | | | | | |
| Page | | **390** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0683** | | | | | | | | | | | | | **M** | **S** | | **OP0687** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | A55645047 | | | |  | | | SWIVEL CLIP ASSY | | | | | | 2 |  | | A55645047 | | |  | | SWIVEL CLIP ASSY | | | | 9 |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Fit clip to the TMS Pipes as shown.  : 그림과 같이 클립을 파이프에 조립하시오. | | | | | | | | | | | | | | | | Instruction:  : Fit clip to the TMS Pipes as shown.  : 그림과 같이 클립을 파이프에 조립하시오. | | | | | | | | | | | |
| Page | | **395** | | Issue | | **15** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | | | SOP No. | | | **SOPKR1663** | | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0690** | | | | | | | | | | | | | | | | | **M** | **S** | | **OP0000** | | | | | | | |
| Ref. | | | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | Qty. | |
|  | | | | B21924150 | | | |  | | | CABLE TIE | | | | | | | | 1 |  | |  | | |  | |  | |  | |
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| 1220HTXS STD | | | | | | 1820HTXS STD | | | |  | | | | 1820HTXS HYX | | | 1220HTXS 50025241 | | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 |
| 1220HTXS XD+ | | | | | | 1820HTXS XD+ | | | | 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ Hynix |
| **DASH**  **BOARD**  **GAS MODULE**  **HEATED**  **EXHAUST**  TMS Cable  **DRY PUMP THERMISTER**  DRY PUMP  Inverter cable  Heater module  **BOOSTER THERMISTER**  EMS  For Intel, there is no EMS loom.  **:Intel의 경우 EMS 룸이 없다.** | | | | | | | | | | | | | | | | | | | | **BLANK** | | | | | | | | | | |
| Instruction:  : Tie cable tie as shown.  : Fit connectors to Control Module following procedure as shown.  **: 그림과 같이 케이블타이를 묶으시오.**  **: 그림과 같이 순서에 맞게 커넥터를 끼우시오.** | | | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | |
| Page | | **400** | | | Issue | | **02** | | Approved | | |  | | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | |
| **M** | **S** | | **OP0700** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | |  | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| **X**  **O**  **X**  **1**  **2**  **3**  **4**  **5**  **6** | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Instruction:  : Arrange all Looms as shown. Dashboard cable should be put on the bottom than other cables.  : 그림과 같이 모든 룸을 정리하시오. 대시보드 케이블을 가장 아래에 위치하세요. | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Page | | **410** | | Issue | | **10** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v4.doc | | |

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|  | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0710** | | | | | | | | | | | | | **M** | **S** | | **OP0720** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | M56400022 | | | |  | | | DRIP\_TRAY\_200HP | | | | | | 1 |  | | M66930018 | | |  | | SIDE PANEL 901MM LG | | | | 2 |
|  | | 218680023 | | | |  | | | M5X12 POZI HD SEMS | | | | | | 4 | 1820 | | M66930020 | | |  | | TOP PANEL 1820 ASSY | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 1220 | | M66920020 | | |  | | TOP PANEL 1220 ASSY | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  |  | | 218680023 | | |  | | M5X12 POZI HD SEMS | | | | 20 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 1220HTXS STD | | | | | 1820HTXS STD | | |  | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | 1220HTXS STD | | | | 1820HTXS STD | |  | | 1820HTXS HYX | | 1220HTXS 50025241 | |
| 1220HTXS XD+ | | | | | 1820HTXS XD+ | | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
|  | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:  : Assemble Drip tray to the bulkheads.  : 그림과 같이 드립 트레이를 조립 하시오. | | | | | | | | | | | | | | | | Instruction:  : Assemble all Panels.  : 모든 판넬을 조립 하시오.  : Tighten all screws which were pre-tightened. (20Nm)  : 가 조립 되었던 모든 스크류를 20Nm로 조이시오. | | | | | | | | | | | |
| Page | | **420** | | Issue | | **02** | Approved | | |  | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | |

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|  | | | | | | | | | | | | | | SOP No. | | | **SOPKR1663** | | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | | | |
| **M** | **S** | | | **OP0730** | | | | | | | | | | | | | | | | | **M** | **S** | | **OP0740** | | | | | | | | | | |
| Ref. | | | Man.Item No. | | | | | Ser.Item No. | | | Description | | | | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | | Qty. | |
|  | | | D37480550 | | | | |  | | | | PASSIVE ACCESSORY MODULE | | | | | | | | 1 |  | | D37207061 | | |  | | | CONNECTOR PLUG 06 IL CM XLRLNK | | | | 1 | | |
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| 1220HTXS STD | | | | | | 1820HTXS STD | | | |  | | | | | 1820HTXS HYX | | | 1220HTXS 50025241 | | | 1220HTXS STD | | | | 1820HTXS STD | |  | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | | |
| 1220HTXS XD+ | | | | | | 1820HTXS XD+ | | | | 1220HTXS XD+ | | | | | | 1820HTXS XD+ | | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | | 1820HTXS XD+ | | | | 1820HTXS XD+ Hynix | | |
|  | | | | | | | | | | | | | | | | | | | | | **D37207061 EMS Plug**  Instruction :  iXH1220HTXS INTEL variants의 System 조립 시 EMS plug를 control module에 연결하고 Finish off에서는 EMS plug를 제거하지 않고 Packing 한다. | | | | | | | | | | | | | | | |
| Instruction:   * Assemble Passive Accessory Module as shown. * **그림과 같이 패시브 액세서리 모듈을 조립하시오.** | | | | | | | | | | | | | | | | | | | | | Instruction:   * Assemble EMS Plug in case of iXH1220HTXS 50025241 Variant. * **iXH1220HTXS Intel Variant인 경우 EMS Plug를 조립하시오.** | | | | | | | | | | | | | | | |
| Page | | **430** | | | Issue | | **02** | | Approved | | | |  | | | | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | | | | |

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|  | | | | | | | | | | | | | | | SOP No. | | **SOPKR1663** | | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | | | | |
| **M** | **S** | | | **OP0750** | | | | | | | | | | | | | | | | | **M** | **S** | | **OP0760** | | | | | | | | | | | |
| Ref. | | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | | | Qty. | |
|  | | | A20007171 | | | | |  | | | | LABEL ETL-US KOREA | | | | | | | | 1 |  | | A20007171 | | |  | | | LABEL ETL-US KOREA | | | | | 1 | | |
|  | | | A20001657 | | | | |  | | | | LABEL - ROHS (20 YEAR) | | | | | | | | 1 |  | | A20001657 | | |  | | LABEL - ROHS (20 YEAR) | | | | | | 1 | |
|  | | | A20007044 | | | | |  | | | | PUMP LABEL - COMMON (KOREA) | | | | | | | | 1 |  | | A20007044 | | |  | | PUMP LABEL - COMMON (KOREA) | | | | | | 1 | |
|  | | | A20001832 | | | | |  | | | | LABEL-MAINS SCCR 200-230V 38A | | | | | | | | 1 |  | | A20001832 | | |  | | LABEL-MAINS SCCR 200-230V 38A | | | | | | 1 | |
|  | | | A20007197 | | | | |  | | | | LABEL-MAINS INPUT 380-480V MAX.20A | | | | | | | | 1 |  | | A20007197 | | |  | | LABEL-MAINS INPUT 380-480V MAX.20A | | | | | | 1 | |
| XD+ LV | | | A20008985 | | | | |  | | | | LABEL-MAINS SCCR 200-230V 40A | | | | | | | | 1 |  | |  | | |  | |  | | | | | |  | |
| XD+ HV | | | A20008986 | | | | |  | | | | LABEL-MAINS SCCR 380-480V 26A | | | | | | | | 1 |  | |  | | |  | |  | | | | | |  | |
| 1220HTXS STD | | | | | | 1820HTXS STD | | | | |  | | 1820HTXS HYX | | | | | 1220HTXS 50025241 | | | 1220HTXS STD | | | | 1820HTXS STD | |  | | | 1820HTXS HYX | | | 1220HTXS 50025241 | | | | |
| 1220HTXS XD+ | | | | | | 1820HTXS XD+ | | | | 1220HTXS XD+ | | | | | | 1820HTXS XD+ | | | 1820HTXS XD+ Hynix | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | 1220HTXS XD+ | | | | 1820HTXS XD+ | | | | 1820HTXS XD+ Hynix | | |
|  | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | |
| Instruction:   * Attach Labels as shown. * **그림과 같이 Label을 부착하시오.** | | | | | | | | | | | | | | | | | | | | | Instruction:   * Attach Labels as shown. * **그림과 같이 Label을 부착하시오**   **.** | | | | | | | | | | | | | | | | |
| Page | | **440** | | | Issue | | **15** | | Approved | | | | |  | | | | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v6.doc | | | | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1663** | | | Title: | | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | | | | | | | | | |
| **M** | **S** | | **OP0770** | | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | | Ref. | | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
|  | | A20007139 | | | |  | | | | LABEL - XCEDE LOGO | | | | | | 1 | |  | |  | |  | |  | | | |  |
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| 1220HTXS STD | | | | 1820HTXS STD | | | |  | | | | | 1820HTXS HYX | | 1220HTXS 50025241 | | | 1220HTXS XD+ | | | 1820HTXS XD+ | | 1220HTXS XD+ | | 1820HTXS XD+ | | 1820HTXS XD+ Hynix | |
| TDS017548 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Instruction:   * After adjusting TDS017548 on photo’s position, attach the XCEDE label(A20007139) * **TDS017548을 사진 위치에 맞추고, XCEDE label(A20007139)를 부착하시오.** | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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|  | | | | | | SOP No. | **SOPKR1663** | Title: | **iXH1220&1820HTXS SYSTEM ASSEMBLY(MK2)** | |
| |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | | **Standard Tool Description** | **Qty** | **M / S** | **Special Tool No.** | **Special Tool Description** | **Qty** | **M / S** | | Torque Wrench 17Nm | 2 | M/S |  |  |  |  | | Air Torque Wrench 17Nm | 1 | M/S |  |  |  |  | | Torque Wrench 20Nm | 3 | M/S |  |  |  |  | | Electrical Torque Wrench 20Nm | 1 | M/S |  |  |  |  | | Torque Wrench 10Nm | 2 | M/S |  |  |  |  | | Torque Driver 2.8Nm | 2 | M/S |  |  |  |  | | Torque Driver 2Nm | 3 | M/S |  |  |  |  | | Torque Wrench 30Nm | 2 | M/S |  |  |  |  | | Torque Wrench 7Nm | 1 | M/S |  |  |  |  | | Torque Driver 7Nm | 1 | M/S |  |  |  |  | | Torque Wrench 4.5Nm | 1 | M/S |  |  |  |  | | Torque Wrench 3.5Nm | 3 | M/S |  |  |  |  | | Digital Pressurs Gauge | 1 | M/S |  |  |  |  | | Clare Genie Safety Electrical Test | 1 | M/S |  |  |  |  | | Air Torque Wrench 30Nm | 1 | M/S |  |  |  |  | | Torque Driver 30Nm | 1 | M/S |  |  |  |  | | Hex Wrench 4mm | 2 | M/S |  |  |  |  | | Hex Wrench 3mm | 2 | M/S |  |  |  |  | | Spanner 5/8 | 3 | M/S |  |  |  |  | | Spanner 9/16 | 3 | M/S |  |  |  |  | | Cross driver | 3 | M/S |  |  |  |  | | 21Nm Torque Wrench-9/16” Spanner Attachment | 1 | M/S |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | |  |  |  |  |  |  |  | | | | | | | | | | | |
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