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|  | | | | | | SOP No. | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | |
| Products applicable to | | | | | | | Page | | Issue | Page | Issue | Change History | | Date updated and by whom |
| |  |  | | --- | --- | | **Item No.** | **Description** | | A41600959 | G4 100RC HP XD PUMP 7.5KW SG HV | | A41600958 | G4 100RC HP XD PUMP 7.5KW SG LV | | A41607959 | G4 100RC LP XD PUMP 4.5KW SG HV | | A41607958 | G4 100RC LP XD PUMP 4.5KW SG LV | | A41601958 | G4 200HP PUMP 7.5KW LV XCD | | A41601959 | G4 200RC HP XD PUMP 7.5KW SG HV | | A41602958 | G4 200RC LP XD PUMP 7.5KW SG LV | | A41603959 | G4 300RC LP XD PUMP 7.5KW SG HV | | A41603958 | G4 300RC LP XD PUMP 7.5KW SG LV | | A41648959 | G4 500RC HP XD PUMP 11KW HV | | A41648958 | G4 500RC HP XD PUMP 11KW LV | | A42656959 | NB G4 100RC HP XD PUMP 7.5KW SG HV | | A42656958 | NB G4 100RC HP XD PUMP 7.5KW SG LV | | A42661959 | NB G4 100RC LP XD PUMP 4.5KW SG HV | | A42661958 | NB G4 100RC LP XD PUMP 4.5KW SG LV | | A42642958 | NB G4 200HP PUMP 7.5KW LV XCD WB | | A42642959 | NB G4 200RC HP XD PUMP 7.5KW SG HV | | A42660958 | NB G4 200RC LP XD PUMP 7.5KW SG LV | | A42646959 | NB G4 300RC LP XD PUMP 7.5KW SG HV | | A42646958 | NB G4 300RC LP XD PUMP 7.5KW SG LV WB | | A42643959 | NB G4 500RC HP XD PUMP 11KW HV WB | | A42643958 | NB G4 500RC HP XD PUMP 11KW LV WB | | A41672958 | NB G4 200HP S XD+ PUMP 7.5KW LV WB | | A41672959 | NB G4 200HP S XD+ PUMP 7.5KW HV WB |   Service Note: For Service Spares P/Ns, please refer to the parts manuals. Spares Head plates or spares stators are come without dowels. If replacement is required for any headplate or stator, please refer to SOPKR0109 for the doweling operations. | | | | | | | F1  H1  R6  R1  R4  R5  10  20  30  33  37  40  50  60  70  80  90  100  110  120  130  140  150  160  170  180  190  200  210  220  230  240  250  260  270  280  290  300  310  320  330  335  340  350 | | 10  10  05  05  03  02  10  10  10  10  10  10  10  02  10  10  02  10  10  02  02  05  10  02  10  02  10  02  02  02  02  03  03  02  02  02  02  02  02  05  10  10  10  10 | 360  370  380  390  400  410  420  430  440  450  460  470  480  490  500  510  520  530  540  550  560  R2  570  580  590  600  610  620  630  640  650  660  670  680  690  700  710  720  730  740  750  B1  B2 | 02  02  02  02  02  02  02  07  02  03  03  06  02  02  02  02  02  02  04  09  02  02  07  07  07  04  02  02  02  04  02  02  08  02  02  02  02  02  05  05  05  01  06 | Issue 01  First issue.  Issue 02  Add new variants.  Issue 03  Added R4: Bearing handling.  Added R5: XCEDE reference “do not prep”  Page 250 OP450 changed picture to show correct TDS.  Page 260 OP460 changed picture to show correct TDS.  Page 460 OP860 Added TDS numbers for new axle setting ring adjustment tools  Page 470 OP880 Added TDS numbers for new axle setting ring adjustment tools.  B2 ADDED TDS number for new axle setting ring adjustment tools  Issue 04  Page600\_OP1100 / Page640\_OP1190: Added item for Non-bead type  Page 550\_OP1010: Added symbol for i-marking  Issue 05  F1 updated to new templates  Deleted F2/ F3/F4  Added R7 symbols reference  R1 updated i-mark colour for PC to red.  Page 40 OP0070 Added “Hazard finger trap” symbol  Page 70 OP0120 Added “Hazard finger trap” symbol  Page 100 OP0170 Added “Hazard finger trap” symbol  Page 140 OP0240 Added “Hazard finger trap” symbol  Page 170 OP0290 Added “Hazard finger trap” symbol  Page 320 OP0580Added bolt specification for attaching DP to turn over jig  EC11331  Deleted R3 sintered filters now moved to systems SOP.  Page 730 OP1350/1360 removed filters.  Page 740 OP1370 added blanking plates only 100/150crs.  Page 750 OP1390 updated Leak rate from1X10-6 to 5.0X10-6  Issue 06  F1 updated to issue 09 for change to history date column  Changed to “Date updated and by whom”.  Page 470 OP870 added TDK220051 for full float measurement. OP880added note to remove TDK220051  B2 added TDK220051.  Reviewed All page’s symbols and amended where required. | | 2017-06-23  2017-08-01  2017-09-27  R Prodger  2021-09-09  Eddie Yu  2021/11/02  R Prodger  2022/02/25  R Prodger |
| Page | **F1** | Issue | **10** | Approved | Daniel.Park | | | | | | | | SOP TEMPLATE – FRONT SHEET LANDSCAPE v9.doc | |

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|  | | | | | | SOP No. | **SOPKR1662** | | Title: | **iXH XD Pump Cartridge Build** | | |
| Change History | | | | | | | | Updated | | Change History | | Date updated and by whom |
| Issue 07  Added H1 History template.  Page 110 OP190 correct X2 to X & Y for retractable dowel depth.  Page 430 OP790 Showed correct orientation for 100crs oil throwers.  Page 570 OP1050 made OP 100crs only for shaft and gear run out due to confusion.  Page 580 OP1060 made OP 150crs only for shaft and gear run out, updated pictures to show correct location for X/Y gear face check due to confusion.  Page 590 OP1080 Updated rolling clearance to make clearer to requirement  Issue 08  Page F1 : Added new pump variants for Non-bead type by EC13902  Page 670 OP1240 : changed all Motor type from MK1 to MK2 by EC13623  Issue 09  Page 550 OP1010 : added instruction for Y gear assembly sequence.  Issue 10  Page F1 : Added new 2 items(A41672958, A41672959)  Page H1 : Updated Issue10 History  Page10 OP0020 : Added new 2 shafts(A41672930, A41672931) which used to new 200HP S XD+ variants  Page20 OP0040 : Added new HV stator(A41672917) which used to new 200HP S XD+ variants  Page30 OP0050 : Moved checking 50um feeler gauge from OP0060 to OP0050 because it shouldn’t remove shaft jig in case of 200HP S XD+.  Page33 OP0062 : Added new operation which fit FKM o-ring due to new 200HP S XD+ variants.  Page33 OP0065 : Added new operation which fit new 2nd stage stator(XD) due to new 200HP S XD+ variants.  Page37 OP0067 : Added new operation which fit bolts due to new 200HP S XD+ variants.  Page40 OP0070 : Added new 2nd rotors(XD) which used to new 200HP S XD+ variants  Page40 OP0080 : Added H02137011(FFKM o-ring) which used to new 200HP S XD+  Page50 OP0100 : Added new 3rd stator(XD) which used to new 200HP S XD+ variants  Page70 OP0120 : Added 200HP S XD+ variants in used 3rd rotors  Page70 OP0130 : Added H02137011(FFKM o-ring) which used to new 200HP S XD+  Page80 OP0150 : Added new 4th stator(XD) which used to new 200HP S XD+ variants  Page100 OP0170 : Added 200HP S XD+ variants in used 4th rotors  Page110 OP0200 : Added H02137011(FFKM o-ring) which used to new 200HP S XD+  Page 120 OP0210 : Applicable only 100LP & 200LLP(SOP correction)  Page 130 OP0230 : Applicable only 100LP & 200LLP(SOP correction)  Page150 OP0270 : Added new LV stator(XD) which used to new 200HP S XD+ variants  Page170 OP0290 : Added 200HP S XD+ variants in used LV rotors  Page190 OP0330 : Added H02137011(FFKM o-ring) which used to new 200HP S XD+  Page190 OP0340 : Added new LV headplate(XD) which used to new 200HP S XD+ variants  Page330 OP0603 : Added new operation which fit FKM o-ring & XD HV TBP due to new 200HP S XD+ variants.  Page335 OP0607 : Added new operation which fit FKM o-ring & thermal spacer ceramic due to new 200HP S XD+ variants. | | | | | | | | 2022/07/15  R Prodger  2022/07/29  Joel Kim  2022/11/03  Joel Kim  2022/11/06  Evan Kim | | Page335 OP0610 : Moved fit spacer operation from page330. / Added A41672143(New spacer) which used to new 200HP S XD+  Page340 OP0630 : Added new HV headplate(XD) which used to new 200HP S XD+ variants  Page350 OP0640 : Added new bolts which used to new 200HP S XD+ variants | |  |
| Page | **H1** | Issue | **10** | Approved | Daniel.Park | | | | | | SOP TEMPLATE – HISTORY SHEET LANDSCAPE v9.doc | |

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|  | | | | | SOP No. | | **SOPKR1662** | | Title: | | **iXH XD Pump Cartridge Build** | |
| **Symbols** | | | | | | | | | | | | |
|  | 제거  Remove | | | | | | |  | | 권상 리프트 사용  Overhead lift required | | |
|  | 확인  Check | | | | | | |  | | 영구 표식  Indelible mark | | |
|  | 벌려진 각도가 45º을 넘지 않게 하시오  Maximum span angle 45º | | | | | | |  | | 최대압력(bar)  Maximum Pressure (bar) | | |
|  | 중량물  Hazard Heavy object | | | | | | |  | | 조립위치로 밀어 넣으시오  Push home | | |
|  | 조립위치로 밀어 넣으시오  Hand tight by tool | | | | | | |  | | 표면 크리닝  Clean surface | | |
|  | 손으로 조립/해체하시오  Hand assemble / disassemble | | | | | | |  | | 검사  Inspect | | |
|  | 정상  Correct | | | | | | |  | | Fomblin 오일  Fomblin oil | | |
|  | 비정상  Incorrect | | | | | | |  | | Fomblin 그리스  Fomblin Grease | | |
|  | 측정  Measure | | | | | | |  | | 토크알림- 제한 XXXNm  Torque XXX Nm | | |
|  | 관리양식에 기록  Record on build sheet | | | | | | |  | | 록타이트 알림 – 제한 XXX  Loctite XXX | | |
|  | 시계방향으로 돌리시오  Turn clockwise | | | | | | |  | | 물림위험  Hazard Finger trap | | |
|  | 시계반대방향으로 돌리시오  Turn anti-clockwise | | | | | | |  | |  | | |
| Page | R6 | Issue | 05 | Approved | | Daniel.Park | | | | | | SOP TEMPLATE –SYMBOLS SHEET LANDSCAPE v8.doc |

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|  | | | | | | | | SOP No. | **SOPKR1662** | Title: | **iXH XD Pump Cartridge Build** | |
| **M** | | **S** | | **Instruction for bolts** | | | | | | | | |
| Refer to symbol for marking  심볼을 참조 하시오  **Apply “I” Markings 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.** | | | | | | | | | | | | |
| Instruction:  **모터에 조립시 사용 되는**  **모든 볼트에 아이 마킹 하시오..**  **Apply I-marking to all bolt with motor**  **Apply “I” Markings 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.**   * **Red colour use in Production, Blue colour use in Service.** * 빨간색**은 생산, 파란색은 서비스에서 사용** | | | | | | | | | | | | |
| Page | **R1** | | Issue | | **05** | Approved | Daniel.Park | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc |

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|  | | | | | | | | SOP No. | **SOPKR1662** | Title: | **iXH XD Pump Cartridge Build** | |
| **M** | | **S** | | **Instruction for bolts** | | | | | | | | |
| **PREPERATION MUST NOT BE PERFORMED ON XCEDE COMPONENTS UNDER ANY CIRCUMSTANCES.** | | | | | | | | | | | | |
| Page | **R4** | | Issue | | **03** | Approved | Daniel.Park | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc |

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|  | | | | | | | | SOP No. | | | **SOPKR1662** | | Title: | **iXH XD Pump Cartridge Build** | | | | |
| **M** | | **S** | | **Bearing Handling** | | | | | | | | | | | | | | |
| 300LLP | | | | | 200HP | | 500HP | | | 200LLP | | P2 300LLP | 300LLP | | 200HP | 500HP | 200LLP | P2 300LLP |
| 200LLP XD | | | | | P2 300LLP XD | | 500H SG-NR | | | 200H SG | |  | 200LLP XD | | P2 300LLP XD | 500H SG-NR | 200H SG |  |
|  | | | | |  | |  | | |  | |  |  | |  |  |  |  |
| **DO NOT OPEN BEARINGS UNTILL READY TO USE** | | | | | | | | | | | | | **1**    **2**    **4**  **3** | | | | | |
| Instruction: | | | | | | | | | | | | | Instruction: | | | | | |
| Page | **R5** | | Issue | | **03** | Approved | | | Daniel.Park | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | |

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|  | | | | | | | | | | | SOP No. | | | | **SOPKR1662** | | | Title | | **iXH XD Pump Cartridge Build** | | | | | | | | | | | | |
| **M** | **S** | | | **OP0010** | | | | | | | | | | | | | | **M** | **S** | | | **OP0020** | | | | | | | | | | | |
| Ref. | | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | Qty. | Ref. | | | Man item N  X | | Ser item No  X | | Man item N  Y | | Ser item No  Y | | Description | | | Qty. | |
|  | | |  | | | | |  | | | |  | | | | |  | 0020/0030 | | | A41207130 | | A41207730 | | A41207131 | | A41207731 | | X Shaft / Y shaft 100LP | | | 1/1 | |
|  | | |  | | | | |  | | | |  | | | | |  | 0020/0030 | | | A41200130 | | A41200730 | | A41200131 | | A41200731 | | X Shaft / Y shaft 100HP | | | 1/1 | |
|  | | |  | | | | |  | | | |  | | | | |  | 0020/0030 | | | A41202130 | | A41202730 | | A41202131 | | A41202731 | | X Shaft / Y shaft 200LP | | | 1/1 | |
|  | | |  | | | | |  | | | |  | | | | |  | 0020/0030 | | | A41201130 | | A41201730 | | A41201131 | | A41201731 | | X Shaft / Y shaft 200HP | | | 1/1 | |
|  | | |  | | | | |  | | | |  | | | | |  | 0020/0030 | | | A41203130 | | A41203730 | | A41203131 | | A41203731 | | X Shaft / Y shaft 300LP | | | 1/1 | |
|  | | |  | | | | |  | | | |  | | | | |  | 0020/0030 | | | A41248130 | | A41248730 | | A41248131 | | A41248731 | | X Shaft / Y shaft 500NR | | | 1/1 | |
|  | | |  | | | | |  | | | |  | | | | |  | 0020/0030 | | | A41672930 | | TBD | | A41672931 | | TBD | | X Shaft / Y shaft 200HP S XD+ | | | 1/1 | |
|  | | |  | | | | |  | | | |  | | | | |  |  | | |  | |  | |  | |  | |  | | |  | |
|  | | |  | | | | |  | | | |  | | | | |  |  | | |  | |  | |  | |  | |  | | |  | |
| 100LP XD | | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | | 100HP XD | | 200LP XD | | 200HP XD | | | 300LP XD | | |
| 500HP XD | | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | | 200HP S XD+ | |  | |  | | |  | | |
|  | | | | | |  | | |  | | | |  | | |  | |  | | | | | |  | |  | |  | | |  | | |
|  | | | | | |  | | |  | | | |  | | |  | |  | | | | | |  | |  | |  | | |  | | |
| 100Ctrs TDS012306  150Ctrs TDS012200  Kitted Caravan  TDS012511 | | | | | | | | | | | | | | | | | | Y shaft TDS012209  X shaft TDS012231  **1**  **2**  From Caravan  To Build Fixture | | | | | | | | | | | | | | | |
| Instruction:   * Service Note: Service use local kitting baskets instead of TDS012511. | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | | | | |
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| **M** | **S** | | **OP0030** | | | | | | | | | | | | | **M** | **S** | | **OP0040** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | |  | | | | | |  | 0040 | | A41200517 | | | A41200717 | | HV/2nd Stage Stator 100LP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0040 | | A41200517 | | | A41200717 | | HV/2nd Stage Stator 100HP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0040 | | A41202017 | | | A41202717 | | HV/2nd Stage Stator 200LP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0040 | | A41201017 | | | A41201717 | | HV/2nd Stage Stator 200HP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0040 | | A41203017 | | | A41203717 | | HV/2nd Stage Stator 300LP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0040 | | A41205017 | | | A41205717 | | HV/2nd Stage Stator 500NR | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0040 | | A41672917 | | | TBD | | HV STAGE STATOR - PLATING XD 200HP S XD+ | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  |
| 100LP XD | | | | | 100HP XD | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| 150Ctrs TDS012222  100Ctrs TDS012124 | | | | | | | | | | | | | | | | 150Ctrs Use Lifting Magnet  100Ctrs Use M10 Eye bolts | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction:   * Service Note: For 100Crs Flow line, use IS0200386 for lifting. | | | | | | | | | | | |
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| **M** | **S** | | **OP0050** | | | | | | | | | | | | | **M** | **S** | | **OP0060** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **<50µm**  **x2**  Paint blue if NR pump  24mm hex socket +  40Nm torque wrench  **x4**  50um feeler gauge | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:   * Note: If NR pump – Paint blue as indicated | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **30** | | Issue | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0062** | | | | | | | | | | | | | **M** | **S** | | **OP0065** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty |
|  | | H02134011 | | | |  | | | O-RING FKM HP 255.5ID X 4.0SEC | | | | | | 1 |  | | A41672918 | | |  | | 2ND STAGE STATOR - PLATING XD | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| Instruction:  : Doing cleaning the O’ring groove before assembing O’ring,  : 오링을 조립하기 전에 오링 그르브를 클리닝 하시오.  : Fit FKM o-ring to HV stator as shown.  : 보이는 것과 같이 FKM 오링을 HV stator에 조립하시오. | | | | | | | | | | | | | | | | Instruction:  : Fit 2nd stator onto HV stator as shown.  : 보이는 것과 같이 2nd stator를 HV stator에 핏하시오.  : Remove shaft alignment jig after assembled 2nd stator.  : 2nd stator를 조립한 후에 shaft alignment jig를 제거하시오   * Service Note: For 100Crs Flow line, use IS0200386 for lifting. | | | | | | | | | | | |
| Page | | **33** | | Issue | | **10** | | Approved | | | |  | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0067** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 0090 | | 218091453 | | | |  | | | SCREW CAP HT M10X30 G12.9 100C | | | | | | | 8 |  |  | |  | |  | | | |  |
|  | |  | | | |  | | |  | | | | | | |  |  |  | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | |  | |  | |  | |  | |
| Instruction:   * 1. Rotate the key to the right position. Choose 100 Centre or 150 Centre * 1. 조립중인 펌프를 확인하고 키를 100센터 또는 150센터로 돌려 선택하시오. * 2. Turn it back to original position. * 2. 키를 원래의 위치(가운데)로 돌려 놓으시오. * 3. Fix as number sequence at 55Nm torque. * 3. 순서대로 스크류를 조립하여 55Nm로 조이시오. * 4. Check the blue light illuminate * 4. 스크류 조립이 완료되면 Andon light의 파란색 램프가 점등되었는지 확인하시오.   + ***Tensor driver의 전원 차단 금지 !! (프로그램이 초기화 됨)***   Service Note: Service uses 55Nm manual torque Wrench and follows the same tightening sequence. | | | | | | | | | | | | | **1**  **3**  **11**  **12**  **8**  **6**  **9**  **2**  **4**  **10**  **5**  **7**  **Screw Tightening Pattern**  The same for all stators   * ***100Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8   * ***150Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8🡪9🡪10🡪11🡪12  : Error  : Error  : Pass  : Process clear  **Tip**  **1**  **100Ctrs**  **150Ctrs**  **2**  **3** | | | | | | | | | | | | | |
| Page | | **37** | | Issue | | **10** | Approved | | |  | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | | SOP No. | | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | |
| **M** | **S** | | | **OP0070** | | | | | | | | | | | | | | | | **M** | **S** | **OP0080** | | | | | | | | |
| Ref. | | | Man item No X2 | | | | Ser item No  X2 | | | | Man item No Y2 | Ser item No  Y2 | | | | Description | | | Qty | Ref. | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty |
| 0050/0060 | | | A41207132 | | | | A41207732 | | | | A41207133 | A41207733 | | | | X2/Y2 R0TOR SG 100LP | | | 1 | 1090 | H02134011 | | | A41200816 KIT | | ORING VIT9830 255.5ID X 4.0SEC 100C | | | | 1 |
| 0050/0060 | | | A41200132 | | | | A41200732 | | | | A41200133 | A41200733 | | | | X2/Y2 R0TOR SG 100HP | | | 1 | 0070 | H02134013 | | | A41205816 KIT | | ORING VIT9830 371.5ID X 4.0SEC 150C | | | | 1 |
| 0050/0060 | | | A41202132 | | | | A41202732 | | | | A41202133 | A41202733 | | | | X2/Y2 R0TOR SG 200LP | | | 1 |  | H02137011 | | | H02137711 | | ORING FFKM TSS J8290 252.0ID X 3.88SEC | | | | 1 |
| 0050/0060 | | | A41201132 | | | | A41201732 | | | | A41201133 | A41201733 | | | | X2/Y2 ROTOR SG 200HP | | | 1 |
| 0050/0060 | | | A41203132 | | | | A41203732 | | | | A41203133 | A41203733 | | | | X2/Y2 R0TOR SG 300LP | | | 1 |  |  | | |  | |  | | | |  |
| 0050/0060 | | | A41248133 | | | | A41248732 | | | | A41248133 | A41248733 | | | | X2/Y2 R0TOR SG 500NR | | | 1 |  |  | | |  | |  | | | |  |
| 0050/0060 | | | A41672932 | | | | TBD | | | | A41672933 | TBD | | | | X2./Y2 ROTOR PLATING XD 200HP S XD+ | | | 1 |  |  | | |  | |  | | | |  |
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| 100LP XD | | | | | | 100HP XD | | | 200LP XD | | | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | | 200HP S XD+ | | |  | | | | | |  | | |  | | 500HP XD | | | 200HP S XD+ | |  | |  | |  | |
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| Instruction: | | | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | |
| Page | | **40** | | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0090** | | | | | | | | | | | | | **M** | **S** | | **OP0100** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | |  | | | | | |  | 0080 | | A41200519 | | | A41200719 | | 3rd stage stator 100LP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0080 | | A41600919 | | | A41600719 | | 3rd stage stator - Plated XD 100HP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0080 | | A41600919 | | | A41600719 | | 3rd stage stator - Plated XD 200LP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0080 | | A41601919 | | | A41601719 | | 3rd stage stator - Plated XD 200HP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0080 | | A41601919 | | | A41601719 | | 3rd stage stator - Plated XD 300LP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0080 | | A41205019 | | | A41205719 | | 3rd stage stator 500NR | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0080 | | A41672919 | | | TBD | | 3rd stage stator – Plated XD 200HP S XD+ | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| 150Ctrs TDS012222  100Ctrs TDS012124 | | | | | | | | | | | | | | | | 150Ctrs Use Lifting Magnet  100Ctrs Use M10 Eye bolts | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction:   * Service Note: For 100Crs Flow line, use IS0200386 for lifting. | | | | | | | | | | | |
| Page | | **50** | | Issue | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0110** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 0090 | | 218092453 | | | |  | | | SCR CAP HT ENP M10X30LG G12.9 100C | | | | | | | 8 |  |  | |  | |  | | | |  |
| 0090 | | 218092453 | | | |  | | | SCR CAP HT ENP M10X30LG G12.9 150C | | | | | | | 12 |  |  | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
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| Instruction:   * 1. Rotate the key to the right position. Choose 100 Centre or 150 Centre * 1. 조립중인 펌프를 확인하고 키를 100센터 또는 150센터로 돌려 선택하시오. * 2. Turn it back to original position. * 2. 키를 원래의 위치(가운데)로 돌려 놓으시오. * 3. Fix as number sequence at 55Nm torque. * 3. 순서대로 스크류를 조립하여 55Nm로 조이시오. * 4. Check the blue light illuminate * 4. 스크류 조립이 완료되면 Andon light의 파란색 램프가 점등되었는지 확인하시오.   + ***Tensor driver의 전원 차단 금지 !! (프로그램이 초기화 됨)***   Service Note: Service uses 55Nm manual torque Wrench and follows the same tightening sequence. | | | | | | | | | | | | | **1**  **3**  **11**  **12**  **8**  **6**  **9**  **2**  **4**  **10**  **5**  **7**  **Screw Tightening Pattern**  The same for all stators   * ***100Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8   * ***150Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8🡪9🡪10🡪11🡪12  : Error  : Error  : Pass  : Process clear  **Tip**  **1**  **100Ctrs**  **150Ctrs**  **2**  **3** | | | | | | | | | | | | | |
| Page | | **60** | | Issue | | **02** | Approved | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | | **SOPKR1662** | | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0120** | | | | | | | | | | | | | | | | **M** | **S** | | **OP0130** | | | | | | | | |
| Ref. | | | Man item No X3 | | | Ser item No | | | | Man item No Y3 | | Ser item No | | | | Description | | Qty | Ref. | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
| 0100/0110 | | | A41207134 | | | A41207734 | | | | A41207135 | | A41207735 | | | | X3/Y3 ROTOR SG 100LP | | 1 | 100C | H02134011 | | | | A41200816 KIT | | ORING VIT9830 255.5ID X 4.0SEC 100C | | | | 1 |
| 0100/0110 | | | A41600934 | | | A41600734 | | | | A41600935 | | A41600735 | | | | X3/Y3 ROTOR-Plated  XD 100HP | | 1 | 150C | H02134013 | | | | A41205816 KIT | | ORING VIT9830 371.5ID X 4.0SEC 150C | | | | 1 |
| 0100/0110 | | | A41600934 | | | A41600734 | | | | A41600935 | | A41600735 | | | | X3/Y3 ROTOR-Plated  XD 200LP | | 1 |  | H02137011 | | | | H02137711 | | ORING FFKM TSS J8290 252.0ID X 3.88SEC | | | | 1 |
| 0100/0110 | | | A41601934 | | | A41601734 | | | | A41601935 | | A41601735 | | | | X3/Y3 ROTOR-Plated  XD 200HP / 200HP S XD+ | | 1 |  |  | | | |  | |  | | | |  |
| 0100/0110 | | | A41601934 | | | A41601734 | | | | A41601935 | | A41601735 | | | | X3/Y3 ROTOR-Plated  XD 300LP | | 1 |  |  | | | |  | |  | | | |  |
| 0100/0110 | | | A41248134 | | | A41248734 | | | | A41248135 | | A41248735 | | | | X3/Y3 ROTOR SG 500NR | | 1 |  |  | | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| Instruction: | | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **70** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0140** | | | | | | | | | | | | | **M** | **S** | | **OP0150** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty |
|  | |  | | | |  | | |  | | | | | |  | 0120 | | A41600920 | | | A41600720 | | 4th Stage Stator 100LP-PLATED XD | | | |  |
|  | |  | | | |  | | |  | | | | | |  | 0120 | | A41200520 | | | A41200720 | | 4th Stage Stator 100HP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0120 | | A41200520 | | | A41200720 | | 4th Stage Stator 200LP | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0120 | | A41601920 | | | A41601720 | | 4th Stage Stator 200HP-PLATED XD  XD | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0120 | | A41601920 | | | A41601720 | | 4th Stage Stator 300LP-PLATED XD  XD | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0120 | | A41605920 | | | A41648720 | | 4th Stage Stator 500HP-PLATED XD XD | | | | 1 |
|  | |  | | | |  | | |  | | | | | |  | 0120 | | A41672920 | | | TBD | | 4th STAGE STATOR 200HP S XD+- PLATED XD | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| 150Ctrs TDS012222  100Ctrs TDS012124 | | | | | | | | | | | | | | | | 150Ctrs Use Lifting Magnet  100Ctrs Use M10 Eye bolts | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction:  Service Note: For 100Crs Flow line, use IS0200386 for lifting. | | | | | | | | | | | |
| Page | | **80** | | Issue | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0160** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 0090 | | 218092453 | | | |  | | | SCR CAP HT ENP M10X30LG G12.9 100C | | | | | | | 8 |  |  | |  | |  | | | |  |
| 0090 | | 218092453 | | | |  | | | SCR CAP HT ENP M10X30LG G12.9 150C | | | | | | | 12 |  |  | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | |  | |  | |  | |  | |
| Instruction:   * 1. Rotate the key to the right position. Choose 100 Centre or 150 Centre * 1. 조립중인 펌프를 확인하고 키를 100센터 또는 150센터로 돌려 선택하시오. * 2. Turn it back to original position. * 2. 키를 원래의 위치(가운데)로 돌려 놓으시오. * 3. Fix as number sequence at 55Nm torque. * 3. 순서대로 스크류를 조립하여 55Nm로 조이시오. * 4. Check the blue light illuminate * 4. 스크류 조립이 완료되면 Andon light의 파란색 램프가 점등되었는지 확인하시오.   + ***Tensor driver의 전원 차단 금지 !! (프로그램이 초기화 됨)***   Service Note: Service uses 55Nm manual torque Wrench and follows the same tightening sequence. | | | | | | | | | | | | | **1**  **3**  **11**  **12**  **8**  **6**  **9**  **2**  **4**  **10**  **5**  **7**  **Screw Tightening Pattern**  The same for all stators   * ***100Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8   * ***150Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8🡪9🡪10🡪11🡪12  : Error  : Error  : Pass  : Process clear  **Tip**  **1**  **100Ctrs**  **150Ctrs**  **2**  **3** | | | | | | | | | | | | | |
| Page | | **90** | | Issue | | **02** | Approved | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | | **SOPKR1662** | | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0170** | | | | | | | | | | | | | | | | **M** | **S** | **OP0180** | | | | | | | | |
| Ref. | | | Man item No | | | | Ser item No | | | | Man itemNo | | Ser item No | | | | Description | | Qty | Ref. | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0130/0140 | | | A41607936 | | | | A41607736 | | | | A41607937 | | A41607737 | | | | X4/Y4 ROTOR-Plated XD 100LP | | 1 | 0180 | A41200346 | | | A41200346 | | EXT DOWEL 10DIA X 14LG 100C | | | | 2 |
| 0130/0140 | | | A41600936 | | | | A41600736 | | | | A41600937 | | A41600737 | | | | X4/Y4 ROTOR-Plated XD 100HP | | 1 | 0180 | A41204046 | | | A41204046 | | EXT DOWEL4DIAX18LG 150C | | | | 2 |
| 0130/0140 | | | A41600936 | | | | A41600736 | | | | A41600937 | | A41600737 | | | | X4/Y4 ROTOR-Plated XD 200LP | | 1 |  |  | | |  | |  | | | |  |
| 0130/0140 | | | A41601936 | | | | A41601736 | | | | A41601937 | | A41601737 | | | | X4/Y4 ROTOR-Plated XD 200HP /200HP S XD+ | | 1 |  |  | | |  | |  | | | |  |
| 0130/0140 | | | A41601936 | | | | A41601736 | | | | A41601937 | | A41601737 | | | | X4/Y4 ROTOR-Plated XD 300LP | | 1 |  |  | | |  | |  | | | |  |
| 0130/0140 | | | A41248136 | | | | A41248736 | | | | A41248137 | | A41248737 | | | | X4/Y4 ROTOR NR 500NR | | 1 |  |  | | |  | |  | | | |  |
| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | | 200HP XD | | | | 300LP XD | | 100LP XD | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | | |  | | | | |  | | | |  | | 500HP XD | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | | | | **2**  **x2**  **1**  150Ctrs 24mm spanner or equivalents  100Ctrs 19mm spanner  **4**  150Ctrs TDS012210  100Ctrs TDS012110  **3** | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | |
| Page | | **100** | | | | Issue | | **10** | | Approved | | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0190** | | | | | | | | | | | | | | **M** | **S** | | | **OP0200** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | | |  | | | |  | | | | | |  | 0070 | | H02134011 | | | | A41200816 KIT | | ORING VIT9830 255.5ID X 4.0SEC.100C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 0070 | | H02134013 | | | | A41205816 KIT | | ORING VIT9830 371.5ID X 4.0SEC. 150C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  |  | | H02137011 | | | | H02137711 | | ORING FFKM TSS J8290 252.0ID X 3.88SEC | | | | 1 |
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| 100LP XD | | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
| 100Ctrs < 44.75mm  150Ctrs < 61.50mm  **Dowel Depth Check**  **X & Y**  Vernier callipers | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | | **110** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0210** | | | | | | | | | | | | | | **M** | **S** | | **OP0220** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0158 | | A41607921 | | | | A41607721 | | | | 5th  Stage Stator- Plated XD 100LP | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0158 | | A41648921 | | | | A41648721 | | | | 5th  Stage Stator- Plated XD 500HP | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | |  | | | |  | |  | |  | |  | |
| 500HP XD | | | | | 200HP S XD+ | | | 200LLP XD | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| 150Ctrs Use Lifting Magnet  100Ctrs TDS012129  150Ctrs TDS012223  100Ctrs Use M10 Eye bolts | | | | | | | | | | | | | | | | | **Left Blank** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **120** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0230** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 0090 | | 218092453 | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9 100C | | | | | | 8 |  |  | |  | |  | | | |  |
| 0090 | | 218092453 | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9 150C | | | | | | 12 |  |  | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 500HP XD | | 200HP S XD+ | | 200LLP XD | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | |  | |  | |  | |  | |
| Instruction:   * 1. Rotate the key to the right position. Choose 100 Centre or 150 Centre * 1. 조립중인 펌프를 확인하고 키를 100센터 또는 150센터로 돌려 선택하시오. * 2. Turn it back to original position. * 2. 키를 원래의 위치(가운데)로 돌려 놓으시오. * 3. Fix as number sequence at 55Nm torque. * 3. 순서대로 스크류를 조립하여 55Nm로 조이시오. * 4. Check the blue light illuminate * 4. 스크류 조립이 완료되면 Andon light의 파란색 램프가 점등되었는지 확인하시오.   + ***Tensor driver의 전원 차단 금지 !! (프로그램이 초기화 됨)***   Service Note: Service uses 55Nm manual torque Wrench and follows the same tightening sequence. | | | | | | | | | | | | | **1**  **3**  **11**  **12**  **8**  **6**  **9**  **2**  **4**  **10**  **5**  **7**  **Screw Tightening Pattern**  The same for all stators   * ***100Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8   * ***150Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8🡪9🡪10🡪11🡪12  : Error  : Error  : Pass  : Process clear  **Tip**  **1**  **100Ctrs**  **150Ctrs**  **2**  **3** | | | | | | | | | | | | | |
| Page | | **130** | | Issue | | | **10** | | Approved | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0240** | | | | | | | | | | | | | | **M** | **S** | | | **OP0250** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
| 0130 | | A41607938 | | | | | A41607738 | | | | X5 ROTOR - Plated XD | | | | | | 1 | 0070 | | H02134011 | | | | A41200816 KIT 2 | | ORING VIT9830 255.5ID X 4.0SEC.100CTR | | | | 1 |
| 0140 | | A41607939 | | | | | A41607739 | | | | Y5 ROTOR - Plated XD | | | | | | 1 | 0070 | | H02134013 | | | | A41205816 KIT 2 | | ORING VIT9830 371.5ID X 4.0SEC.150CTR | | | | 1 |
| 0130 | | A41248138 | | | | | A41258738 | | | | X5 ROTOR NR 500NR | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0140 | | A41248139 | | | | | A41248739 | | | | Y5 ROTOR NR 500NR | | | | | | 1 |  | |  | | | |  | |  | | | |  |
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| 100LP XD | | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | | **140** | | Issue | | | **05** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0260** | | | | | | | | | | | | | | **M** | **S** | | **OP0270** | | | | | | | | |
| Ref. | | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | |  | | | |  | | | |  | | | | | |  | 100LP XD | | A41607922 | | | A41607722 | | LV Stage Stator-Plated XD 100LP | | | | 1 |
|  | | |  | | | |  | | | |  | | | | | |  | 100HP XD | | A41600922 | | | A41600722 | | LV Stage Stator-Plated XD 100HP | | | | 1 |
|  | | |  | | | |  | | | |  | | | | | |  | 200LP XD | | A41600922 | | | A41600722 | | LV Stage Stator-Plated XD 200LP | | | | 1 |
|  | | |  | | | |  | | | |  | | | | | |  | 200HP XD | | A41601922 | | | A41601722 | | LV Stage Stator-Plated XD 200HP | | | | 1 |
|  | | |  | | | |  | | | |  | | | | | |  | 300LP XD | | A41601922 | | | A41601722 | | LV Stage Stator-Plated XD 300LP | | | | 1 |
|  | | |  | | | |  | | | |  | | | | | |  | 500HP XD | | A41648922 | | | A41648722 | | LV Stage Stator-Plated XD 500HP | | | | 1 |
|  | | |  | | | |  | | | |  | | | | | |  | 200HP S XD+ | | A41672922 | | | TBD | | LV STATOR - PLATED XD 200HP S XD+ | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| 150Ctrs TDS012223  100Ctrs TDS012129 | | | | | | | | | | | | | | | | | | 150Ctrs Use Lifting Magnet  100Ctrs Use M10 Eye bolts | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **150** | | | | Issue | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0280** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 0090 | | 218092453 | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9 100C | | | | | | | 8 |  |  | |  | |  | | | |  |
| 0090 | | 218092453 | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9 150C | | | | | | | 12 |  |  | |  | |  | | | |  |
|  | |  | | | |  | | | |  | | | | | | |  |  |  | |  | |  | | | |  |
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| 100LP XD | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | | 300LP XD | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
|  | | | |  | | | |  | | | |  | | | |  | |  | |  | |  | |  | |  | |
| Instruction:   * 1. Rotate the key to the right position. Choose 100 Centre or 150 Centre * 1. 조립중인 펌프를 확인하고 키를 100센터 또는 150센터로 돌려 선택하시오. * 2. Turn it back to original position. * 2. 키를 원래의 위치(가운데)로 돌려 놓으시오. * 3. Fix as number sequence at 55Nm torque. * 3. 순서대로 스크류를 조립하여 55Nm로 조이시오. * 4. Check the blue light illuminate * 4. 스크류 조립이 완료되면 Andon light의 파란색 램프가 점등되었는지 확인하시오.   + ***Tensor driver의 전원 차단 금지 !! (프로그램이 초기화 됨)***   Service Note: Service uses 55Nm manual torque Wrench and follows the same tightening sequence. | | | | | | | | | | | | | | **1**  **3**  **11**  **12**  **8**  **6**  **9**  **2**  **4**  **10**  **5**  **7**  **Screw Tightening Pattern**  The same for all stators   * ***100Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8   * ***150Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8🡪9🡪10🡪11🡪12  : Error  : Error  : Pass  : Process clear  **Tip**  **1**  **100Ctrs**  **150Ctrs**  **2**  **3** | | | | | | | | | | | | | |
| Page | | **160** | | | Issue | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0290** | | | | | | | | | | | | | | **M** | **S** | | **OP0300** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0200 | | A41607940 | | | | A41607740 | | | | LV stage Rotor-Plated XD 100LP | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0200 | | A41600940 | | | | A41600740 | | | | LV stage Rotor-Plated XD 100HP | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0200 | | A41600940 | | | | A41600740 | | | | LV stage Rotor-Plated XD 200LP | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0200 | | A41601940 | | | | A41601740 | | | | LV stage Rotor-Plated XD 200HP/200HP S XD+ | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0200 | | A41601940 | | | | A41601740 | | | | LV stage Rotor-Plated XD 300LP | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0200 | | A41248150 | | | | A41248750 | | | | LV stage Rotor 500NR | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| **x2** | | | | | | | | | | | | | | | | | 150Ctrs TDS012354  100Ctrs TDS012312  **x2**  **1**  **2**  **3**  **4**  X- 19mm spanner  Y- 17mm spanner  Y X | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction:   * Do not tighten excessively. | | | | | | | | | | | |
| Page | | **170** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0310** | | | | | | | | | | | | | | **M** | **S** | | **OP0320** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 0160 | | A41215143 | | | A41215743 | | COMMON SPACER.150C | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **<100µm FELLER GAUGE**  1  8  7  6  5  4  3  2  ISO 200395  100um feeler gauge | | | | | | | | | | | | | | | | | 150Ctrs Only | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **180** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0330** | | | | | | | | | | | | | | **M** | **S** | | | **OP0340** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
| 0070 | | H02134011 | | | | A41200816 KIT 2 | | | | ORING VIT9830 255.5ID X 4.0SEC.100C | | | | | | 1 | 0260 | | A41602923 | | | | A41601723 | | LV Head plate-Plated XD 200HP | | | | 1 |
| 0070 | | H02134013 | | | | A41205816 KIT | | | | ORING VIT9830 371.5ID X 4.0SEC.150C | | | | | | 1 | 0260 | | A41602923 | | | | A41601723 | | LV Head plate-Plated XD 300LP | | | | 1 |
|  | | H02137011 | | | | H02137711 | | | | ORING FFKM TSS J8290 252.0ID X 3.88SEC | | | | | | 1 | 0260 | | A41615923 | | | | A41648723 | | LV Head plate-Plated XD 500HP | | | | 1 |
| 0260 | | A41672923 | | | | TBD | | LV HEADPLATE-PLATING XD 200HP S XD+ | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | 150Ctrs Use Lifting Magnet  100Ctrs Use M10 Eye bolts | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction:  Service Note: For 100Crs Flow line, use IS0200386 for lifting. | | | | | | | | | | | | |
| Page | | **190** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | | **OP0350** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 0090 | | 218092453 | | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9, 100C | | | | | | | 8 |  |  | |  | |  | | | |  |
| 0090 | | 218092453 | | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9. 150C | | | | | | | 12 |  |  | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | | 300LP XD | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | | |  | | | |  | | | |  | |  | |  | |  | |  | |  | |
| Instruction:   * 1. Rotate the key to the right position. Choose 100 Centre or 150 Centre * 1. 조립중인 펌프를 확인하고 키를 100센터 또는 150센터로 돌려 선택하시오. * 2. Turn it back to original position. * 2. 키를 원래의 위치(가운데)로 돌려 놓으시오. * 3. Fix as number sequence at 55Nm torque. * 3. 순서대로 스크류를 조립하여 55Nm로 조이시오. * 4. Check the blue light illuminate * 4. 스크류 조립이 완료되면 Andon light의 파란색 램프가 점등되었는지 확인하시오.   + ***Tensor driver의 전원 차단 금지 !! (프로그램이 초기화 됨)***   Service Note: Service uses 55Nm manual torque Wrench and follows the same tightening sequence. | | | | | | | | | | | | | | | **1**  **3**  **11**  **12**  **8**  **6**  **9**  **2**  **4**  **10**  **5**  **7**  **Screw Tightening Pattern**  The same for all stators   * ***100Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8   * ***150Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8🡪9🡪10🡪11🡪12  : Error  : Error  : Pass  : Process clear  **Tip**  **1**  **100Ctrs**  **150Ctrs**  **2**  **3** | | | | | | | | | | | | | |
| Page | | | **200** | | | Issue | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0360** | | | | | | | | | | | | | | **M** | **S** | | | **OP0370** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. |  | |  | | | |  | |  | | | |  |
|  | | H03517004 | | | |  | | | | 1/8"BSP T PRESSURE PLUG. 100C | | | | | | 8 |  | |  | | | |  | |  | | | |  |
|  | | H03517004 | | | |  | | | | 1/8"BSP T PRESSURE PLUG. 150C | | | | | | 9 |  | |  | | | |  | |  | | | |  |
|  | | H03517004 | | | |  | | | | 1/8"BSP T PRESSURE PLUG. 500H | | | | | | 12 |  | |  | | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| Bottom  Top  **2**  **1** | | | | | | | | | | | | | | | | | 24Nm torque wrench + 8mm hex socket | | | | | | | | | | | | |
| Instruction:   * Mask every holes using 1/8” plug with 5mm Alley Key. * 1/8” plug를 사용하여 모든 퍼지라인을 막으시오. * The number of set screw is up to pump variants, but **all holes** should be masked.   Set screw 수량은 펌프 | | | | | | | | | | | | | | | | | Instruction:   * Ensure ETP bushes are tightened prior to seal installation * ETP 부쉬를 씰링 파트 조립 전에 24Nm 토크로 조이시오. | | | | | | | | | | | | |
| Page | | **210** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0380** | | | | | | | | | | | | | | **M** | **S** | | | **OP0390** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
| 0270 | | H02134023 | | | | A41200815 KIT1 | | | | ORING VIT9830 85.0ID X 3.5SEC.100C | | | | | | 2 | 0320 | | A41205060 | | | | A41205815 KIT 1 | | DYNAMIC SEAL ASSY. 150C | | | | 2 |
| 1410 | | H02134025 | | | | A41205815 KIT1 | | | | ORING VIT9830 110.0ID X 3.5SEC.150C | | | | | | 2 | 0320 | | A41201060 | | | | A41200815 KIT 1 | | DYNAMIC SEAL ASSY. 100C | | | | 2 |
| 1070 | | A24803004 | | | | A41205815 KIT1 | | | | MAGNET - 14MM DIA X 5MM LG.150C | | | | | | 6 |  | |  | | | |  | |  | | | |  |
| 0850 | | A24803004 | | | | A41200815 KIT1 | | | | MAGNET - 14MM DIA X 5MM LG. 100C | | | | | | 6 |  | |  | | | |  | |  | | | |  |
|  | |  | | | |  | | | |  | | | | | |  |  | |  | | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **x6**  **x2** | | | | | | | | | | | | | | | | | **1**  8mm allen key  TDS012242 (LV Support bar)  **x2** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction:   * Service Note: For 100Crs Flow line, use manual press IS0200397 instead of TDS012242. | | | | | | | | | | | | |
| Page | | **220** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0400** | | | | | | | | | | | | | | **M** | **S** | | **OP0410** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 0340 | | H02134004 | | | A41200815 KIT 1 | | ORING VIT9830 67.5IDX2.75SEC.100C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0340 | | H02134004 | | | A41205815 KIT 1 | | ORING VIT9830 67.5IDX2.75SEC.150C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0355 | | A41200066 | | | A41200066 | | SEAL OIL CATCHER. 100/150C | | | | 2 |
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| 100LP XD | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | 200HP S XD+ | | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **150Ctrs** TDS012221  **100Ctrs** TDS012143  **4**  **x2**  **3** | | | | | | | | | | | | | | | | | 150Ctrs TDS012224  **1**  **2**  **3**  100Ctrs TDS012144  **4** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instructin: | | | | | | | | | | | |
| Page | | **230** | | | Issue | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0420** | | | | | | | | | | | | | | **M** | **S** | | | **OP0430** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **Push**  **2**  **1**  **x2** | | | | | | | | | | | | | | | | | Depth Limits: Upper 11.07mm  Lower 10.33mm  3  2  1  4  3  1  2  Depth Gauge | | | | | | | | | | | | |
| Instruction:   * Service Note: For 100Crs Flow line, use manual press IS0200397 instead of TDS012242. | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **240** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0440** | | | | | | | | | | | | | | **M** | **S** | | | **OP0450** | | | | | | | | |
| Ref | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
| 0620 | | A41200065 | | | | A41200065 | | | | U SECTION THROWER 100C | | | | | | 2 | 0325 | | H02134015 | | | | A41200815 KIT 1 | | ORING VIT9830 36.6ID X 4.0SEC. 100C | | | | 2 |
| 0330 | | A41204071 | | | | A41204071 | | | | U SECTION THROWER 150C | | | | | | 2 | 1420 | | H02134016 | | | | A41205816 KIT 1 | | ORING VIT9830 45.1ID X 3.0SEC. 150C | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| Upper  Bottom  **x2** | | | | | | | | | | | | | | | | | **1**  **2**  **x2**  150Ctrs TDS012215A\_B  100Ctrs TDS012115A\_H | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **250** | | Issue | | | **03** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0460** | | | | | | | | | | | | | | **M** | **S** | | | **OP0470** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 0350 | | A20403081 | | | | A20403781 | | S-ROW BALL BRG 85X36.5X. 100C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0350 | | A20403083 | | | | A20403783 | | S-ROW BALL BRG 110X45X9. 150C | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **x2** | | | | | | | | | | | | | | | | | **Bearing ball에 Oil 도포**  **Apply the oil in the bearing** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **260** | | Issue | | | **03** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP0480** | | | | | | | | | | | | | | **M** | **S** | | | **OP0490** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 0670 | | A41200049 | | | | A41200049 | | HV THROWER SPACER. 100C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0370 | | A41204049 | | | | A41204049 | | OIL THROWER SPACER. 150C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  |  | |  | | | |  | |  | | | |  |
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| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **x2**  150Ctrs TDS012228  100Ctrs TDS012145 | | | | | | | | | | | | | | | | | **x2** | | | | | | | | | | | | |
| Instruction:   * Service Note: For 100Crs Flow line, use manual press IS0200397 instead of TDS012242. | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **270** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0500** | | | | | | | | | | | | | | **M** | **S** | | **OP0510** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0360 | | A41201055 | | | | A41201755 | | | | AXIAL SET RING. 100C \_ OLD | | | | | | 2 | 0400 | | A41200345 | | | A41200345 | | OIL THROWER ASSY, THREADED.100C | | | | 1 |
| 0360 | | A30353055 | | | | A30353755 | | | | AXIAL SET RING. 150C \_ OLD | | | | | | 2 | 0400 | | A41204045 | | | A41204045 | | OIL THROWER ASSY, THREADED.150C | | | | 1 |
| New | | A41201067 | | | |  | | | | AXIAL SET RING - 100 CRS 30DEG | | | | | | 2 |  | |  | | |  | |  | | | |  |
| New | | A30353067 | | | |  | | | | AXIAL SET RING-150CRS 30 DEG | | | | | | 2 |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| **Note: service use paired old and new**  x2 | | | | | | | | | | | | | | | | | **x5**  150Ctrs TDS012225  100Ctrs TDS012136  150Nm torque wrench | | | | | | | | | | | |
| Instruction:   * 엑셋링을 조립 하시오. | | | | | | | | | | | | | | | | | Instruction:   * Loosen and retighten 5 times to ensure thrower is correctly seated. * 오일스로워가 올바르게 조립되는 것을 확인하기 위해 오일스로워의 풀고 조이기를 5회 반복하시오. | | | | | | | | | | | |
| Page | | **280** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0520** | | | | | | | | | | | | | | **M** | **S** | | **OP0530** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0680 | | A41200344 | | | | A41200344 | | | | OIL THROWER ASSY – PLAIN. 100C | | | | | | 1 | 0480 | | A24301066 | | | A24301766 | | KEY - 8 X 10 X 18 LG. 100C | | | | 1 |
| 0410 | | A41204044 | | | | A41204044 | | | | OIL THROWER ASSY – PLAIN. 150C | | | | | | 1 | 0480 | | A24301068 | | | A24301768 | | KEY 12 X 8 X 25 LG. 150C | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| 150Ctrs  100Ctrs | | | | | | | | | | | | | | | | | 150Ctrs TDS012258  100Ctrs TDS012158  **1**  **2**  **3** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction:   * Service Note: If required to re-install Tollok Bush or Coupling onto the gears, please refer to SOPSH0086. | | | | | | | | | | | |
| Page | | **290** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0540** | | | | | | | | | | | | | | **M** | **S** | | **OP0550** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0430 | |  | | | | |  | | | | X GEAR. 100C | | | | | | 1 | 0880 | | 218091495 | | | A41200815 KIT1 | | SCREW CAP HT M12 X 40 LG. 100C | | | | 1 |
| 0430 | |  | | | | |  | | | | X GEAR. 150C | | | | | | 1 | 0870 | | 218984943 | | | A41200815 KIT1 | | DISC SPRING 29OD x 13ID x3. 100C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 0880 | | 218091495 | | | A41205815 KIT1 | | SCREW CAP HT M12X 40 LG. 150C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 0870 | | 218984943 | | | A41205815 KIT1 | | DISC SPRING 29OD x 13ID x3. 150C | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **1**  **2**  TDS012146 | | | | | | | | | | | | | | | | | | **1**  **2**  **3**  90Nm torque wrench +  10mm AF Bit w/ adapter | | | | | | | | | | | |
| Instruction:   * Press gear on half way. Inspect for swarf if found remove gear and investigate. * 기어를 반정도 입입한 상태에서 기어하단에 티끌이 없는지 확인후 완전히 압입한다. * Note: Can use both Grade A & B gears on pump cartridges. * Service Note: For 100Crs Flow line, use manual press IS0200397 + IS0200398 for this operation. | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | | **300** | | | Issue | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0560** | | | | | | | | | | | | | | **M** | **S** | | | **OP0570** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **8mm Allen Key.**  100Ctrs TDS012315  150Ctrs TDS012329 | | | | | | | | | | | | | | | | | | **1**  **2**  **x2**  **x2**  24mm hex socket  8mm hex head adapter | | | | | | | | | | | | |
| Instruction:   * Service Note: For 100Crs Flow Line, Service turn 180deg refer to SOPSH0012 and must lock the X-Gear at this Stage using IS0200399 or TDS012307. | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | | **310** | | | Issue | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0580** | | | | | | | | | | | | | | **M** | **S** | | **OP0590** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| TDS012440  TDS012412 Service use  TDS012202  As well  **Dry Pumps(100C/150C)**  **- M14x60 Soc cap with washer x 2EA**  **- M8x45 Soc cap with washer x 2EA**  **3**  **2**  **1** | | | | | | | | | | | | | | | | | 100Ctrs TDS012307  150Ctrs TDS012230 | | | | | | | | | | | |
| Instruction:   * 이스트를 이용하여 펌프를 턴오버 픽스쳐. * Service Note: For 100Crs Flow Line, turn 180deg refer to SOPSH0012. | | | | | | | | | | | | | | | | | Instruction:   * Service Note: For 100Crs, Service can use IS0200399 or the new TDS012307 | | | | | | | | | | | |
| Page | | **320** | | Issue | | | **05** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP0600** | | | | | | | | | | | | | | **M** | **S** | | **OP0603** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  |  | | H02134011 | | |  | | O-RING FKM HP 255.5ID X 4.0SEC | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  |  | | A41672022 | | |  | | HV TBP PLATED XD | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **180°** | | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:   * Service Note: For 100Crs Flow Line, turn 180deg referring to SOPSH0012. | | | | | | | | | | | | | | | | | Instruction:  : Fit the FKM o-ring and the XD HV TBP onto HV stator as shown.  : FKM o-ring 및 XD HV TBP를 HV stator위에 보이는 것과 같이 Fit 하시오.   * Service Note: For 100Crs Flow Line, turn 180deg referring to SOPSH0012. | | | | | | | | | | | |
| Page | | **330** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP0607** | | | | | | | | | | | | | | **M** | **S** | | **OP0610** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | H02134011 | | | |  | | | | O-RING FKM HP 255.5ID X 4.0SEC | | | | | | 1 | 0500 | | A41201143 | | | A41201143 | | SPACER COMMON 100C | | | | 2 |
|  | | A30392058 | | | |  | | | | THERMAL SPACER CERAMIC MSB | | | | | | 8 |  | | A41672143 | | | TBD | | SPACER COMMON 100 CRS | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | ***100LP XD, 100HP XD***  ***200LP XD, 200HP XD***  ***200HP S XD+ only*** | | | | | | | | | | | |
| Instruction:  : Fit the FKM o-ring and thermal spacer ceramic onto XD HV TBP as shown.  : FKM o-ring 및 thermal spacer ceramic을 XD HV TBP위에 보이는 것과 같이 Fit 하시오. | | | | | | | | | | | | | | | | | Instruction:  : Fit the SPACER onto each shaft as shown.  : 스페이서를 각 샤프트에 보이는 것과 같이 핏하시오. | | | | | | | | | | | |
| Page | | **335** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0620** | | | | | | | | | | | | | | **M** | | **S** | | **OP0630** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | Man.Item No. | | | | | Ser.Item No. | | Description | | | | Qty. |
| 1090 | | H02134011 | | | | | A41200815 KIT 2 | | | | ORING VIT9830 255.5ID X 4.0. 100C | | | | | | 1 | 0540 | A41201027 | | | | | A41201727 | | HV Headplate SG 100C | | | | 1 |
| 0070 | | H02134013 | | | | | A41205816 KIT 2 | | | | ORING VIT9830 371.5ID X 4.0. 150C | | | | | | 1 | 0540 | A41205027 | | | | | A41205727 | | HV Headplate. 150C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 0540 | A41672927 | | | | | TBD | | HV HEADPLATE-PLATING XD–200HP S XD+ | | | | 1 |
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| 100LP XD | | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | | Use Lifting Magnet | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | | **340** | | Issue | | | **10** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0640** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
| 0090 | | 218092453 | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9. 100C | | | | | | | 8 |  |  | |  | |  | | | |  |
| 0090 | | 218092453 | | | |  | | | | SCR CAP HT ENP M10X30LG G12.9. 150C | | | | | | | 12 |  |  | |  | |  | | | |  |
| 200HP S XD+ | | 218092457 | | | |  | | | | SCR CAP HT ENP M10X50LG G12.9 200HP S XD+ | | | | | | | 8 |  |  | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | | |  | | | |  | | |  | |  | |  | |  | |  | |  | |
| Instruction:   * 1. Rotate the key to the right position. Choose 100 Centre or 150 Centre * 1. 조립중인 펌프를 확인하고 키를 100센터 또는 150센터로 돌려 선택하시오. * 2. Turn it back to original position. * 2. 키를 원래의 위치(가운데)로 돌려 놓으시오. * 3. Fix as number sequence at 55Nm torque. * 3. 순서대로 스크류를 조립하여 55Nm로 조이시오. * 4. Check the blue light illuminate * 4. 스크류 조립이 완료되면 Andon light의 파란색 램프가 점등되었는지 확인하시오.   + ***Tensor driver의 전원 차단 금지 !! (프로그램이 초기화 됨)***   Service Note: Service uses 55Nm manual torque Wrench and follows the same tightening sequence. | | | | | | | | | | | | | | **1**  **3**  **11**  **12**  **8**  **6**  **9**  **2**  **4**  **10**  **5**  **7**  **Screw Tightening Pattern**  The same for all stators   * ***100Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8   * ***150Ctrs***   1🡪2🡪1🡪2🡪3🡪4🡪5🡪6🡪7🡪8🡪9🡪10🡪11🡪12  : Error  : Error  : Pass  : Process clear  **Tip**  **4**  **100Ctrs**  **150Ctrs**  **2**  **3** | | | | | | | | | | | | | |
| Page | | **350** | | Issue | | | **10** | Approved | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP0650** | | | | | | | | | | | | | | **M** | **S** | | | **OP0660** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qt. |
| 0270 | | H02134023 | | | | | A41200815 KIT 1 | | | | ORING VIT9830 85.0ID X 3.5SEC 100C | | | | | | 2 | 0320 | | A41201060 | | | | A41200815 KIT1 | | DYNAMIC SEAL ASSY. 100C | | | | 2 |
| 0650 | | H02134025 | | | | | A41205815 KIT 1 | | | | ORING VIT9830 110.0ID X 3.5SEC. 150C | | | | | | 2 | 0610 | | A41205060 | | | | A41205815 KIT1 | | DYNAMIC SEAL ASSY. 150C | | | | 2 |
| 0850 | | A24803004 | | | | | A41200815 KIT 1 | | | | MAGNET - 14MM DIA X 5MM LG. 100C | | | | | | 6 |  | |  | | | |  | |  | | | |  |
| 0850 | | A24803004 | | | | | A41205815 KIT 1 | | | | MAGNET – 14MM DIAX 5 MM LG. 150C | | | | | | 6 |  | |  | | | |  | |  | | | |  |
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| 100LP XD | | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **x2**  **x6** | | | | | | | | | | | | | | | | | | **x2** | | | | | | | | | | | | |
| Instruction:   * Ensure o-ring groove is free from swarf. * 베어링 오링 홈에 오링을 삽입하시오, 조립 전 오링홈의 가공 잔여물을 확인하시오.자석을 조립하시오. | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | |
| Page | | | **360** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0670** | | | | | | | | | | | | | | **M** | **S** | | | **OP0680** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 0340 | | H02134004 | | | | A41200815 KIT1 | | ORING VIT9830 67.5ID X 2.75SEC.100C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0630 | | H02134004 | | | | A41205815 KIT1 | | O RING VIT9830 67.5ID X 2.75SEC.150C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0625 | | A41200066 | | | | A4100066 | | SEAL OIL CATCHER. 100/150C | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| 150Ctrs TDS012221  100Ctrs TDS012143  TDS012242 (LV Support bar)  **Push**  **1**  **2**  **3**  **x2**  **x2**  8mm Allen key | | | | | | | | | | | | | | | | | 150Ctrs TDS012224  **1**  **2**  **3**  **4**  100Ctrs TDS012144  **x2** | | | | | | | | | | | | |
| Instruction:   * Service Note: For 100Crs Flow line, use manual press IS0200397 instead of TDS012242. | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **370** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0690** | | | | | | | | | | | | | | **M** | **S** | | | **OP0700** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **x2**  **1**  **2**  **Push** | | | | | | | | | | | | | | | | | 3  4  1  2  Depth Limits: Upper 11.07mm  Lower 10.33mm  Depth Gauge | | | | | | | | | | | | |
| Instruction   * Service Note: For 100Crs Flow line, use manual press IS0200397 instead of TDS012242. | | | | | | | | | | | | | | | | | Instruction | | | | | | | | | | | | |
| Page | | **380** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0710** | | | | | | | | | | | | | | **M** | **S** | | | **OP0720** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
| 0620 | | A41200065 | | | | A41200065 | | | | U SECTION THROWER. 100C | | | | | | 2 | 0325 | | H02134015 | | | | A41200815 KIT 1 | | ORING VIT9830 36.6ID X 4.0SEC.100C | | | | 2 |
| 0620 | | A41204071 | | | | A41204071 | | | | U SECTION THROWER. 150C | | | | | | 2 | 0325 | | H02134016 | | | | A41205815 KIT 1 | | ORING VIT9830 45.1ID X 3.0SEC. 150C | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| Upper  Bottom  **x2** | | | | | | | | | | | | | | | | | **1**  **x22**  150Ctrs TDS012215A  100Ctrs TDS012115A  **2** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **390** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0730** | | | | | | | | | | | | | | **M** | **S** | | | **OP0740** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 0350 | | A20403081 | | | | A20403781 | | S-ROW BALL BRG 85 X 36.5. 100C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0640 | | A20403083 | | | | A20403783 | | S-ROW BALL BRG 110 X 45 X 19. 150C | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **x2** | | | | | | | | | | | | | | | | | **Bearing ball에 Oil 도포**  **Apply the oil in the bearing** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **400** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0750** | | | | | | | | | | | | | | **M** | **S** | | **OP0760** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty |
|  | |  | | | |  | | | |  | | | | | |  | 0670 | | A41200049 | | | A41200049 | | HV THROWER SPACER. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0670 | | A41204049 | | | A41204049 | | OIL THROWER SPACER. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **x2**  150Ctrs TDS012228  100Ctrs TDS012145 | | | | | | | | | | | | | | | | | Shaft only  **X1** | | | | | | | | | | | |
| Instruction:   * Service Note: For 100Crs Flow line, use manual press IS0200397 instead of TDS012242. | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **410** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0770** | | | | | | | | | | | | | | **M** | **S** | | **OP0780** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0650 | | 218984024 | | | | A41200815 KIT1 | | | | WAVED SPRING 85 OD X 72 ID. 100C | | | | | | 2 | 0660 | | A41201056 | | | A41201056 | | BEARING RETAINER PLATE. 100C | | | | 1 |
| 0650 | | 218984025 | | | | A41205815 KIT1 | | | | WAVED SPRING 110 OD x 100.7ID.150C | | | | | | 2 | 0470 | | 27522-046 | | |  | | M6X16 SOC HD CAP ENP CO. 100C | | | | 9 |
|  | |  | | | |  | | | |  | | | | | |  | 0660 | | A30352056 | | | A30352056 | | BEARING RETAINER PLATE. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0590 | | 27522-046 | | |  | | M6X16 SOC HD CAP ENP CO. 150C | | | | 8 |
|  | |  | | | |  | | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | 14Nm torque wrench + 6mm AF bit with adapter  100Ctrs  150Ctrs  **Screw Tightening Pattern**  **1→2→3→4→5→7→8→9→1→2**  **Screw Tightening Pattern**  **1→2→3→4→5→7→8→1→2** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **420** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0790** | | | | | | | | | | | | | | **M** | **S** | | **OP0800** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0680 | | A41200344 | | | | A41200344 | | | | OIL THROWER ASSY – PLAIN.100C | | | | | | 2 | 0720 | | A22408003 | | |  | | LOCKNUT M35 x 1.5 x 8 THICK.100C | | | | 1 |
| 0680 | | A41204044 | | | | A41204044 | | | | OIL THROWER ASSY – PLAIN.150C | | | | | | 2 | 0720 | | A22408004 | | |  | | LOCKNUT M40 x 1.5 x 9 THICK. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| 100Ctrs  150Ctrs  **x2**  1  2  1  2 | | | | | | | | | | | | | | | | | 150Ctrs  100Ctrs  Upper  Bottom | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **430** | | Issue | | | **07** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0810** | | | | | | | | | | | | | | **M** | **S** | | **OP0820** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty |
|  | |  | | | |  | | | |  | | | | | |  | 0690 | | A41200048 | | | A41200048 | | HV CLAMPING SPACER 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0690 | | A41204048 | | | A41204048 | | HV CLAMPING SPACER. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0870 | | 218984943 | | | A41200815 KIT 1 | | DISC SPRING. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0880 | | 218091495 | | | A41200815 KIT 1 | | M12 x 40 SHCS. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0700 | | 218984943 | | | A41205815 KIT 1 | | DISC SPRING. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0710 | | 218091495 | | | A41205815 KIT 1 | | M12 x 40 SHCS. 150C | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| 150Ctrs TDS012220  100Ctrs TDS012122 | | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **440** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0830** | | | | | | | | | | | | | | **M** | **S** | | **OP0840** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 0740 | | A22305001 | | | | A41200815 KIT 1 | | | | COILED MIST FILTER. 100C | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0970 | | 211910003 | | | | A41200815 KIT 1 | | | | INT CIRCLIP 29.1 O:D X 1.2 THK. 100C | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0740 | | A22305001 | | | | A41205815 KIT 1 | | | | COILED MIST FILTER. 150C | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 0760 | | 211910003 | | | | A41205815 KIT 1 | | | | INT CIRCLIP 29.1 0:D X 1.2 THK. 150C | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| **1**  **2**  **3**  Internal circlip pliers | | | | | | | | | | | | | | | | | **90°** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction:   * Service Note: For 100Crs Flow line, Service turns 90deg refer to SOPSH0013. | | | | | | | | | | | |
| Page | | **450** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0850** | | | | | | | | | | | | | | **M** | **S** | | **OP0860** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| 100Ctrs  TDS012307  150Ctrs  TDS012230 | | | | | | | | | | | | | | | | | mm  Inch  **3**  ***.000mm ± 000***  **3**  **2**  150Crs  TDS012404  100Crs  TDS012403  (OLD SETTING RINGS) 100Crs  TDS012407  (NEW SETTING RINGS) 150Crs  TDS012439  (NEW SETTING RINGS) 100Crs  TDK220044  (OLD SETTING RINGS) 150Crs  TDS012408 | | | | | | | | | | | |
| Instruction:   * Service Note: Service removes IS0200399 or the new TDS012307 | | | | | | | | | | | | | | | | | Instruction:   * 부착하시오. * Loosen set rings completely and set gauge to zero. * 셋링을 완전히 푼다음 게이지를 제로세팅하시오.   Service Note: Service can use existing TDS012138 -> TDS012407, TDS012204 -> TDS012408, IS0200396 -> TDS012403 & TDS012203 -> TDS012404 temporary until next tool replacement. | | | | | | | | | | | |
| Page | | **460** | | Issue | | | **03** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0870** | | | | | | | | | | | | | | **M** | **S** | | **OP0880** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| ***Axial Float Value***  **100LP : 0.200 ~ 0.250mm**  **100HP/200LP : 0.200 ~ 0.250mm**  **200HP/300LP : 0.370 ~ 0.420mm**  **450HP(SG) : 0.465 ~ 0.515mm**  **450HP(NR) : 0.495 ~ 0.545mm**  **500HP : 0.376 ~ 0.426mm**  **2**  TDK220051  **1** | | | | | | | | | | | | | | | | | mm  Inch  **3**  ***.000mm ± 000***  **3**  150Crs  TDS012404  100Crs  TDS012403 | | | | | | | | | | | |
| Instruction:   * Tighten set rings from start to finish * 셋링을 끝까지 조이시오. | | | | | | | | | | | | | | | | | * Instruction * Remove the jig TDK220051 and set gauge to zero.   TDK220051제거 후 게이지를 제로 세팅 하시오.Service Note: Service can use existing TDS012138 -> TDS012407, TDS012204 -> TDS012408, IS0200396 -> TDS012403 & TDS012203 -> TDS012404 temporary until next tool replacement. | | | | | | | | | | | |
| Page | | **470** | | Issue | | | **06** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP0890** | | | | | | | | | | | | | | **M** | **S** | | **OP0900** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 100C | | A41201057 | | |  | | AXIAL SETRING LOCKINGPLAT. 100C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0890 | | A41205057 | | |  | | AXIAL SETRING LOKING PLATE. 150C | | | | 2 |
|  | |  | | | |  | | | |  | | | | | |  | 0895 | | 218436290 | | |  | | Scr btn hd hex soc np M5 x 10.100/150C | | | | 2 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| **2**  **3**  ***Axial Set Value***  **100Ctrs**  **0.042mm ± 0.002**  **150Ctrs - 450H only**  **0.165mm ± 0.002**  **150Ctrs - 500H only**  **0.125mm ± 0.002**  **1** | | | | | | | | | | | | | | | | | TDK220016  100ctr  TDK220015 150 ctr  **4**  **3**  **2**  **1**  **x2** | | | | | | | | | | | |
| Instruction:   * Tighten set rings to achieve a set as shown above. * Axial setting 값을 얻기 위하여 그림과 같이 셋링을 조이시오. | | | | | | | | | | | | | | | | | Instruction:   * Ensure locking plates are fully engaged with set rings * 셋링와 셋링락킹 플레이트가 정확히 체결되어야 한다. | | | | | | | | | | | |
| Page | | **480** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP0910** | | | | | | | | | | | | | | **M** | **S** | | **OP0920** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | A41205066 | | | |  | | | | AXIAL SET RING LOCK PLT 30 DEG | | | | | | 2 |  | |  | | |  | |  | | | |  |
|  | | A41201066 | | | |  | | | | AXIAL SET RING LOCKING PLATE | | | | | | 2 |  | |  | | |  | |  | | | |  |
|  | | 218430125 | | | |  | | | | SCR CAP LOW HD M5X10 GR10.9 | | | | | | 2 |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | |  | | | |  | |  | |  | |  | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
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| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **490** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | **SOPKR1662** | | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0930** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man .Item No. | | | | Ser. Item No. | | | | Description | | | | | | Qty. | | Ref. | Man. Item No. | | Ser. Item No. | | Description | | | | Qty. |
| 100LP XD | | | | 100HP XD | | | | | 200LP XD | | | | 200HP XD | | 300LP XD | | 500HP XD | | | 200HP S XD+ | |  | |  | |  | |
|  | | | |  | | | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| **>Instruction**  set ring 을 완전히 조립 후 다음 작업자가 locking plate spanner 를 사용하여 set ring 이 정확히 조립 되어 있는지 더블 체크 한 후 아이 마킹 확인.  **>Instruction**  **Ensure locking plate is fully engaged with set ring.**  **If movement felt, remove plates clean Loctite and repeat setting procedure.**  **If no movement felt, “Buddy check” must be performed. Second operator**  **use the “key” for the checking a good fixation offset ring.**  **Set ring \_ Buddy check** | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Page | | **500** | | | Issue | | **02** | Approved | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | **SOPKR1662** | | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0940** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man .Item No. | | | | Ser. Item No. | | | | Description | | | | | | Qty. | | Ref. | Man. Item No. | | Ser. Item No. | | Description | | | | Qty. |
| 100LP XD | | | | 100HP XD | | | | | 200LP XD | | | | 200HP XD | | 300LP XD | | 500HP XD | | | 200HP S XD+ | |  | |  | |  | |
|  | | | |  | | | | |  | | | |  | |  | |  | | |  | |  | |  | |  | |
| **Feeler gauge**  **Lead gap**    **Trail gap**  **Y**  **X**  **Y**  **X**  **Timing Clearances**  (unit : ㎛)  Instruction:  Tip for Lead & Trail Gap  Shim-stack size to start with: 100 pumps = 0.190mm, 200/300 = 0.230mm & 450H/500H = 0.280mm. Then check Lead & Trail gaps according to Build Sheet. If necessary, re-adjust new shim stack size.   |  |  |  |  |  | | --- | --- | --- | --- | --- | |  | **Setting**  **Gap** | **Min**  **Lead** | **Min**  **Trail** | **Min**  **Total** | | **100LP/HP** | **190** | **220** | **150** | **400** | | **200LP/HP, 300LP** | **230** | **240** | **170** | **440** | | **450HP(SG/NR), 500H** | **280** | **290** | **290** | **N/A** | | **500H LV**  **Rotor Rolling Clearance** | **Min 280** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| Page | | **510** | | | Issue | | **02** | Approved | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP0950** | | | | | | | | | | | | | | **M** | **S** | | **OP0960** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | | |  | | | |  | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| 150Ctrs TDS012230  100Ctrs TDS012307 | | | | | | | | | | | | | | | | | Insert feeler gauge between ***“Lead gap”***  5.5  0.6  1  **x2**  TDS012421  2 | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **520** | | Issue | | | **02** | Approved | | | Daniel.Park | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP0970** | | | | | | | | | | | | | | **M** | **S** | | **OP0980** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | 300LP XD | |  | | | |  | |  | |  | |  | |
| 500HP XD | | | | | 200HP S XD+ | | | |  | | | |  | |  | |  | | | |  | |  | |  | |  | |
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| Instruction:  When locating Y shaft gear, ensure high spots (2 lines teeth) on gears are aligned.  Y 기어 조립 전, 기어의 하이스폿 이 그림과 같이 바르게 연결되었는지 확인하시오 | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **530** | | Issue | | | **02** | Approved | | | Daniel.Park | | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | **SOPKR1662** | | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP0990** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man .Item No. | | | | Ser. Item No. | | | | Description | | | | | | Qty. | | Ref. | Man. Item No. | | Ser. Item No. | | Description | | | | Qty. |
| 100LP XD | | | | 100HP XD | | | | | 200LP XD | | | | 200HP XD | | 300LP XD | | 500HP XD | | | 200HP S XD+ | |  | |  | |  | |
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| **Oil must not exist on the marked point of below picture.**  **Oil 성분이 아래 표시된 부분에 남아 있으면 절대 안됨.**  **Do not work with gloves which are stained with oil or grease.**  **Oil, grease가 묻은 장갑으로 작업하지 마시오.**   1. Separate four bolt from 150C Locking Assy and three bolt from 100C Locking Assy. 2. 150C Locking Assy는 4개, 100C Locking Assy는 3개의 Bolt들을 분리하시오. 3. As shown picture, Wipe marked three point of separated locking assy with cleaner. 4. 분리된 Locking Assy의 그림에 표시된 3부분을 Cleaner를 사용하여 깨끗이 닦는다. | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Page | | **540** | | | Issue | | **01** | Approved | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1000** | | | | | | | | | | | | | | **M** | **S** | | **OP1010** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| 150Ctrs TDS012241  TDS012242 (LV Support bar)  **1**  **x2**  **2**  100Ctrs TDS012147 | | | | | | | | | | | | | | | | | **x4**  150Ctrs – 4 Places  17Nm Torque Wrench  **x3**  100Ctrs – 3 Places  14Nm Torque Wrench | | | | | | | | | | | |
| Instruction:   * Pull gear TDS tool in a counter clockwise direction while the gear is being pressed on.   기어를 압입하기 전 TDS 툴을 반 시계방향으로 살며시 돌리고 그 상태를 유지하며 완전히 압입하시오.  Service Note: For 100Crs Flow line, use manual press IS0200397 + IS0200398 for this operation | | | | | | | | | | | | | | | | | Instruction:   * Fit tollok to Y gear. * Y 기어에 톨록을 조립한다. * Repeat torque OP 3 times so maximum torque is achieved. * 최대 토크값을 얻기 위하여 토크 작업을 3회 반복한다. | | | | | | | | | | | |
| Page | | **550** | | Issue | | | **09** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1020** | | | | | | | | | | | | | | **M** | **S** | | **OP1030** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| 100Ctrs TDS012307  150Ctrs TDS012230 | | | | | | | | | | | | | | | | | **Feeler gauge**  **Lead gap**    **Trail gap**  **Y**  **X**  **Y**  **X**  **Timing Clearances**  (unit : ㎛)   |  |  |  |  |  | | --- | --- | --- | --- | --- | |  | **Setting**  **Gap** | **Min**  **Lead** | **Min**  **Trail** | **Min**  **Total** | | **100LP/HP** | **190** | **220** | **150** | **400** | | **200LP/HP, 300LP** | **230** | **240** | **170** | **440** | | **450HP(SG/NR), 500H** | **280** | **290** | **290** | **N/A** | | **500H LV**  **Rotor Rolling Clearance** | **Min 280** | | | | | | | | | | | | | | | |
| Instruction:   * Service Note: Service removes IS0200399 or the new TDS012307 | | | | | | | | | | | | | | | | | Instruction:   * Check Lead & Trail gaps in according to Build Sheet. If unable set removey gear and re-adjust shim stack size. Repeat from OP0862 * Lead & Trail gap을 다시 체크하시오. | | | | | | | | | | | |
| Page | | **560** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **Gear Removal** | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
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| **100crs iS0200495**  **150crs iS0200496** | | | | | | | | | | | | | | | | | **TDS012259**  **TDS012260** | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | |
| Page | | **R2** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1040** | | | | | | | | | | | | | | **M** | **S** | | **OP1050** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **BREAKOUT**  **<2.2 Nm**  **360°**  Dial torque wrench + 10mm AF bit adapter | | | | | | | | | | | | | | | | | **Y SHAFT RUN-OUT**  **0.030mm MAX**  **Y SHAFT RUN-OUT**  **0.025mm MAX**      **Y GEAR FACE RUN OUT**  **0.030mm MAX** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **570** | | Issue | | | **07** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1060** | | | | | | | | | | | | | | **M** | **S** | | | **OP1070** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 0910 | | H02134002 | | | | A41800816 KIT 2 | | ORING VIT9830 19.6ID X 2.4SEC. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0750 | | A41200711 | | | | A41200711 | | CHECK VALVE ASSY PK.10. 100/150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0760 | | 211910004 | | | | A41200816 KIT 2 | | INT CIRCLIP 27.9 O:D X 1.2 THK. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0740 | | A22305001 | | | | A41200815 KIT 1 | | COILED MIST FILTER. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0970 | | 211910003 | | | | A41200815 KIT 1 | | INT CIRCLIP 29.1 O:D X 1.2 THK100/150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0950 | | A22305001 | | | | A41205815 KIT 1 | | COILED MIST FILTER. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0760 | | 211910003 | | | | A41205815 KIT 1 | | INT CIRCLIP 27.9 0:D X 1.2 THK. 150C | | | | 1 |
| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **X GEAR FACE RUN OUT**  **0.030mm MAX *[150Ctrs only]***  **Y GEAR FACE RUN OUT**  **0.030mm MAX**  **Y SHAFT RUN-OUT**  **0.030mm MAX** | | | | | | | | | | | | | | | | | TDS012218  **1**  **2**  **3**  **4** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **580** | | Issue | | | **07** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP1080** | | | | | | | | | | | | | | **M** | **S** | | **OP1090** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| >0.180mm | | | | | | | | | | | | | | | | | >0.300mm | | | | | | | | | | | |
| Instruction:  LV rolling clearance | | | | | | | | | | | | | | | | | Instruction:  LV rolling clearance | | | | | | | | | | | |
| Page | | **590** | | Issue | | | **07** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1100** | | | | | | | | | | | | | | **M** | **S** | | | **OP1110** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
| 0800 | | A25976001 | | | | A25976701 | | | | SIGHT GLASS REFLECTOR. 100/150C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0810 | | A27820008 | | | | A27820708 | | | | COMPRESSION RING. 100/150C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0780 | | H02134007 | | | | A41200815 KIT 1 | | | | O RING 31.34 ID X 3.53 SEC. 100C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0780 | | H02134007 | | | | A41205815 KIT 1 | | | | O RING 31.34 ID X 3.53 SEC. 150C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0820 | | A29201004 | | | | A29201704 | | | | SIGHT GLASS. 100/150C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
|  | | A41201025 | | | |  | | | | END COVER | | | | | | 1 |  | |  | | | |  | |  | | | |  |
|  | | A41205025 | | | |  | | | | HV END COVER 150 CRS INT PIPE | | | | | | 1 |  | |  | | | |  | |  | | | |  |
|  | | A41201076 | | | |  | | | | **NB**-END COVER | | | | | | 1 |  | |  | | | |  | |  | | | |  |
|  | | A41205028 | | | |  | | | | **NB**-HV END COVER 150 CRS INT PIPE | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **1**  **2**  **3**  **4** | | | | | | | | | | | | | | | | | **450SG, 450NR 500H,**  **100H, 100LP, 200H 200LP, 300LP** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **600** | | Issue | | | **04** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP1120** | | | | | | | | | | | | | | **M** | **S** | | | **OP1130** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
| 0780 | | H02134007 | | | | A41200815 KIT 1 | | | | O RING 31.34 ID X 3.53 SEC. 100C | | | | | | 1 | 1090 | | H02134011 | | | | A41200816 KIT 2 | | ORING VIT9830 255.5ID X 4.0SEC. 100C | | | | 1 |
| 0780 | | H02134007 | | | | A41205815 KIT 1 | | | | O RING 31.34 ID X 3.53 SEC. 150C | | | | | | 1 | 0860 | | H02134013 | | | | A41295816 KIT 2 | | ORING VIT9830 371.5ID X 4.0SEC. 150C | | | | 1 |
| 0830 | | A20416007 | | | | A20416707 | | | | SIGHT GLASS BEZEL.. 100C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0830 | | A20416012 | | | | A20416712 | | | | SIGHT GLASS BEZEL. 150C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 1060 | | 218436290 | | | |  | | | | M5 X 10 SCR BTN HD. 100C | | | | | | 4 |  | |  | | | |  | |  | | | |  |
| 0840 | | 218436290 | | | |  | | | | M5 X 10 SCR BTN HD. 150C | | | | | | 4 |  | |  | | | |  | |  | | | |  |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **1**  **2** | | | | | | | | | | | | | | | | | 90°  **1**  **2** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction:   * Service Note: For 100Crs Flow line, the follow operations should be done horizontally and no more turning required. | | | | | | | | | | | | |
| Page | | **610** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1140** | | | | | | | | | | | | | | **M** | **S** | | **OP1150** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | | 218092453 | | | | 218092453 | | | | SCR CAP HT ENP M10X30LG G12.9G12.9 | | | | | | 8 | 0800 | | A25976001 | | | A25976701 | | SIGHT GLASS REFLECTOR. 100/150C | | | | 1 |
|  | | 218092453 | | | | 218092453 | | | | SCR CAP HT ENP M10X30LG G12.9 | | | | | | 10 | 0810 | | A27820008 | | | A27820708 | | COMPRESSION RING. 100/150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0780 | | H02134007 | | | A41200815 KIT 1 | | O RING 31.34 ID X 3.53 SEC. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0990 | | H02134007 | | | A41205815 KIT 1 | | O RING 31.34 ID X 3.53 SEC. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0820 | | A29201004 | | | A29201704 | | SIGHT GLASS. 100/150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 1010 | | A41201024 | | |  | | GEAR COVER | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 150C | | A41206024 | | |  | | GEAR COVER 150 CRS | | | | 1 |
| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | |  | | |  | |  | | | |  | |  | |  | |  | |
| 55Nm Torque Wrench + 8mm AF Bit with Adaptor  **100Ctrs: 218092453\*8**  **150Ctrs: 218092453\*10** | | | | | | | | | | | | | | | | | **1**  **2**  **3**  **4** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction:   * Service Note: For 100Crs Flow line, the follow operations should be done horizontally and no more turning required. | | | | | | | | | | | |
| Page | | **620** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | | **OP1160** | | | | | | | | | | | | | | **M** | **S** | | **OP1170** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | | |  | | | |  | | | | | |  | 0780 | | H02134007 | | | A41200815 KIT1 | | O RING 31.34 ID X 3.53 SEC. 100C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 0990 | | H02134007 | | | A41205815 KIT1 | | O RING 31.34 ID X 3.53 SEC. 150C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 0830 | | A20416007 | | | A20416707 | | SIGHT GLASS BEZEL. 100C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 1050 | | A20416012 | | | A20416712 | | SIGHT GLASS BEZEL. 150C | | | | 1 |
|  | |  | | | | |  | | | |  | | | | | |  | 1060 | | 218436290 | | |  | | M5 X 10 SCR BTN HD. 100/150C | | | | 4 |
|  | |  | | | | |  | | | |  | | | | | |  |  | |  | | |  | |  | | | |  |
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| 100LP XD | | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **450SG, 450NR 500H,**  **100H, 100LP, 200H 200LP, 300LP** | | | | | | | | | | | | | | | | | | **1**  **2** | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | | **630** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1180** | | | | | | | | | | | | | | **M** | **S** | | | **OP1190** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
| 1080 | | A21035164 | | | | A21035164 | | | | COLLECTION TRAY. 100C | | | | | | 1 | 0924 | | H02134018 | | | | A41200815 KIT1 | | ORING VIT9830. 100C | | | | 1 |
| 1080 | | A21035171 | | | | A21035171 | | | | COLLECTION TRAY. 150C | | | | | | 1 | 1390 | | H02134003 | | | | A41205815 KIT1 | | ORING VIT9830 61.51ID X 2.4 SEC 150C | | | | 1 |
| 0926 | | 218436290 | | | |  | | | | M5 X 10 SCR BTN HD HEX SOC NP 100/150C | | | | | | 2 | 0980 | | A41201042 | | | | A41201042 | | LV COOLING ASSY. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0980 | | A41206042 | | | | A41206042 | | LV COOLING ASSY. 150C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  |  | | A41201048 | | | |  | | **NB**-LV COOLING ASSY | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  |  | | A41206043 | | | |  | | **NB**-LV COOLING ASSY | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 0926 | | 218092330 | | | |  | | SCR CAP HT NI M 5.X16LG. 100C | | | | 4 |
|  | |  | | | |  | | | |  | | | | | |  | 0985 | | 218092330 | | | |  | | SCR CAP HT NI M 5.X16LG. 150C | | | | 4 |
| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | |  |  |  | | --- | --- | --- | |  | **100** | **150** | | **Bead** | A41201042 | A41206042 | | **NB** | A41201048 | A41206043 |   **1**  **2**  **3**  **x4**  **10Nm** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **640** | | Issue | | | **04** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1200** | | | | | | | | | | | | | | | **M** | **S** | | | **OP1210** | | | | | | | | |
| Ref. | | Man.Item No. | | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
| 1090 | | H02134011 | | | | A41200816 KIT 2 | | | | | ORING VIT9830 255.5ID X 4.0SEC. 100C | | | | | | 1 | 0090 | | 218092453 | | | |  | | SCR CAP HTENP.M10X30LG 100C | | | | 7 |
| 150C | | H02134013 | | | | A41205816 KIT 2 | | | | | ORING VIT9830 371.5ID X 4.0SEC. 150C | | | | | | 1 | 0090 | | 218092453 | | | |  | | SCR CAP HT ENP.M10X30LG 150C | | | | 11 |
|  | |  | | | |  | | | | |  | | | | | |  |  | |  | | | |  | | GEAR COVER ASSY. 100C | | | | 1 |
|  | |  | | | |  | | | | |  | | | | | |  |  | |  | | | |  | | GEAR COVER ASSY. 150C | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | | 55Nm Torque Wrench + 8mm AF Bit with Adaptor | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **650** | | Issue | | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1220** | | | | | | | | | | | | | | **M** | **S** | | | **OP1230** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty |
| 0924 | | H02134018 | | | | A41200815 KIT1 | | | | ORING VIT9830. 100C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 1390 | | H02134003 | | | | A41205815 KIT1 | | | | ORING VIT9830 61.51ID X 2.4 SEC150C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0980 | | A41201042 | | | | A41201042 | | | | LV COOLING ASSY. 100C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0980 | | A41206042 | | | | A41206042 | | | | LV COOLING ASSY. 150C | | | | | | 1 |  | |  | | | |  | |  | | | |  |
| 0926 | | 218092330 | | | |  | | | | SCR CAP HT NI M 5.X16LG. 100C | | | | | | 4 |  | |  | | | |  | |  | | | |  |
| 0985 | | 218092330 | | | |  | | | | SCR CAP HT NI M 5.X16LG. 150C | | | | | | 4 |  | |  | | | |  | |  | | | |  |
| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | |  | | | | |  | |  | |  | |  | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | |  | | | | |  | |  | |  | |  | |
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| **45°** | | | | | | | | | | | | | | | | | **Left Blank** | | | | | | | | | | | | |
| Instruction:   * Service Note: For 100Crs Flow line, the follow operations should be done horizontally and no more turning required. | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **660** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | **iXH XD Pump Cartridge Build** | | | | | | | | |
| **M** | **S** | | **OP1240** | | | | | | | | | | | | | | | | | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | | Description | | | | | | Qty. | Ref. | Man.Item No. | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | 100HP XD | | | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 500HP XD | | 200HP S XD+ | |  | |  | |  | |
|  | | | |  | | | | |  | | | |  | | |  | |  | |  | |  | |  | |  | |
| Instruction:   * Select right motor * 펌프에 해당하는 올바른 모터를 조립하시오. | | | | | | | | |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | | ***No.*** | ***DP No.*** | ***DP Description*** | ***Voltage*** | ***KW*** | ***Motor No.*** | ***Motor Description*** | | 1 | A41600959 | G4 100RC HP XD PUMP 7.5KW SG HV | **HV** | **7.5KW** | A07117061 | MTR 7.5KW 340V 90/100HZ 2P W-B | | 2 | A41600958 | G4 100RC HP XD PUMP 7.5KW SG LV | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 3 | A41607959 | G4 100RC LP XD PUMP 4.5KW SG HV | **HV** | **4.5KW** | A07115061 | MTR 4.5KW 340V 90/100HZ 2P W-B | | 4 | A41607958 | G4 100RC LP XD PUMP 4.5KW SG LV | **LV** | **4.5KW** | A07115060 | MTR 4.5KW 180V 90/100HZ 2P W-B | | 5 | A41601958 | G4 200HP PUMP 7.5KW LV XCD | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 6 | A41601959 | G4 200RC HP XD PUMP 7.5KW SG HV | **HV** | **7.5KW** | A07117061 | MTR 7.5KW 340V 90/100HZ 2P W-B | | 7 | A41602958 | G4 200RC LP XD PUMP 7.5KW SG LV | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 8 | A41603959 | G4 300RC LP XD PUMP 7.5KW SG HV | **HV** | **7.5KW** | A07117061 | MTR 7.5KW 340V 90/100HZ 2P W-B | | 9 | A41603958 | G4 300RC LP XD PUMP 7.5KW SG LV | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 10 | A41648959 | G4 500RC HP XD PUMP 11KW HV | **HV** | **11KW** | A07118061 | MTR 11KW 340V 180/200HZ 4P W-B | | 11 | A41648958 | G4 500RC HP XD PUMP 11KW LV | **LV** | **11KW** | A07118060 | MTR 11KW 180V 180/200HZ 4P W-B | | 12 | A42656959 | NB G4 100RC HP XD PUMP 7.5KW SG HV | **HV** | **7.5KW** | A07117061 | MTR 7.5KW 340V 90/100HZ 2P W-B | | 13 | A42656958 | NB G4 100RC HP XD PUMP 7.5KW SG LV | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 14 | A42661959 | NB G4 100RC LP XD PUMP 4.5KW SG HV | **HV** | **4.5KW** | A07115061 | MTR 4.5KW 340V 90/100HZ 2P W-B | | 15 | A42661958 | NB G4 100RC LP XD PUMP 4.5KW SG LV | **LV** | **4.5KW** | A07115060 | MTR 4.5KW 180V 90/100HZ 2P W-B | | 16 | A42642958 | NB G4 200HP PUMP 7.5KW LV XCD WB | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 17 | A42642959 | NB G4 200RC HP XD PUMP 7.5KW SG HV | **HV** | **7.5KW** | A07117061 | MTR 7.5KW 340V 90/100HZ 2P W-B | | 18 | A42660958 | NB G4 200RC LP XD PUMP 7.5KW SG LV | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 19 | A42646959 | NB G4 300RC LP XD PUMP 7.5KW SG HV | **HV** | **7.5KW** | A07117061 | MTR 7.5KW 340V 90/100HZ 2P W-B | | 20 | A42646958 | NB G4 300RC LP XD PUMP 7.5KW SG LV WB | **LV** | **7.5KW** | A07117060 | MTR 7.5KW 180V 90/100HZ 2P W-B | | 21 | A42643959 | NB G4 500RC HP XD PUMP 11KW HV WB | **HV** | **11KW** | A07118061 | MTR 11KW 340V 180/200HZ 4P W-B | | 22 | A42643958 | NB G4 500RC HP XD PUMP 11KW LV WB | **LV** | **11KW** | A07118060 | MTR 11KW 180V 180/200HZ 4P W-B | | | | | | | | | | | | | | | | | | | | |
| Page | | **670** | | | Issue | | **8** | | | Approved | | | | Daniel.Park | | | | | | | | | | | SOP TEMPLATE – SINGLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1250** | | | | | | | | | | | | | | **M** | **S** | | **OP1260** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 1200 | | A24301064 | | | | A24301764 | | | | KEY - 7 X 8 X 35 LG. 100/150C | | | | | | 1 | 1220 | | A41200051 | | | A41200051 | | COUPLING – MOTOR. 100/150C | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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|  | | | | | | | | | | | | | | | | | **1**  **2**  3Nm Torque Wrench + 3mm AF Bit with Adaptor | | | | | | | | | | | |
| Instruction:   * 모터샤프트에 키를 조립하시오. | | | | | | | | | | | | | | | | | Instruction:   * 스크류에 록타이트를 바른후 커플링을 모터 샤프트에 조립하시오. | | | | | | | | | | | |
| Page | | **680** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1270** | | | | | | | | | | | | | | **M** | **S** | | **OP1280** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | | Qty | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty |
| 1240 | | A41200050 | | | | A41200816 KIT 2 | | | | COUPLING – SPIDER. 100C | | | | | | 1 | 1210 | | H02134017 | | | A41200815 KIT 1 | | O RING VIT9830 212.0ID X. 100C | | | | 1 |
| 1240 | | A41200050 | | | | A41205816 KIT 2 | | | | COUPLING – SPIDER. 150C | | | | | | 1 | 1210 | | H02134017 | | | A41205815 KIT 1 | | O RING VIT9830 212.0ID X 150C | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | 200LP XD | | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | |  | | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| Instruction   * 스파이터 커플링을조립하시오. | | | | | | | | | | | | | | | | | Instruction:   * 오링에 폼블리스를 바른 후 모터에 조립하시오. | | | | | | | | | | | |
| Page | | **690** | | Issue | | **02** | | Approved | | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | |  | | | | | | | | | |
| **M** | **S** | | **OP1290** | | | | | | | | | | | | | **M** | **S** | | | **OP1300** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | |  | | | | | |  | 0090 | | 218092453 | | | |  | | SCR CAP HT NI M10.X 30LG. 100/150C | | | | 8 |
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| 100LP XD | | | | | 100HP XD | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| TDS017555 | | | | | | | | | | | | | | | | TDS 012321  **1** | | | | | | | | | | | | |
| Instruction: | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **700** | | Issue | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1310** | | | | | | | | | | | | | | **M** | **S** | | | **OP1320** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty | Ref. | | Man.Item No. | | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | |  | | | | | |  | 1130 | | A26002063 | | | | A26002763 | | 3/8” BSP PLUG HEX DRIVE. 1OO | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 1100 | | H02134001 | | | | A41200815 KIT 1 | | ORING VIT9830 19.5ID X 3.0SEC. 100C | | | | 1 |
|  | |  | | | |  | | | |  | | | | | |  | 1100 | | H02134001 | | | | A41200815 KIT 1 | | O RING VIT9830 19.5ID X 3.0 SEC 150C | | | | 1 |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | | 200HP S XD+ | |  | |  | |  | |
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| **360°**  10mm A/F hex key | | | | | | | | | | | | | | | | | **1**  **2**  10mm A/F hex key | | | | | | | | | | | | |
| Instruction:   * Ensure no backlash between motor and pump. * 백레시가 있는지 확인하시오. (없어야 할 것) | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | | |
| Page | | **710** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1330** | | | | | | | | | | | | | | **M** | **S** | | **OP1340** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| Instruction: | | | | | | | | | | | | | | | | | Instruction:   * 호이스트를 이용하여 펌프를 페인트 트롤리에 올리시오 * Service Note: For 100Crs Flow line, Service can use any existing paint trolley. | | | | | | | | | | | |
| Page | | **720** | | Issue | | | **02** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1350** | | | | | | | | | | | | | | **M** | **S** | | **OP1360** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
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| Instruction: | | | | | | | | | | | | | | | | | Instruction: | | | | | | | | | | | |
| Page | | **730** | | Issue | | | **05** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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|  | | | | | | | | | | | SOP No. | | | **SOPKR1662** | | | Title: | | **iXH XD Pump Cartridge Build** | | | | | | | | | |
| **M** | **S** | | **OP1370** | | | | | | | | | | | | | | **M** | **S** | | **OP1380** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
| 150C | | A41205053 | | | |  | | | | STATIC FILTER COVER PLATE PK1 | | | | | | 2 | **1100** | | H02134001 | | | A41200815 KIT 1 | | ORING VIT9830 19.5ID X 3.0. 100C | | | | 3 |
| 150C | | 27522-046 | | | |  | | | | M6X16 SOC HD CAP SCREW | | | | | | 8 | **1130** | | A26002063 | | | A26002763 | | 3/8"BSP PLUG HEX DRIVE. 100/150C | | | | 3 |
|  | | H03517004 | | | |  | | | | 1/8"BSP TAPER PRESSURE PLUG | | | | | | 2 |  | |  | | |  | |  | | | |  |
| 100C | | 27522-046 | | | |  | | | | M6X16 SOC HD CAP SCREW | | | | | | 4 |  | |  | | |  | |  | | | |  |
| 100C | | A41200054 | | | |  | | | | STATIC FILTER COVER PLATE Pk.1 | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 150C | | H02134003 | | | |  | | | | ORING VIT9830 61.5ID X 2.4SEC | | | | | | 2 |  | |  | | |  | |  | | | |  |
| 0570 | | H02134000 | | | | A41200816 KIT2 | | | | ORING VIT9830 44.5ID X 2.4SEC. 100C | | | | | | 1 |  | |  | | |  | |  | | | |  |
| 100LP XD | | | | | 100HP XD | | | 200LP XD | | | | 200HP XD | | | 300LP XD | | 100LP XD | | | | 100HP XD | | 200LP XD | | 200HP XD | | 300LP XD | |
| 500HP XD | | | | | 200HP S XD+ | | |  | | | |  | | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
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| **1**  **2**  **X8**  150Ctrs  100Ctrs | | | | | | | | | | | | | | | | | End Cover  **1**  Gear Cover  **2**  +  **X22**  10mm AF hex key  **해당 플러그는 조립을 하지 마시오** | | | | | | | | | | | |
| Instruction:   * 커버 플레이트를 조립하시오. | | | | | | | | | | | | | | | | | Instruction:   * 조립하시오. | | | | | | | | | | | |
| Page | | **740** | | Issue | | | **05** | | Approved | | | | Daniel.Park | | | | | | | | | | | | | SOP TEMPLATE – DOUBLE LANDSCAPE v7.doc | | |

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| **M** | **S** | | **OP1390** | | | | | | | | | | | | | | **M** | **S** | | **OP1400** | | | | | | | | |
| Ref. | | Man.Item No. | | | | Ser.Item No. | | | | Description | | | | | | Qty. | Ref. | | Man.Item No. | | | Ser.Item No. | | Description | | | | Qty. |
|  | |  | | | |  | | | | Inlet adaptor NW40 | | | | | | 1 |  | | A20001085 | | |  | | DIRECTION LABEL | | | | 1 |
| OK MESSAGE ME WHEN | |  | | | | SEL1148 | | | | Outlet blanking plate 100C | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | |  | | | | SEL1143 | | | | Outlet blanking plate 150C | | | | | | 1 |  | |  | | |  | |  | | | |  |
|  | |  | | | |  | | | | Gear cover adaptor NW25-BSP3/8” | | | | | | 1 |  | |  | | |  | |  | | | |  |
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| 500HP XD | | | | | 200HP S XD+ | | |  | | | | |  | |  | | 500HP XD | | | | 200HP S XD+ | |  | |  | |  | |
|  | | | | |  | | |  | | | | |  | |  | |  | | | |  | |  | |  | |  | |
| For 2 Minutes  Spec < 5.0 X 10-6 mbar l/sec | | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| Instruction:   * Service Note: Service uses blank & NW fittings in according to Master Tool List.. | | | | | | | | | | | | | | | | | Instruction:   * Attach allow direction sticker on pump motors as shown with leak test pass. * 리크테스트 합격시 그림과 같이 화살표방향 스티커를 펌프 모터에 붙이시오. | | | | | | | | | | | |
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|  | | | | | SOP No. | **SOPKR1662** | Title: | **iXH XD Pump Cartridge Build** | |
| |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | | **Standard Tool Description** | **Qty** | **M / S** | **Special Tool No.** | **Special Tool Description** | **Qty** | **M / S** | | 8mm Socket | 1 | M/S | TDS012110 | G4 100CRS LV PIN FITTING TOOL | 1 | M/S | | 24mm socket | 1 | M/S | TDS012115 | G4 100tr VARISEAL INSERTION TOOL | 2 | M/S | | 2Nm Torque wrench | 1 | M/S | TDS012122 | G4 100CRS RING NUT TORQUE OP2 | 1 | M/S | | 4.6Nm Torque wrench | 2 | M/S | TDS012124 | G4 100CRS SHAFT PROTECTOR - LONG | 1 | M/S | | 10Nm Torque wrench | 5 | M/S | TDS012129 | G4 100CRS SHAFT PROTECTOR - SHORT | 1 | M/S | | 14Nm Torque wrench | 1 | M/S | TDS012136 | G4 100CRS OIL THROWER TOOL | 1 | M/S | | 17Nm Torque wrench | 1 | M/S | TDS012143 | G4 100ctr X-GEAR PRESS ALIGN TOOL | 1 | M/S | | 24Nm Torque wrench | 1 | M/S | TDS012144 | 100ctr OIL SEAL CATCHER | 1 | M/S | | 40Nm Torque wrench | 1 | M/S | TDS012145 | G4 100 HYD. BEARING TOOL | 1 | M/S | | 55Nm Torque wrench | 3 | M/S | TDS012146 | G4 150ctr X-GEAR PRESS ALIGN TOOL | 1 | M/S | | 90Nm Torque wrench | 2 | M/S | TDS012147 | G4 100tr Y-GEAR PRESS ALIGN TOOL | 1 | M/S | | 150Nm Torque Wrench | 1 | M/S | TDS012158 | 100CTR XSHAFT KEY INSERT TOOL |  | M/S | | 3mm AF Bit with Adaptor | 2 | M/S | TDS012164 | G4 100CTR NRV ORING TOOL | 1 | M/S | | 4mm AF Bit with Adaptor | 1 | M/S | TDS012200 | 105CRS BUILD FIXTURE | 2 | M/S | | 5mm AF Bit with Adaptor | 1 | M/S | TDS012202 | 150crs TURNOVER PLATE - Pump/Booster | 2 | M/S | | 6mm AF Bit with Adaptor | 1 | M/S | TDS012203 | AXIAL SETTING INDICATOR | 1 | M/S | | 8mm 50mm long AF Bit with Adaptor | 1 | M/S | TDS012306 | 100CRS BUILD FIXTURE | 2 | M/S | | 8mm AF Bit with Adaptor | 3 | M/S | TDS012209 | X-SHAFT LIFTING TOOL | 2 | M/S | | 10mm AF Bit with Adaptor | 2 | M/S | TDS012210 | G4 150CRS LV PIN FITTING TOOL | 1 | M/S | | 3mm AF Hex T Bar | 1 | M/S | TDS012215 | G4 150tr VARISEAL INSERTION TOOL | 2 | M/S | | 5mm AF Hex T Bar | 1 | M/S | TDS012218 | G4 NRV PRESS TOOL | 1 | M/S | | 3/16” AF Hex T Bar | 1 | M/S | TDS012220 | G4 150CRS RING NUT TORQUE OP2 | 1 | M/S | | 1/8” AF Hex Key | 1 | M/S | TDS012221 | 150CRS DYNAMIC SEAL PRESS TOOL | 2 | M/S | | 13mm Combination Spanner | 1 | M/S | TDS012222 | G4 150CRS SHAFT PROTECTOR - LONG | 2 | M/S | | 17mm Combination Spanner | 1 | M/S | TDS012223 | G4 150CRS SHAFT PROTECTOR - SHORT | 2 | M/S | | 19mm Combination Spanner | 1 | M/S | TDS012224 | 150ctr OIL SEAL CATCHER | 2 | M/S | | Plastic Headed Mallet | 1 | M/S | TDS012225 | G4 150CRS OIL THROWER TOOL | 1 | M/S | | Internal Circlip Pliers | 1 | M/S | TDS012228 | G4 150 HYD. BEARING TOOL | 1 | M/S | | 247870 - dial torque wrench | 1 | M/S | TDS012230 | G4 150CRS GEAR LOCKING TOOL | 1 | M/S | | | | | | | | | | |
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|  | | | | | SOP No. | **SOPKR1662** | Title: | **iXH XD Pump Cartridge Build** | |
| |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | | **Standard Tool Description** | **Qty** | **M / S** | **Special Tool No.** | **Special Tool Description** | **Qty** | **M / S** | | Digital plunge clock with magnetic base | 1 | M/S | TDS012115 | G4 100tr VARISEAL INSERTION TOOL | 2 | M/S | | Vernier Calliper | 1 | M/S | TDS012232 | CARTRIDGE BUILD TROLLEY | 2 | M/S | | Makita Cordless Driver | 5 | M/S | TDS012233 | SOFT-G4 150CRS OIL THROWER TOOL | 1 | M/S | | Loctite 222 | 1 | M/S | TDS012239 | DC TORQUE TOOL | 1 | M/S | | Fomblin Oil | 1 | M/S | TDS012240 | 150crs MOBILE TURNOVER TROLLEY | 4 | M/S | | Depth Gauge | 2 | M/S | TDS012241 | G4 150tr Y-GEAR PRESS ALIGN TOOL | 1 | M/S | |  |  |  | TDS012242 | G4 150CRS HYDRAULIC ASSY TOOL | 2 | M/S | |  |  |  | TDS012258 | 150CTR XSHAFT KEY INSERT TOOL | 1 | M/S | |  |  |  | TDS012266 | G4 150crs PAINT TROLLEY | 2 | M/S | |  |  |  | TDS012306 | 100CRS BUILD FIXTURE | 2 | M/S | |  |  |  | TDS012307 | G4 100CRS GEAR LOCKING TOOL | 1 | M/S | |  |  |  | TDS012312 | G4 100crs LV ROTOR PRESS TOOL | 1 | M/S | |  |  |  | TDS012315 | G4 100CRS LIFTING TOOL | 1 | M/S | |  |  |  | TDS012329 | G4 150CRS LIFTING TOOL | 1 | M/S | |  |  |  | TDS012354 | G4 150crs LV ROTOR PRESS TOOL | 1 | M/S | |  |  |  | TDS012403 | 100CRS AXIAL SETTING INDICATOR | 1 | M/S | |  |  |  | TDS012404 | 150CRS AXIAL SETTING INDICATOR | 1 | M/S | |  |  |  | TDS012407 | 100CRS AXIAL SET SPANNER(OLD) | 1 | S | |  |  |  | TDS012408 | 150CRS AXIAL SET SPANNER(OLD) | 1 | S | |  |  |  | TDS012412 | TURNOVER FIXTURE PLATE | 4 | M/S | |  |  |  | TDK220016 | LOCKING PLATE JIG\_G4 MODULE DRY | 1 | M/S | |  |  |  | TDS017555 | MOTOR LIFTING TOOL | 1 | M/S | |  |  |  | iSO200945 | 100 crs gear removal tool | 1 | M/S | |  |  |  | iSO200946 | 150 crs gear removal tool | 1 | M/S | |  |  |  | TDS012259 | 100 crs gear removal tool spacer | 1 | M/S | |  |  |  | TDS012260 | 150 crs gear removal tool spacer | 1 | M/S | |  |  |  | TDK220044 | 100CRS AXIAL SET SPANNER(NEW) | 1 | MS | |  |  |  | TDS012439 | 150CRS AXIAL SET SPANNER(NEW) | 1 | M/S | |  |  |  | TDK220051 | Full axle float jig | 1 | M/S | | | | | | | | | | |
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