

## Standardized Assembly Work Instructions

Cooler Code: AVIX-WorkInstruction Parallel

This Document Was Composed in Python by Mirko Glavan



# Cooler Code: AVIX-WorkInstruction Parallel

Tool Name	Description		Picture
impact drill			
6mm bit			8
8mm bit			
19mm bit			
3/8mm bit			
19mm socket			
torque wrench			
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Tool Name	Description	Picture
10 snips pliers		
loctite243		
loctite567		William & San
torque seal (orange)		
yellow paint pen		

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Cooler Code: **AVIX-WorkInstruction** Parallel

Operation 1 Description:

1.Prepare the Housing for Assembly by fastening the edge grip on the perimeter and placing lifting brackets.



Parts:

Tools:

30- 3121813-Housing x1 90-7702136-Lifting Bracket x1 210- 2506913-SCHS M8 1.25x25 x1

160-2506176-Foam Tape x2"





Operation Time: 120.0 sec Issued By: Mirko Glavan Approved By:

Total Time: 120.0 sec Signed: File D.O.B: 06-24-2024 Page: OP - 3 / 6



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Operation 2 Description:

2. Prepare the Heat **Exchanger with Spacers** fastened with SCHS bolts. Add hex plug and SAE plug as shown. Torque SAE to 90 ft/lbs. Mark torqued bolts and plugs in yellow as shown. Apply Loctite 567 to the hex plug on bottom threads.







Parts:

10-2581247-HE x1

20-2583479-Spacer x1

190-601476-SCHS M8

1.25x45 x8

180- 2506870-Flat

Washer x8

110- 2580116-MNPT08

Plug x1

100-2581382-SAE Plug

х1

Tools:

3/8mm bit

6mm bit

impact drill

torque wrench

19mm bit

yellow paint pen

loctite567

Operation Time: 240.0 sec

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Total Time: 360.0 sec

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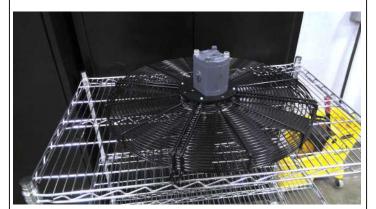
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#### Operation 3 Description:

3. Flip the Heat Exchanger to add the fan after it is assembled. Add 2" reflective tape to the center of part 60. Refer to BOM or drawing for any uncertainties with washers and bolts. Note that the nut and washer from the motor (MN, MW) must be used to install the fan. Use torque seal after these are added with Loctite 243 on the MN. Torque this to 22 ft/lbs.





Parts:

70- 2581683-HMotor x1
60- 3106375-Motor
Support Bracket x1
50- 3121812-Fan Grill x1
40- 3121815-Fan x1
210- 2506913-SCHS M8
1.25x25 x8
220- 2589303-Flat
Washer M8 x8

170- 2957994-Reflective

Tools:
impact drill
8mm bit
6mm bit
torque wrench
loctite243
19mm bit

Tape x1

Operation Time: 360.0 sec Issued By: Mirko Glavan Approved By:

Total Time: 720.0 sec Signed: File D.O.B: 06-24-2024 Page: OP - 5 / 6



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#### Operation 4 Description:

4. Add feet to the cooler.
After this is completed,
add yellow paint to all
exterior bolts and apply
sticker labels as shown.
Add loctite243 to bolts on
the feet. In/Out Labels,
Product Label, Logo
Label, Fan Rotation
Label required in neat,
correct orientation. Note
there are 2 sets of In/Out
labels (on HE and on
Motor)





Parts:

80- 2592683-Mounting

Foot x1

180- 2506870-Flat

Washer x2

210-2506913-SCHS M8

1.25x25 x1

150- 2507170-IN\_OUT

Labels x2

130-2507152-HYDAC

Logo Label x1

120- 2581335-Part Label

x1

140- 2507164-Ran

Rotation Label (CCW) x1

Tools:

loctite243

6mm bit

impact drill

yellow paint pen

Total Time: 960.0 sec | Signed: | File D.O.B: 06-24-2024 | Page: OP - 6 / 6