

















# Standardized Assembly Work Instructions




Cooler Code: AVIX-WorkInstruction Parallel



This Document Was Composed in Python by Mirko Glavan

| PYTHON Work Instrunctions |  |   | Cooler Code:<br>AVIX-WorkInstruction<br>Parallel |
|---------------------------|---|---|--|
| Tool Name                 | Description   | Picture   |  |
| impact drill              |   |    |  |
| 6mm bit                   |   |    |  |
| 8mm bit                   |   |   |  |
| 19mm bit                  |   |  |  |
| 3/8mm bit                 |   |  |  |
| 19mm socket               |   |  |  |
| torque wrench             |   |  |  |
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| PYTHON Work Instrunctions |  | Cooler Code:<br>AVIX-WorkInstruction<br>Parallel                                      |
|---------------------------|---|---|
| Tool Name                 | Description   | Picture   |
| 10 snips pliers           |   |    |
| loctite243                |   |    |
| loctite567                |   |   |
| torque seal (orange)      |   |  |
| yellow paint pen          |   |  |

|                         |                        |                 |  |
|-------------------------|------------------------|-----------------|--|
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| PYTHON Work Instrunctions  |  |  |  | Cooler Code:<br>AVIX-WorkInstruction<br>Parallel |                  |
| Operation 1 Description:<br><br>1.Prepare the Housing<br>for Assembly by<br>fastening the edge grip<br>on the perimeter and<br>placing lifting brackets. |    |   | <p>Parts:</p> <p>30- 3121813-Housing x1</p> <p>90- 7702136-Lifting<br/>Bracket x1</p> <p>210- 2506913-SCHS M8<br/>1.25x25 x1</p> <p>160- 2506176-Foam<br/>Tape x2"</p> <p>Tools:</p> <p>6mm bit</p> <p>impact drill</p> <p>10 snips pliers</p> |  |                  |
|  |  |   |  |  |                  |
| 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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| <p>PYTHON Work Instrunctions</p>   |   |                               | <p>Cooler Code:<br/>AVIX-WorkInstruction<br/>Parallel</p>  |
| <p>Operation 2 Description:</p> <p>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.</p> |  |                               | <p>Parts:</p> <p>10-2581247-HE x1</p> <p>20-2583479-Spacer x1</p> <p>190- 601476-SCHS M8 1.25x45 x8</p> <p>180- 2506870-Flat Washer x8</p> <p>110- 2580116-MNPT08 Plug x1</p> <p>100- 2581382-SAE Plug x1</p> <p>Tools:</p> <p>3/8mm bit</p> <p>6mm bit</p> <p>impact drill</p> <p>torque wrench</p> <p>19mm bit</p> <p>yellow paint pen</p> <p>loctite567</p> |
| <p>Operation Time: 240.0 sec</p>   | <p>Issued By: Mirko Glavan</p>   |                               | <p>Approved By:</p>  |
| <p>Total Time: 360.0 sec</p>   | <p>Signed:</p>   | <p>File D.O.B: 06-24-2024</p> | <p>Page: OP - 4 / 6</p>  |

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| <p>PYTHON Work Instrunctions</p>   |   |                               | <p>Cooler Code:<br/>AVIX-WorkInstruction<br/>Parallel</p>  |
| <p>Operation 3 Description:</p> <p>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.</p> |  |                               | <p>Parts:</p> <p>70- 2581683-HMotor x1<br/>60- 3106375-Motor Support Bracket x1<br/>50- 3121812-Fan Grill x1<br/>40- 3121815-Fan x1<br/>210- 2506913-SCHS M8 1.25x25 x8<br/>220- 2589303-Flat Washer M8 x8<br/>170- 2957994-Reflective Tape x1</p> <p>Tools:</p> <p>impact drill<br/>8mm bit<br/>6mm bit<br/>torque wrench<br/>loctite243<br/>19mm bit</p> |
| <p>Operation Time: 360.0 sec</p>   | <p>Issued By: Mirko Glavan</p>   | <p>Approved By:</p>           |  |
| <p>Total Time: 720.0 sec</p>   | <p>Signed:</p>   | <p>File D.O.B: 06-24-2024</p> | <p>Page: OP - 5 / 6</p>  |



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| <p>PYTHON Work Instrunctions</p>  |   |                               | <p>Cooler Code:<br/>AVIX-WorkInstruction<br/>Parallel</p>   |
| <p>Operation 4 Description:</p> <p>4. Add feet to the cooler.</p> <p>After this is completed, add yellow paint to all exterior bolts and apply sticker labels as shown.</p> <p>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)</p> |  |                               | <p>Parts:</p> <p>80- 2592683-Mounting Foot x1</p> <p>180- 2506870-Flat Washer x2</p> <p>210- 2506913-SCHS M8 1.25x25 x1</p> <p>150- 2507170-IN_OUT Labels x2</p> <p>130- 2507152-HYDAC Logo Label x1</p> <p>120- 2581335-Part Label x1</p> <p>140- 2507164-Ran Rotation Label (CCW) x1</p> <p>Tools:</p> <p>loctite243</p> <p>6mm bit</p> <p>impact drill</p> <p>yellow paint pen</p> |
| <p>Operation Time: 240.0 sec</p>  | <p>Issued By: Mirko Glavan</p>   | <p>Approved By:</p>           |   |
| <p>Total Time: 960.0 sec</p>  | <p>Signed:</p>   | <p>File D.O.B: 06-24-2024</p> | <p>Page: OP - 6 / 6</p>   |