

Step 1

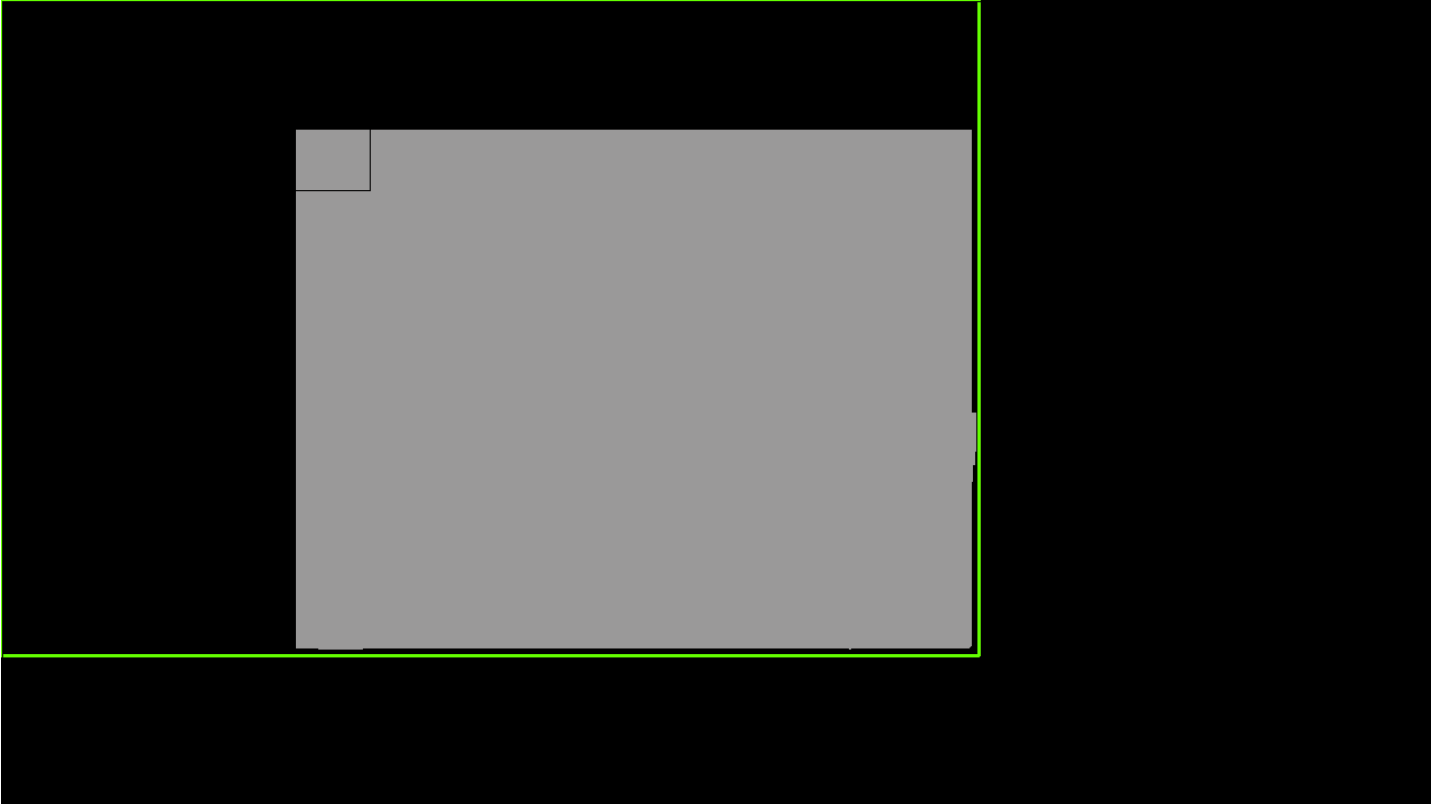


Written Instructions:

To Begin, orient the Heat Exchanger (PN: 3394011)

upright. Collect this part from those pulled.

Step 2



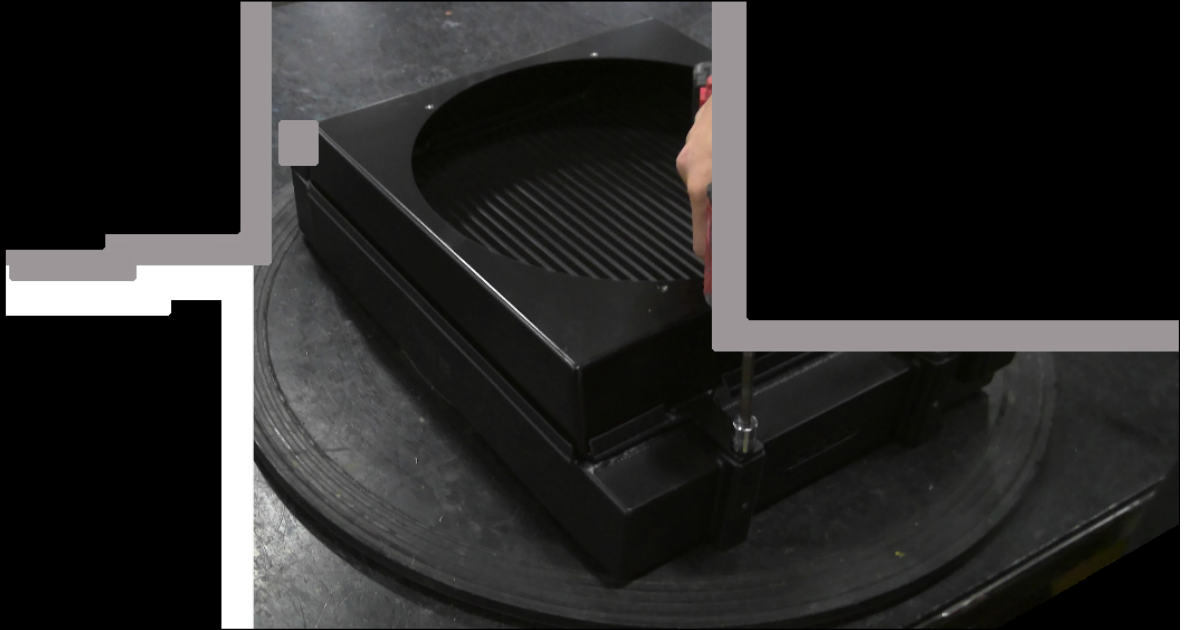
Written Instructions:

Next, place the Housing on top of the Heat Exchanger.

NOTE: Edge Grip and Foam Tape must be applied prior to installation (shown later)

WARNING: Ensure housing holes face the operator (shown later)

Step 3



Written Instructions:

Next, Drill Bolts with a Torque

Drill into place.(PN: 601376 and 2580868)

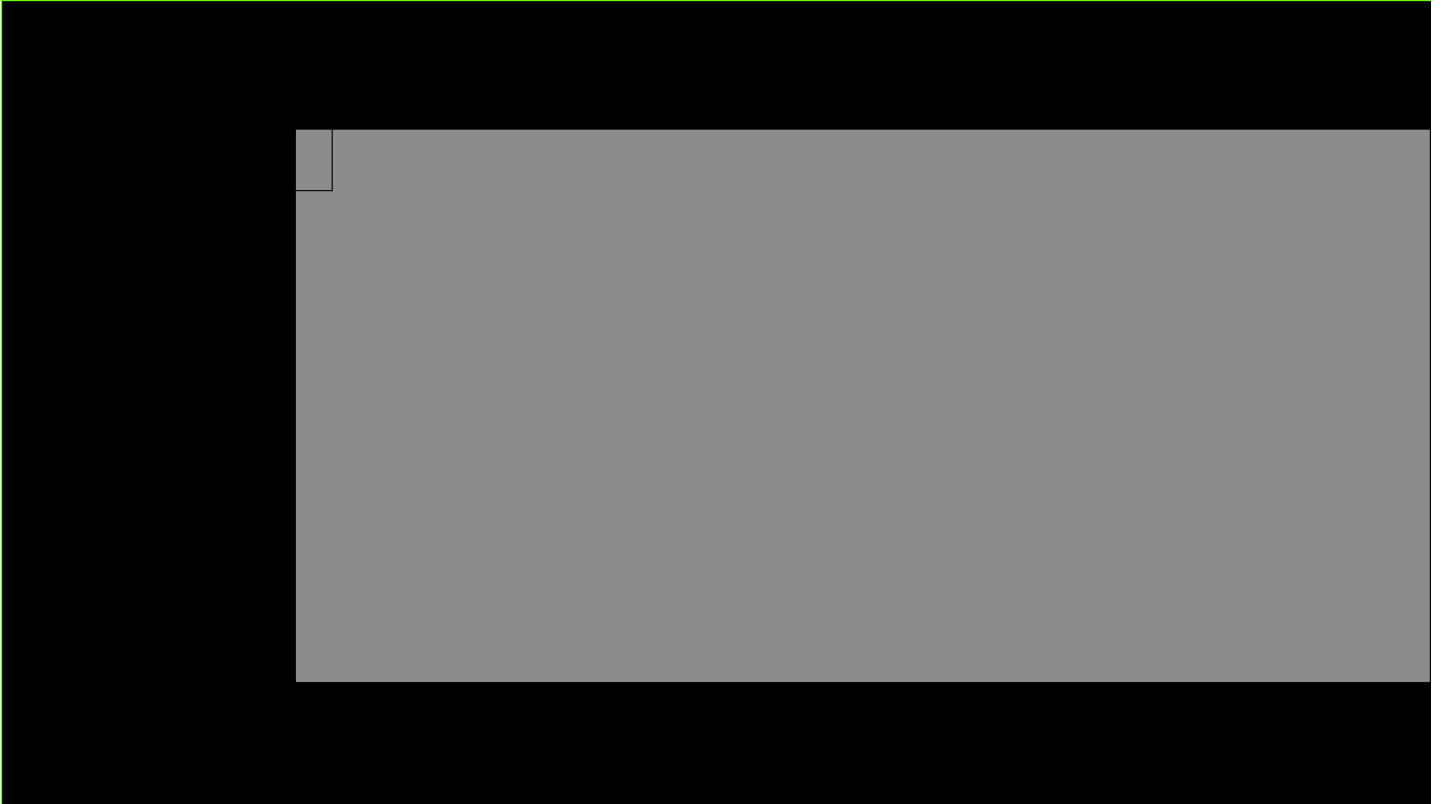
NOTE: Lock Washers must be

applied, and Torque Value (22) must be met

WARNING: Thread screws prior to

drill to prevent stripping.

Step 4

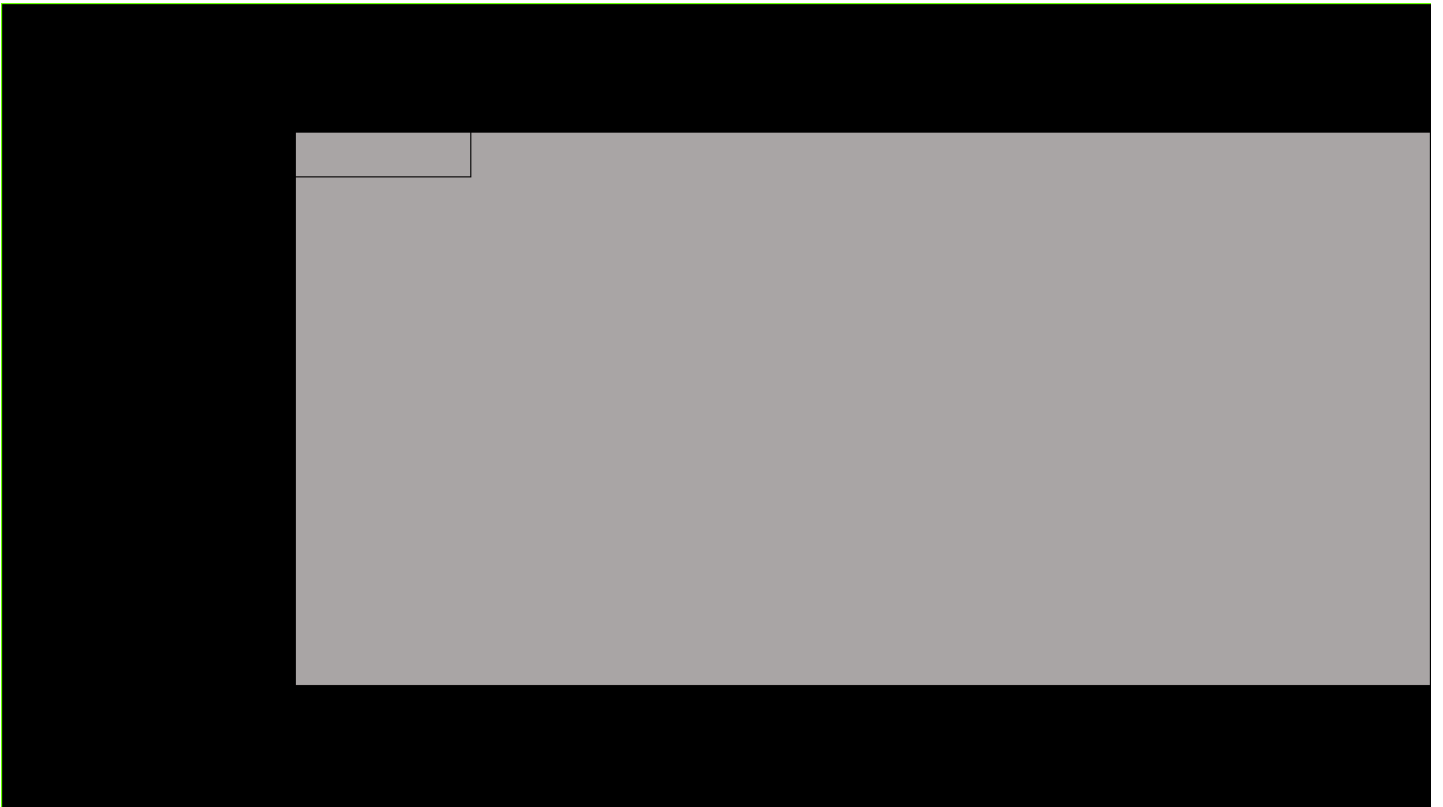


Written Instructions:

Next, place the fan (PN: 2957926) on top of the housing, aligning the bolt holes.

NOTE: The yellow sticker (highlighted) should be oriented towards the top.

Step 5

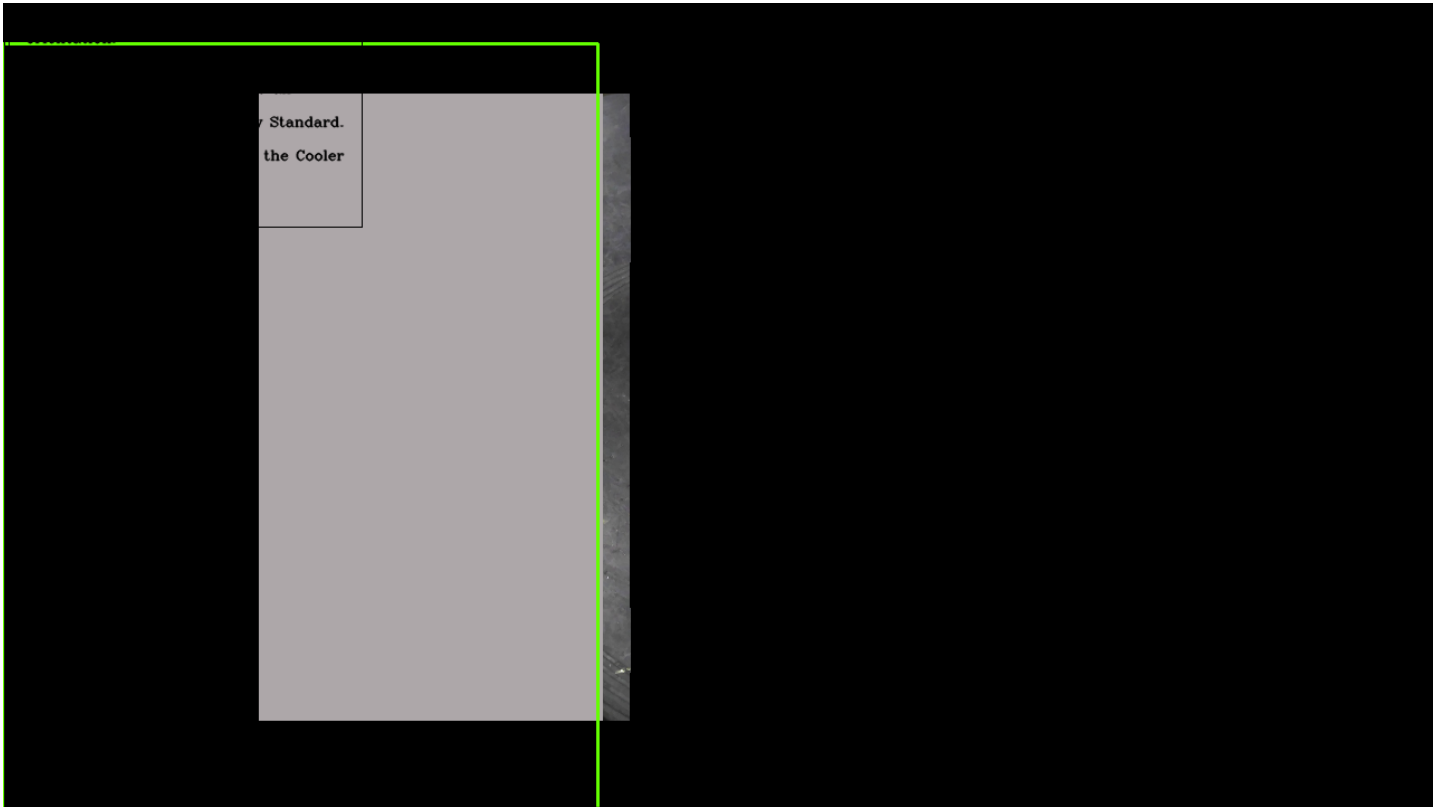


Written Instructions:

NOTE: Use the blue torque drill to fasten lock washers and bolts to 5 ft/lbs each. The PNs for these were
PN: 636196, 2580868.

Drill until a Green prompt light
and a *beep* is audible. Check lock
asher deployment.

Step 6



Written Instructions:

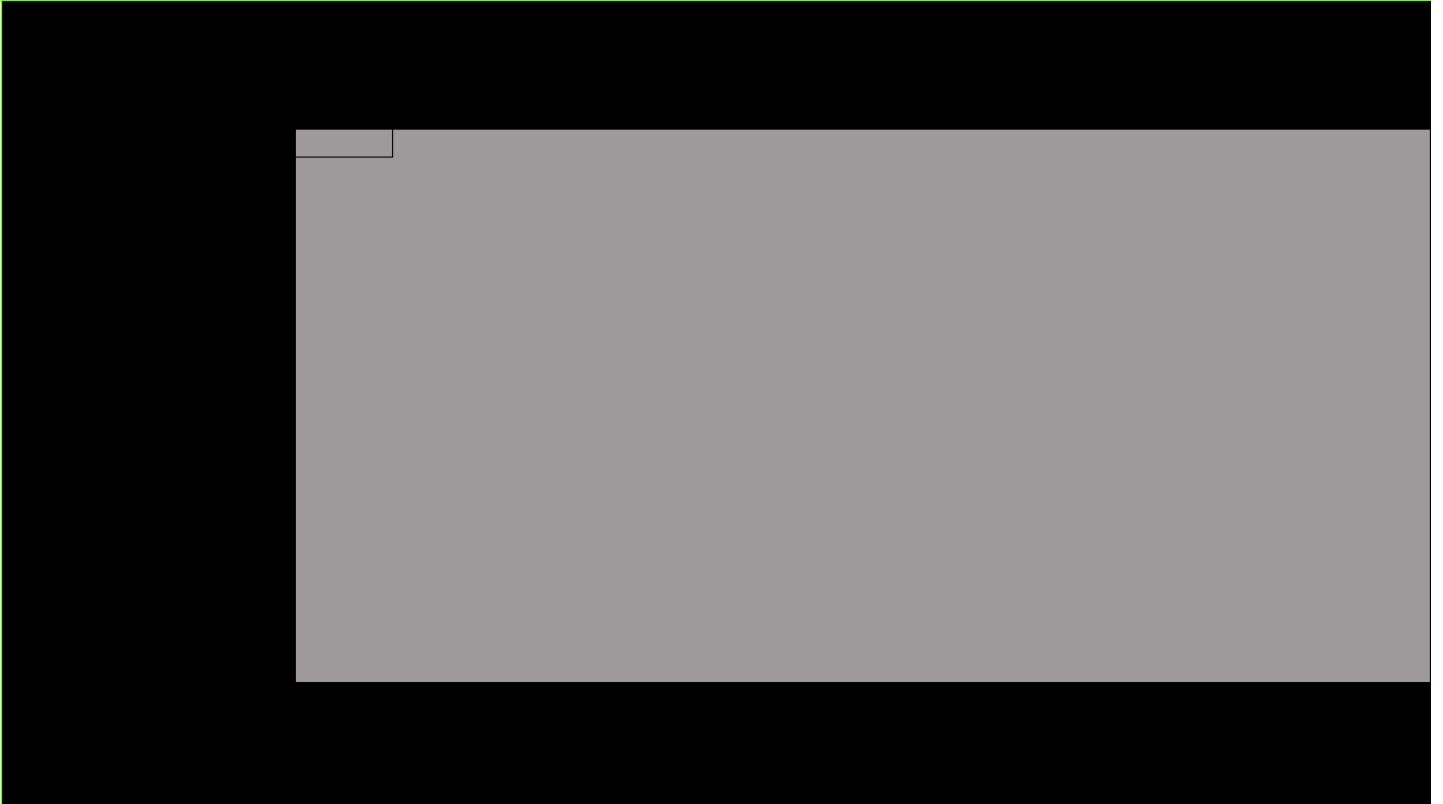
Apply the HYDAC Sticker in the shown orientation.

NOTE: Bubbles, Horizontal Alignment, Orientation, and Centering are all

important for meeting Quality Standard.

Ensure this is done neatly or the Cooler may come back!

Step 7

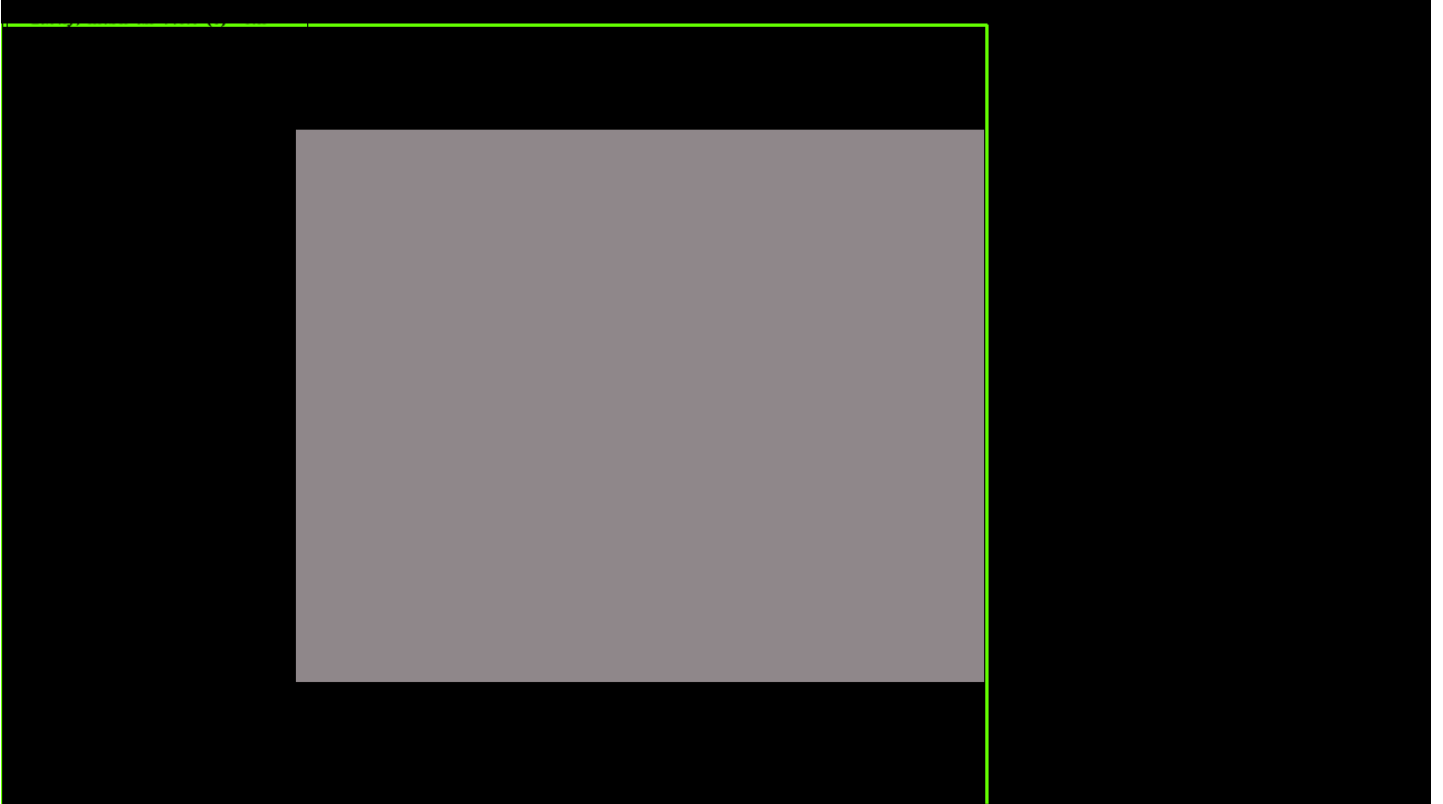


Written Instructions:

WARNING: Tie the cable on the fan as shown.

Do not pinch, double
knot, or perform any action that
may compromise the quality of the
wires inside.

Step 8



Written Instructions:

Lastly, mark all bolts (8) with the yellow paint marker. This is to ensure the customer cannot mess with the bolt after shipment .



Written Instructions:

You have now completed the assembly!

Refer to the drawing to ensure all steps were followed correctly. Ensure all labels were attached neatly.

When all steps are completed, locate a

Quality employee for inspection (if

necessary). Repeat this process until the order is fulfilled