

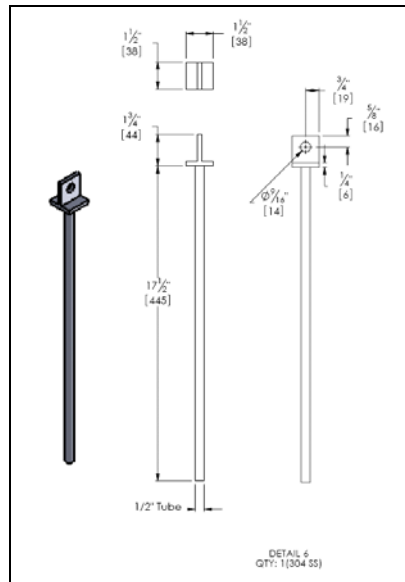
## UTILIDOR ACCESS HATCH ASSEMBLY PROCEDURE

This is a guideline for hatch assembly. Contractor must also refer to "*Hatch Drawings 099947-53, Sheets 1 thru 7 of 7*". On arrival this is what the access hatch will look like (with the latch installed and frame exterior coated green).



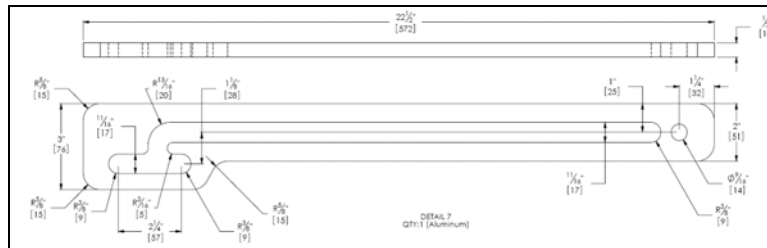
*Layout of hatch and parts on arrival in Alaska*

## ITEMS TO ASSEMBLE:



**Detail 6**

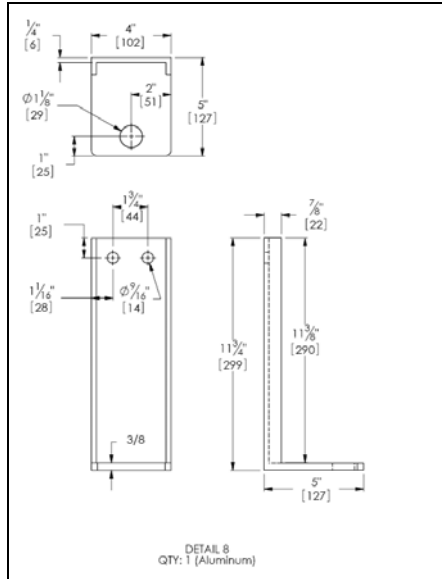
*Stainless Steel Shock Rod.*



**Detail 7**

*Aluminium J-arm.*

## ITEMS TO ASSEMBLE:



**Detail 8**

*Aluminium Shock Tower*

## STEPS TO ASSEMBLING THE UTILIDOR ACCESS HATCHES:

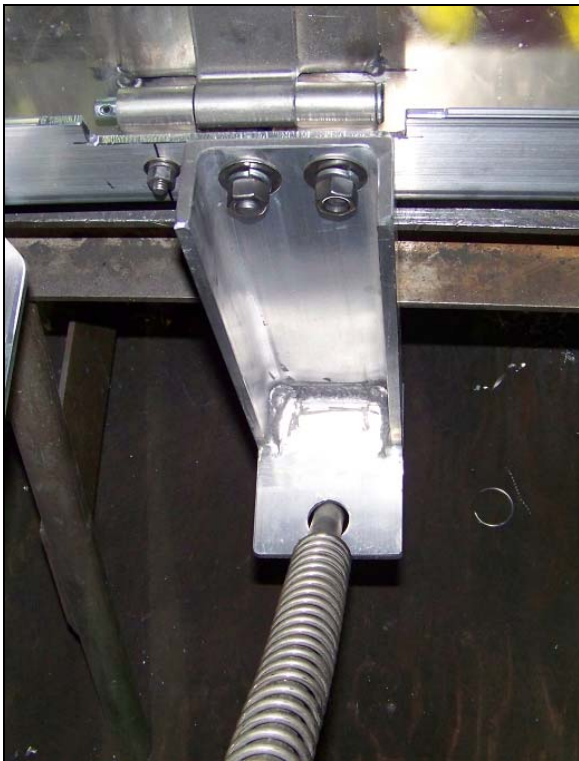
### Step 1:



Remove the center and right bolts on the left hinge. Each SS bolt is  $\frac{1}{2}$ " by  $1\frac{1}{2}$ ", with two  $\frac{1}{2}$ " SS flat washers, two  $\frac{1}{2}$ " SS lock washers and two  $\frac{1}{2}$ " SS nuts.

Insert the aluminum shock tower into the frame, align over center and right bolts, reinstall the washers and nuts and tighten the assembly.

### Step 2:



Place spring on stainless steel shock rod and insert into bottom hole of aluminum shock tower.



## STEPS TO ASSEMBLING THE UTILIDOR ACCESS HATCHES:

### Step 3:



Bolt top of stainless steel shock rod in between the two support plates, located on the lid above door hinge.

Bolt holding shock rod to the lid is one ½" by 2" SS bolt, two ½" SS flat washers and one ½" SS nylok nut.

### Step 4:



Remove the nylok nut and one flat washer from the ready rod attached to the angle support under the frame.

Install the aluminum J-arm onto the ready rod making sure the "right" side of pivot table is facing the front of the hatch.

## STEPS TO ASSEMBLING THE UTILIDOR ACCESS HATCHES:



Aluminum J-arm is attached to the ready rod with two  $\frac{5}{8}$ " SS flat washers and one  $\frac{5}{8}$ " SS nylok nut.

### Step 5:



The bolt holding the aluminum J-arm to the lid is one  $\frac{1}{2}$ " by 2" SS bolt, two  $\frac{1}{2}$ " SS flat washers and one  $\frac{1}{2}$ " SS nylok nut.

**ACCESS HATCH IS ASSEMBLED!**