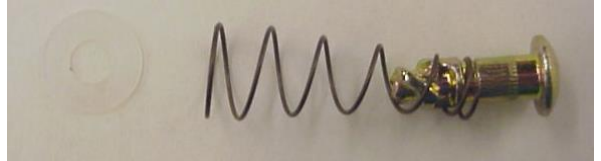
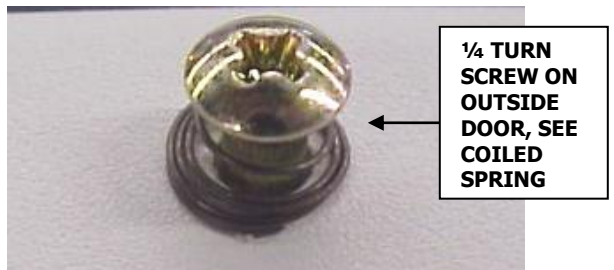
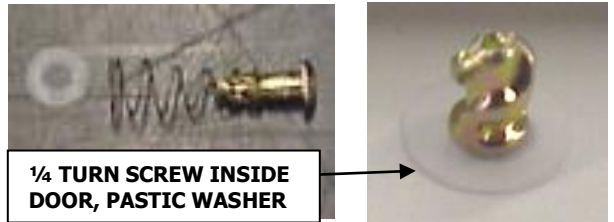


# I30 NRTL HOUSING DOOR ASSEMBLY

- 1) THE I30 HAS A RIGHT AND LEFT HINGED QUICK RELEASE DOOR. ADHERE LEDCO DOMED EMBLEM (LAB05A) **AS09** TO BOTH DOORS BEFORE ASSEMBLY.



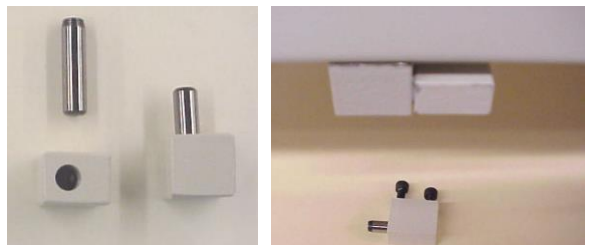
- 2) THE RIGHT SIDE HOUSING DOOR (I30 095.4R) **AS18** IS ASSEMBLED BY FIRST ATTACHING (3) HINGE QUARTER TURN LATCHES. USING THE QUARTER TURN DOOR LATCH KIT (PML002) **AS08** PLACE THE SMALLER END OF SPRING ON QUARTER TURN FASTENER SCREW. INSERT QUARTER TURN FASTENER SCREW INTO HOLE ON OUTSIDE OF DOOR, DEPRESSING SPRING ON OUTSIDE. FROM INSIDE, SLIDE THE PLASTIC WASHER OVER THREADS OF QUARTER TURN FASTENER SCREW UNTIL WASHER RESTS ON SHAFT.



- 3) CONNECT A SMALL FAN GUARD, (PRF120) **AS07** TO THE DOOR USING (4) 10-32 X 3/8 TH ON THE OUTSIDE AND (4) #10 KEPS HEX NUT ON THE INSIDE.



- 4) ARBOR PRESS (4) 3/16 X 3/4 DOWEL PINS (.187J0P12) ONE EACH INTO (4) ROTATING HINGE BLOCKS (C25 106.4) **RACK 11**. THERE ARE TWO ON EACH DOOR. CONNECT (1) ROTATING HINGE BLOCK ASSEMBLY TO THE LOWER LIP OF THE DOOR WITH THE DOWEL FACING INWARD. USE (2) 6-32 X 3/8 SHCS. THE SECOND BLOCK IS ATTACHED WHEN THE DOOR IS CONNECTED TO THE HOUSING.



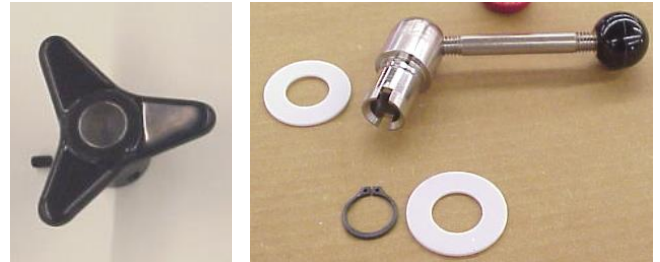
- 5) THE LEFT SIDE HOUSING DOOR (I30 095.5.4L) **AS18** ALSO HAS (3) QUARTER TURN LATCHES. ASSEMBLE THESE LATCHES THE SAME AS ON THE RIGHT SIDE HOUSING DOOR DESCRIBED ABOVE.

- 6) CONNECT A SMALL FAN GUARD, (PRF120) TO THE LEFT SIDE HOUSING DOOR. USE (4) 10-32 X 3/8 TH ON THE OUTSIDE AND SECURE WITH (4) #10

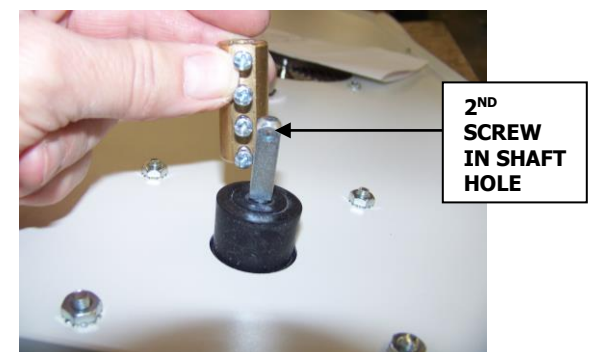
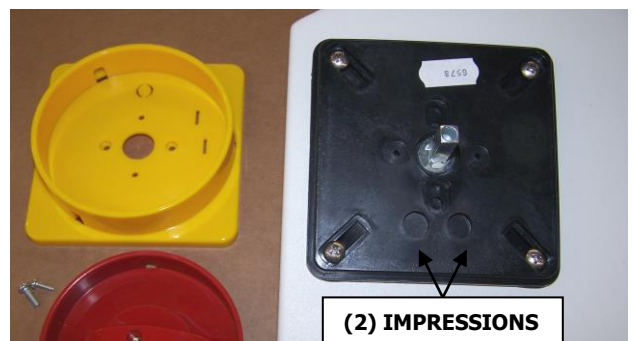
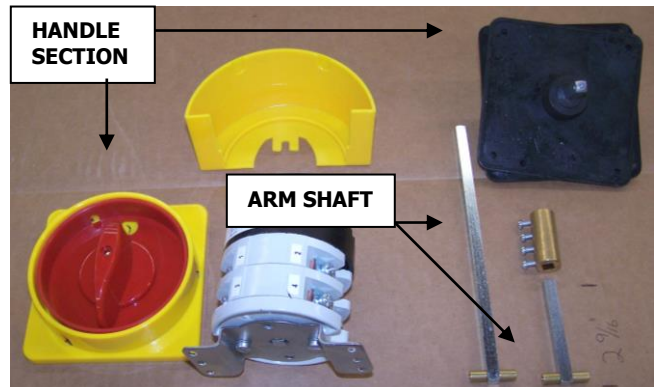


**KEPS HEX NUTS ON THE INSIDE.**

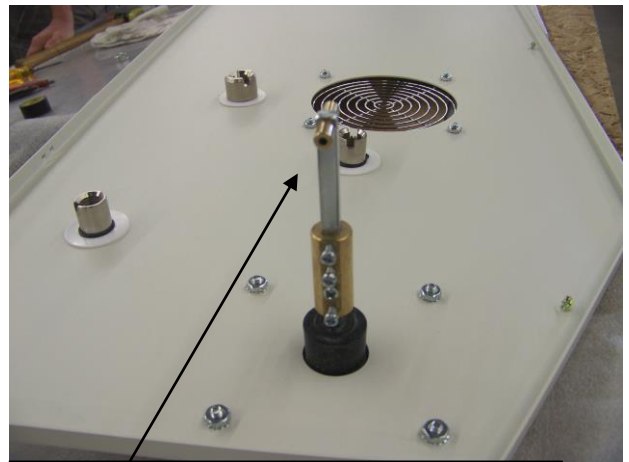
- 7) **PLACE A TEFLON FRICTION WASHER (EP25 004.4) RACK 9 ON A CAMSHAFT HANDLE LOCATOR (D105 131.4) RACK 2. FROM INSIDE THE DOOR SLIDE THE CAMSHAFT LOCATOR THROUGH THE APERTURE UNDER THE FAN GUARD FOR CHILL ROLL POSITION SELECTION. ON THE OUTSIDE OF THE DOOR ADD ANOTHER TEFLON FRICTION WASHER OVER THE CAMSHAFT. THEN SECURE THE WASHER WITH A 3/4" RETAINING RING (PRR192) AS08.**
- 8) **ON THE OUTSIDE OF THE DOOR SECURE A BLACK CAMSHAFT HANDLE (PRH140) AS07 TO THE CAMSHAFT LOCATOR. USE A 1/4-20 X 3/8 SS FITTED INTO SHAFT THREADS.**
- 9) **REPEAT THIS ASSEMBLY PROCEDURE USING TEFLON WASHERS AND 3/4" RETAINING RINGS FOR THE (3) SMALLER CAMSHAFT DRIVERS (I30 131.4) RACK 16.**
- 10) **PLACE LOCTITE ON THE THREADS OF (3) KNOB EXTENSIONS (I30 132.4) RACK 16. SECURE TO CAMSHAFT DRIVERS.**
- 11) **THREAD (3) 1" DIA. BLACK REID TOOL KNOBS (PRK140) RACK 16 ON KNOB EXTENSIONS.**
- 12) **SECURE THE DARK COVER HANDLE SECTION OF THE MAIN POWER SWITCH (PRS376) AS08 TO OUTER DOOR. ALIGN THE (2) ROUND IMPRESSIONS BELOW ARM EXTENSION TO FACE FRONT AND REAR OF I30. SECURE HANDLE SECTION WITH (4) 10-32 X 1/2 PHMS ON OUTSIDE AND (4) #10 KEPS HEX NUTS ON INSIDE.**
- 13) **MEASURE THE ARM/SHAFT OF THE MAIN POWER SWITCH TO 2 9/16" FROM THE PIN END OF SHAFT AND REMOVE EXTRA END OF SHAFT WITH HACK SAW. BUFF END.**
- 14) **ON THE INNER LEFT DOOR, WITH THE DARK DOOR HANDLE SHAFT HOLE FACING FRONT AND REAR, SLIDE THE BRASS CYLINDER ONTO THE SHAFT AND TIGHTEN THE SECOND SCREW THROUGH THE SHAFT HOLE. TIGHTEN THE FIRST SCREW ON THE INNER SHAFT.**



**CAMSHAFT DRIVER, KNOBS, EXTENSION, WASHERS,**



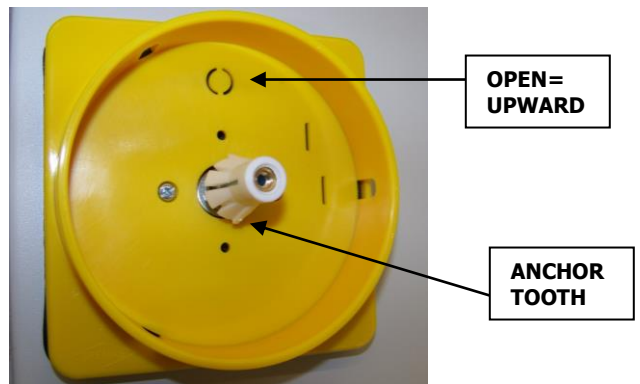
15) INSERT THE SHAFT END OF THE SHORTENED ARM SHAFT, WITH THE PIN HORIZONTAL, FACING FRONT AND BACK, INTO THE BRASS CYLINDRICAL SHAFT END. SLIDE SHAFT IN PAST THE OUTER (2) SCREWS AND TIGHTEN THE LAST TWO SCREWS ON THE SHORTENED SHAFT SHAFT.



2 9/16" ARM SHAFT PIN FACES FRONT & REAR

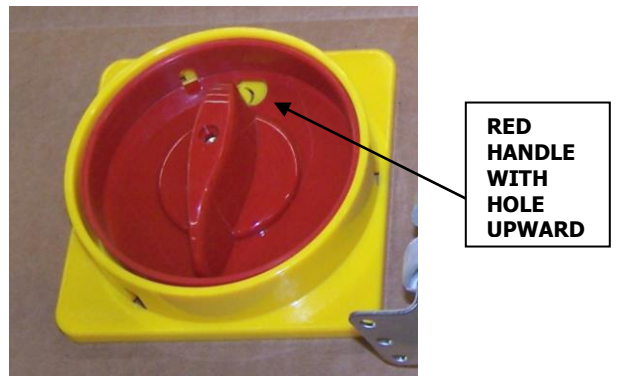
16) ON THE OUTER DOOR SECURE THE YELLOW COVER SECTION TO THE DARK PORTION WITH (2) SCREWS PROVIDED. ORIENT THE YELLOW SECTION WITH THE CIRCLE UPWARD.

17) PLACE THE WHITE SLOTTED CATCH OR 'ANCHOR' WITH (2) TEETH FACING UP AND DOWN. THE BRASS THREADS ARE OUTWARD.



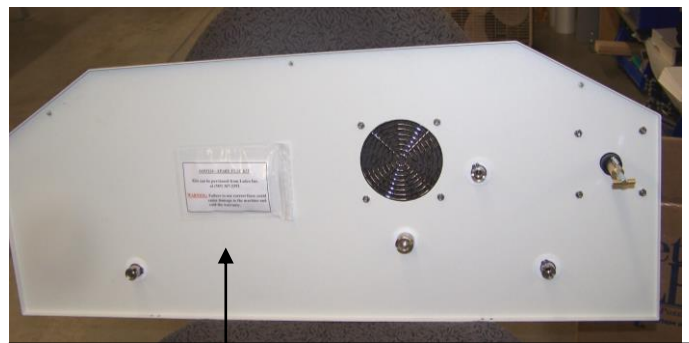
18) INSERT THE CENTER PORTION OF THE RED COVER OVER THE OUTER ARM SHAFT WHICH HAS THE WHITE ANCHOR ON IT. ORIENT THE HANDLE WITH THE OPEN AREA OF RED CIRCLE UPWARD. USE THE SCREW PROVIDED TO TIGHTEN RED SECTION INTO THE CENTER ANCHOR THREADS.

19) ON THE INNER LEFT DOOR SECURE A SPARE FUSE KIT (SPFI30) AS09, LOCATED BEHIND AND IN LINE WITH THE FAN GUARD. USE SPRAY ADHESIVE TO SECURE THE SPARE FUSE PACKET TO THE DOOR, AS THE FUSE POUCH DOES NOT STICK TO THE DOOR PAINT WELL. ALLOW THE ADHESIVE TIME TO DRY, ONCE IT IS ON THE DOOR.



20) TO INSTALL THE DOORS, SLIDE THE DOOR ROTATING HINGE BLOCK DOWEL PIN INTO THE LOWER HOUSING STATIONARY BLOCK. ALIGN THE SECOND ROTATING HINGE BLOCK AND SLIDE THAT DOWEL INTO THE REMAINING STATIONARY HINGE BLOCK. USE (2) 6-32 X 3/8 SHCS TO SECURE THE DOOR TO HOUSING.

21) AFTER THE I30 HAS BEEN TESTED. THE DOORS ARE LIFTED AND SECURED WITH THE THREE HINGE QUARTER TURN LATCHES. USE A PHILLIPS HEAD



SPARE FUSE KIT: (1) 3 AMP SLO BLO, (1) 8 AMP (2) 20 AMP

**SCREWDRIVER. YOU MAY NEED TO ANGLE THE SCREWDRIVER TO REACH THE HOUSING LATCH. THE I30 IS TESTED WITH THE DOORS OPEN.**

