

Assembly instruction Lift System Mondo II

1) Before start to build the cabin the following preparatory work is to do:

I. Pre-Assembly base

Required items: U-profile (20731); Strip (20729); 2 x hexagon head screw M6 x 60 mm (20736); 2 x nut M6 (20735); 4 x washer 6.4 x 12 x 1.6 mm (20737), 2 x expanding rivets (19969)



a) Finding of the Centre at the rear of the base traverse.

For help to find the central positioning of the U-profile (20731), the U-bracket is fitted in the middle with a notch.



b) The base has to be drilled in the two holes of the bottom of the U-profile with a 5 mm \varnothing drill.





- c) The double-walled base must be drilled with a bit 7.5 or 8 mm in the two holes of the brackets of the U-profile. Please pay attention on horizontal drilling because of the two holes on the back site.
- d) Now the U-profile and the sheet metal strips (20729) will be screwed together. Therefore 2 x hexagon head screws M6 x 60 mm (20736); 2 x nut M6 (20735) and are 4 x washers 6.4 x 12 x 1.6 mm (20737) are needed.
- e) The U-profile will be fixed with the two expanding rivets 4.8 x 18 mm (19969).



II. Preassembly door front

Required items: T-fitting (20730); 2 x cylinder head screw M8 x 35 mm (19771); 2 x lock nut M8 (19925); 2 x large washer (20058); 2 x small washer (20059)



- a) Above on the frame of the front doors will be drilled two holes. The coat hook is located on the bottom hole.



- b) Into these holes will be inserted two cylinder head screws M8 x 35 mm (19771) and the two large washers (20058).



Required items: T-fitting (20730); 2 x cylinder head screw M8 x 35 mm (19771); 2 x lock nut M8 (19925); 2 x large washer (20058); 2 x small washer (20059)

- c) The small washers (20059); the T-fitting (20730) and the lock nuts M8 (19925) must be screwed on the inside of the door front. The drill of the T-fitting must show down with the largest distance from the horizontal bar.



- d) The coat hook will be riveted to on the upper edge of the door.

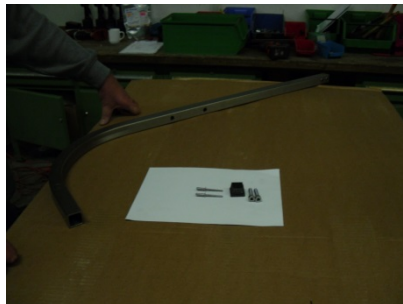


- 2) Assemble the cabin completely

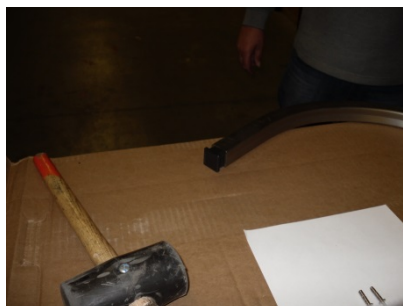
- 3) Assembly Lift Kit

- I. Assembly square tube

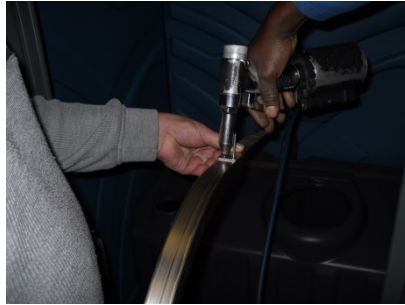
Required items: square tube (20733); Square head plug (20748); 2 x blind rivet (20738); 2 x cylinder head screw M8 x 35 mm (19771)



- a) The square head plug (20748) must be pressed into the short vent of the square tube (20733).



- b) The short end of the bent square tube (20733) has to be connected with the metal strip by 2 blind rivets (20738).



- c) Pass the free end of the square tube over the horizontal bar of the T-fitting and fix both parts with two cylinder screws M8 x 35 mm (19771). The strip must flush at the rear panel.



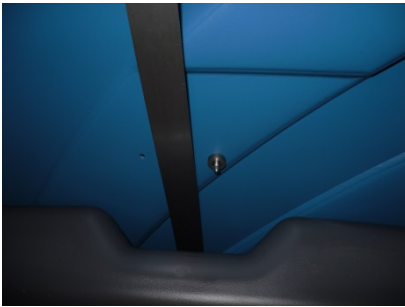
II. Assembly on rear panel

Required items: 3 x metal bracket (20732); 6 x blind rivet 4.8 x 17 mm (19968); 2 x spacer (20749)



- a) For fixation of the visible part of metal strip on the rear panel will be three metal brackets 80 x 20 x 1,5 mm (20732) installed. The top bracket must be fixed approximate 80 mm below the end of the pipe. The other two should follow at a distance of approximately 545 mm. 5 mm holes must be drilled in the rear panel before riveting with the six blind rivets 4.8 x 17 mm (19968).

For riveting the rivet gun will be used outside the cabin. Additional the bottom flap will be riveted with two spacers (20749).



II. Assembly round steel bar

Required items: 1 x round steel bar; 2 x bellows (19856); 2 x nut M12 (19923); 2 x lock nut M 12 (19924)

- a) Before installing the round steel bar (19870) must be two two bellows (19856) slided across over the threaded part and then a nut M12 (19923) is to be screw up to the end of the thread.



- b) Then two circular holes will be drilled with a diameter of 50 mm in the roof for the round steel bar. Therefore the center of the circle must be marked with a small bit inside the cabin and outside the cabin a circle cutter will be used. For this procedure the cabin must be tipped.





- c) The ends of the hook must be passed through the established roof vents and the drills in the square tube and must be fixed with a safety nut M12 (19924).





- 4) At the end of the assembly the cabins must be checked by using the appropriate checklist and when the quality check is passed a GS-label on the cabin. Two of 100 cabins must be checked for quality.