

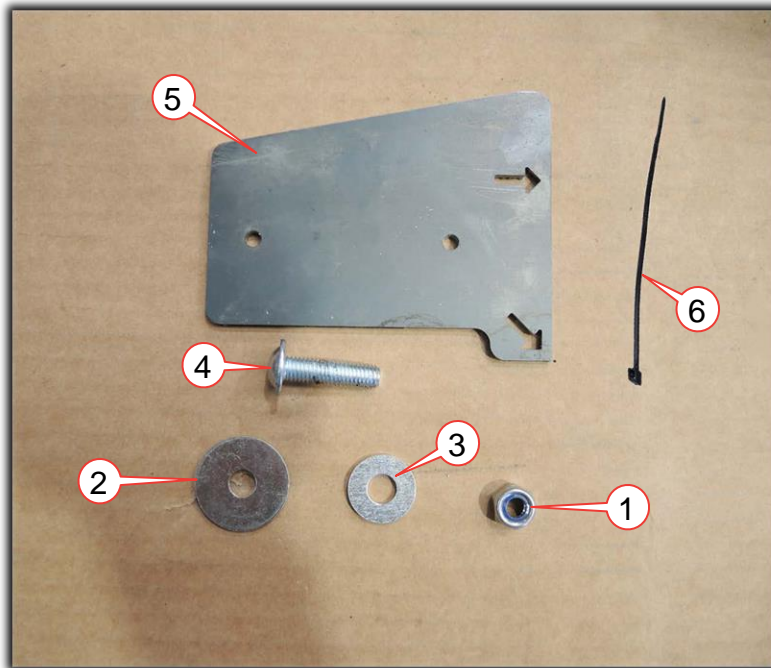
REAR ENGINE COVER REPAIR

This document is intended to assist the service technician in an event the epoxy failed between the rear hood and mounting hinge bracket. These instructions will outline the steps to insure the correct primer, adhesive process and a template for drilling holes to add additional support bolts to the assembly.

MQ Part # RX1575RCOVERKIT - Hardware Kit w/Template (includes items 1-6)

Item	Description	Qty.
1	Nyloc nut M8	4
2	Flat washer	4
3	Flat washer M8	4
4	Bolt M8X30	4
5	Drilling Template	1
6	Cable Ties	6
◇	3M™ Panel Bonding Adhesive – 200 ml P/N 08115	1

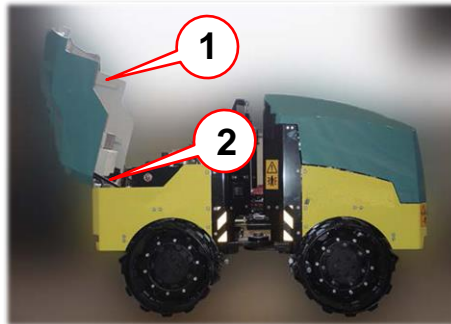
◇ Not Supplied



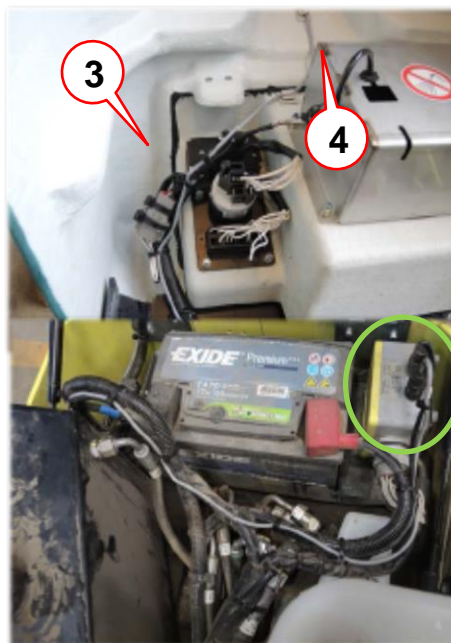
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SAFETY FIRST! Installation should be performed by qualified technicians. Do not operate or service the equipment before reading the operations manual. Safety precautions should be followed at all times!

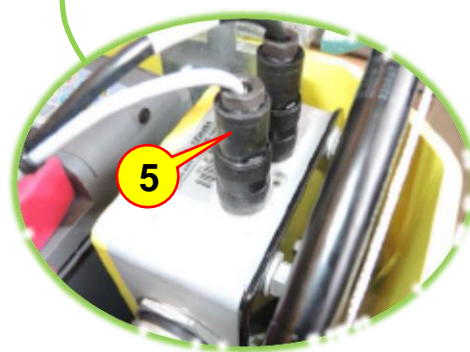


- 1) Lift rear hood open for accessing components
- 2) Disconnect battery cables

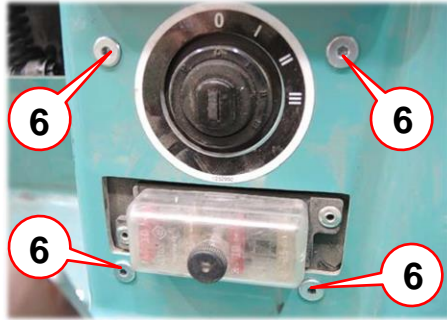


- 3) Disconnect harness connector
- 4) Disconnect umbilical cord harness connector

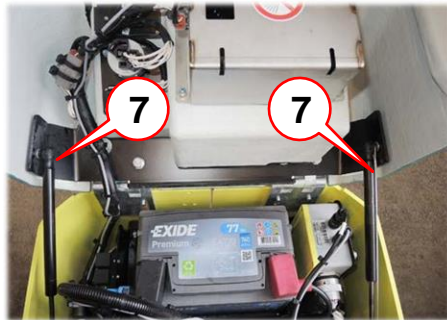
- 5) Remove cable ties and unplug particularly called out connector from receiver



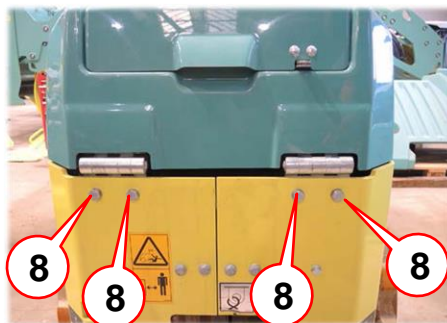
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- 6) Dismount the switch and fuse box by removing the screws (006-010-33) from the engine cover

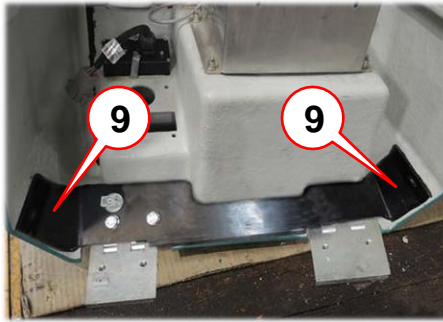


- 7) Remove the gas strut and safety cable, lower/close the engine cover after completed. (003-040-106)

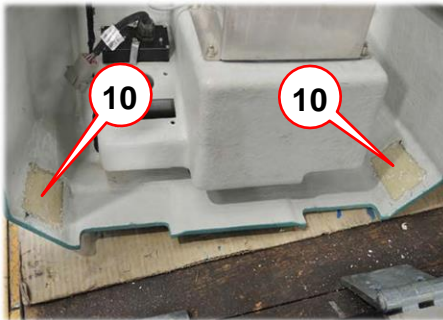


- 8) Remove screws (003-040-122) from hinges then remove the engine cover and put it to the side

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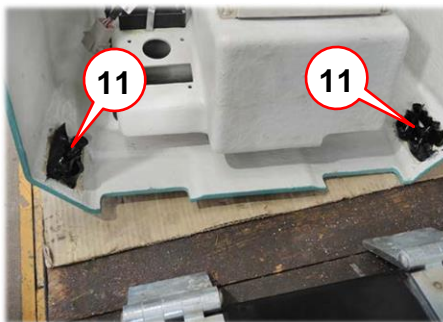


9) Lay the engine cover upside down on a piece of cardboard and carefully detach the holder with hinges from the cover.



10) Scuff, clean and degrease all glue residue and dirt from glued surfaces, allow time to dry.

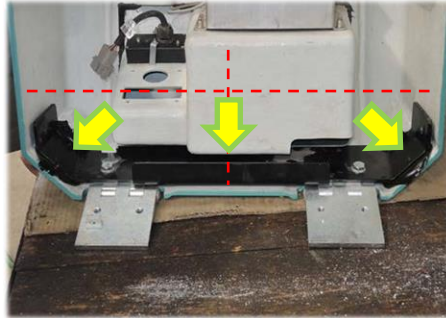
Note: Any damage to the coating on the holder ends must be treated with a new anti-corrosion coating of paint



11) Apply 3M™ Panel Bonding Adhesive 200 ml per the manufacturer's recommendations.

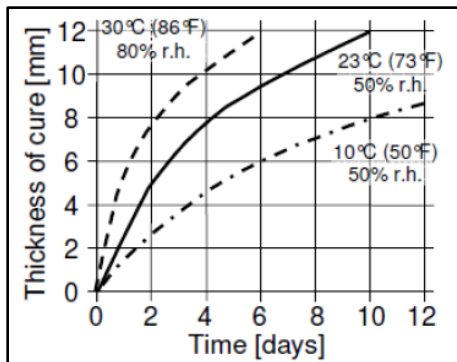


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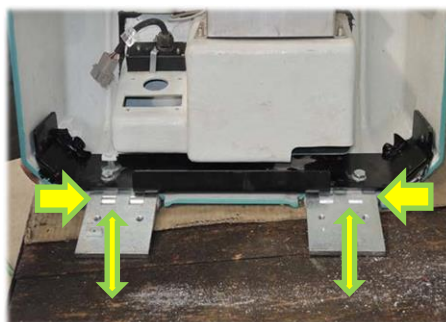
12) Center the holder and align it flush with the edge/end of the engine cover and set it down on the glue

Note: Carefully clamp holder at glued surface ends just to where the glue is not squeezing out



13) Allow the glue to cure for the duration specified in the chart according to the 3M™ manufacturer's technical data. The values shown below are for ambient air temperature and substrate

- Temperature at 73°F (23°C)
- Work Time: 90 minutes
- Clamp Time: 4 hours
- Cure Time: 24 hours

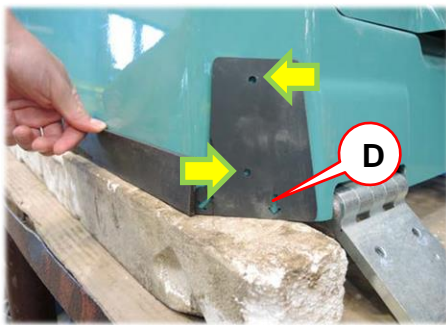


14) Before mounting the engine cover back onto the machine/frame, ensure the hinges are well lubricated and moving freely

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- 15) Align the gas strut's screws (003-040-24) with the holder to prevent contact with the engine cover



- 16) Use the drilling template (item 5) to mark drilling points on the engine cover. Location arrows (D) should point to the corners of the engine cover when placed in the correct position



- 17) Pre-drill holes using a 3/16" drill bit



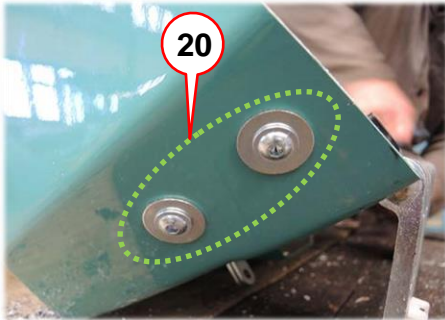
- 18) Remove template and drill/enlarge 3/16" holes by using a 23/64" drill bit

Note: Use clamps to secure the holder to the engine cover

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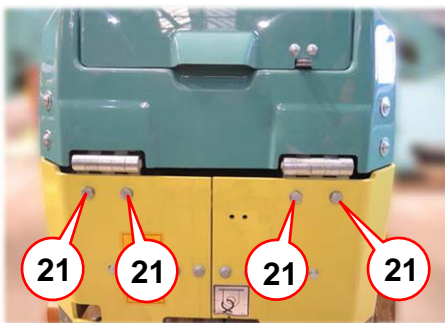
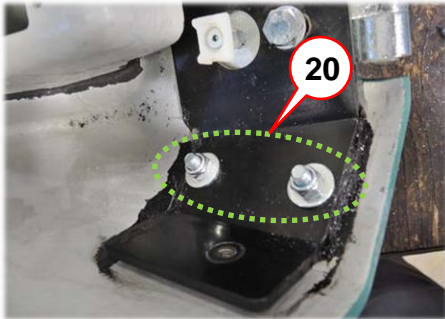
19) Deburr the drilled holes



20) Mount the following:

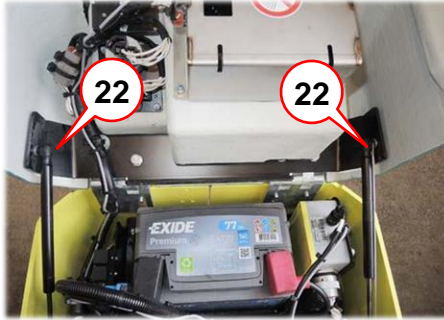
- Items 4: Bolts M8X30
- Items 2 & 3: Flat washers
- Items 1: Nyloc nut M8

Note: Torque screws to 26.55 inch lbs.
(3 Nm)

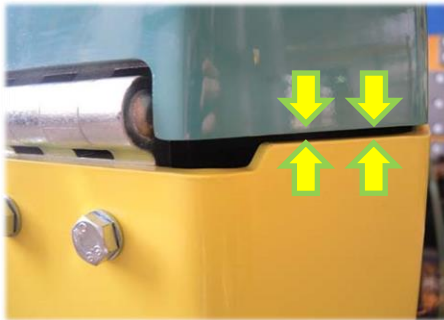


21) Mount the engine cover (003-040-1) onto the machine and secure with screws (003-040-122)

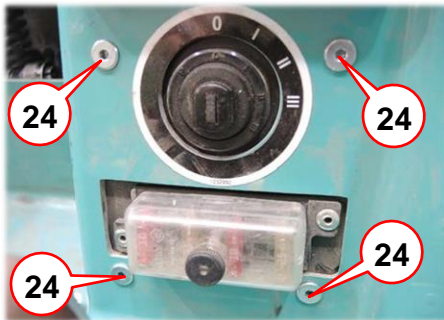
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22) Mount the gas struts (003-040-106)

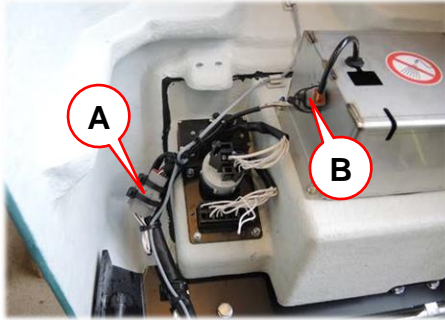


23) **Note:** Make sure there is a clearance between the engine cover and the machine frame

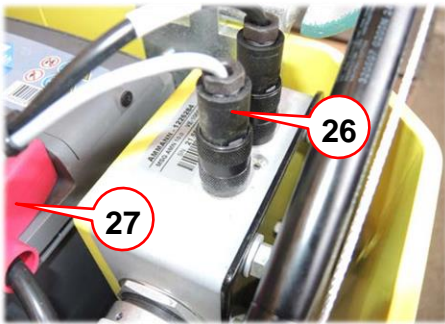


24) Mount the switch and fuse box to the engine cover and secure with the four screws (006-010-33)

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25) Reconnect the harness connectors at points A & B and secure harness and connectors with supplied cable ties



26) Reconnect receiver eye connector to receiver/control box and secure harness with supplied cable ties

27) Reconnect battery cables



Before putting the machine into operation again, test all functions of the machine according to the operation's manual