



***Assembly instruction of
cab for
Doosan D/G15/18S,E-5,
D/G20SC-5***

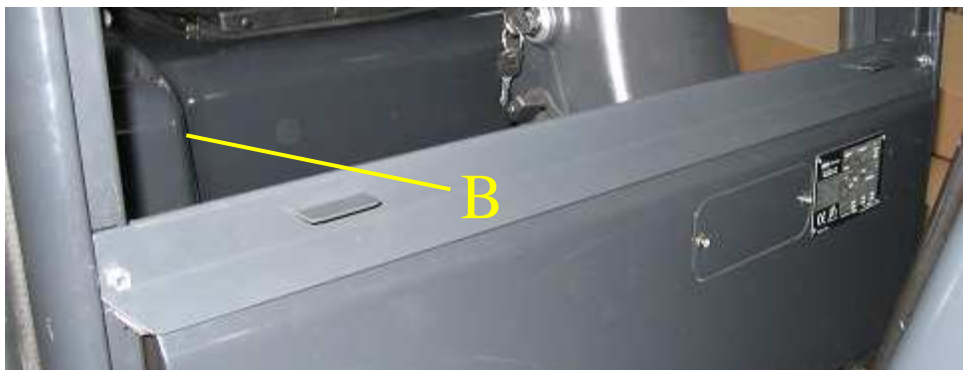


I. FRONT PANEL

1. Assembly front upper beam (A) to front upper flat bar using self-drilling screws. This beam should be put (located) in such position so lower ends adhere to cavity of OHG and channel bar that is welded to this beam adheres to flat bar of OHG.



2. Put (locate) front lower beam (B) to cockpit of forklift in such position so ends of this beam adhere to cavity of OHG and lower bended part of this beam adheres to this cockpit evenly. Assembly this beam using self-drilling screws 6,3x25.



3. Put front glass/pane to OHG pushing it on seal slightly. Mark places for holes of assembly holders on OHG (C). Drill holes Ø 11 there and set blind rivet nuts M8 there. Assembly glass using M8x25 screws.





II. REAR PANEL

1. Screw rear lamps out. Put (locate) rear upper beam (A) to rear upper profile of OHG in such way so holes for electric wires and screws in beam suit to holes in OHG. Screw rear lamps back and connect them back.



2. Screw holder (B) out, then turn it for 180° and assembly this holder right back.



3. Put (locate) rear lower bar (C) with rear lower beam (D) to inner part of rear profiles of forklift in such way so seal on rear lower beam (D) adheres to cover of forklift (E) steadily. Assembly rear lower beam to OHG using self-drilling Ø6,3x19 screws.



4. Assembly rear frame (F) with rear middle bar (G) to assembled lower bar before using hand-wheels.
Assembly rear middle bar to OHG using self-drilling Ø6,3x19 screws





4. Put (locate) glass to items assembled before: upper beam, middle bar and OHG pushing it on seal slightly. Mark places for assembly holes on OHG looking at holders of glass (H). In marked places drill Ø 11 holes and set blind rivet nuts M8 there. Assembly glass using M8x25 screws.

5. When service by engine or/and its accessories must be done, rear frame should be dismantled (F) using four hand-wheels before cover of engine is opened.



III. DOORS

1. Put and set (locate) door with hinges so distance between inner part of cavity of OHG and edge of door (seal) is the same in all places at front and upper part of OHG.
2. Mark places for holes to set blind rivet nuts M8 on OHG.
3. Drill holes $\varnothing 11$ and set blind rivet nuts in these places. Assembly hinges to OHG using M8x30 screws with oval head preliminary (A).
4. Put and set (locate) door once more as point 1 and if distance between inner part of cavity of OHG and edge of door (seal) is the same in all places assembly screw of hinges finally.

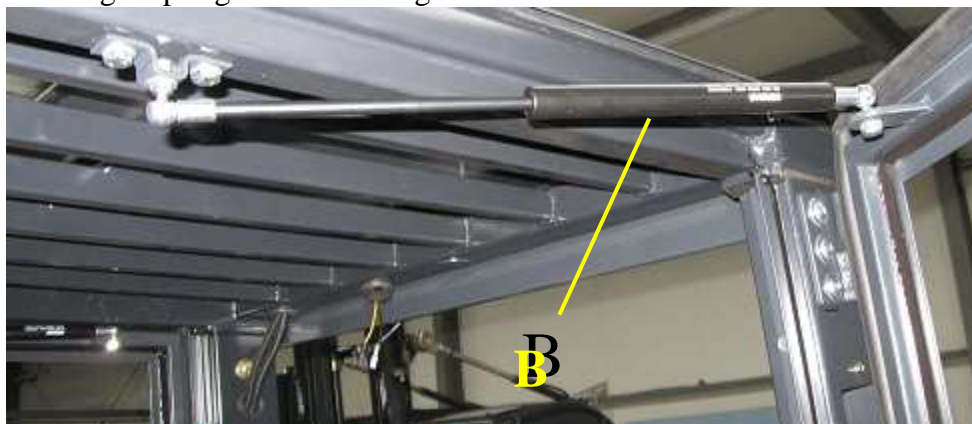


5. Assembly gas spring with holders (B) to ball pin by OHG of door.
6. Put (locate) gas springs in so called „dead” position (gas spring is stretched fully), then close door leaving 10 cm distance between door and OHG. In such way mark place for holder of gas spring. When this position is marked then 7,5 cm towards hinges should be taken to mark holes for blind rivet nuts M8. (7,5 cm is length of closed gas spring)



7. Drill holes Ø11,2 in marked places and set blind rivet nuts there.

8. Assembly holders of gas springs to OHG using M8x20 screws



9. Push door to OHG, try latch of lock on (C), mark assembly holes on OHG. Drill holes Ø11,2 in marked places and set blind rivet M8 nuts there. Assembly latch using M8x30 screws with oval head.

10. Mark place of mounting slide guide (D). Drill Ø9 holes in marked spots and set blind rivet nuts M6 there. Assembly slide guide to OHG using M6x20 screws



11. Put (locate) floor (E) to OHG then mark places for assembly holes. Drill holes Ø4,8 in marked places and thread these drilled holes using screw cutter M6. Assembly floor to OHG using M6x15 screws.

12.



12. If there is any gap between floor of door and floor of forklift when door is closed, floor of door must be regulated (G).



13. Assembly angle bar (H) (in one facet with cavity of door OHG) to inner rear part of OHG using self-drilling Ø6,3x25 screws.



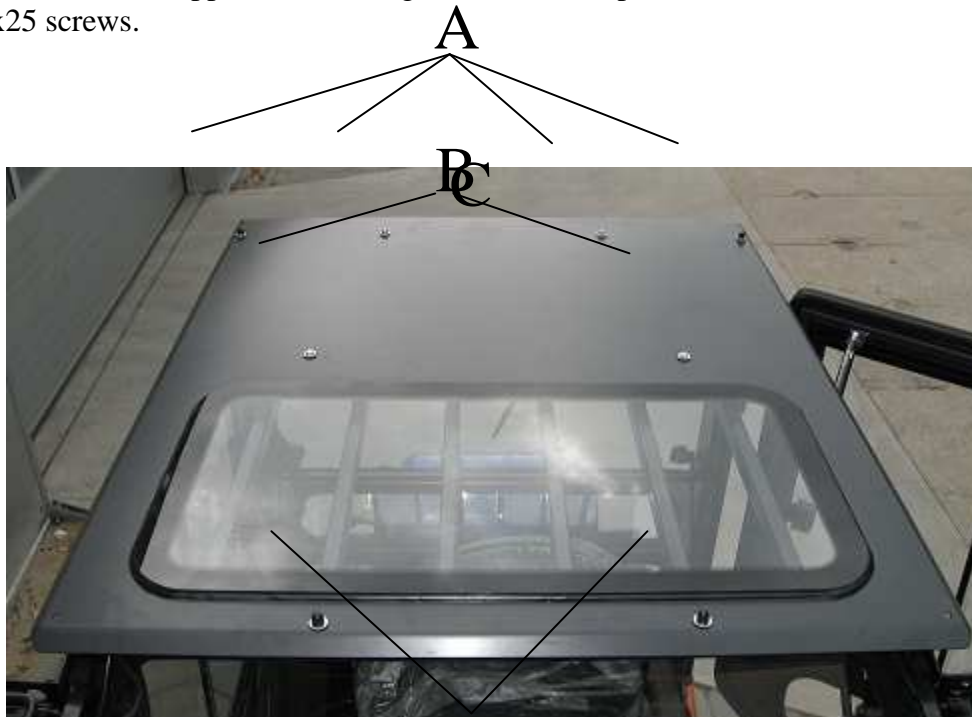


IV. ROOF

1. Stick seal UD54 around upper edge of OHG. Put roof on OHG in such way so all distances: left, right, front, rear directions are the same.

Assembly roof in such way:

- fasten self-drilling 6,3x25 screws through holes at rear part (A) of roof
- fasten M6x20 screws through holes at middle part (B) of roof, but before it drill (using drill 4,8) and thread holes (using screw cutter M6) in flat bar of OHG.
- drill lower holes Ø7 in front upper beam through holes at front part (C) of roof and assembly these two units using M6x25 screws.





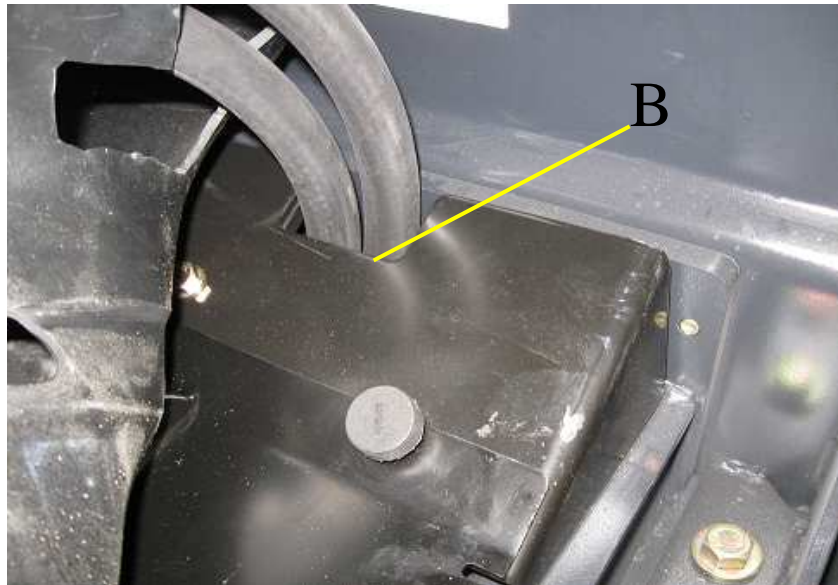
V. HEATER

1. Put heater with assembled holder (A) to cockpit in such way so lower glass of door does not touch holder of this heater. Then mark places for assembly holes on OHG.



2. In marked places drill holes $\varnothing 11$ and then set blind rivet nuts M8 there. Assembly heater using M8x25 screws

3. Draw hoses toward chamber of engine using original hole (B) that is in right part of floor of forklift.



4. Screw temperature sensor out (C).



5. Screw original screws out (D) and (E).



6. Assembly temperature sensor in place of original screw (D). Assembly hose that takes heating staff out of heater using reduction in place of original screw (F).



7. Assembly hose that supplies heating staff to heater using reduction in place of unscrewed temperature sensor (G).



K.B.O



G

