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Assembly instruction Doosan cabin D/G20/25/30/33E/P-5 D/G35C-5

1. Front panel

1.1 Using self-drilling screws attach front upper beam (A) to OHG. Adjust it in such a way that its bottom ends align inner parts of front pillars and its top part aligns top parts of OHG.



A

1.2. Put front lower beam (B) against dashboard in such a way that its ends align inner part of front pillars and its inner part aligns dashboard simultaneously. Attach it using self-drilling



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screws.



B

1.3. Put front screen on OHG pushing gently on seal. Mark assembly holes (C). Drill \varnothing 11 holes and put M8 rivetnuts. Attach the screen using M8x25 screws.



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C



2. Rear panel

2.1. Take off rear lamps. Put top rear beam (A) on top part of rear pillars in such a way that holes for electric harness and assembly screws align original holes in OHG. Attach lamps back and plug them in.



A



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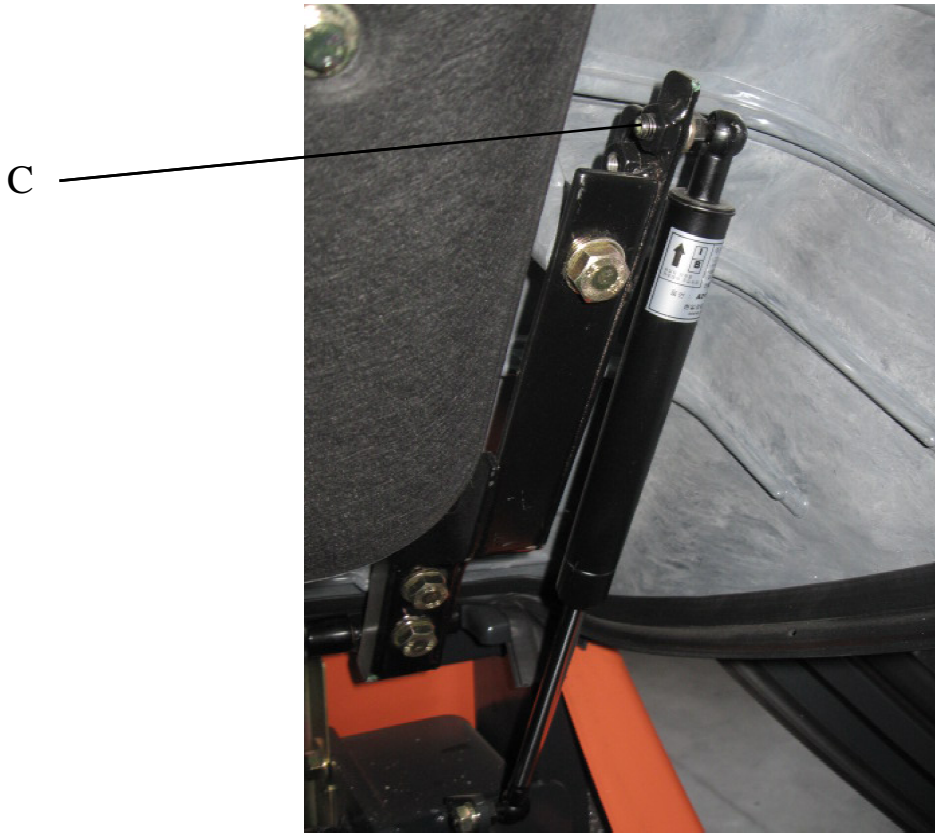
2.2. Put rear lower beam (B) to OHG in such a way that its bottom edge with seal aligns truck cooler cover. The distance between upper and lower beam should be approx. 845 mm. Attached the beam using 6,3x25 self-drilling screws.



2.3. Move bonnet gas spring pin 1 hole backwards (C) to reduce bonnet opening degree.



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2.4. Put front screen on OHG pushing gently on seal. Mark assembly holes (D). Drill \varnothing 11 holes and put M8 rivetnuts. Attach the screen using M8x25 screws.



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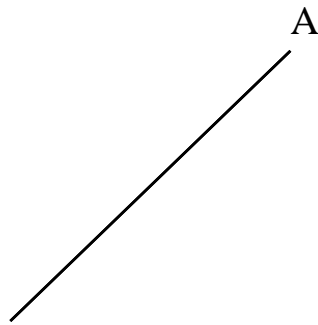


D



3. Door

- 3.1. Put the door against OHG in such a way that distance between OHG profile inner and door edge stays the same all way round.
- 3.2. Mark assembly holes for hinges
- 3.3. Drill $\varnothing 11$ holes and put M8 rivetnuts.
- 3.4. Attach hinges using M8x30 screws (A)





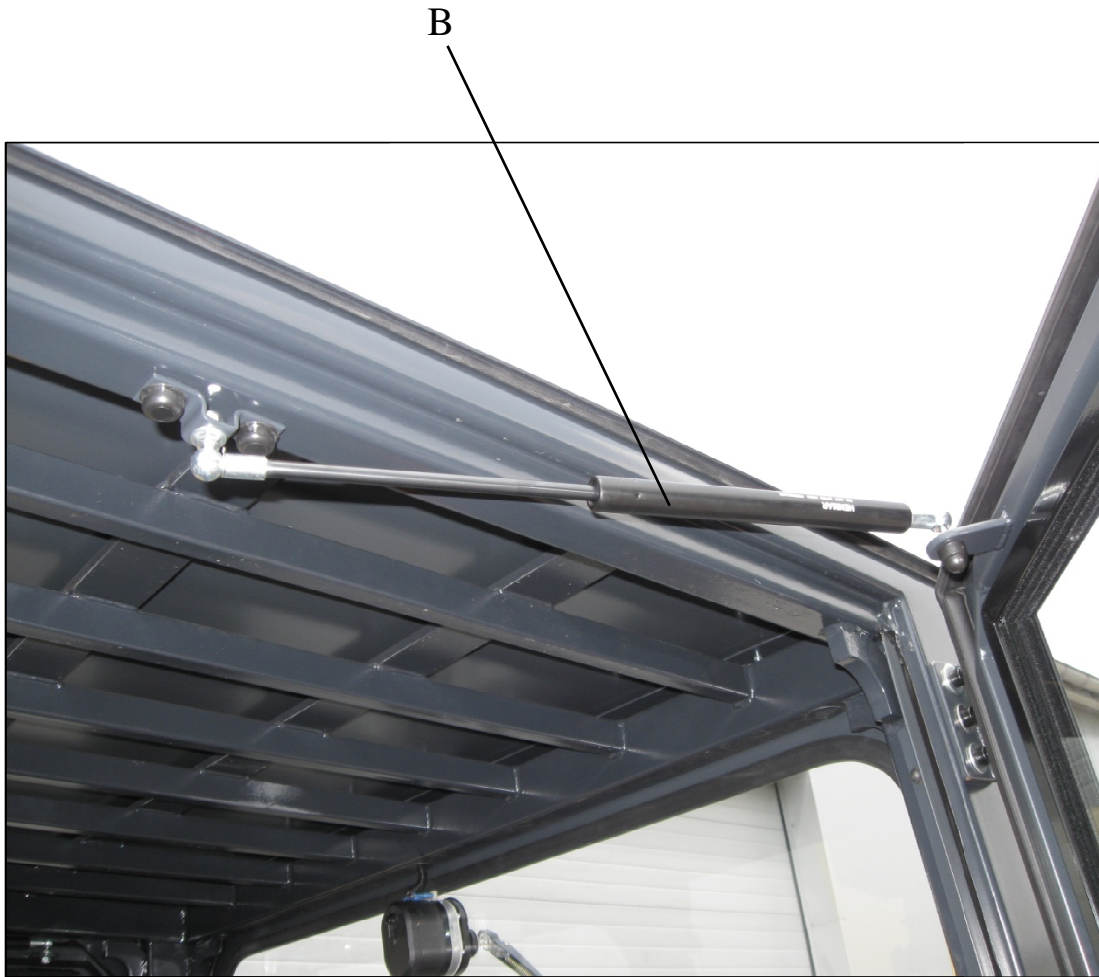
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- 3.5. Attach gas spring to the door holder (B). On the other end of the spring put OHG holder.
- 3.6. Mark deadlock position of gas spring on OHG in such a way that when moving slightly the door, spring doesn't change the position on OHG. From this marked position move backwards by 7 cm.
- 3.7. Mark assembly holes on OHG.
- 3.8. Drill $\varnothing 11$ holes and put M8 rivetnuts.



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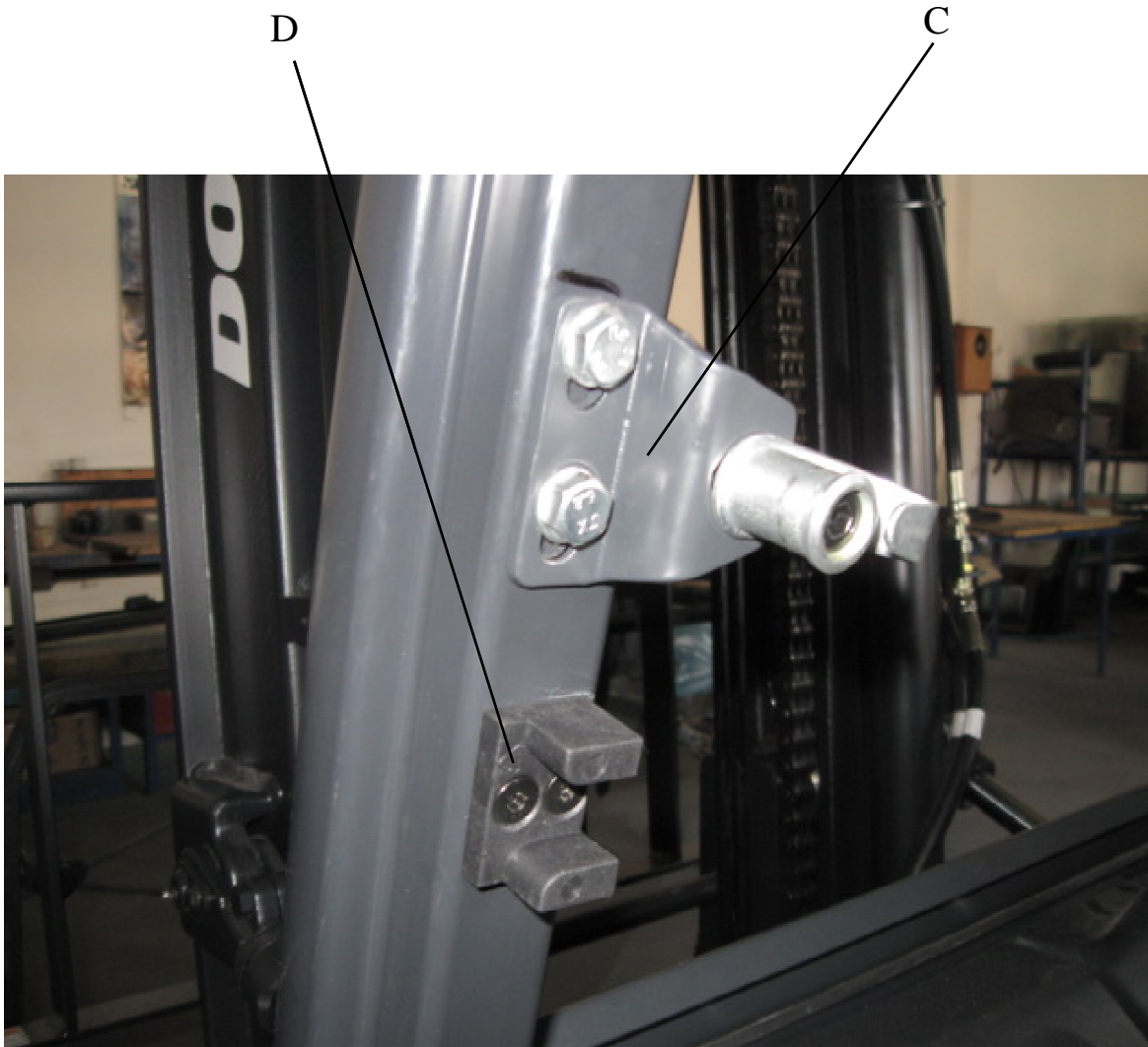


3.9. Push door towards OHG, try lock striker on (C) and mark assembly holes. Drill $\text{\O}11,2$ holes and put M8 rivetnuts. Attach the striker using M8x30 screws.

3.10. Try on slide runner (D) and mark assembly holes. Drill $\text{\O}9$ holes and put M6 rivetnuts. Attach slide runner using M6x20 screws.



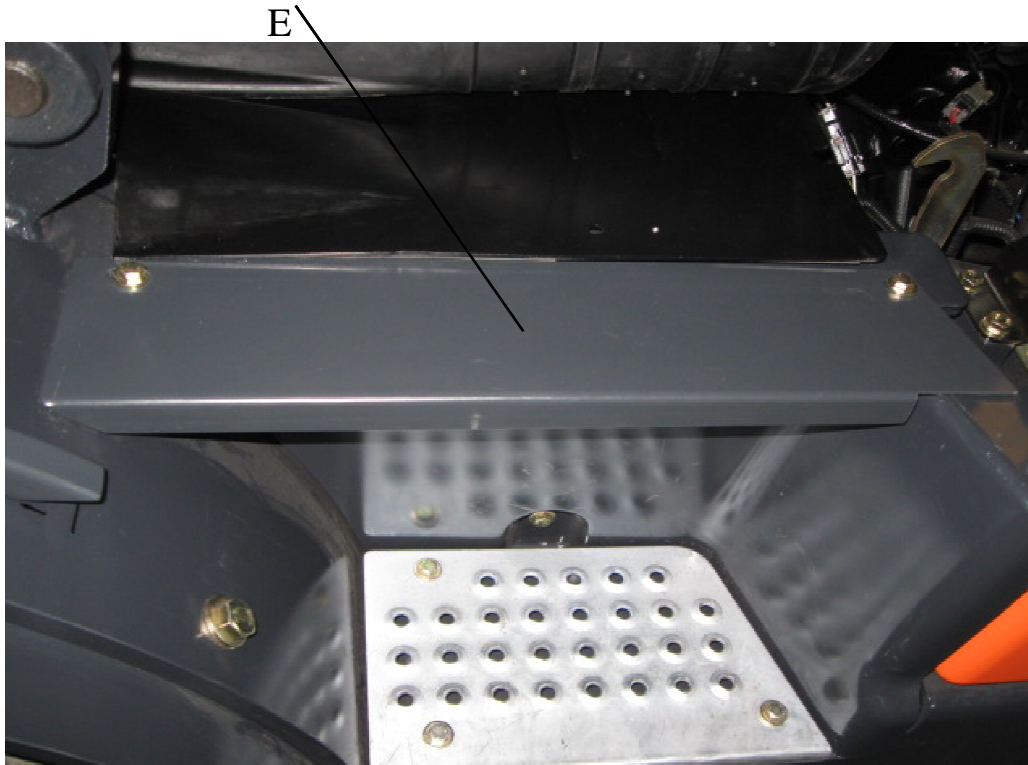
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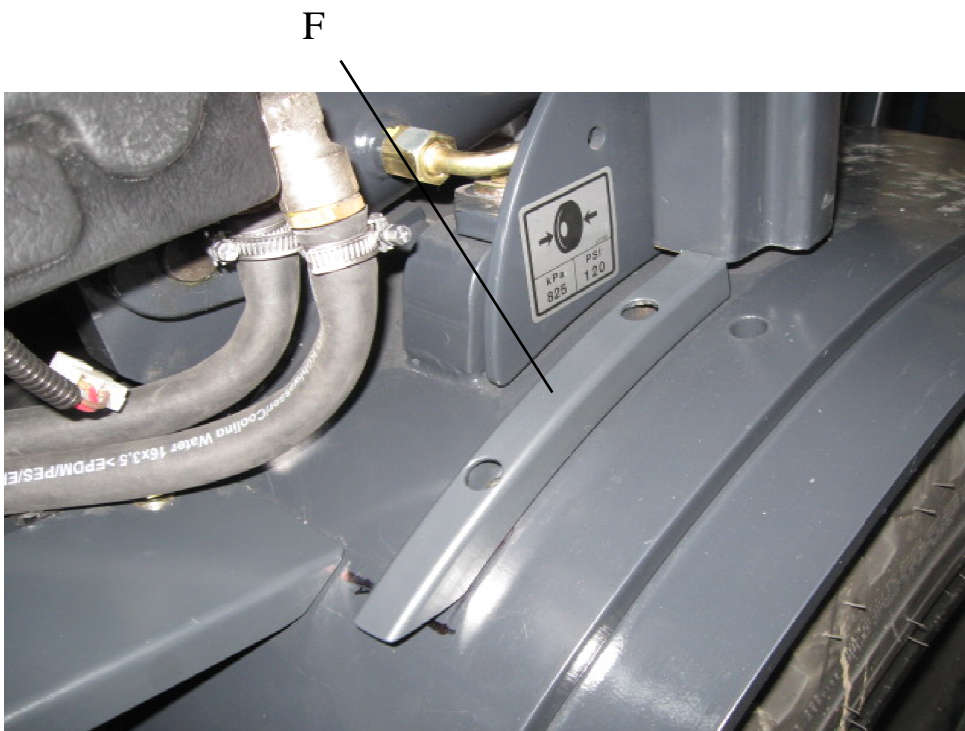


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3.11. Attach floor plate (E) using original holes and screws.



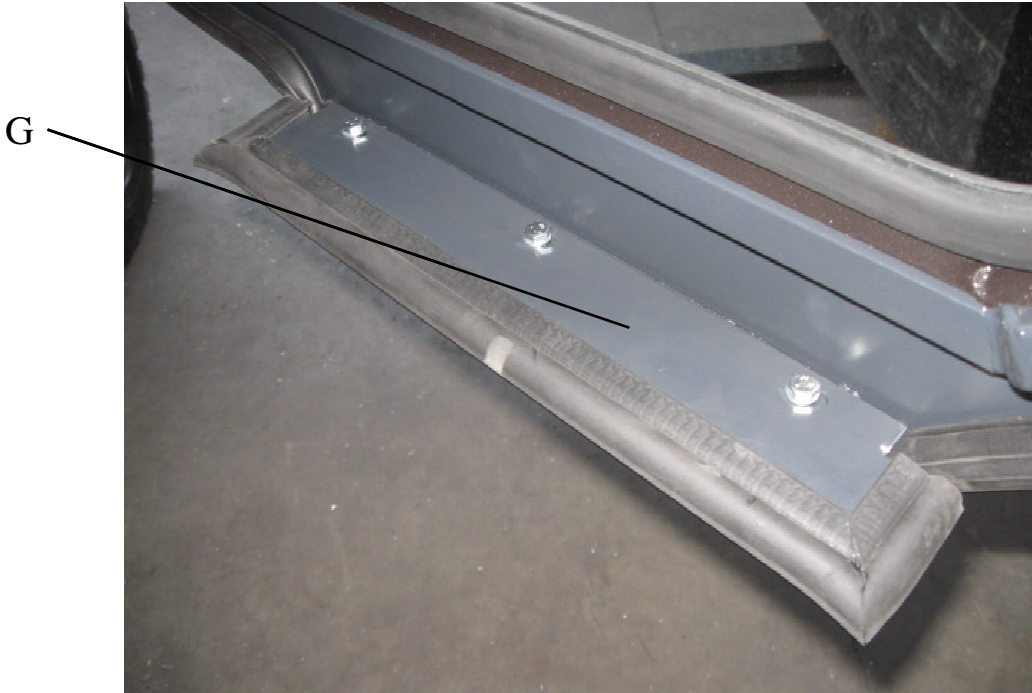
3.12. Attach metal bar to wheel arch (F). Move it forward as much as possible. Mark assembly holes. Drill holes, thread them and attach the bar using M6x20 screws.





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3.13. Adjust floor panels if needed (G) . Attach them using M6x16.



3.14. Attach metal bars to inner part of rear pillars using 6,3x19 self-drilling screws.



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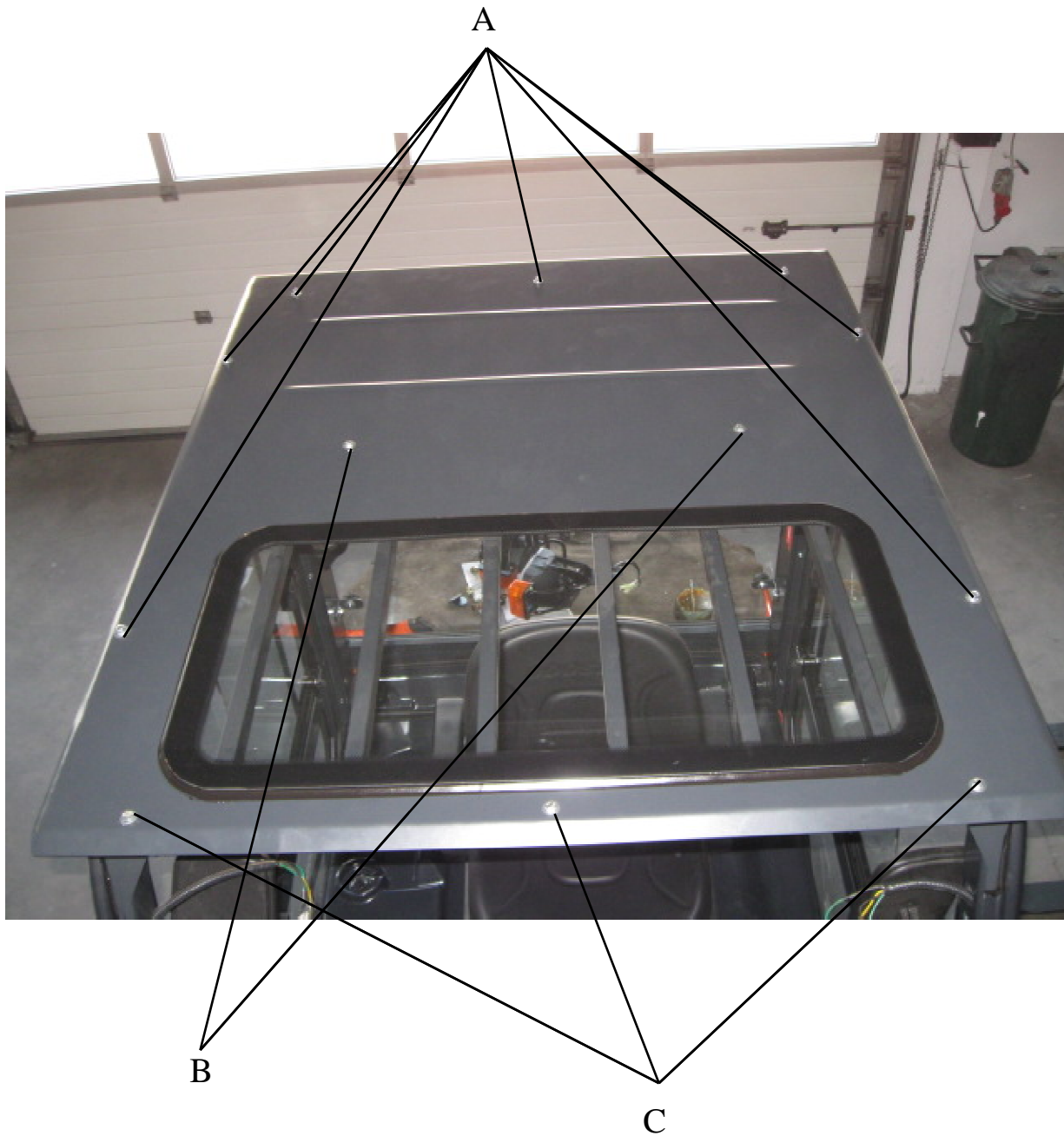
4. Roof panel

4.1. Stick UD54 seal to OHG roof all way round. Put roof panel on the OHG and adjust it appropriately. Attach it the following way:

- attach 6,3x25 self-drilling screws through side and rear panel holes (A)
- mark assembly holes through middle panel holes (B), thread them and attach M6x20 screws
- drill assembly holes through front panel holes (C) and attach it using M6x25 screws with nuts.



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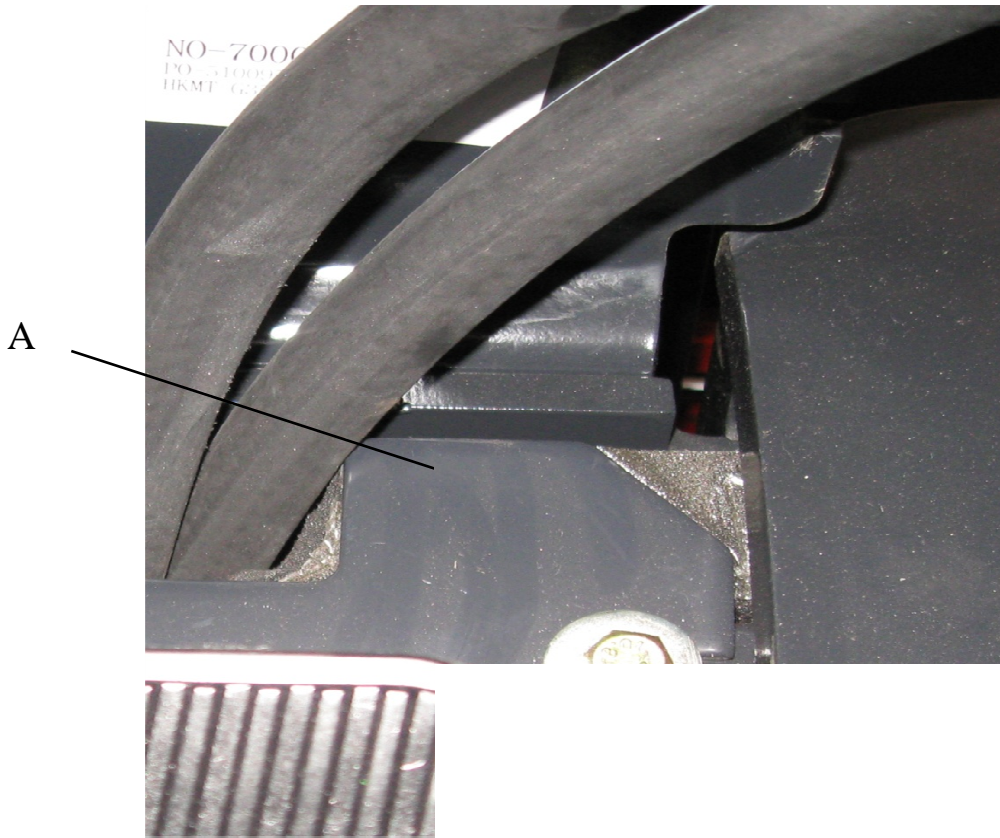


5. Heater

5.1. Run heater hoses through original holes behind accelerator pedal.



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5.2. Attach heater 2-3 cm above tilt cylinder (B). Attach heater inlet (C) hoses using clamps.

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