

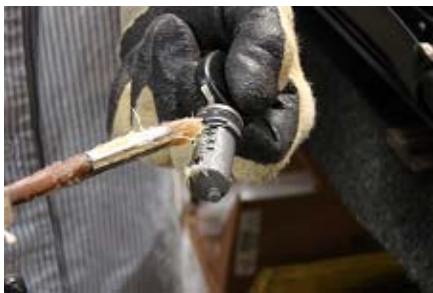
<i>ARE</i> ISO 9001 QUALITY MANUAL	DEPARTMENT Final Assembly	ISSUE DATE 7/14/2011	DOCUMENT
DOCUMENT TYPE Work Instructions	WRITTEN BY (NAME) Rick Smeltzer	APPROVED BY (TITLE) VP Materials/QA	REVISION #
DESCRIPTION Z Series Door Palm Handle Installation			

Parts needed:


1. Either part # PA-16827 (Z Series Molded Palm Handle Non E-lock) or part # PA-16828 (Z Series Molded Palm Handle E-Lock).
2. Part #11475 Z Series door latch cable (order 6 feet to be safe)
3. Part #09162 Z Series Door Cable Compression Sleeve (2 needed)
4. Obtain a lock-housing unit.



5. Grease both sides of the cylinder lock and insert into housing unit with the protruding end at the bottom then remove the keys.



6. Remove the shroud to expose insert holes for installation of the cylinder lock.

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7. Remove plastic cap, nuts and washers and insert lock box into the door coming up from the bottom.

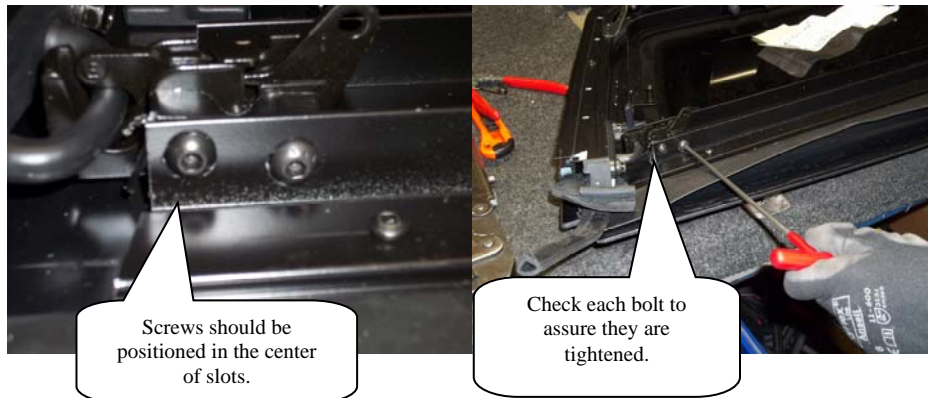


8. Place washers, and nuts back on lock box and hand tighten with sockets starting with the center then doing both end cylinders at the same time (this keeps the lock box level)



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9. Check screws on both latches to assure they are tight.




10. Pull a length of cable from the spool located at your workstation.

You want to measure it using the bottom of the door (it should stretch from one edge of the door to the other). Use wire cutters to cut the cable.



11. Slide a compression sleeve on to one end of the cable then slide the cable through the eyelet after that you slide the end of the cable through the second hole on the compression sleeve.

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12. Push the compression sleeve towards the eyelet as far as it will go.



13. Feed the cable through the hole in the center of the cylinder lock then press cable below the two outside cylinders with your fingertips while putting the plastic cap back on the center cylinder (cap has to start out with letters upside down in order to be installed correctly).



Make sure the cable is in the grooves on both sides of the plastic

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14. Leaving a little bit of slack in the cable feed another compression sleeve on to the end and repeat step 11. Then clamp both sides.

15. Test handle by twisting it clockwise, if installed properly both latches should release. Be sure to shut latches after testing.

16. Place the shroud back into place and drill a small hole using a 1/8 drill bit approximately 4inch from the edge of the shroud. Insert a hex screw into the hole using a screw gun.



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17. Remove all three parts of the ring by placing the screw gun into reverse and removing all the hex screws.

18. Apply approximately 9” of double back tape to the putty flange of each door leg.

- Start at the bottom of each door leg & go up 9” to approximately the middle of the door leg.




Overlap the foam putty approximately 1” onto the double back tape.

Apply approximately 9” of double back tape starting at the bottom. Apply foam putty to the rest of the putty flange.

19. Apply foam putty to the rest of the putty flange.

- Overlap the foam putty approximately 1” onto the double back tape.

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