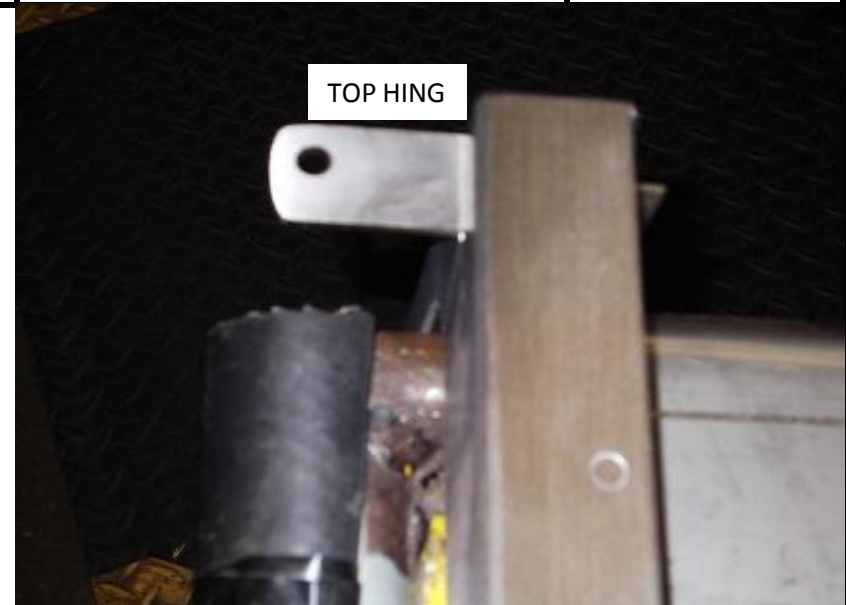


<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1		 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder					

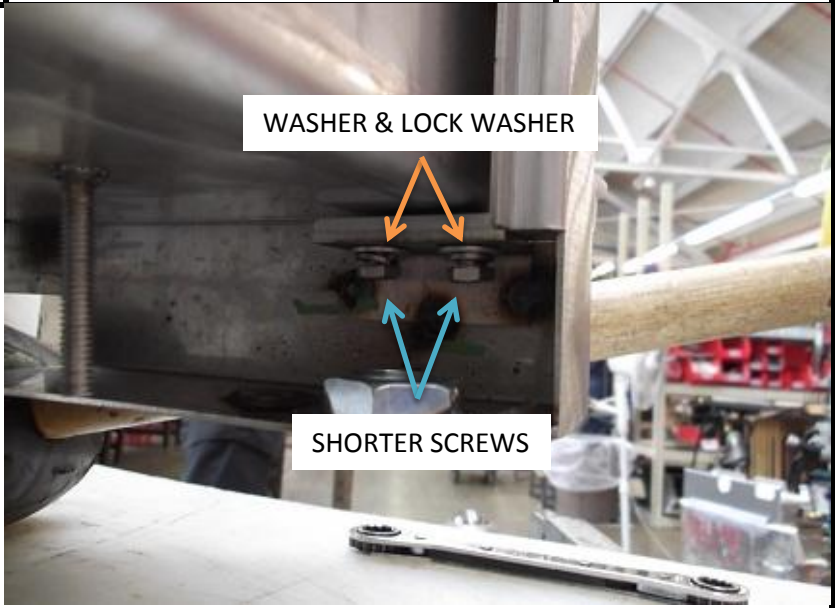
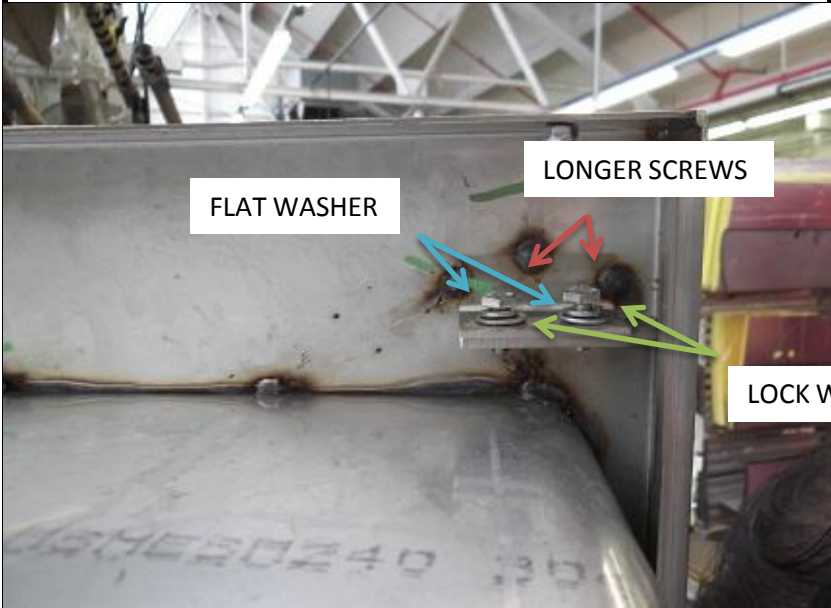


INSERT TOP HING THROUGH SLOT IN FACE.  
 INSERT BOTTOM HINGE THROUGH BOTTOM SLOT.

 ALWAYS VERIFY CAVITY HAS BEEN - SIGNED OFF AS PASSING LEAK TEST BEFORE BEGINNING ASSEMBLY

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY
104035	TOP HINGE	1				
109112	BOTTOM HINGE	1				

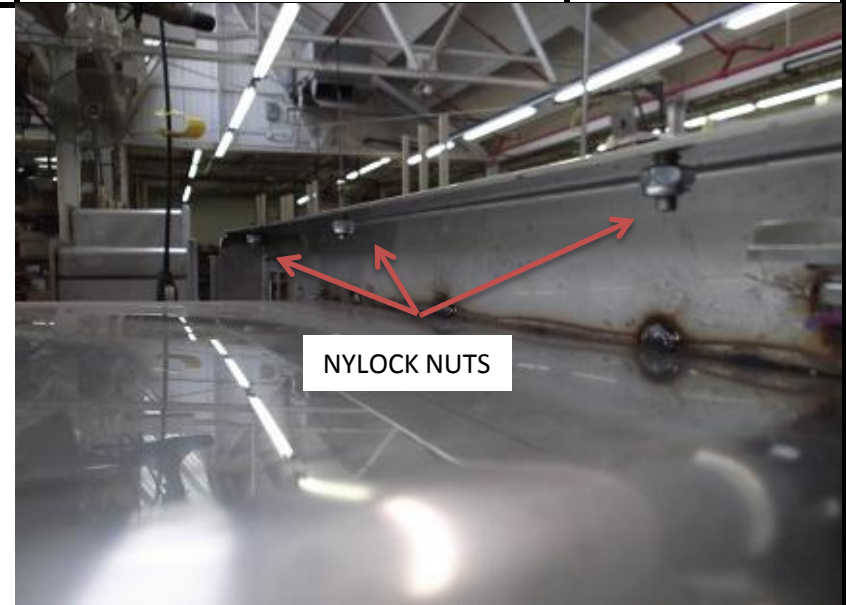
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



THREAD SCREW, LOCK WASHER, AND FLAT WASHER THROUGH BACKSIDE PLATE AND INTO HINGE.  
 ONLY THREAD THE SCREWS DO NOT FULLY TIGHTEN.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
19170	LONGER SCREW	2			
23116	FLAT WASHER	4			
23105	LOCK WASHER	4			
109232	SHORTER SCREW	2			

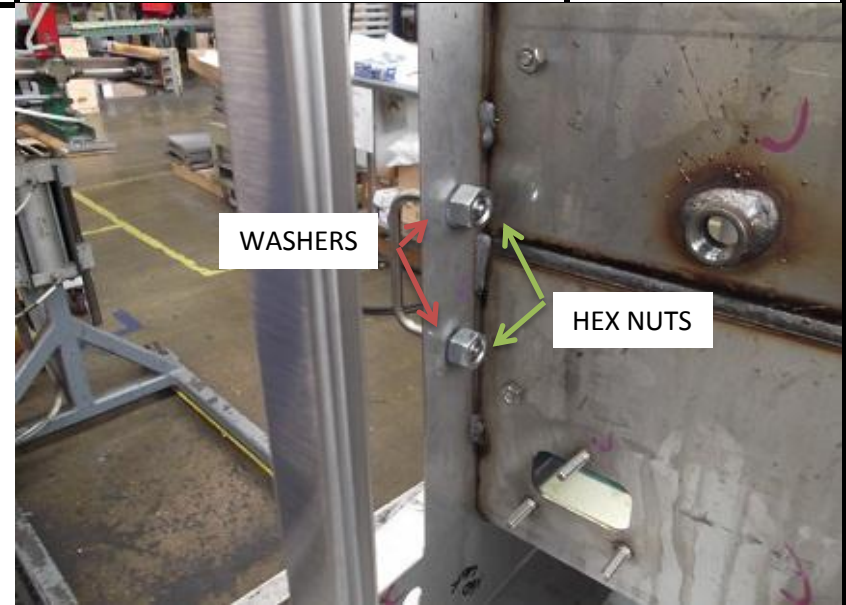
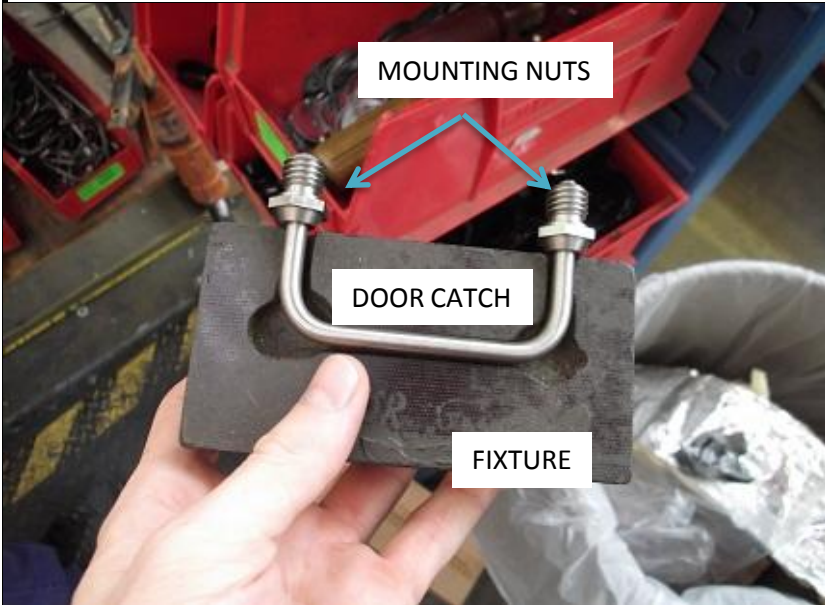
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



PLACE FIXTURE INTO HINGES AND DOOR CATCH HOLES AND LOCK IN PLACE. TIGHTEN HINGES FULLY.  
 THREAD 3 NYLOCK NUTS ONTO STUDS IN THE TOP OF THE FACE. THREAD NUTS ABOUT 3/4 OF THE WAY.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				

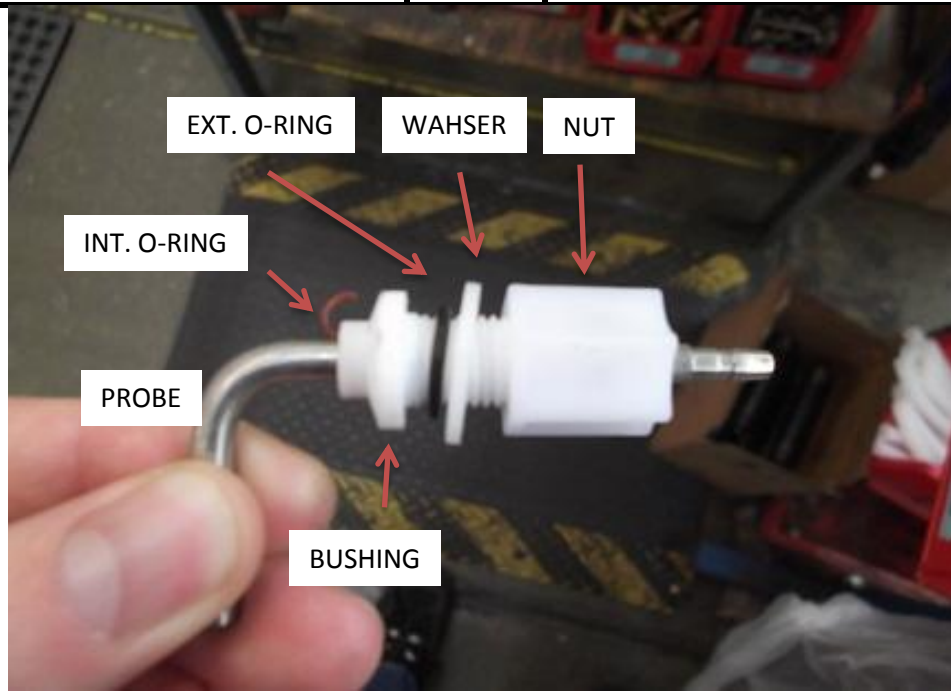


APPLY BLUE LOCTITE TO THREADS ON DOOR CATCH. PLACE CATCH IN FIXTURE AND THREAD MOUNTING NUTS UNTIL THEY TOUCH THE FIXTURE. PUT DOOR CATCH THROUGH THE FACE, APPLY GREEN LOCTITE TO THREADS AND ATTACH WITH NYLON WASHERS AND HEX NUTS.

 KEEP THE MOUNTING NUTS EVEN WITH EACH OTHER ON THE FACE. (FLATS ARE GOING THE SAME DIRECTION ON BOTH NUTS)

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
104046	DOOR CATCH	1			
14695	DOOR CATCH MOUNTING NUT	2			
23149	NYLON WASHER	2			
14649	HEX NUT	2			

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



PLACE INTERNAL O-RING IN SLOT ON PROBE.  
 INSERT PROBE INTO BUSHING UNTIL IS SNAPS IN PLACE.  
 FINISH ASSEMBLY BY PLACING EXTER O-RING, WASHER, AND NUT ON BUSHING.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
109955	PROBE	1	23149	NYLON WASHER	1
109956	BUSHING	1			
109963	INTERNAL O-RING	1			
109964	EXTERNAL O-RING	1			
101316	NUT	1			

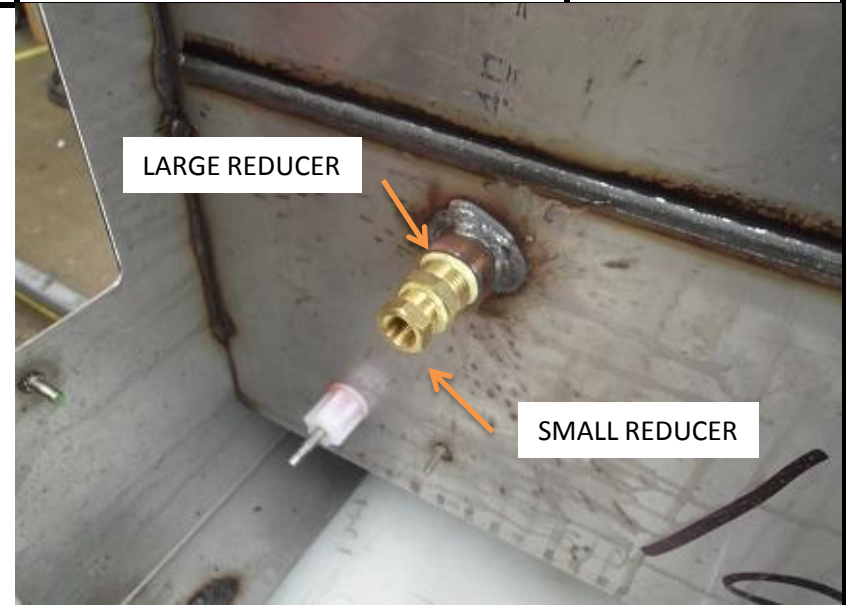
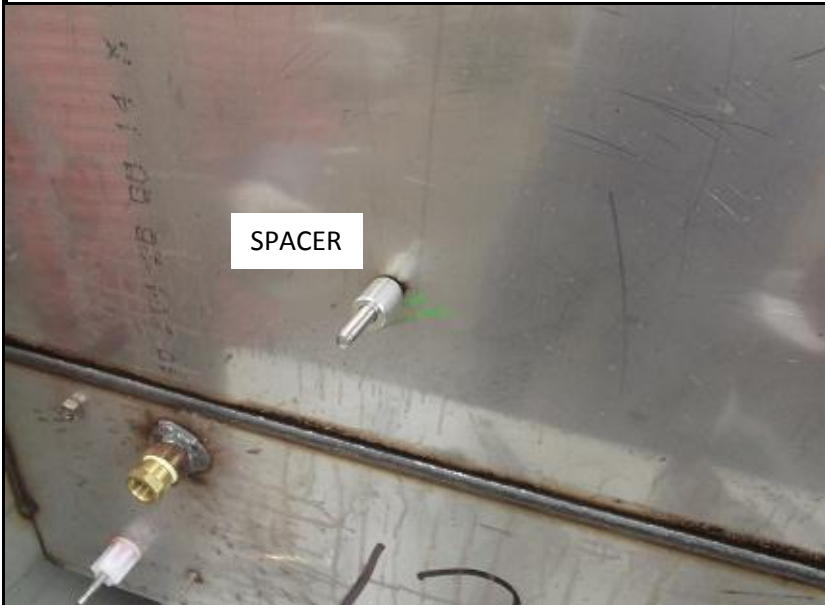
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



REMOVE NUT AND NYLON WASHER FROM PROBE ASSY.  
 INSERT PROBE (PROBE END DOWN) THROUGH THE CAVITY WALL.  
 APPLY RED RTV TO THREAD AND ATTACH PROBE WITH NUT.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				

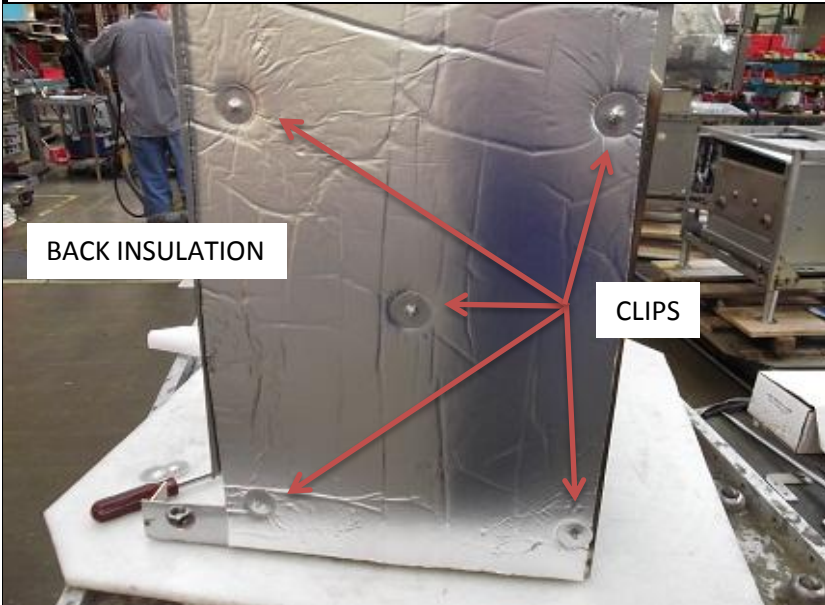


PLACE SPACER ON STUD.  
 APPLY PIPE DOPE TO LARGE AND SMALL REDUCER. THREAD BOTH REDUCERS INTO CAVITY AND TIGHTEN.

 SEE QOP 1

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
195552	SPACER	1			
02594	LARGE REDUCER	1			
02609	SMALL REDUCER	1			

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



PLACE BACK INSULATION ON REAR WALL AND SECURE WITH 5 INSULATION CLIPS.  
 DRAPE BODY INSULATION OVER CAVITY AND CUT OUT CORNER FOR PROBE.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
109138	BACK INSULATION	1			
101953	INSULATION CLIP	5			
109143	BODY INSULATION	1			

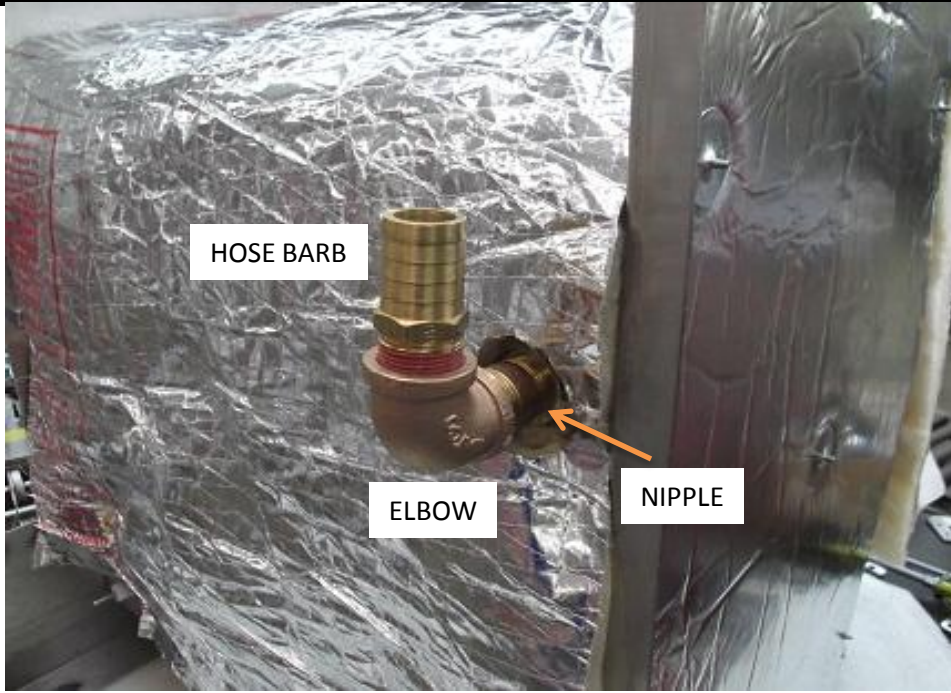
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



CUT HOLE FOR REAR VENT PORT IN INSULATION.  
 FOLD INSULATION OVER AND ALIGN EVEN WITH BOTTOM EDGE.  
 TAPE INSULATION TO BOTTOM AND BACK EDGES.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



APPLY PIPE DOPE TO THREADED NIPPLE AND THREAD INTO VENT PORT IN CAVITY.  
 THREAD ELBOW ON TO NIPPLE AND TIGHTEN. ELBOW MUST POINT UPWARDS.  
 ATTACH HOSE BARB TO ELBOW.

 SEE QOP 1

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY
14431	THREADED NIPPLE	1				
05260	ELBOW	1				
06185	HOSE BARB	1				

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				

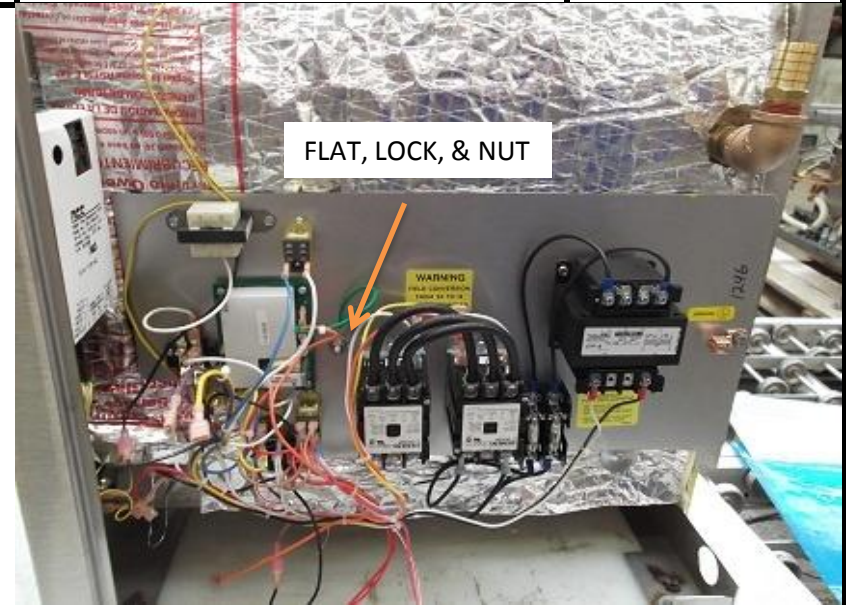


CHECK WORK ORDER FOR MATCHING TIMER PANEL.  
ATTACH CORRECT TIMER PANEL TO UNIT WITH NYLOCK NUTS AND WASHERS.

-  MAKE SURE TIMER PANEL IS CENTERED IN THE OPENING.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
23116	WASHER	2			
14372	NYLOCK NUT	2			

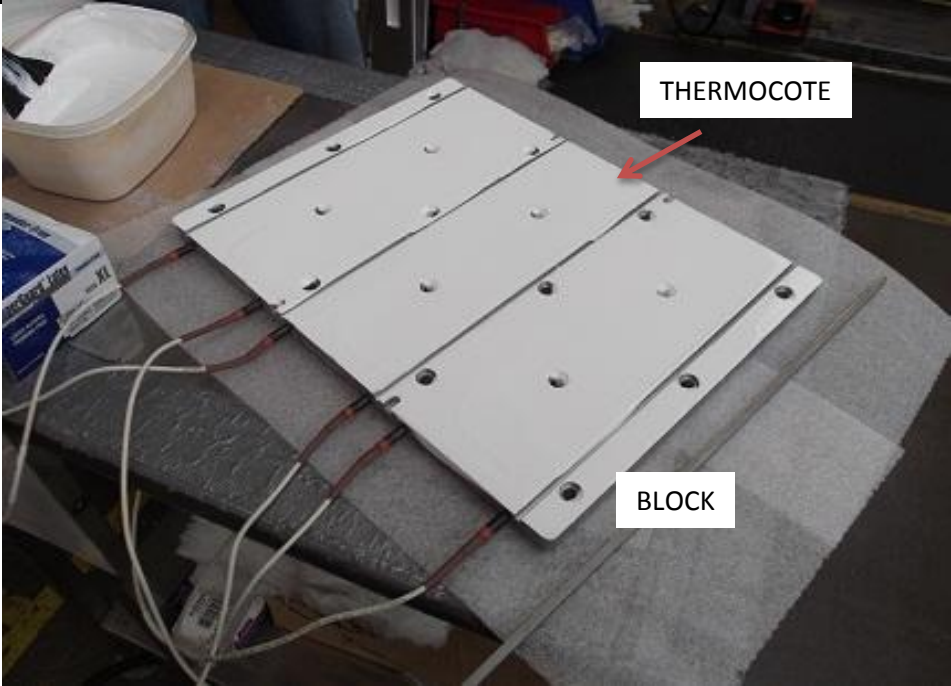
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



REMOVE GROUND SCREW AND PLACE COMPONENT PANEL ON UNIT.  
ATTACH COMPONENT PANEL WITH SCREW FROM GROUND LUG AND FLAT WASHER, LOCK WASHER, & NUT.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
14618	HEX NUT	1			
23116	FLAT WASHER	1			
23105	LOCK WASHER	1			

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				

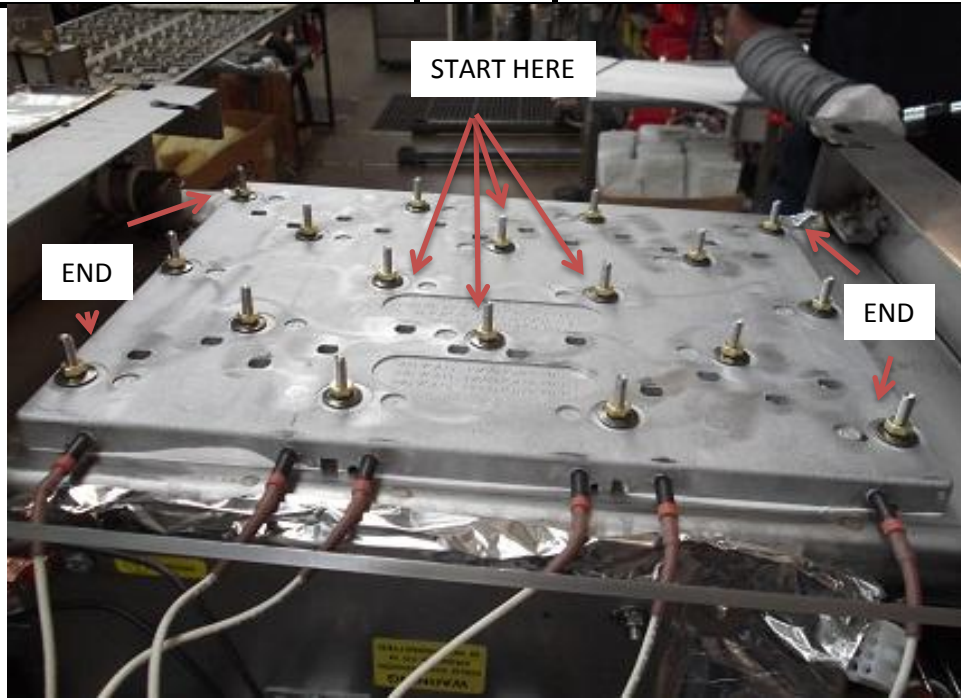




CLEAN OFF BOTTOM AND BLOCK. APPLY A THIN LAYER OF THERMOCOTE TO THE BLOCK AS SHOWN.

- ASSURE NO STUD SPLATTER, DIRT or DEBRIS TO INTERFERE WITH FLUSH MOUNTING OF CORRECT VOLTAGE ELEMENT

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
SEE W/O	HEATER BLOCK	1			
109139	HEAT TRANSFER PASTE				

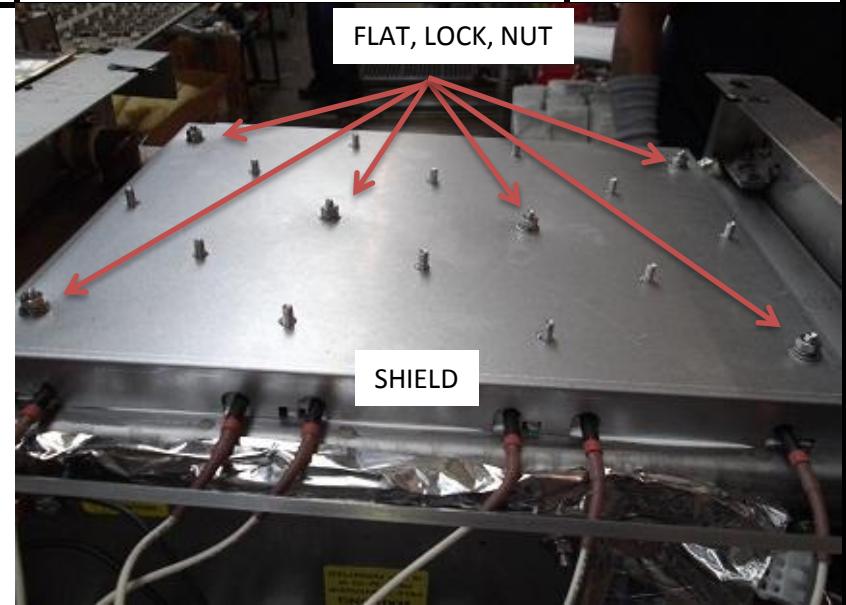
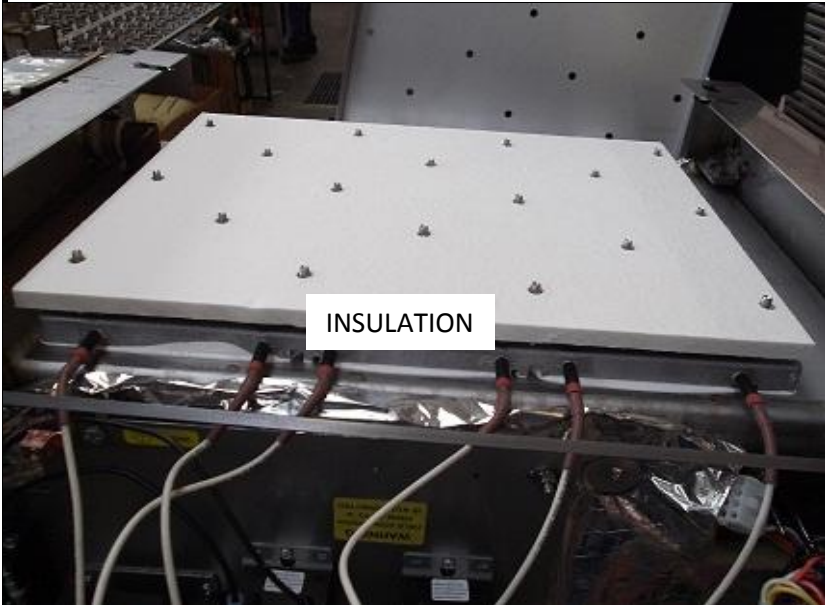
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



PLACE BLOCK OVER STUDS ON TO THE BOTTOM OF THE UNIT AS SHOWN. WIRES SHOULD BE FACING THE COMPONENT PANEL.  
 PLACE WASHER AND NUT ON ALL STUDS.  
 TIGHTEN DOWN NUTS BEGINING IN THE MIDDLE AND WORKING OUTWARDS.  
 TORQUE DOWN NUTS WITH 55 IN-LBS FIRST THEN 70 IN-LBS FOLLOWING THE SAME INWARD TO OUTWARD PATTERN.

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY
112480	WASHER	18				
112481	NUT	18				

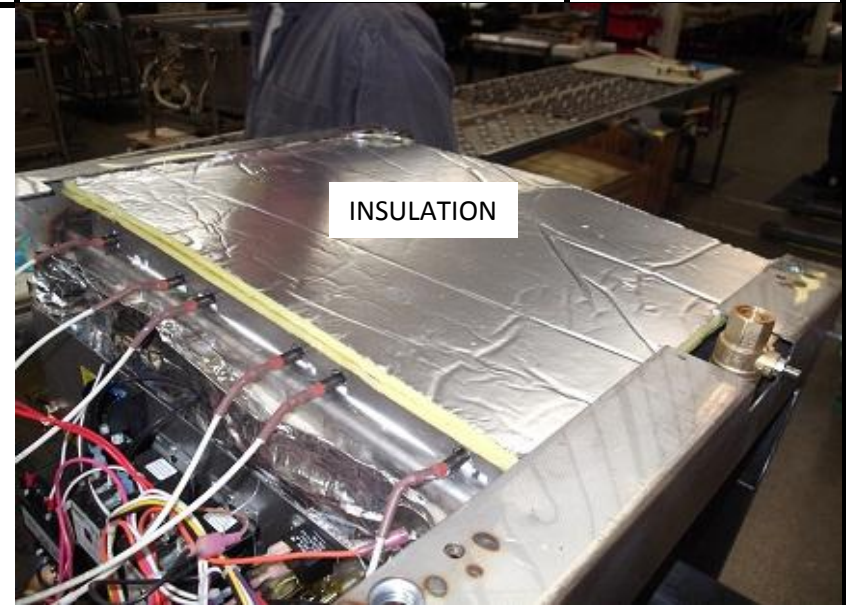
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



PLACE INSULATION BOARD OVER STUDS.  
 PLACE HEAT SHIELD OVER INSULATION.  
 ATTACH HEAT SHIELD WITH FLAT WASHER, LOCK WASHER, HEX NUT.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
113248	INSULATION BOARD	1			
112658	HEAT SHIELD	1			
14618	HEX NUT	6			
23116	FLAT WASHER	6			
23105	LOCK WASHER	6			

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				

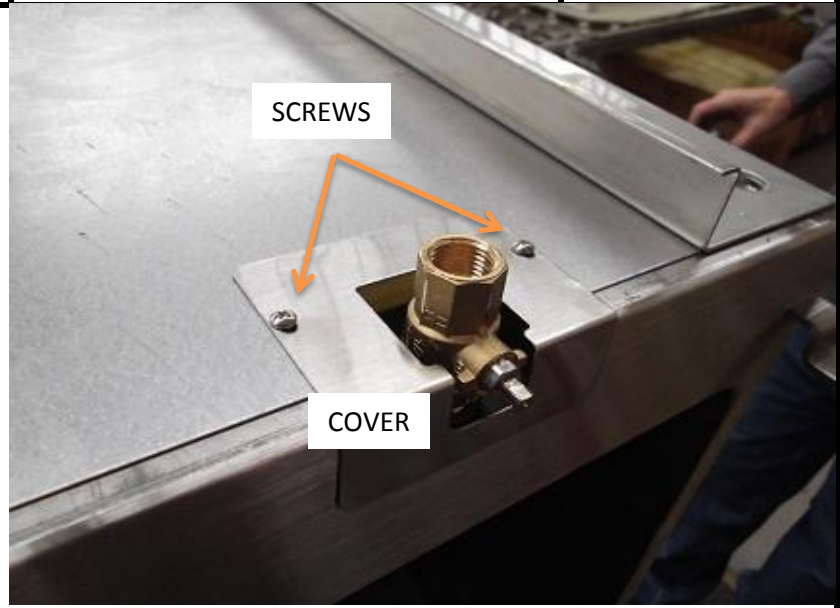
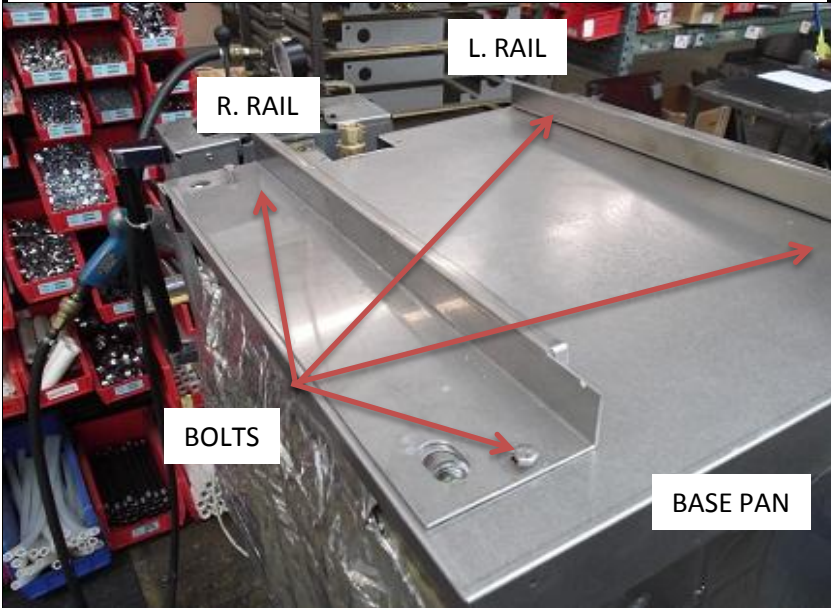


APPLY PIPE DOPE TO BALL VALVE.  
ATTACH BALL VALVE TO DRAIN COUPLING IN BOTTOM OF CAVITY. STEM NEEDS TO FACE THE FRONT OF THE UNIT.  
PLACE 2 PIECES OF BOARD INSULATION ON BOTTOM OF THE UNIT.

 SEE QOP 1

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
109146	BALL VALVE	1			
109136	INSULATION	2			

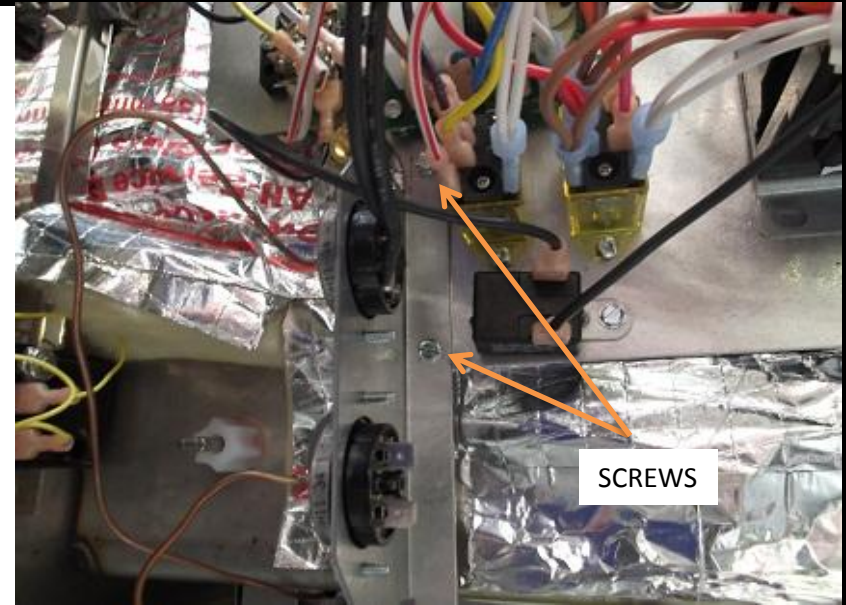
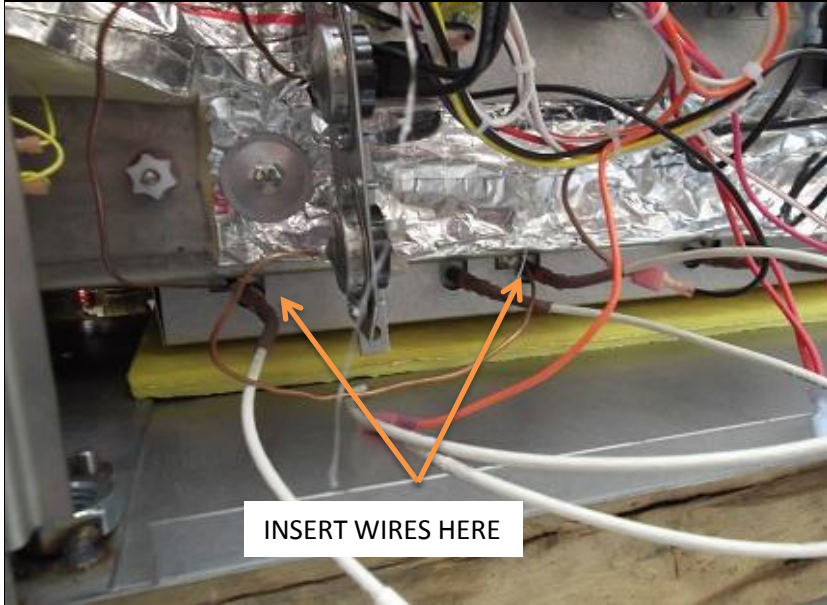
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



PLACE RIGHT AND LEFT RAIL ON BOTTOM OF THE UNIT. BENT UP TABS TO TOWARDS THE BACK OF THE OVEN.  
 ATTACH RAILS WITH BOLTS.  
 PLACE VALVE COVER OVER BALL VALVE AND FASTEN TO BASE PAN WITH SHEET SCREWS.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
1091291	LEFT RAIL	1	104080	SHEET SCREW	2
109129	RIGHT RAIL	1			
109111	BASE PAN	1			
109126	BALL VALVE COVER	1			
19170	BOLT	4			

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				

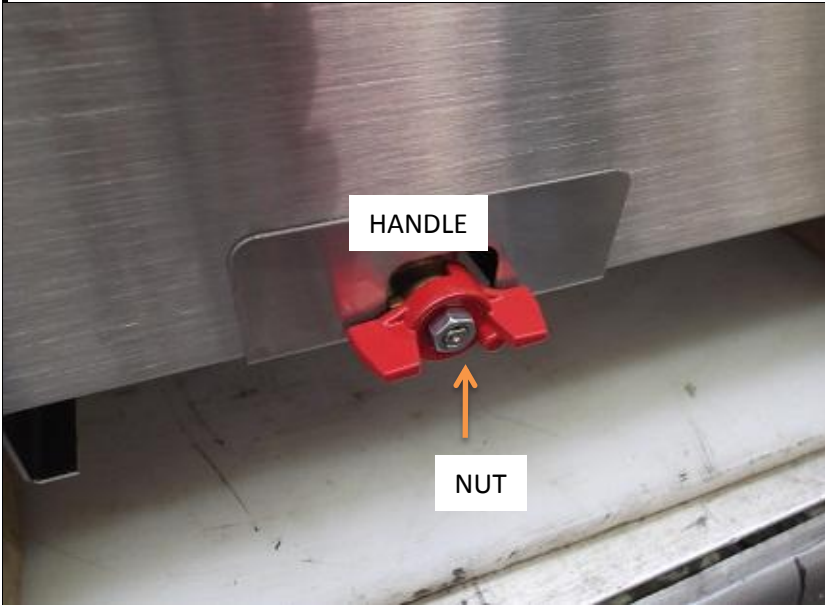


SLIDE HIGH LIMIT TUBES INTO BLOCK SLOTS AS SHOWN.  
ATTACH HIGH LIMIT TO COMPONENT PANEL WITH SCREWS.


 DO NOT PINCH OR BEND CAPILLARY TUBES

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
	HIGH LIMIT ASSY	1			
106754	SCREW	2			

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				

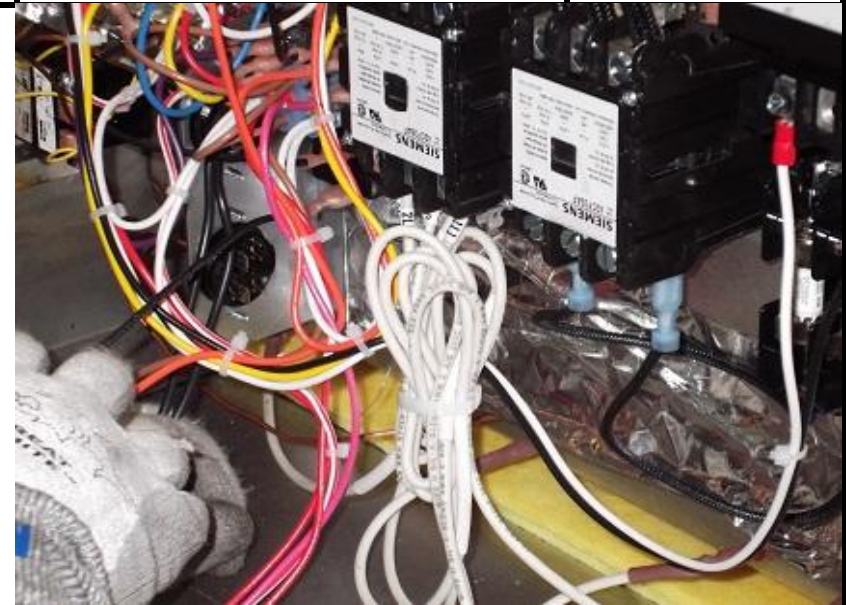
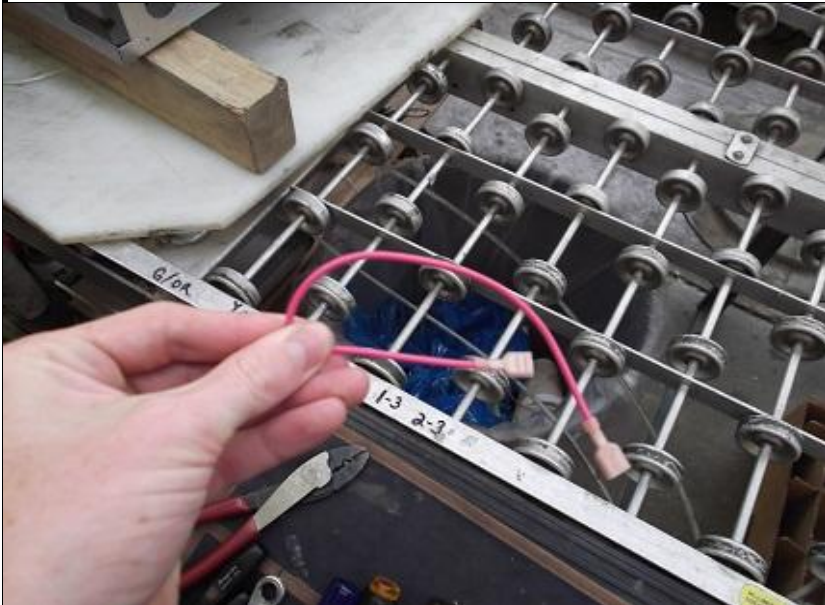


PLACE HANDLE ON BALL VALVE AS SHOWN.  
 ATTACH WITH HEX NUT. APPLY GREEN LOCTITE ON THREAD AFTER TIGHT.  
 ATTACH VENT HOSE TO HOSE BARB WITH 2 WORM CLAMPS.

 SEE QOP 2

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
109529	HANDLE	1			
109590	NUT	1			
085100575	HOSE	1			
03204	HOSE CLAMP	2			

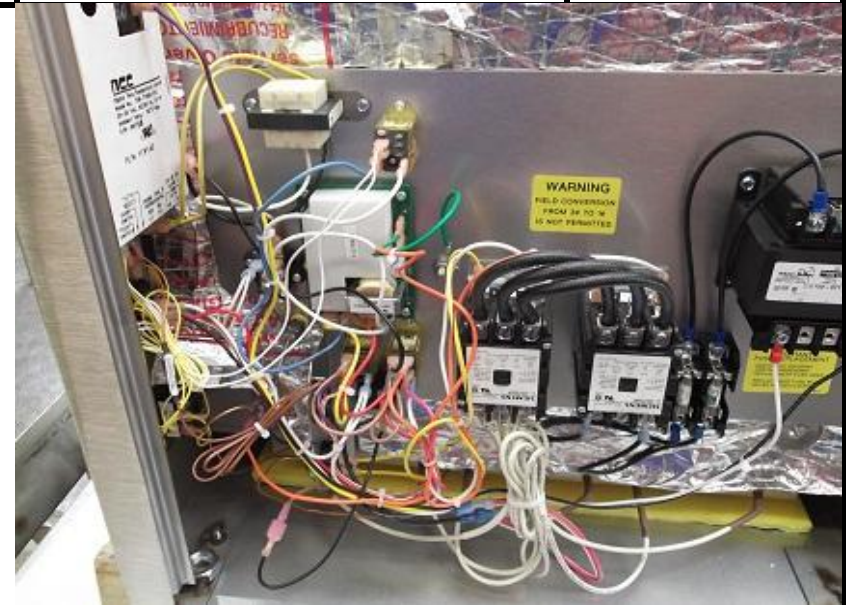
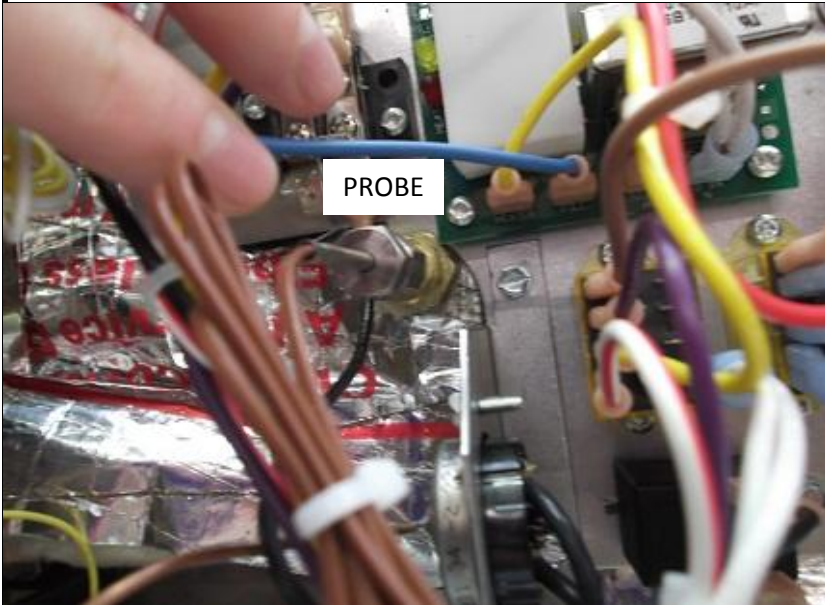
<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				




REMOVE 2 PINK WIRES FROM WIRE HARNESS.  
ATTACH HEATING BLOCK WIRES TO CONTACTOR.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
	WIRE HARNESS (ELECTRIC)	1			

<b>MODEL</b> CUB	<b>PROCESS ID</b> BUILD	<b>REVISION LEVEL</b> 1	 TQC  WORK CONTENT  VERIFY	
<b>REVISED BY:</b> C. Schmauder				



APPLY PIPE DOPE TO THERMOSTAT PROBE AND ATTACH TO REDUCER FITTINGS.  
 COMPLETE WIRING ACCORDING TO WIRING INSTRUCTIONS.

 SEE QOP 1

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
108068	PROBE	1			