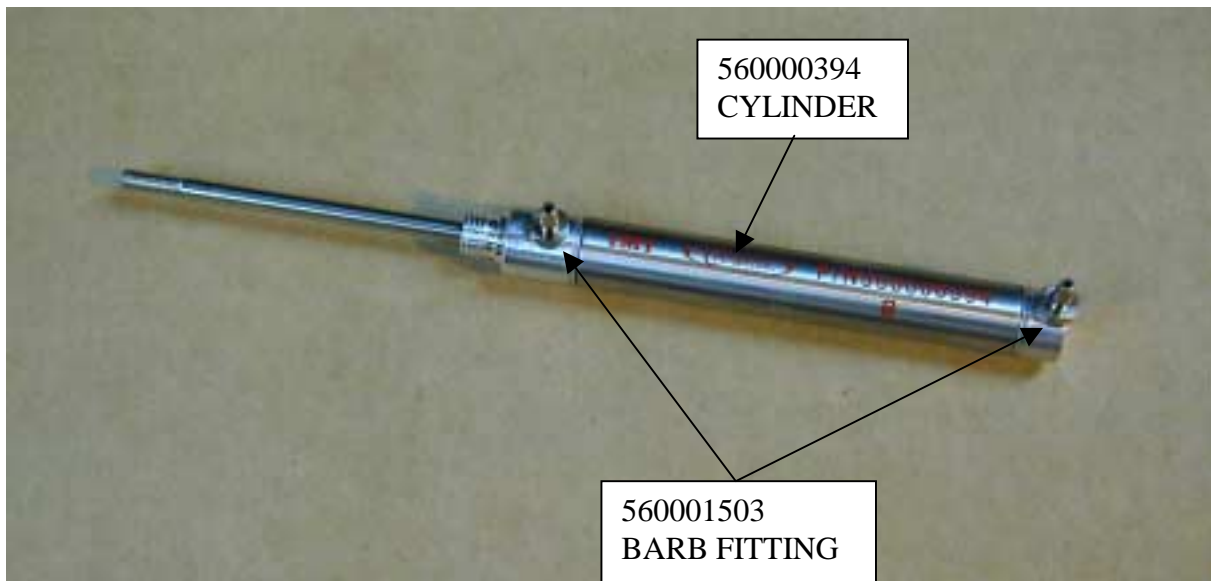
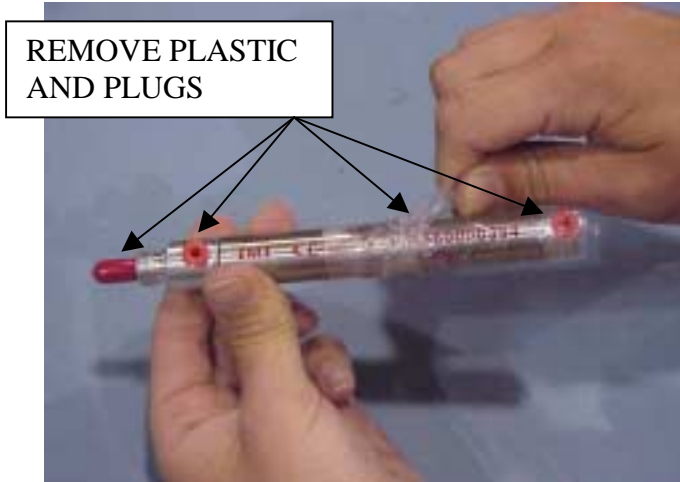


ABS Department – Process Manual

561299995 / 561299997

ABS Ice Gate Assembly

Revision 3-28-2001



Assembly instructions

- 1) Obtain cylinder, unwrap, remove plugs and add barb fittings. **NOTE: MAKE SURE BARB FITTINGS HAVE O RINGS.**

Special Tools/Fixtures Required:

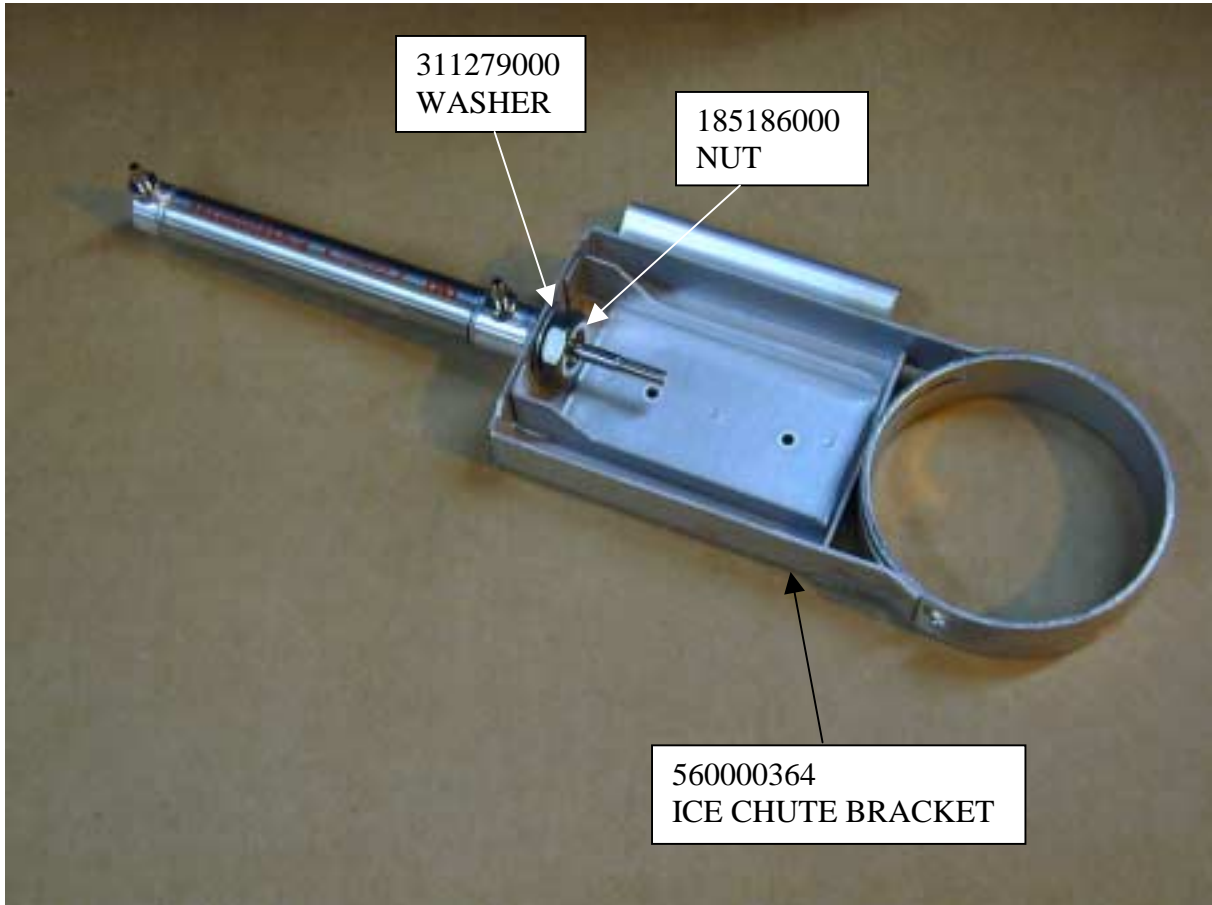
None

ABS Department – Process Manual

561299995 / 561299997

ABS Ice Gate Assembly

Revision 3-28-2001



Assembly instructions

2) Place cylinder into ice chute bracket, attach washer and nut, **hand tighten**.

Special Tools/Fixtures Required:

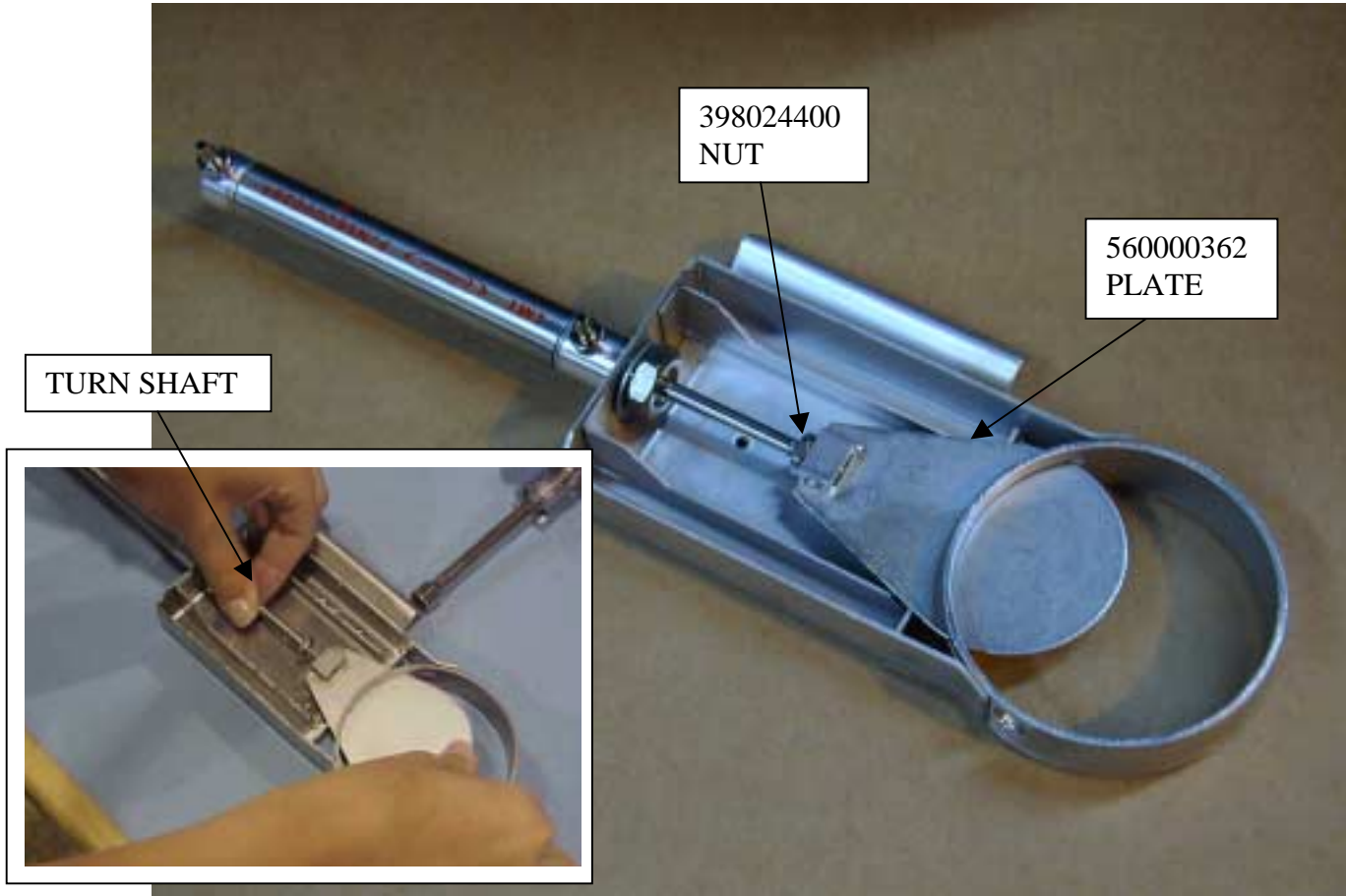
None

ABS Department – Process Manual

561299995 / 561299997

ABS Ice Gate Assembly

Revision 3-28-2001



Assembly instructions

- 3) Place nut all the way down on the threads of the cylinder shaft.
- 4) Slide plate into bracket.
- 5) Turn shaft into plate until tight.
- 6) Tighten nut.

Special Tools/Fixtures Required:

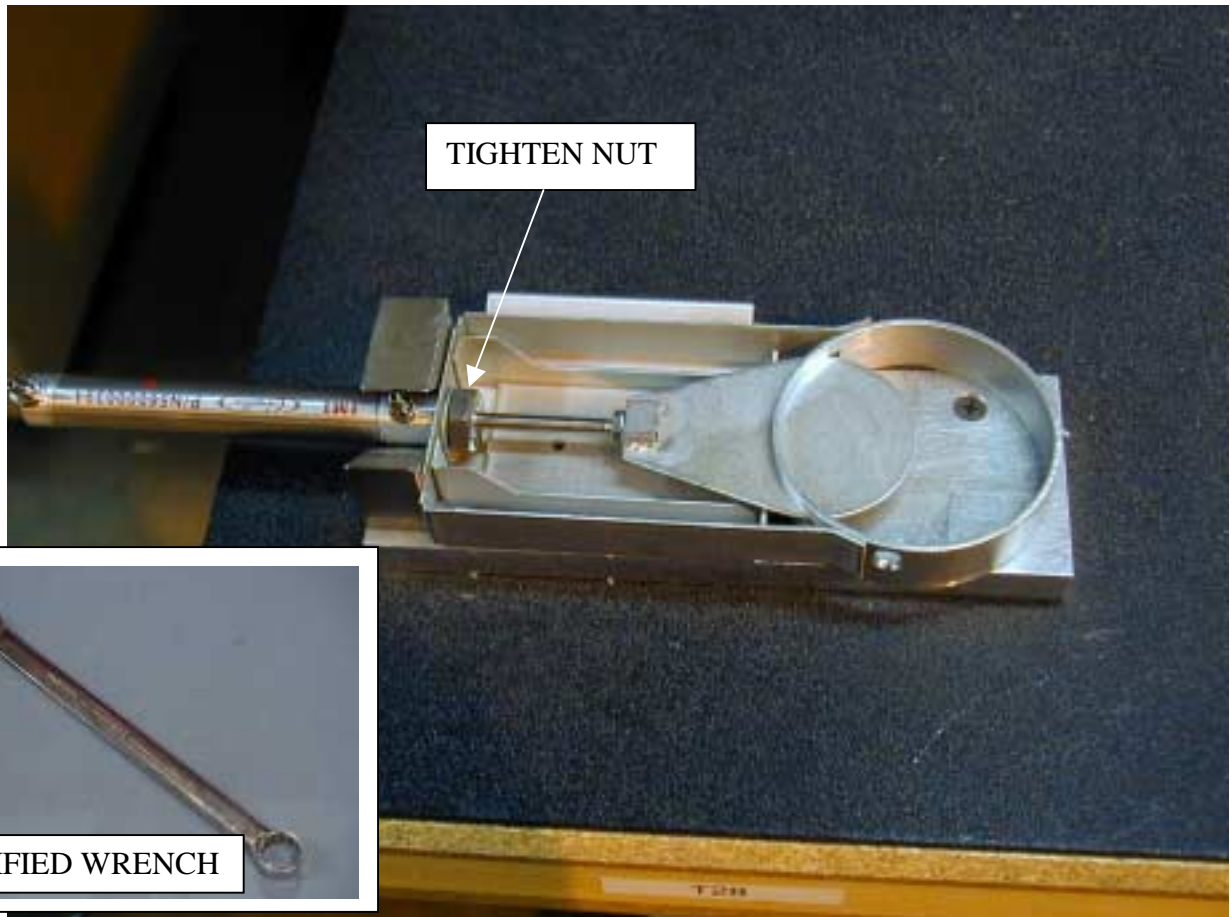
None

ABS Department – Process Manual

561299995 / 561299997

ABS Ice Gate Assembly

Revision 3-28-2001



Assembly instructions

- 7) Place assembly into fixture making sure it is flat to fixture.
- 8) Tighten nut with modified wrench.
- 9) Slide plate back and forth to ensure plate slides freely. **NOTE: WHEN THE CYLINDER IS CLOSED THE PLATE MUST STOP WITHIN THE THICKNESS OF THE STEEL RING.**

Special Tools/Fixtures Required:

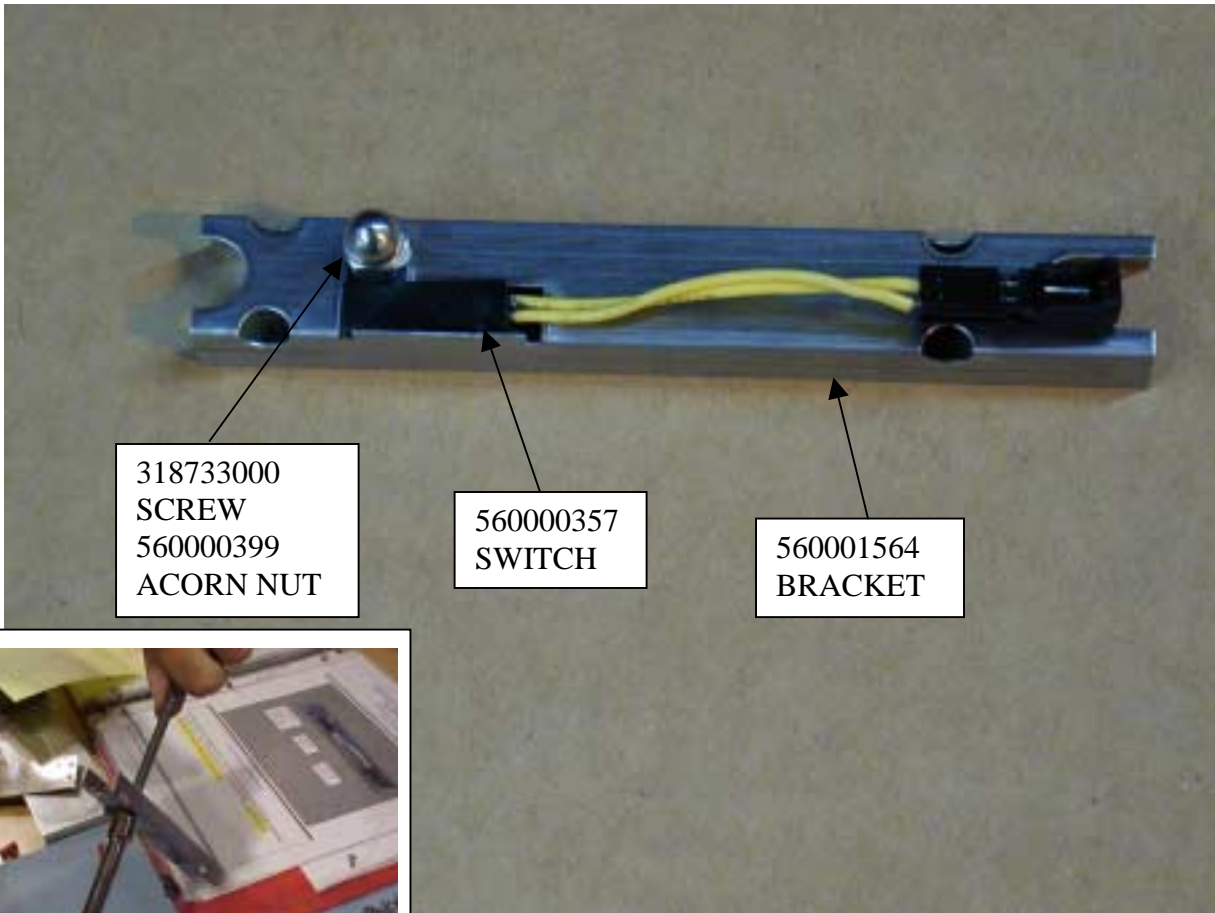
Fixture 56000036201, modified wrench

ABS Department – Process Manual

561299995 / 561299997

ABS Ice Gate Assembly

Revision 3-28-2001



318733000
SCREW
560000399
ACORN NUT

560000357
SWITCH

560001564
BRACKET



Assembly instructions

- 10) Attach switch to bracket using screw and nut having the screw from the underside. The screw has to thread through the hole of the switch. Use a screwdriver and nutdriver as shown in the inset. **NOTE: USE ONLY NON-MAGNETIC SCREWDRIVER. DO NOT USE SWITCH IF BARE WIRE CAN BE SEEN.**

Special Tools/Fixtures Required:

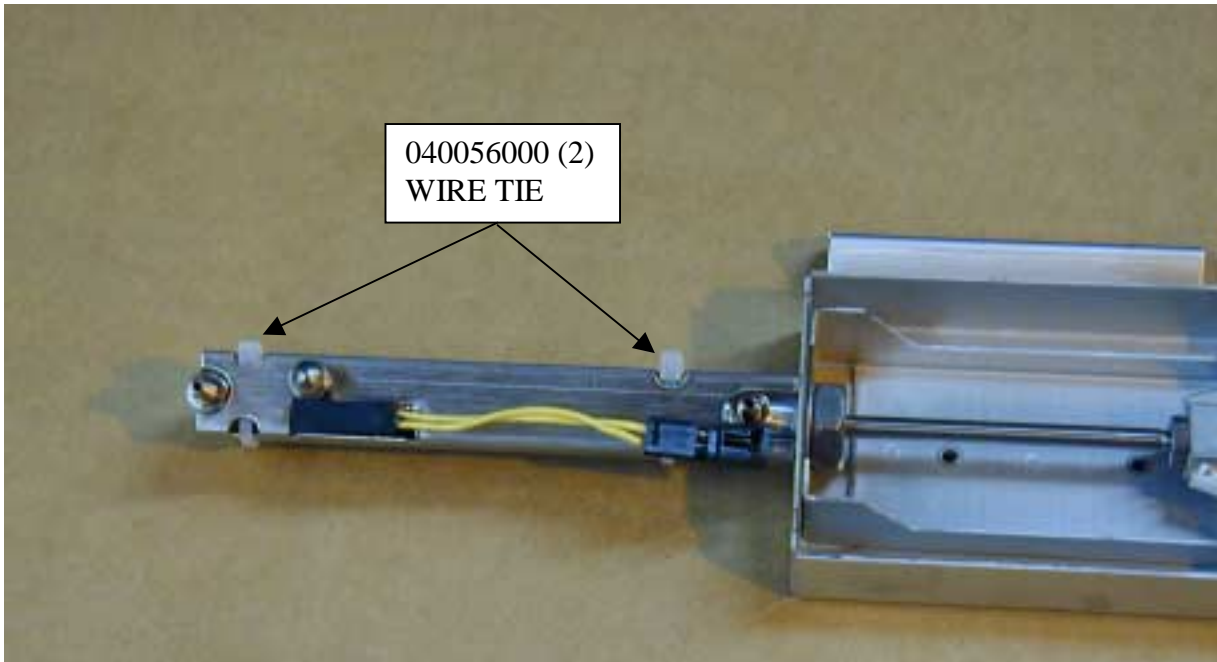
None

ABS Department – Process Manual

561299995 / 561299997

ABS Ice Gate Assembly

Revision 3-28-2001



Assembly instructions

- 11) Set bracket over barb fittings on cylinder and secure using 2 wire ties. Wire ties will route through the holes in the bracket and then around cylinder.

Special Tools/Fixtures Required:

None