



Install: Defrost - IP Mounted - 2 Speed

Part Number: S-1202CUA00221N

WORK INSTRUCTION OVERVIEW

⚠ WARNING

- DO NOT ATTEMPT THIS PROCEDURE IF YOU DO NOT HAVE PROPER TOOLS, TRAINING, AND FACILITIES.
- To protect bystanders and the service technician(s), shut vehicle off, remove the Ignition Key and secure vehicle to prevent unintended movement.

NOTICE

- This product is designed to work in conjunction with our Dual Speed Heater Kits listed below. This product will **not** work with our Vintage HVAC Systems.
 - Part Number - **S-1202BUA00090N** - Dual Speed Heater Kit (6 Hole Dash Panels)
 - Part Number - **S-1202BUA00130N** - Dual Speed Heater Kit (4 Hole Dash Panels)

TOOLS REQUIRED

<ul style="list-style-type: none"> • 10 mm Socket • 13 mm Socket • T30 Torx • 2-1/2" Hole Saw • 9/64 Drill Bit • Socket Driver 	<ul style="list-style-type: none"> • Drill Motor • Center Punch • Deburring Tool • Scissors • Protective Eye-wear
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TORQUE SPECIFICATION

Tighten each fastener to the torque specification below:

- **Pan Screws** – 2.5 N•m (±0.5 N•m)
- **M6 Screws** – 10 N•m (±1 N•m)
- **M8 Bolts** – 23.5 N•m (±3.5)

KIT COMPONENT TABLE

Component	Description	Qty
	Defroster Duct - Lower Distribution P/N: S-1203ZUA00661N	1
	Cover - Defrost P/N: S-1202CUA00231N	2
	Register Ball Valve w/ Hose Adapter P/N: S-1203ZUA00711N	2
	Register Ball Valve P/N: S-1203ZUA00641N	2

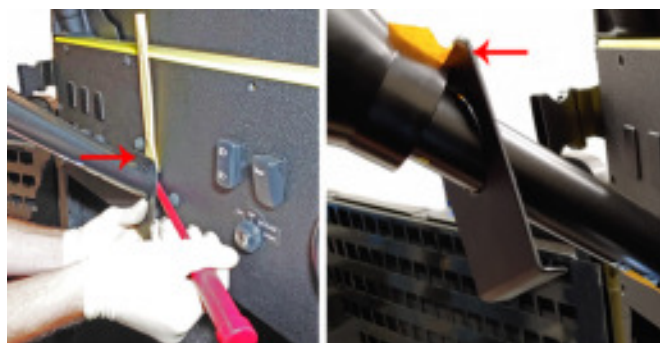
Component	Description	Qty
	Foam - Windshield to ROPS P/N: S-0107AUA00031N	1
	Defrost Hose - 5 ft P/N: S-1202CUA00071N	1
	M6 Plastic Rivet P/N: S-0105ZAW00211N	6

INSTALLATION PROCEDURE

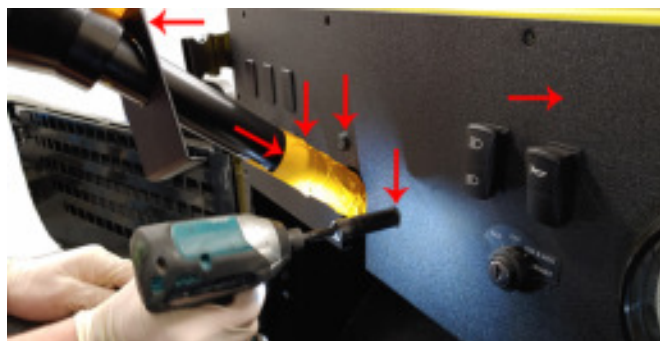
1. Remove (15) M6 T30 torx screws.



2. Carefully pry out steering column cover and tape to steering wheel.



3. Remove (3) M8 bolts, tape cover and column, disconnect switches and remove instrument panel and place on bench.

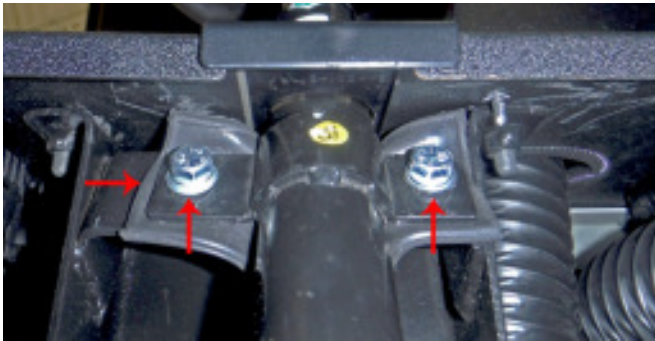




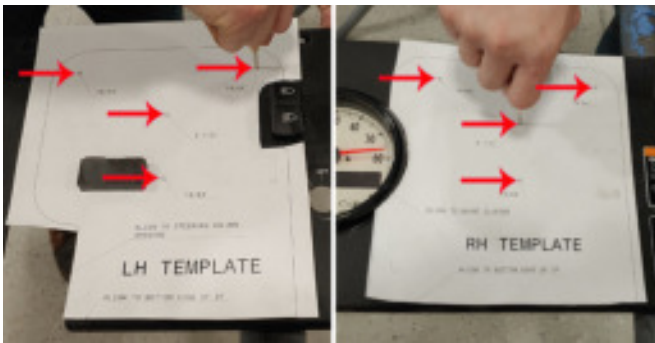
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- 4. If cab interferes with IP removal, remove (2) M8 bolts with (2) M8 washers. Remove (1) rubber spacer.



- 5. Align template at appropriate edges. Using center punch, mark holes to be drilled.



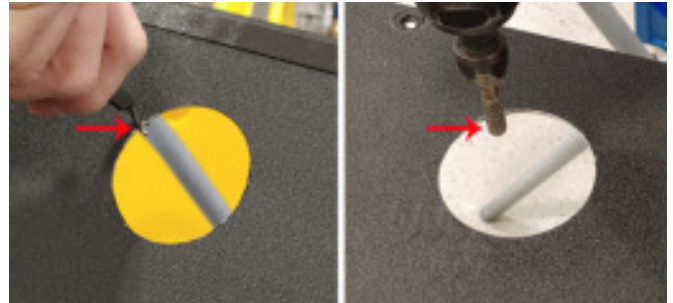
- 6. Using hole saw, drill (2) 2 1/2" holes for defrost covers. Apply cutting oil for cooling.



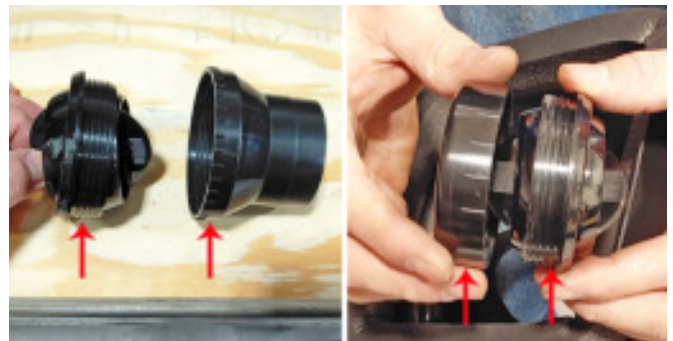
- 7. Drill (6) 9/64" holes. Deburr all rough edges and paint as necessary.



- 8. Deburr all rough edges and paint raw areas as necessary.



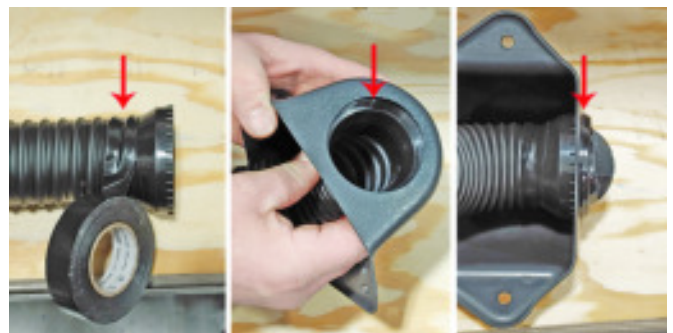
- 9. Take apart (2) register ball valves with hose adapter and (2) register ball valves.



- 10. Measure 30" and cut defrost hose. Remaining section should be roughly 24". Left side will be longer.



- 11. Tape (2) hose adapters within (2) previously cut hoses sections. Place these (2) assemblies inside (2) defrost covers and thread (2) register valves onto hose adapters.

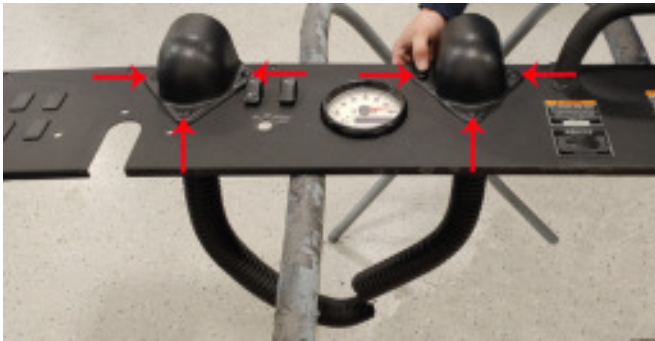




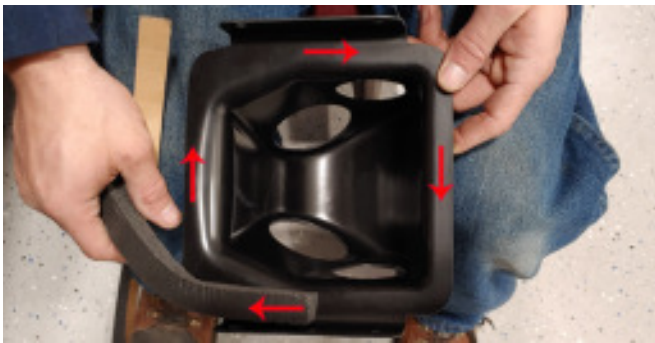
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12. Using (6) plastic rivets, install (2) register assemblies into IP. Assembly with longer hose on left.



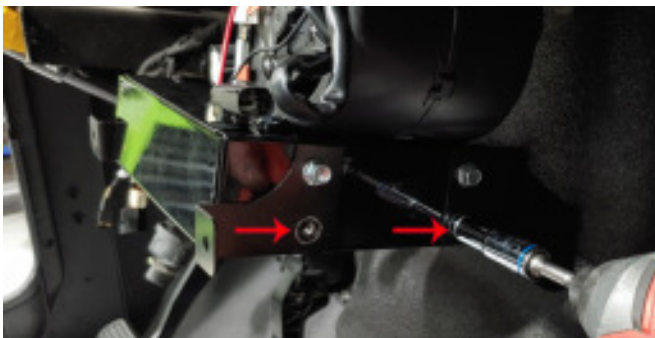
13. Cut seal length to 24" and affix foam around inside edge of lower distribution bowl.



14. Install (2) register ball valves to lower distribution bowl.



15. Remove (2) lower hex bolts from heater. Repeat for opposite side of heater.



16. Install (1) lower distribution bowl re-using (4) hex bolts.

NOTICE

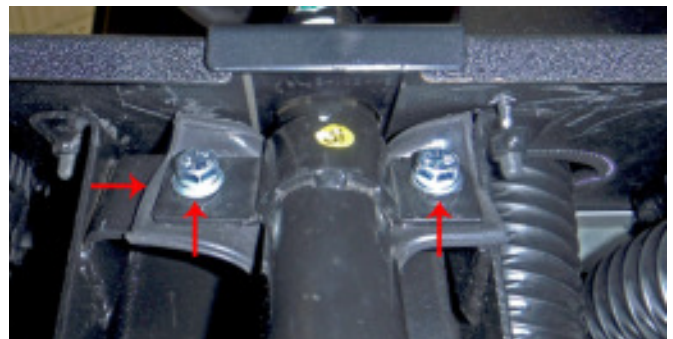
Defrost openings may have smooth outer sides and need (2) self tapping screws (not included) to maintain cable ties.



17. Re-install (3) M8 bolts, remove tape and re-install column cover.



18. Put (1) rubber spacer into place and re-install steering column using (2) M8 bolts with (2) M8 washers.





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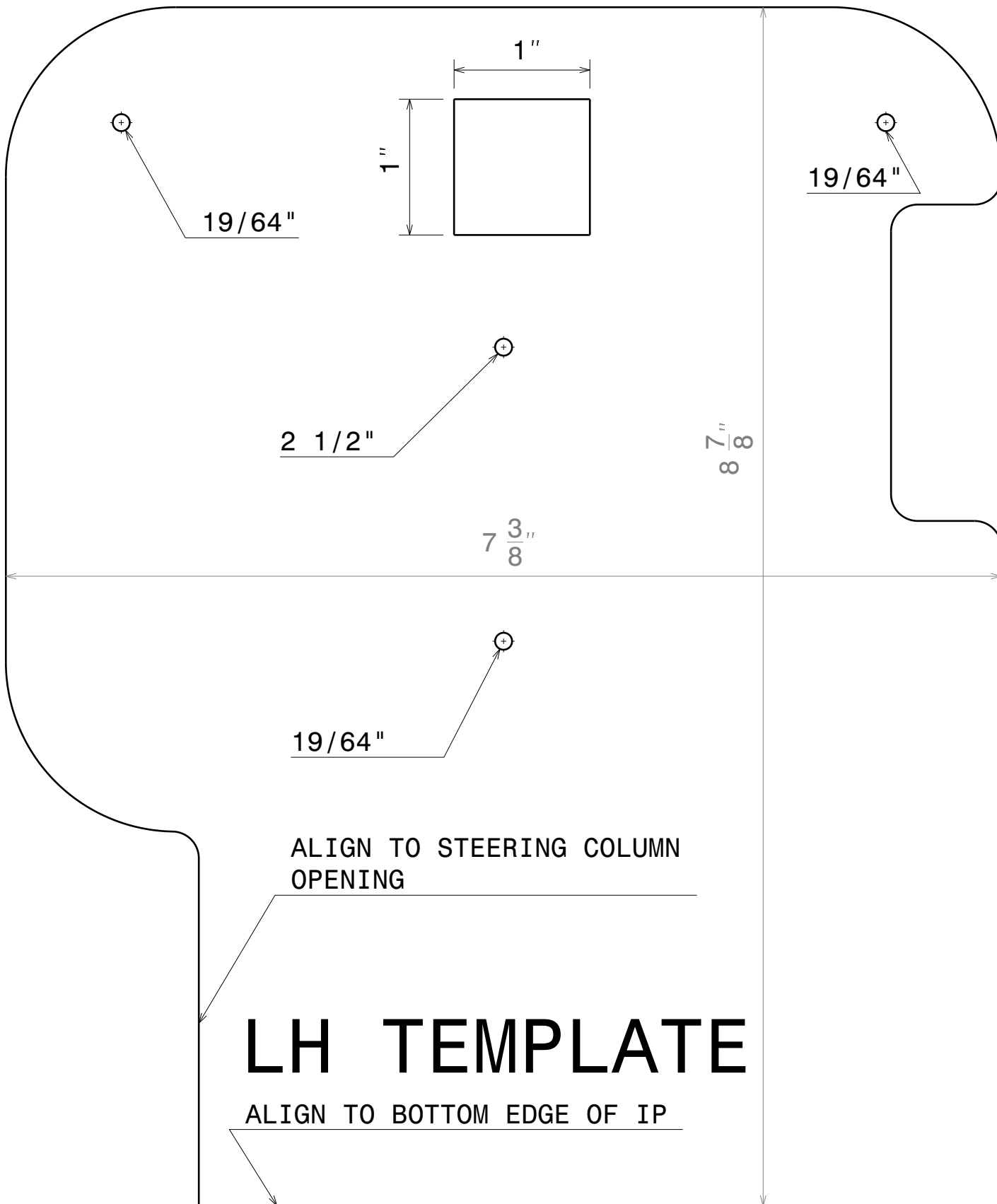
19. Re-install (11) torx screws and torque to specifications.

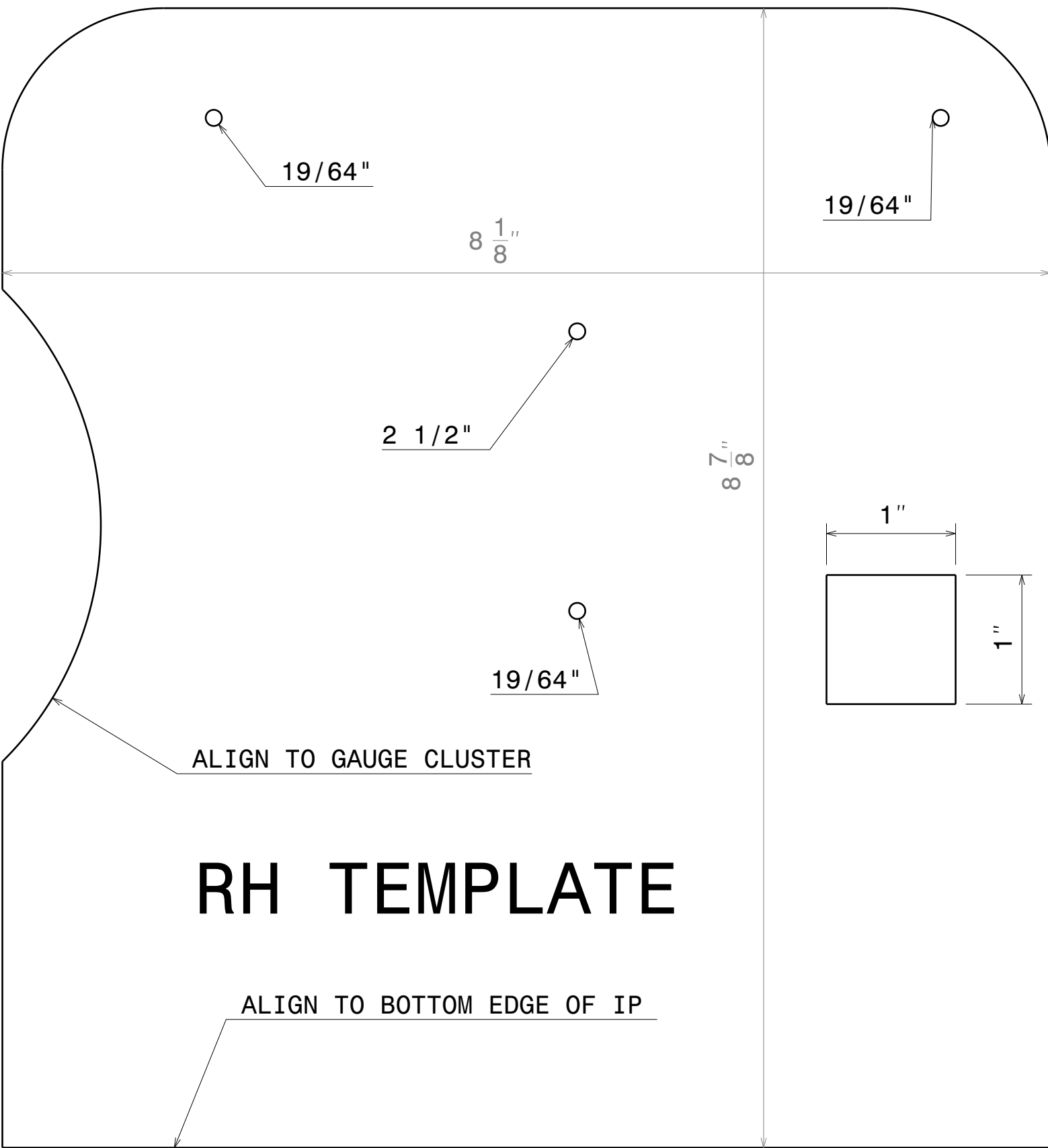
NOTICE You may have to adjust angle of heater to allow IP to fit properly.



20. Install (2) open hose ends into distribution openings. Ridges will keep hoses in place.







RH TEMPLATE