

Aerospool spol. s r. o.

Letisková 10, 971 03 Prievidza
Slovak Republic

Web: www.aerospool.sk

E-mail: aerospool@aerospool.sk

Tel.: +421 46 51 83 200

Fax: +421 46 51 83 250



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**MODIFICATION OF WATER
THERMOSTATS**

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	MODIFICATION OF WATER THERMOSTATS	AS-GDO-00-011E
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0. Document Management

0.1 Amendment Record

Any revision of document must be recorded in following table. Issue, revision and date of revision are indicated in the footer.

Revision	Amendment description	Affected pages	Date
0	First issue	All	16.03.2015
1	Added marking of modified thermostat	7	20.03.2015
2	Added type of thermostats. Formal corrections.	All	02.04.2015

0.2 List of Valid Pages

Page/s	Revision	Date
1 - 6	0	16.03.2015
1 - 7	1	20.03.2015
1 - 7	1	02.04.2015

CONTENT

0.	Document Management	2
0.1	Amendment Record.....	2
0.2	List of Valid Pages	2
1.	Instructions	4

1. Instructions

- a. Loosen the 3 original bolts, which connect thermostat bodies using the hexagon key (3,5 mm). It is necessary to pre-heat the screws before with a hot air gun set to a temperature max. 200 to 250 °C (Fig. 1, Fig. 2). Warning, Do not overheat the rubber sealing in the thermostat. (Fig. 4)!!!

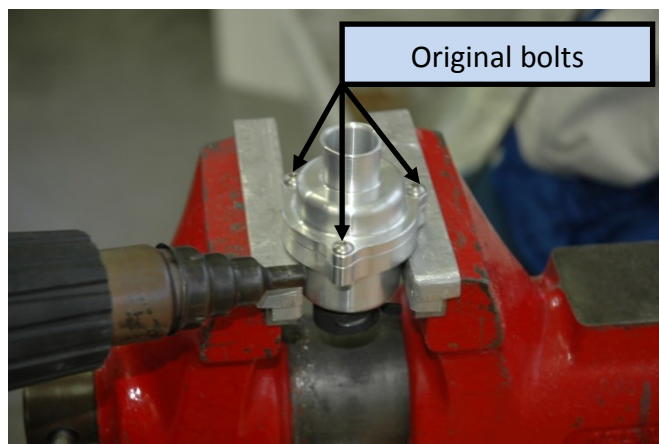


Fig. 1 Direct thermostat (type F1102)

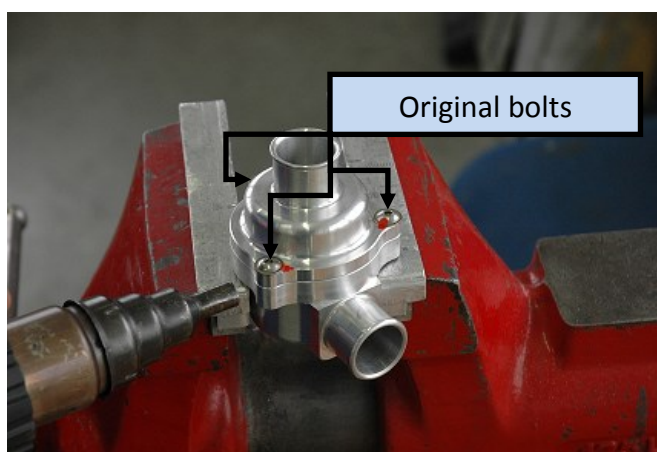


Fig. 2 Thermostat 90° (type F1104)

- b. Disassemble the thermostat (Fig. 3). Thoroughly clear the surfaces using a degrease agent and a dry cloth from the sealing silicone. Use the dry cloth to clean the rubber sealing (Fig. 4).



Fig. 3 (Illustrative)



Fig. 4

- c. Remove the valve from the thermostat body using pliers (Fig. 5 – Fig. 8).

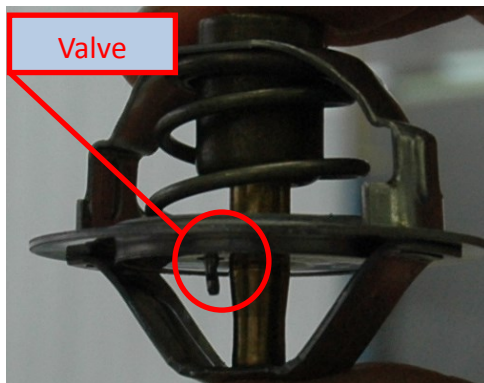


Fig. 5

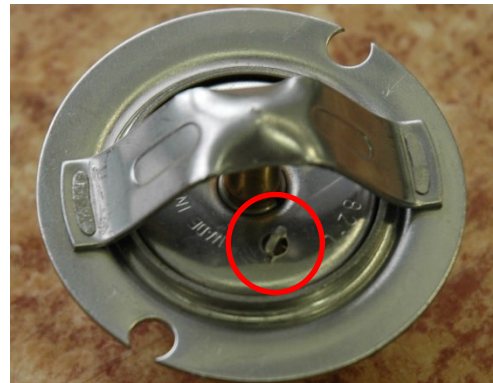


Fig. 6

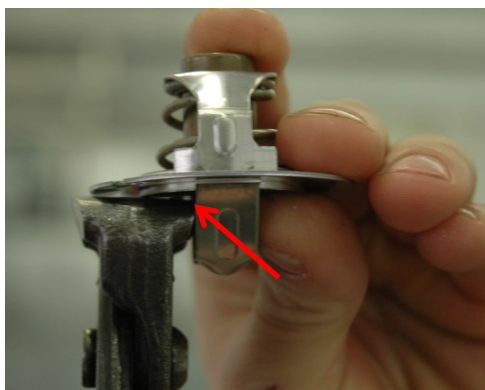


Fig. 7



Fig. 8

- d. After the valve was removed, enlarge the hole to $\varnothing 6$ mm and drill the second hole $\varnothing 6$ mm on the opposite side (Fig. 9, Fig. 10). Smooth the edges of holes. Clean the thermostat body and drilled holes.



Fig. 9

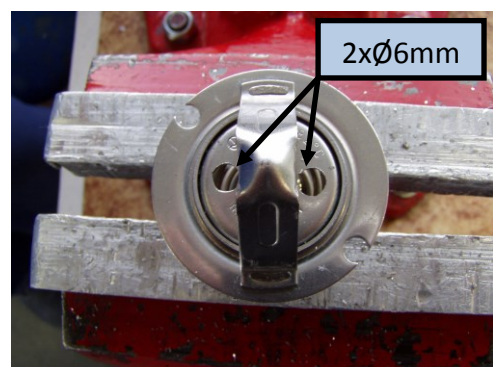


Fig. 10

- e. Clean the threads in threaded part of the thermostat body with a screw-tap M5. Use the cutting oil for this operation (Fig. 11). Degrease the threads with degrease agent.



Fig. 11 (Illustrative)

- f. Apply a fine layer of grease (Vaseline) on the both parts of the thermostat body and the rubber sealing (Fig. 12).



Fig. 12 (Illustrative)

- g. Assemble the thermostat body using new bolts M5x16 (ISO 7380-2 A2) + Loctite 243 and tighten them with 5 Nm (Fig. 13, Fig. 14).



Fig. 13



Fig. 14

h. Mark the modified water thermostat by letter „M“ (minimum height of letter is 3 mm) (Fig. 15, Fig. 16).

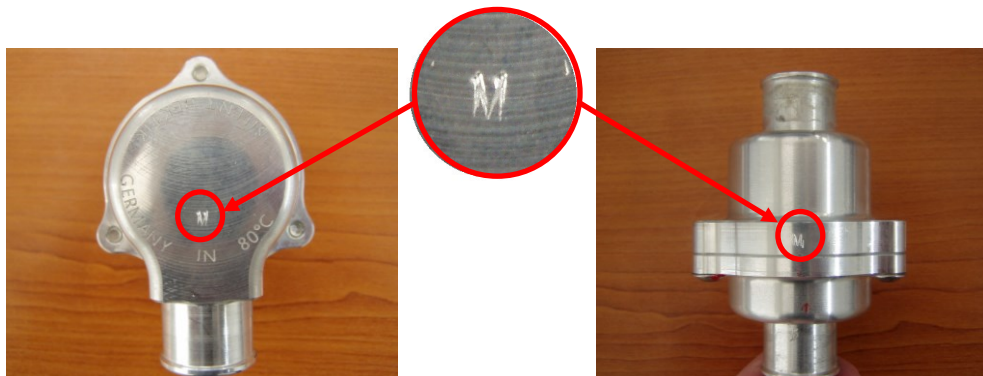


Fig. 15 Thermostat 90° (type F1104)

Fig. 16 Direct thermostat (type F1102)