

Section A-A
IFD - FRONT END DETAIL

Note: Some features removed for clarity

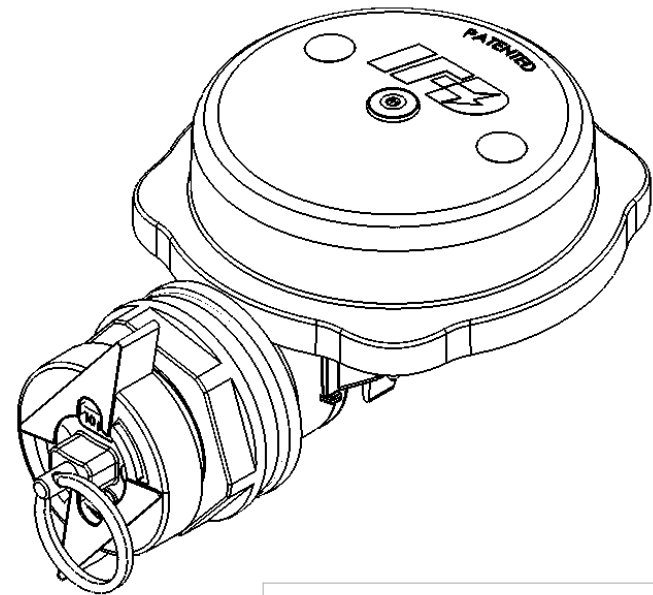


Figure 2

IFD IFD Corporation

TITLE: IFD Orca

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SIZE	PART NO.	REV
A	See IFD price list	0
DRAWN BY: A. Hunsberger		Page 3 of 3

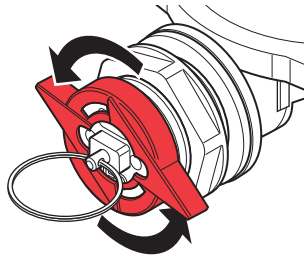
Installing IFD Body and Shipping Lock



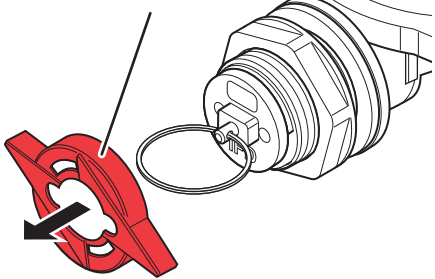
Note: PRD is pre-installed.

Remove Shipping Lock

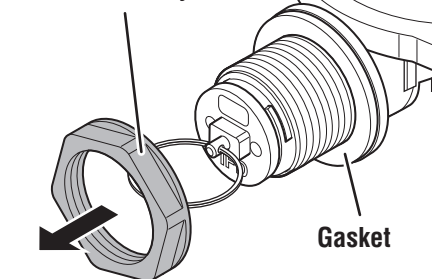
- 1 Turn shipping lock 90° counter-clockwise.



- 2 Remove and retain shipping lock.



- 3 Remove nut. Make sure gasket remains on IFD body.



Gasket

- 4 Insert IFD body into mounting hole with logo side level and facing up.

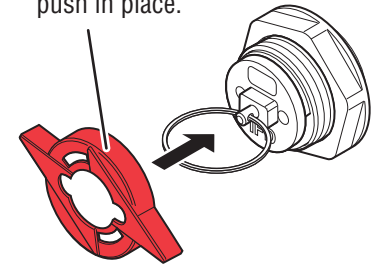
- 5 Install nut and tighten to 90 ± 10 in-lb (10 ± 1 Nm) using a torque wrench.



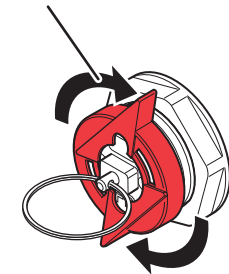
Important: Do not hold IFD while torquing nut. Damage may occur.

Install Shipping Lock

- 6 Insert shipping lock:
 - Line up slot with pull ring.
 - Grasp tabs and push in place.



- 7 Turn tabs 90° clockwise to position tabs vertically.



- 8 Make sure:
 - Tabs are vertical.
 - Shipping lock is fully engaged.