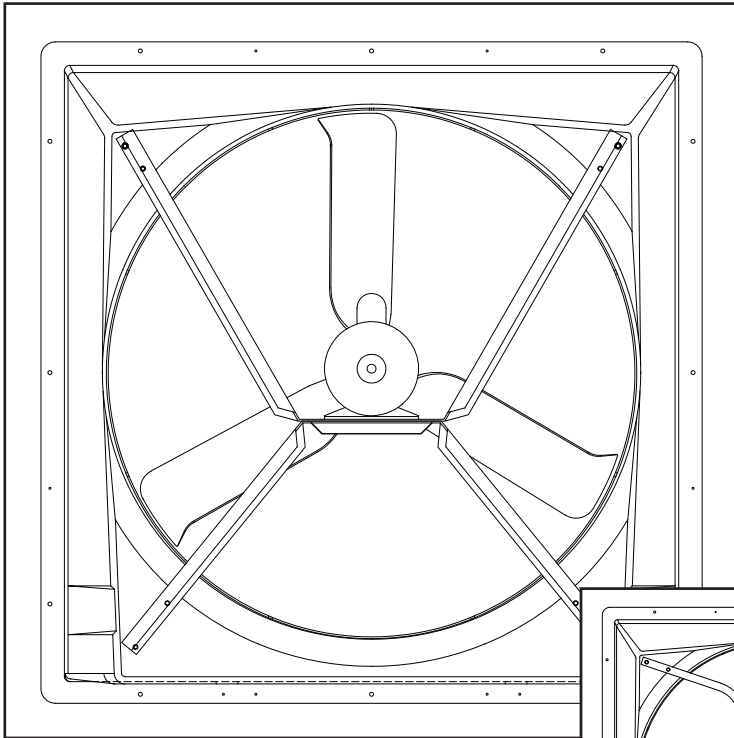
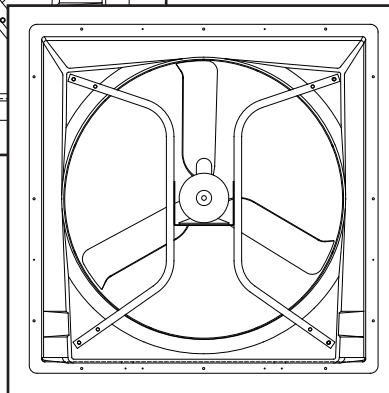


Instruction Manual

Converting 36" AT Direct Drive Fans X-Strut to H-Strut



X-Struts



H-Struts

X-Strut to H-Strut Conversion

36" AT Direct Drive Fans

36" fans built before March 15, 2004

Models: FH1952



X-Strut to H-Strut Conversion 36" AT DD Fans

Instructions for Use and Maintenance

Thank You:

Thank you for purchasing a Munters X-Strut to H-Strut Conversion Kit. Munters equipment is designed to be the highest performing, highest quality equipment you can buy. With the proper installation and maintenance it will provide many years of service.

Please Note:

To achieve maximum performance and insure long life from your Munters product it is essential that it be installed and maintained properly. Please read all instructions carefully before beginning installation.

Warranty:

For Warranty claims information see the "Warranty Claims and Return Policy" form QM1021 available from the Munters Corporation office at 1-800-227-2376 or by e-mail at aghort.info@munters.com.

Conditions and Limitations:

- Products and Systems involved in a warranty claim under the "Warranty Claims and Return Policy" shall have been properly installed, maintained and operated under competent supervision, according to the instructions provided by Munters Corporation.
- Malfunction or failure resulting from misuse, abuse, negligence, alteration, accident or lack of proper installation or maintenance shall not be considered a defect under the Warranty.

Index

Chapters	Page
1. Unpacking the Equipment	4
1.1 Parts List	4
2. Installation Instructions	5-9
2.1 Disassembling the Fan	5
2.2 Pre-assembling the H-Strut Frame	6
2.3 Installing Drive Components and Propeller	9
3. Exploded View and Parts List	10

Unpacking the Equipment

1.

Before beginning installation, check the overall condition of the equipment. Remove packing materials, and examine all components for signs of shipping damage. Any shipping damage is the customer's responsibility and should be reported immediately to your freight carrier.

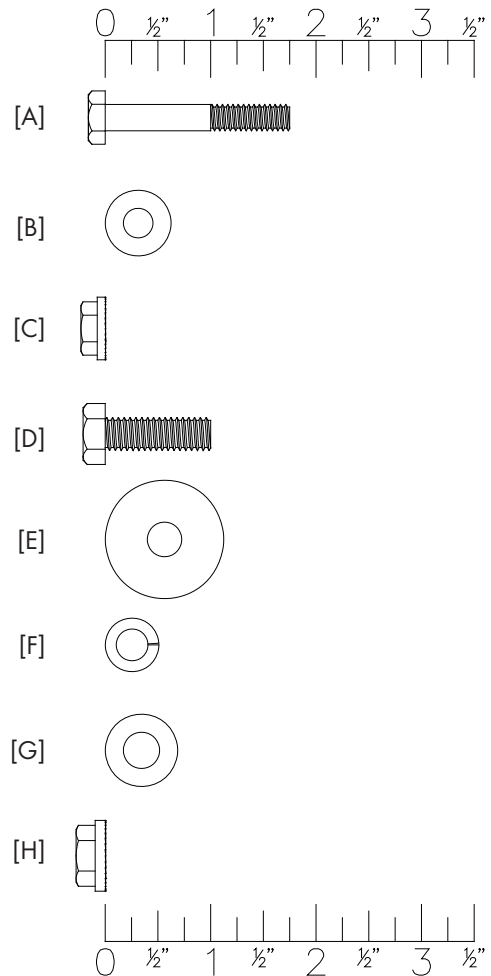
1.1 Parts List

Each Kit includes:

- 1 - Left Tube Strut with Inserts, AL
- 1 - Right Tube Strut with Inserts, AL
- 1 - Motor Base Bracket, CTD-GZ
- 1 - Hardware Package (HP1130) includes:

HP1130 - FH1952 Conversion Kit

ID	Qty.	Cat. No.	Description
[A]	6	KS1006	1/4"-20 x 1.75" Hex Bolt, SS
[B]	6	KW3002	1/4" Type-A Narrow Flat Washer, SS
[C]	6	KN0702	1/4"-20 Serrated Flange Hex Nut, SS
[D]	12	KS1018	5/16"-18 x 1" Hex Bolt, SS
[E]	8	KW3011	5/16" x 1 1/4" OD Flat Washer, SS
[F]	8	KW3504	5/16" Splitlock Washer, SS
[G]	8	KW3004	5/16" Type-A Narrow Flat Washer, SS
[H]	4	KN0704	5/16"-18 Serrated Flange Hex Nut, SS



Installation Instructions

2.

2.1 Disassembling the Fan

Step 1

Remove the shutter or inlet guard from fan. *See Figure 1.*

Step 2

Disconnect electrical power leads from motor. Before removing propeller, place an alignment mark on shaft with a marker. This will be used to reinstall propeller to this location. Take propeller off shaft. Remove motor from struts. *See Figure 2.*

Step 3

Remove the ten (10) fasteners attaching the X-Strut frame to the housing, discard the frame and ten (10) fasteners.

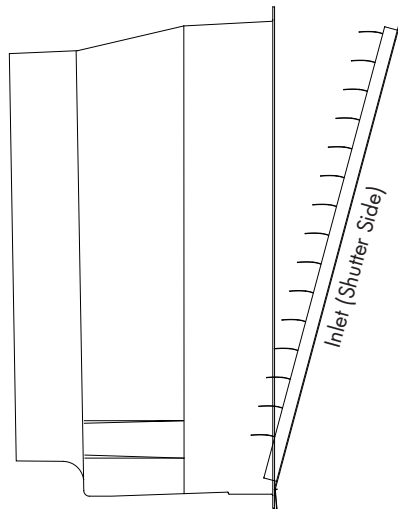


Figure 1

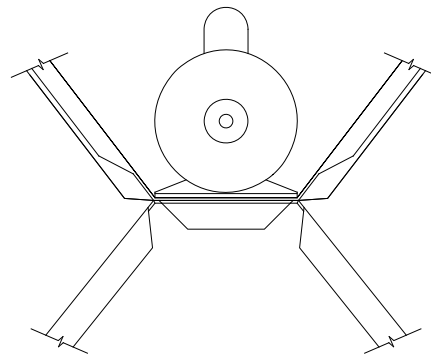


Figure 2

2.2 Pre-assembling the H-Strut Frame

Step 4

Identify/Locate the Left and Right Struts. They can be determined by two steps.

- A) The angle of bend in strut will determine the top/bottom. The larger angle is the top of the strut and the smaller is the bottom. [See Figure 3.](#)
- B) With struts in front of you. The Left strut will have the threaded inserts facing you on the left and the Right strut will have threaded inserts on your right. This is the exhaust side. [See Figure 3.](#)

Step 5

Identify/Locate the Motor Base. The Motor Base has 2 side flanges that will point upward. [See Figure 5.](#)

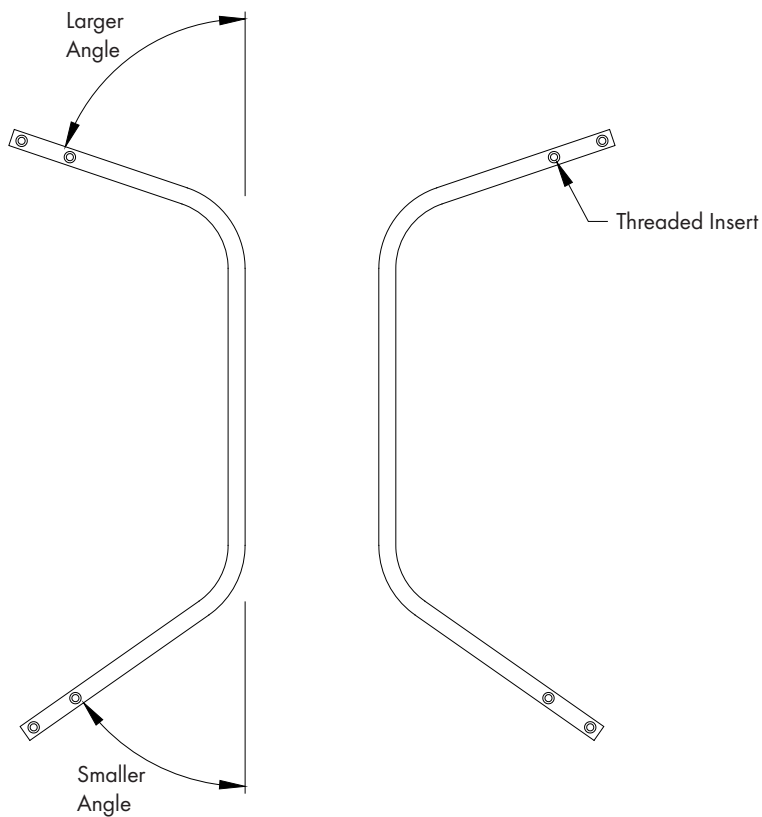


Figure 3

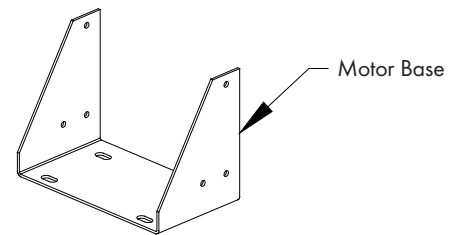


Figure 4

Step 6

With the Struts in front of you (same as Step 4B) fasten the Motor Base to Struts using (6) 1 3/4" Bolts [A], Flat Washer [B] and Flange Nut [C]. The flanges on the Motor Base point upward and the flat edges of the flanges will be on same side as the Threaded Inserts. See Figure 5A and 5B.

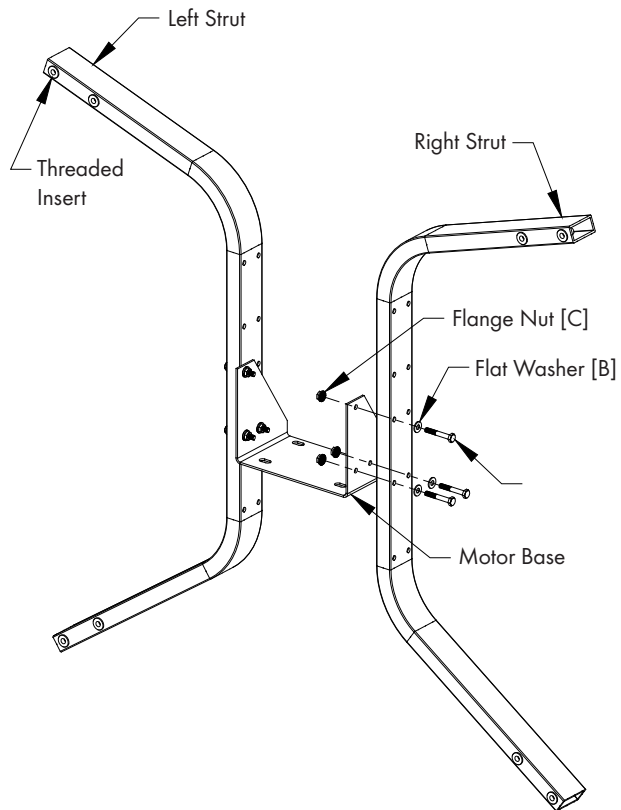


Figure 5A

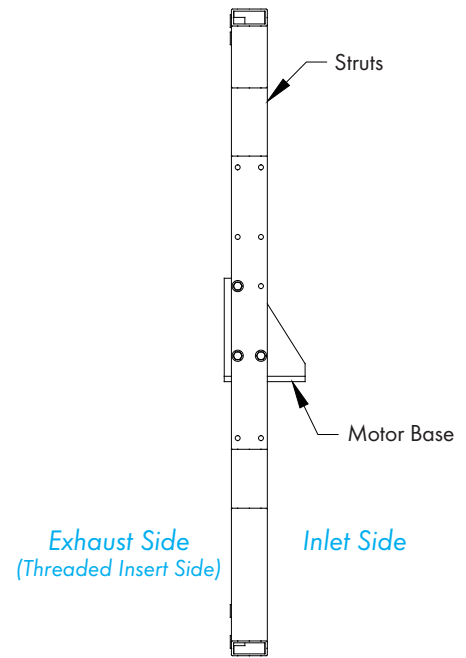


Figure 5B

Step 7

Position assembled H-Strut Assembly into fan housing with the Exhaust Side (threaded inserts) against the housing. *See Figure 6.*

Step 8

Align outermost hole in the top Left Strut to outermost hole in the corner of fan housing and fasten using (1) 1" Bolt [D], Splitlock Washer [F] and Flat Washer [E] from the outside of fan. Be sure Flat Washer [E] is against Fan Housing. Finger tighten only. *See Figure 6.*

Step 9

Repeat Step 8 for other 3 corners of Fan Housing and Strut.

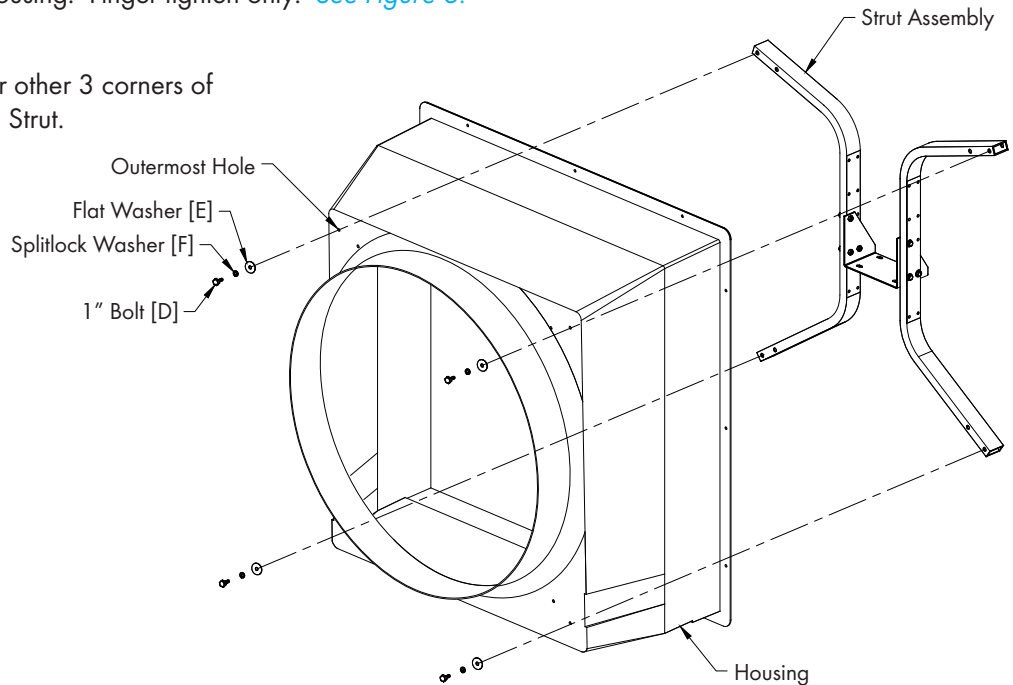


Figure 6

Step 10

From inside of Fan Housing, use a drill and 1/8" bit to drill a pilot hole in each corner of Fan Housing using inner most holes in each strut as a guide. Be sure to center pilot holes. *See Figure 7.*

Step 11

From outside of Fan Housing, drill (4) 1 5/32" holes in Housing using pilot holes from previous step as a guide. *See Figure 8.* Be very careful as to **NOT** drill into Threaded Insert. It is recommended that the bolts installed in outermost holes be loosened or removed to move Strut Assembly away from Housing before drilling.

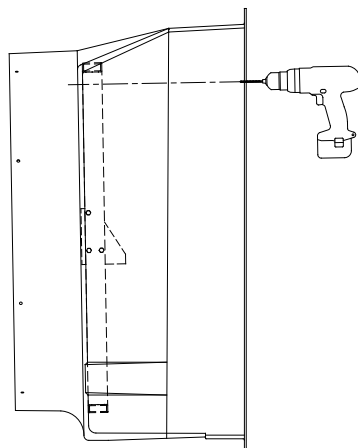


Figure 8
Inside of Housing

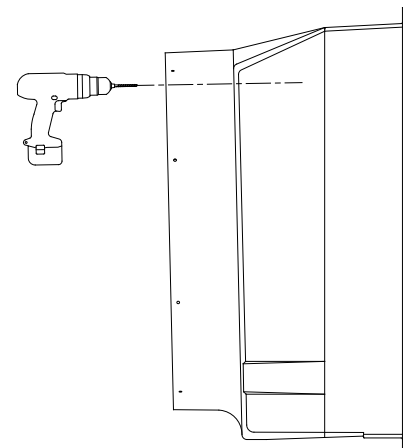


Figure 9
Outside of Housing

Step 12

If Strut Assembly was removed or loosened in Step 11, replace Strut Assembly and tighten fasteners finger tight. In the (4) holes just drilled in housing, secure with (1) 1" Bolt [D], Splitlock Washer [F] and Flat Washer [E], making sure Flat Washer [E] is against Fan Housing and finger tighten.

Step 13

Fully tighten Motor Base bolts first and then tighten the Strut and Housing Bolts.

2.3 Installing Drive Components and Propeller**Step 14**

Install Motor, removed in Step 2, to Motor Base, using (4) 1" Bolts [D], Flat Washers [G] and Flange Nuts [H], insuring the Motor Frame is square with Motor Base. *See Figure 9.*

Step 15

Slide Propeller onto shaft to its original position as marked in Step 4 and tighten set screws to 150 in-lbs. [17 N-m] of torque. Check to be sure Propeller is centered in orifice.

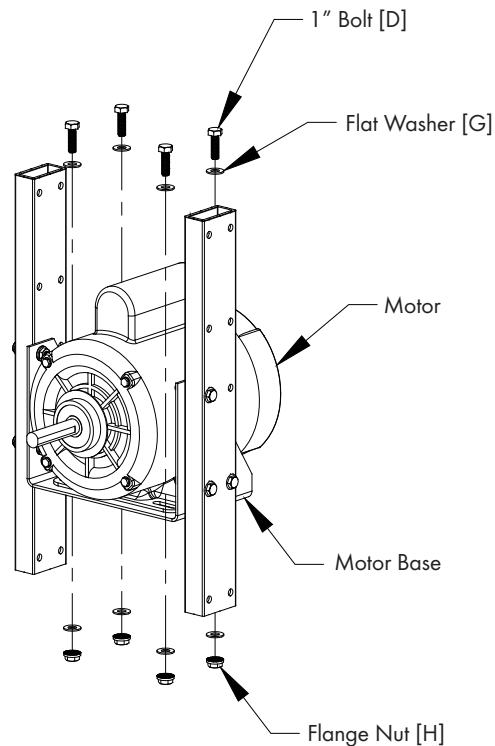
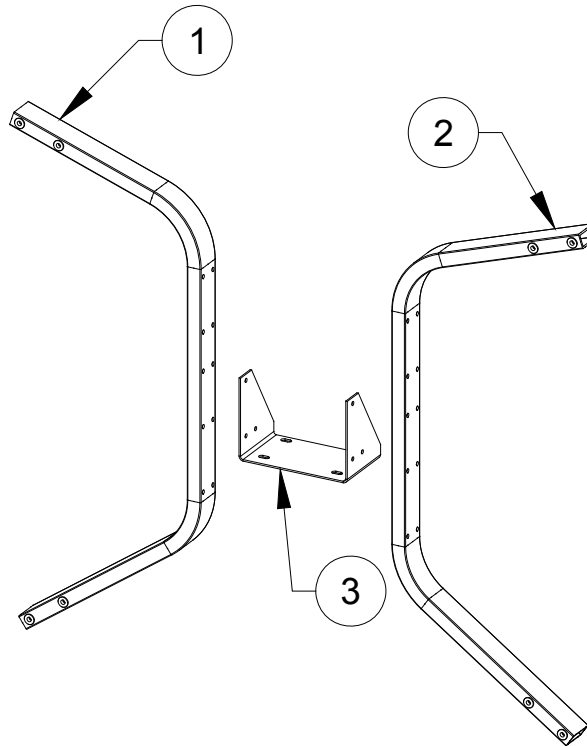


Figure 9

Exploded View and Parts List

3.



Item	Catalog No.		Description	
	VX36 D.D			
1	FH2736		Strut, left, VX, w/inserts, AL	1
2	FH2737		Strut, right, VX, w/inserts, AL	1
3	FH2825		Bracket, DD motor base, coated-galv.	1

36" DD X-Strut to H-Strut Conversion Kit is developed and produced by Munters Corporation, Lansing, Michigan U.S.A. 1-800-227-2376



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