Work Instruction: Install Cabin Heater Kit (4 Hole)
Cabin Heater Kit (P/N-1202BUA00130N)

WORK INSTRUCTION OVERVIEW

**WARNING**

- DO NOT ATTEMPT THIS PROCEDURE IF YOU DO NOT HAVE PROPER TOOLS, TRAINING, AND FACILITIES.
- Read and follow all instructions provided when installing this product. Failure to do so may result in placing occupants at risk of serious injury or death.
- To protect bystanders and the service technician(s), shut vehicle off, remove the Ignition Key and secure vehicle to prevent unintended movement.
- Never operate the vehicle in excess of manufacturer's specifications.

**NOTICE** your ROXOR has one of two different Engine Bay Bulkhead styles, referred to as "4 Hole" and "6 Hole". The installation instructions are different for each. Verify your bulkhead style in Step 1 before drilling any holes.

TOOLS REQUIRED

- 7 mm Drill Bit
- 8 mm Drill Bit
- 12.2 mm Drill Bit
- 32 mm Drill Bit
- 10 mm Socket
- #30 Torx Bit
- Hammer
- Work Light
- Utility Knife
- Magnets or Tape
- Flat Screwdriver
- Small Pry Bar
- Right Angle Drill
- Protective Eye-wear
- Ratchet / Socket Driver
- Torque Wrench (N·m)
- Catch Pan

TORQUE SPECIFICATION

Tighten each fastener to the torque specification below:

- M6 Fasteners (All) – 9.5 N·m (±1.5 N·m)
- Heater Hose Clamps (5/8”) – 7.5 N·m (±0.5 N·m)

CABIN HEATER KIT

<table>
<thead>
<tr>
<th>Kit Component</th>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Heater Assembly</td>
<td>P/N - 1202BUA00011N</td>
<td>1</td>
</tr>
<tr>
<td>Heater Bracket Fasteners</td>
<td>Shipped installed in Heater Assembly</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>Kit Component</th>
<th>Description</th>
<th>Qty</th>
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</thead>
<tbody>
<tr>
<td>Heater Wiring Jumper</td>
<td>Included with Heater Assy.</td>
<td>1</td>
</tr>
<tr>
<td>Cable Ties</td>
<td>Included with Heater Assy.</td>
<td>5</td>
</tr>
<tr>
<td>Heater Hoses</td>
<td>Included with Heater Assy.</td>
<td>2</td>
</tr>
<tr>
<td>Heater Hose Splices</td>
<td>Included with Heater Assy.</td>
<td>2</td>
</tr>
<tr>
<td>Heater Hose Clamps</td>
<td>Included with Heater Assy.</td>
<td>6</td>
</tr>
<tr>
<td>Heater Fan Speed Switch (w/boot)</td>
<td>Included with Heater Assy.</td>
<td>1</td>
</tr>
<tr>
<td>Heater Assembly Brackets P/N - 0101CUA000161N (Right Front)</td>
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<tr>
<td>P/N - 0101CUA000181N (Right Rear)</td>
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<tr>
<td>P/N - 0101CUA000191N (Left Rear)</td>
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<tr>
<td>P/N - 0101CUA000201N (Left Front)</td>
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<tr>
<td>M6 NYLOC Hex Flange Nut P/N - 0000AUA01241N</td>
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<td>Heater Fan Switch P/N - 1803AUA00061N</td>
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<td>Engine Bay Grommets P/N - 0101DUA00991N</td>
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<td>J-Nuts P/N - 0000AUA00411N</td>
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<td>J-Nut Fasteners P/N - 0000AUA00061N</td>
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<tr>
<td>Dash Panel Drill Template P/N - 1202BUA00101N</td>
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<tr>
<td>IP Drill Template P/N - 1202BUA00111N</td>
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INSTALLATION PROCEDURE

1. The following instructions should be used on the 4 hole Engine Bay Bulkhead configuration shown below.

2. Remove (2) right side stock Engine Bay Grommets to use for alignment of Dash Panel Drill Template.

   **CAUTION** Verify wires and wiring harnesses are clear of the drilling area by also placing this template on the engine bay side. Limit the drill penetration distance into the engine bay, unintended damage to vehicle wiring or other components will void your warranty coverage.

3. Use magnets or tape to hold the Dash Panel Drill Template in place while marking and drilling. It is best to use a small pilot drill with this template.

4. Using a right angle drill, install (2) 32 mm holes and (4) 8 mm holes in the locations marked.

5. Using IP Drill Template provided, mark and drill (2) 7 mm and (1) 12.2 mm holes through Instrument Panel for rear Heater Brackets and Switch.

6. Use a deburring tool on both sides of all holes to remove sharp edges. A magnet placed under the hole will help catch metal shavings.

   **NOTICE** To prevent premature rusting of the body, apply paint or other suitable rust inhibitor to all holes drilled for this installation.
7. Sub-assemble Heater as shown. Leave rear brackets loose, torque hose clamps to specifications.

8. Install (2) Engine Bay Grommets into the 32 mm holes drilled earlier. Install (2) front Heater Brackets thru engine bay.

9. Loosely install (4) nuts to front Heater Brackets on engine side.

10. Install sub-assembled Heater into position, with fan up. Lubricate hoses to help installation.

11. Loosely secure Heater to (2) front brackets.

12. Align rear bracket holes to dash panel and install (2) J-Nut fasteners and torque to specifications.


15. Torque (4) front Heater Bracket nuts to specifications.

16. Cut existing Heater hose in two spots, behind Valve Cover Hose Retainer (marked with yellow lines).

**NOTICE**

Place a catch container under hose before cutting or lower coolant level in the radiator.

17. Use (2) Heater Hose Splices and (4) Heater Hose Clamps to complete the heater to cooling system tie in. Tighten hose clamps to specifications and push hoses back into retainer.

18. If your ROXOR is **NOT** equipped with a ROPS Accessory Harness. Disconnect the standard Accessory Harness from the protective cap, located behind the Dash Panel on the passenger side.

19. Connect standard Accessory Harness to Jumper Harness as shown.

20. Connect Jumper Harness back to protective cap as shown.
21. If your ROXOR is equipped with a ROPS Accessory Harness. Disconnect at red arrow and install Jumper Harness between these two connectors. In this case nothing will be reconnected to protective cap.

22. Connect (3) wires to Blower Motor Speed Switch as shown, then install switch thru Dash Panel and secure.

23. Connect long end of Jumper Harness to Heater Assembly connector. Route the Jumper Harness with Instrument Panel Harness and secure with cable ties as required.

24. Locate the harness labeled "Side/Rear LED" or "Accessory #2" behind the left side Dash Panel. Leave harness connected to switch blank and remove tabs to make switch blank easier to remove.

25. Pull harness thru Dash Panel before removing the switch blank.

26. Install (1) Fan Switch to harness and test fan operation, then install Fan Switch into the Dash Panel with fan icon up as shown.

27. Top off engine coolant level before testing the full system. It may be necessary to run the engine for a few minutes to remove any air pockets in the cooling system.