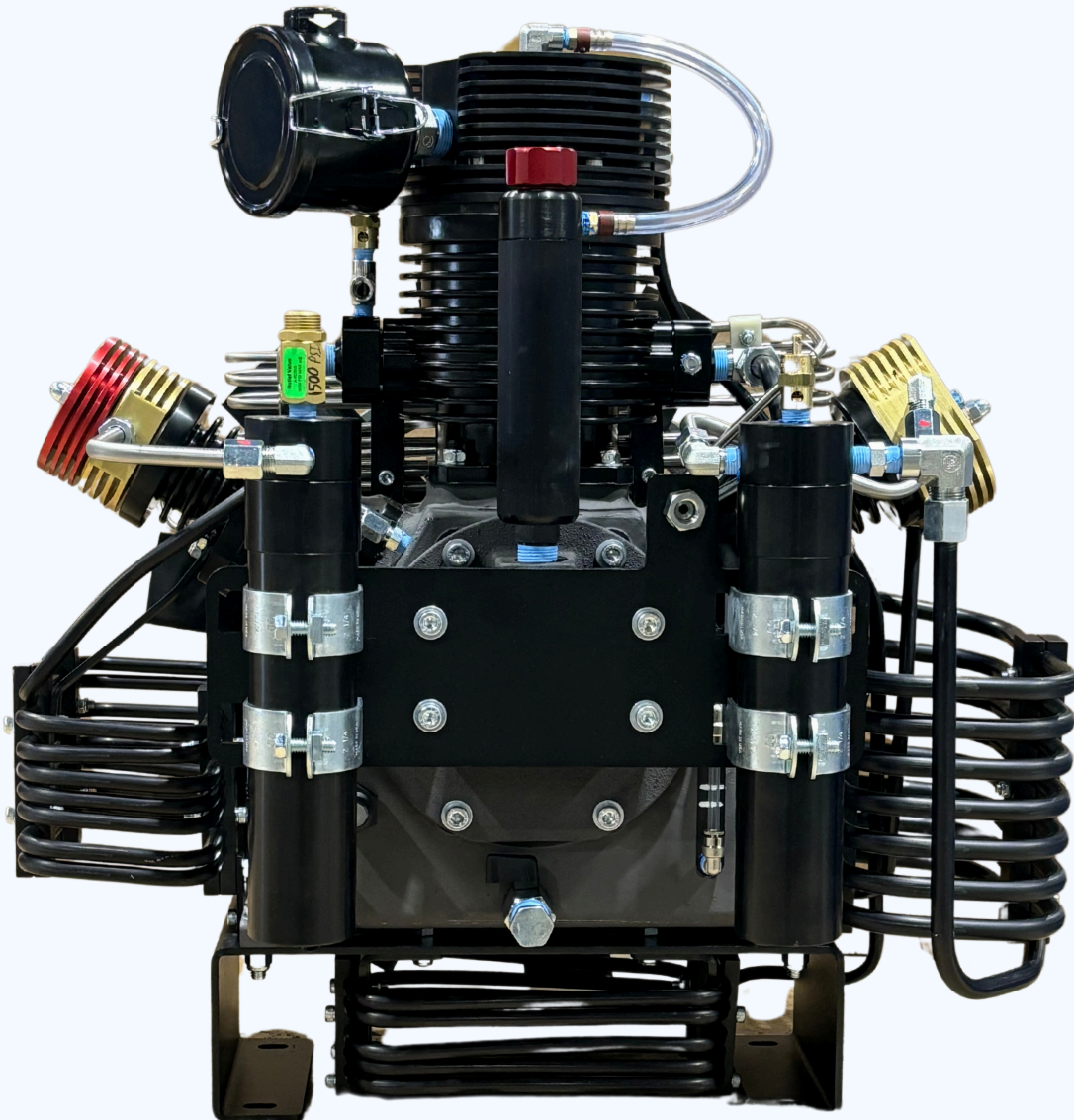
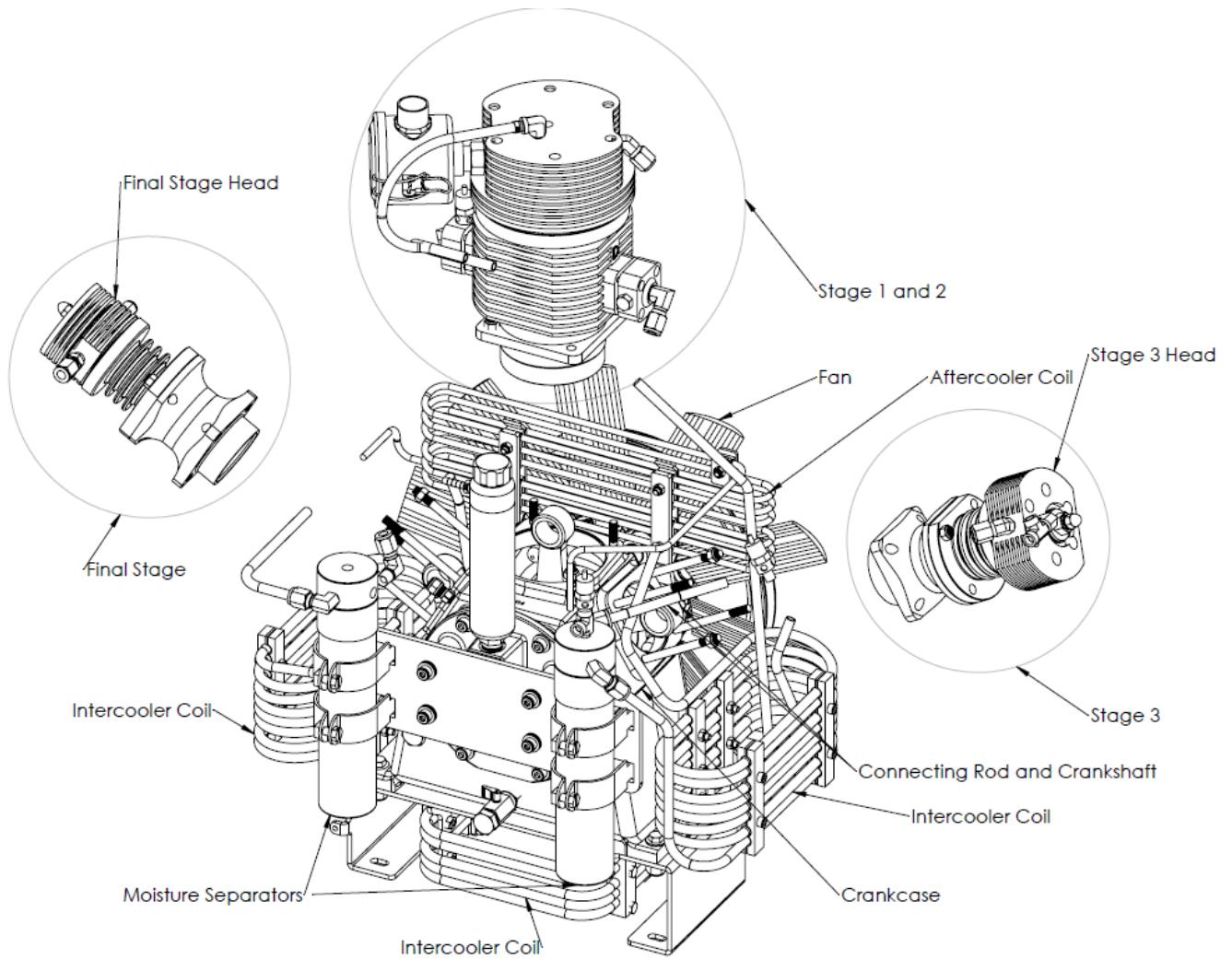




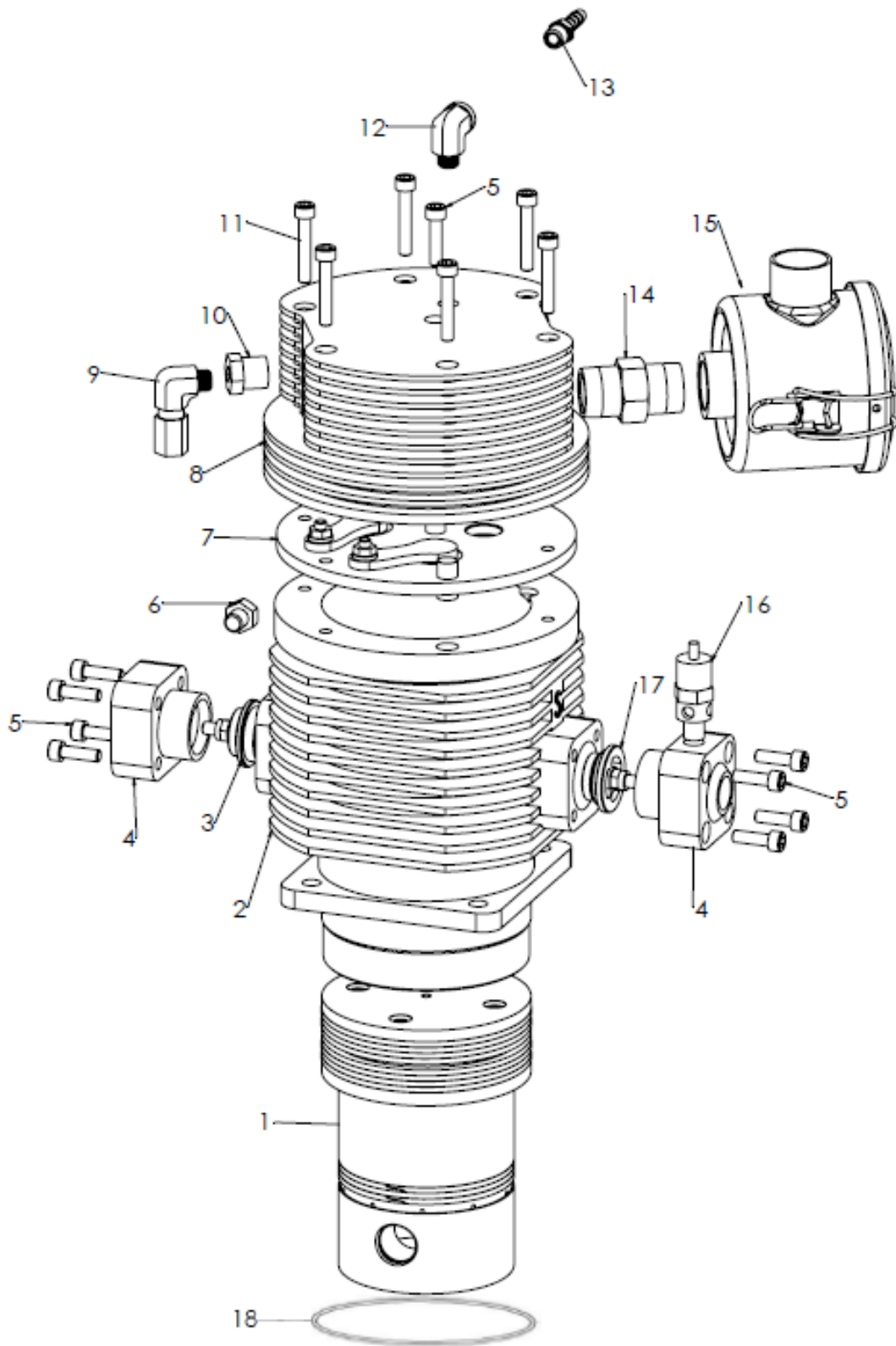
Arctic 1500 Compressor Block Parts Manual





First and Second Stage Assembly	
First and Second Stage Piston Assembly	
Third Stage Assembly	
Third Stage Head Assembly	
Final Stage Assembly	
Final Stage Head Assembly	
Crankshaft and Connecting Rods Assembly	
Crankcase Assembly	
Cooling System Assembly	
Fan Assembly	
Moisture Separator Assembly	

First and Second Stage



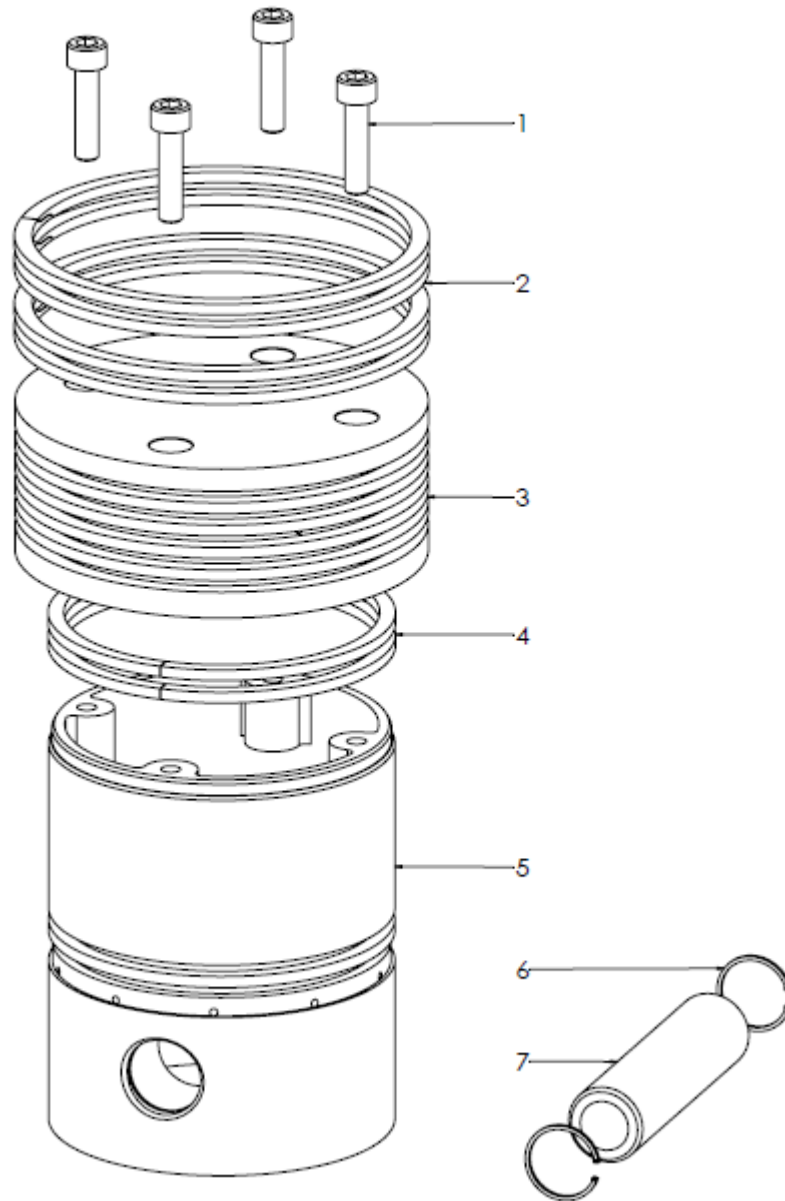
Parts table on next page



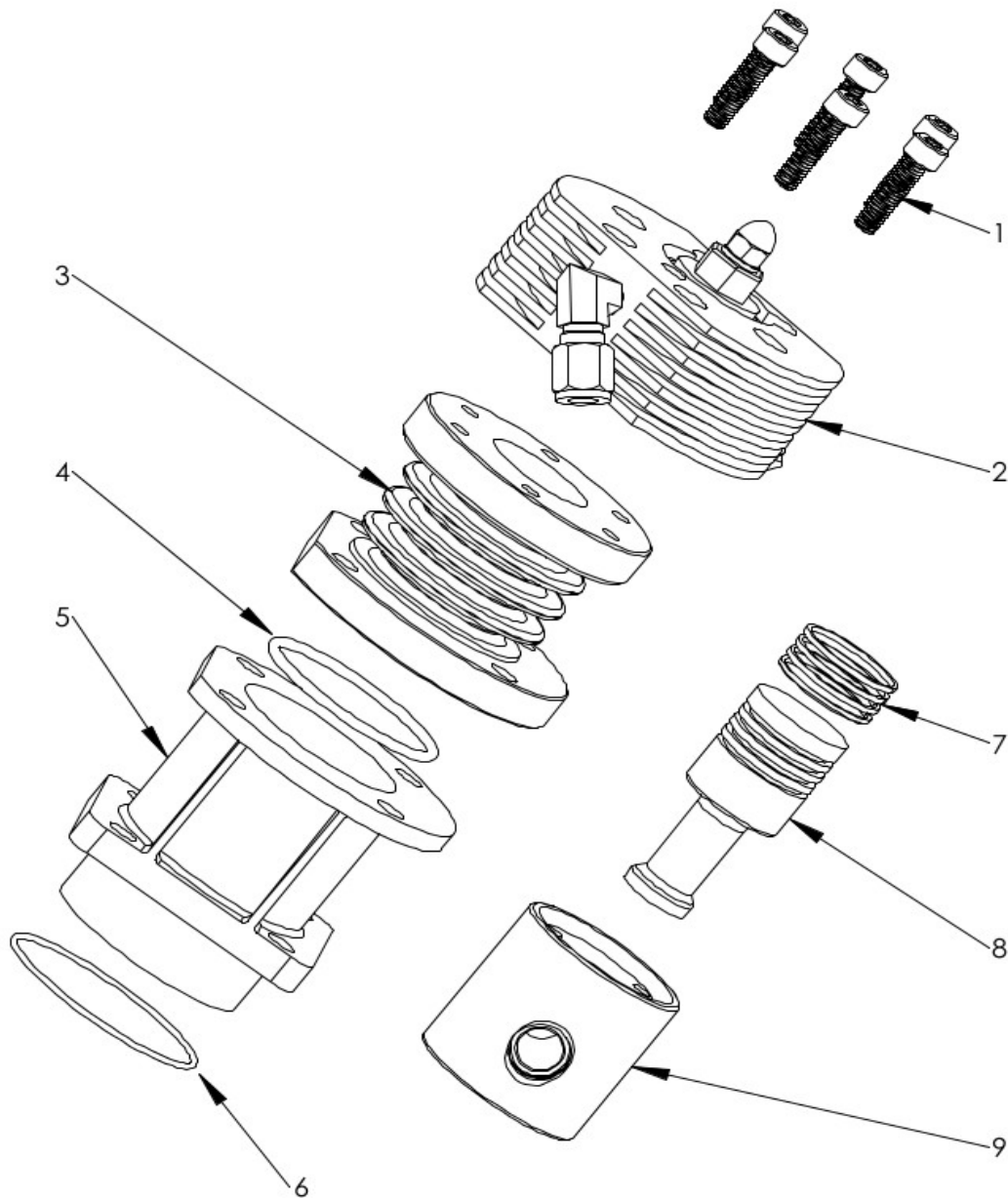
First and Second Stage

Reference #	Part number	Description	Qty
1		First/Second Stage Piston Assembly	1
2	P-1010105	1st / 2nd Stage Cylinder	1
3	P-1525104	2nd Stage Discharge Valve	1
4	P-2010117	2nd Stage Valve Cover	2
5	P-2560109	M6 x 25 SHCS	9
6	F-02502	1/8 NPT Hex Plug	1
7	P-1515501	1st Stage Valve	1
8	P-2010115	1st Stage Head	1
9	F-01252	¼ MNPT x 3/8 MNPT 90° elbow	1
10	F-011521	3/8 MNPT x ¼ FNPT Bushing	1
11	P-2560113	M6 x 40 SHCS	6
12	F-02210	1/8 MNPT x 1/8 FNPT 90° elbow	1
13	F-B-02162	1/8 MNPT x ¼ hose barb brass	1
14	F-25110	¾ NPT Hex Nipple	1
15	P-5520101	Air Intake Housing	1
16	A-R2018	Relief Valve- 150 PSI	1
17	P-1525103	2nd Stage Suction Valve	1

First and Second Piston Assembly

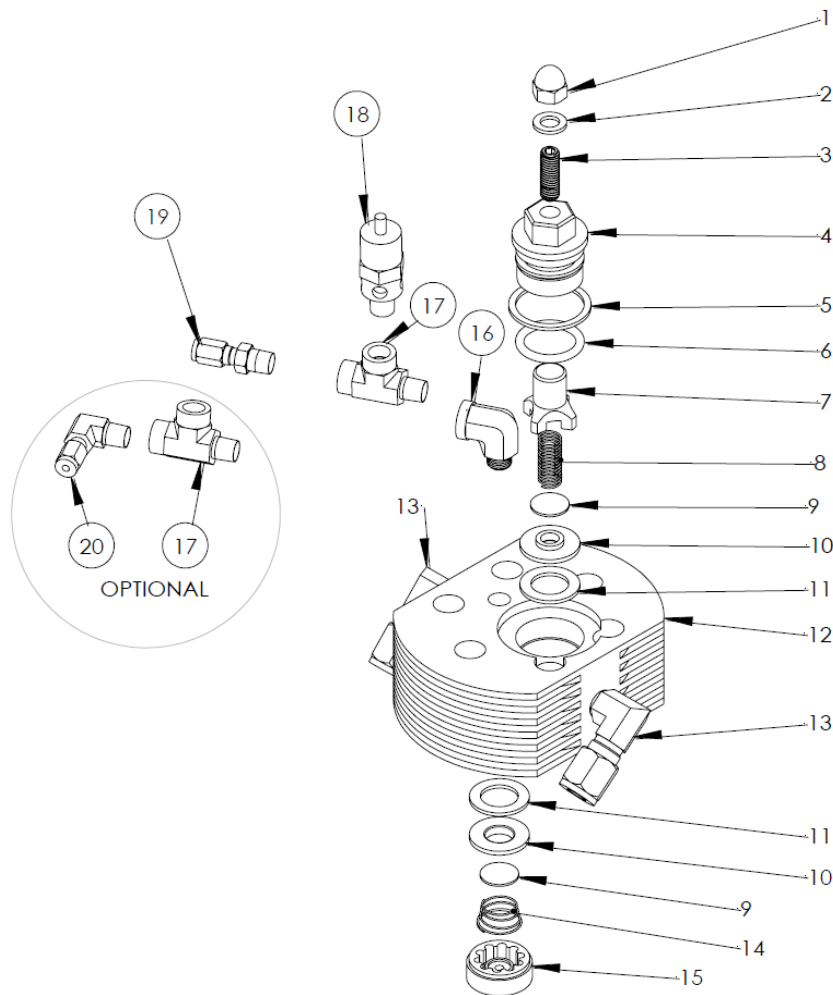


Reference #	Part number	Description	Qty
1	P-2560111	M6 x 45 SHCS	4
2	P-3530701	105mm Piston ring set	4
3	P-3520111	Piston top 105mm	1
4	P-3530703	88mm Piston ring set	1
5	P-3520110	Piston Bottom 88mm	1
6	P-2510215	20mm Internal Snap ring	2
7	P-3055279	78mm Wrist pin	1

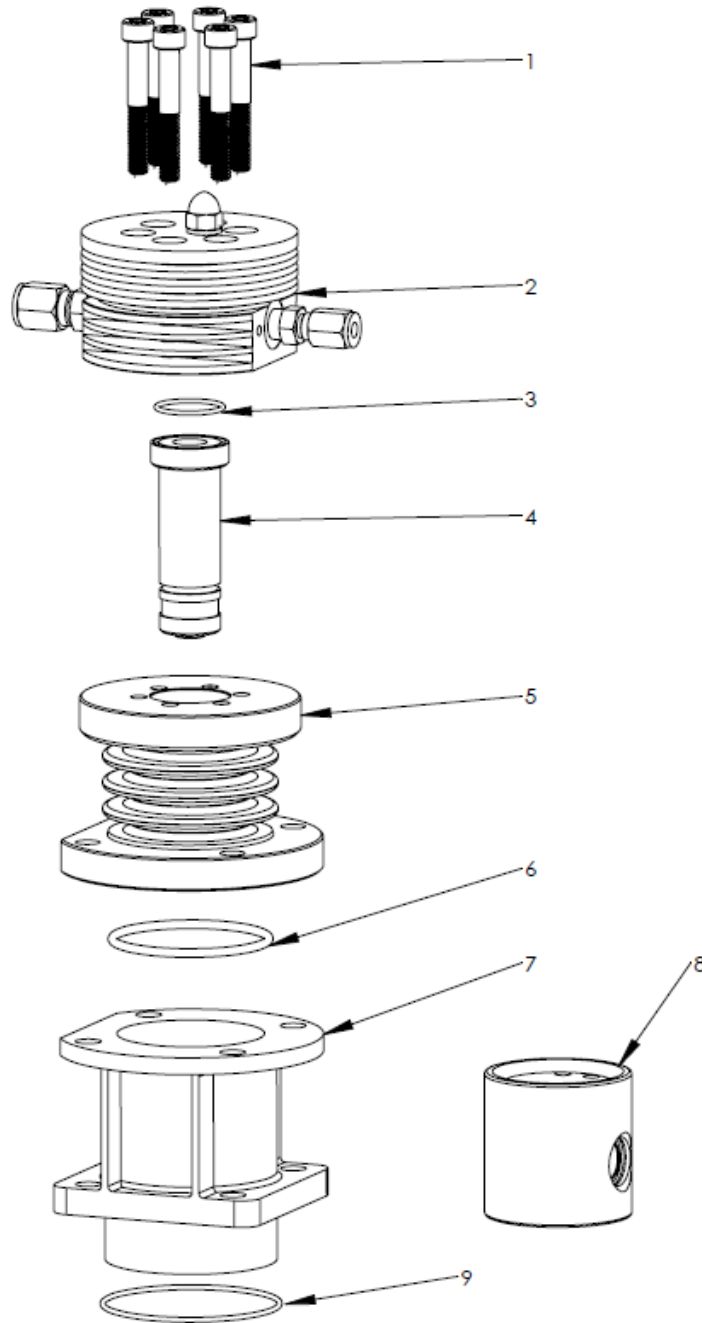


Reference #	Part number	Description	Qty
1	P-2560103	M8 x 30 Socket Head Cap Screw	6
2	P-20190153	Stage 3 Head Assembly (see next page)	1
3	P-1010112	28 mm Cylinder	1
4	OR-V142	Cylinder O-ring	1
5	P-1010102	Guide Cylinder	1
6	OR-BH2X70	Guide Cylinder O-ring	1
7	P-3530302	28 mm Ring Set	1
8	P-3520106	28 mm Piston	1
9	P-3520103	Guide Piston (with pin and clips)	1

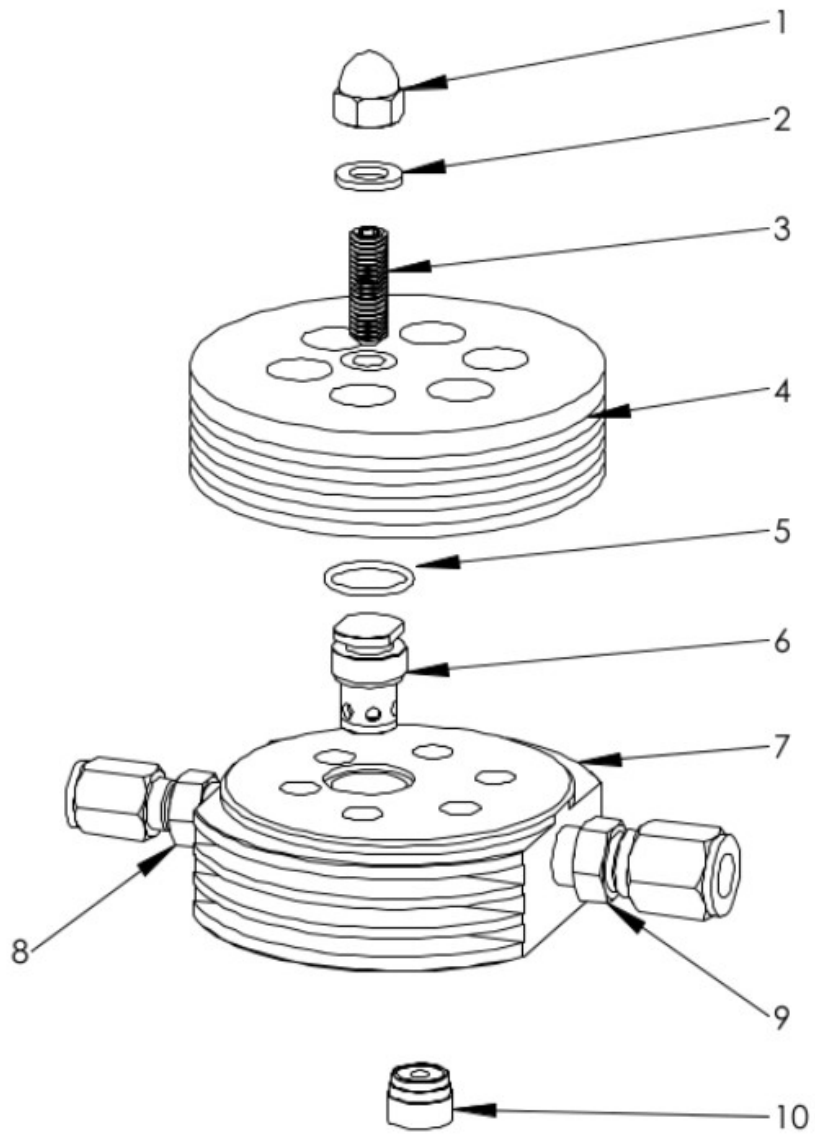
Third Stage Head



Reference #	Part number	Description	Qty
1	P-2530101	M8 Acorn Nut	1
2	P-4030101	M8 Copper Washer	1
3	P-2550101	M8 Set Screw	1
4	P-1540101	3rd Stage Exhaust Valve body	1
5	P-1510101	Steel Washer	1
6	OR-V212	O-Ring	1
7	P-1540102	Exhaust Valve Hold Down	1
8	P-1530101	Exhaust Valve Spring	1
9	P-1545101	3rd Stage Valve Disc	2
10	P-1550101	3rd Stage Exhaust Valve Seat	2
11	P-4030102	Copper Seal	2
12	P-2010102	3rd Stage Head	1
13	F-01252	1/4" MNPT x 3/8" Tube Elbow	1
14	P-1530102	Intake Valve Spring	1
15	P-1540103	Intake Valve Body	1
16	F-02210	1/8" Street Elbow	1
17	F-02410	1/8" T Fitting	1
18	A-R2015	Relief Valve	1
19	F-B-02150	1/8" Tube to 1/8" NPT Male Fitting	1
20	F-B-02250	1/8" NPT Male to 1/8" Tube Elbow	1

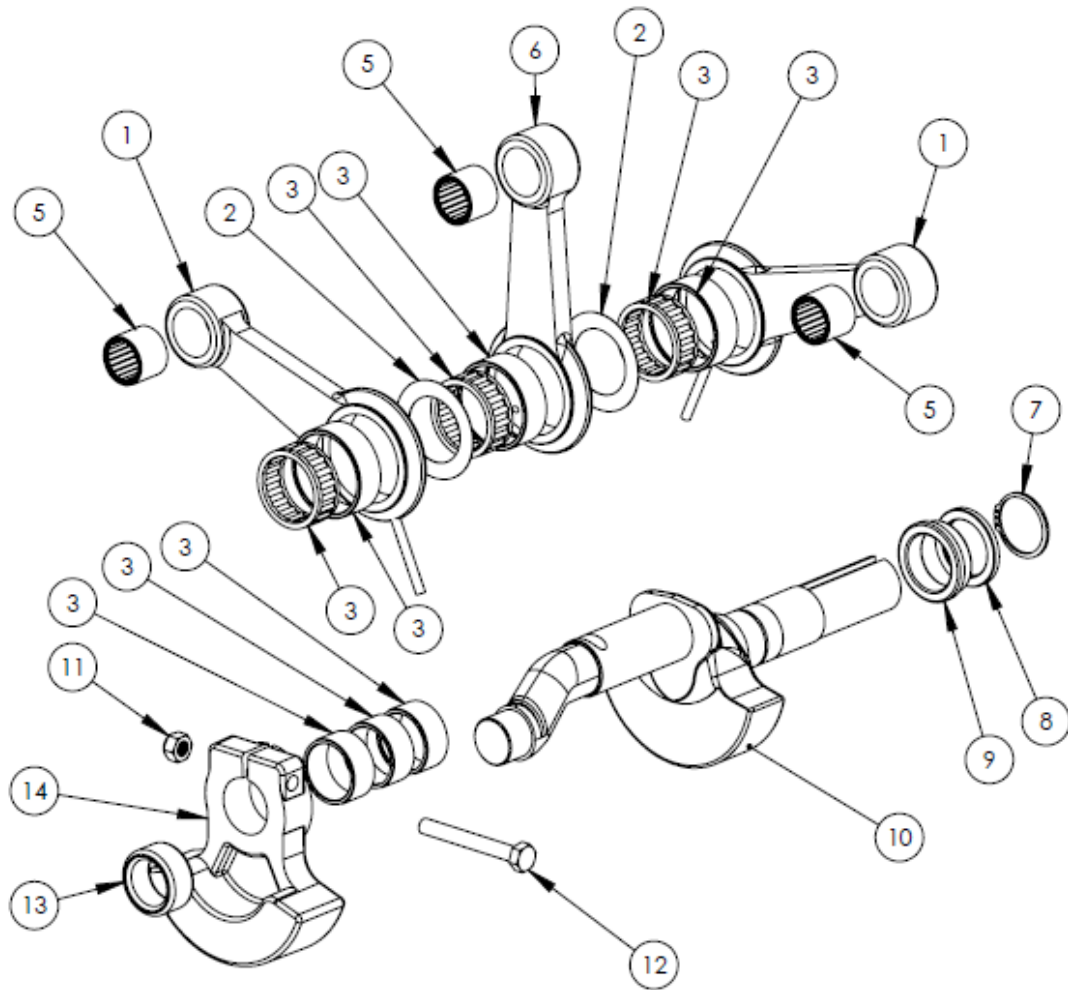


Reference #	Part number	Description	Qty
1	P-2560102	M8 x 55 Socket Head Cap Screw	6
2	P-2090104	Final Stage Head (see next page)	1
3	OR-V022-90	O-Ring	1
4	P-3520162	Final Piston and Sleeve (12 mm)	1
5	P-1010106	Final Cylinder	1
6	OR-V142	Cylinder O-ring	1
7	P-1010103	Guide Cylinder	1
8	P-3520103	Guide Piston (with pin and clips)	1
9	OR-BH2X70	Guide Cylinder O-ring	1



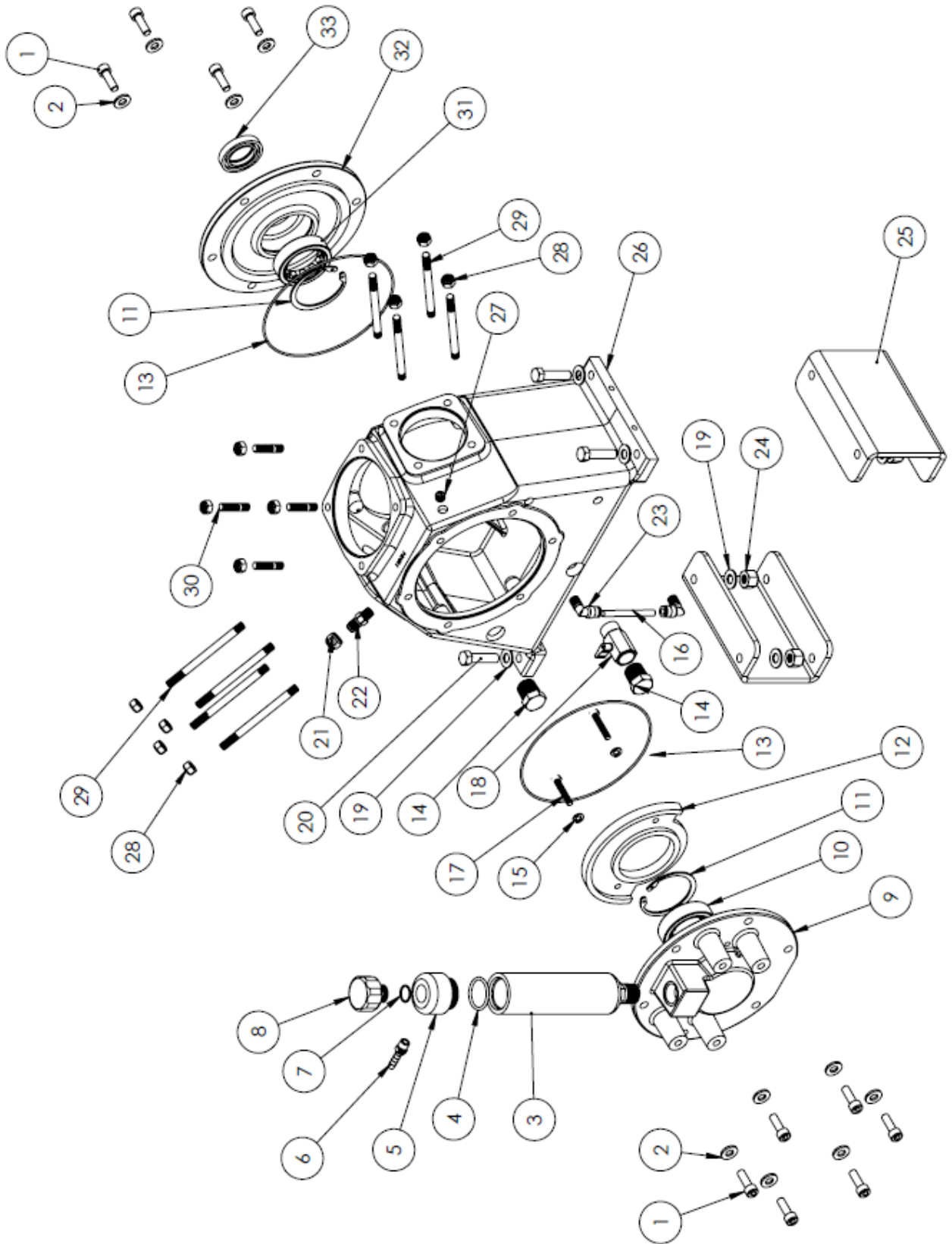
Reference #	Part number	Description	Qty
1	P-2530101	Acorn Nut	1
2	P-4030101	M8 Copper Washer	1
3	P-2550101	Set Screw	1
4	P-2020161	Head Cap (Red)	1
5	OR-V016-90	Final Valve O-ring	1
6	P-1525101	Final Exhaust Valve	1
7	P-2010103	Final Head	1
8	F-01150	1/4" MNPT x 1/4" Tube	1
9	F-011511	1/4" MNPT x 3/8" Tube	1
10	P-1525102	Final Intake Valve	1

Crankshaft Assembly



Reference #	Part #	Description	Qty
1	P-3050101	Connecting rod with splasher	2
2	P-3010101	Shim	2
3	P-3060101	Needle Cage	3
		Outer race	
		Inner Race	
5	P-3060102	Needle Bearing (pin)	3
6	P-3050102	Connecting Rod (without splasher)	1
7	P-2510251	Snap clip	1
8	P-3060103	Spacer (purchased with part 31 in crankcase assembly)	1
9		Inner Race (purchased with part 31 in crankcase assembly)	
10	P-3040101	Crankshaft	1
11	P-2530202	M8 Nylon Insert Lock Nut	1
12	P-2570201	M8×65 Hex Head Bolt	1
13	P-3060104	Inner Race (purchased with part 10 in crankcase assembly)	1
14	P-3010102	Counterweight	1

Crankcase



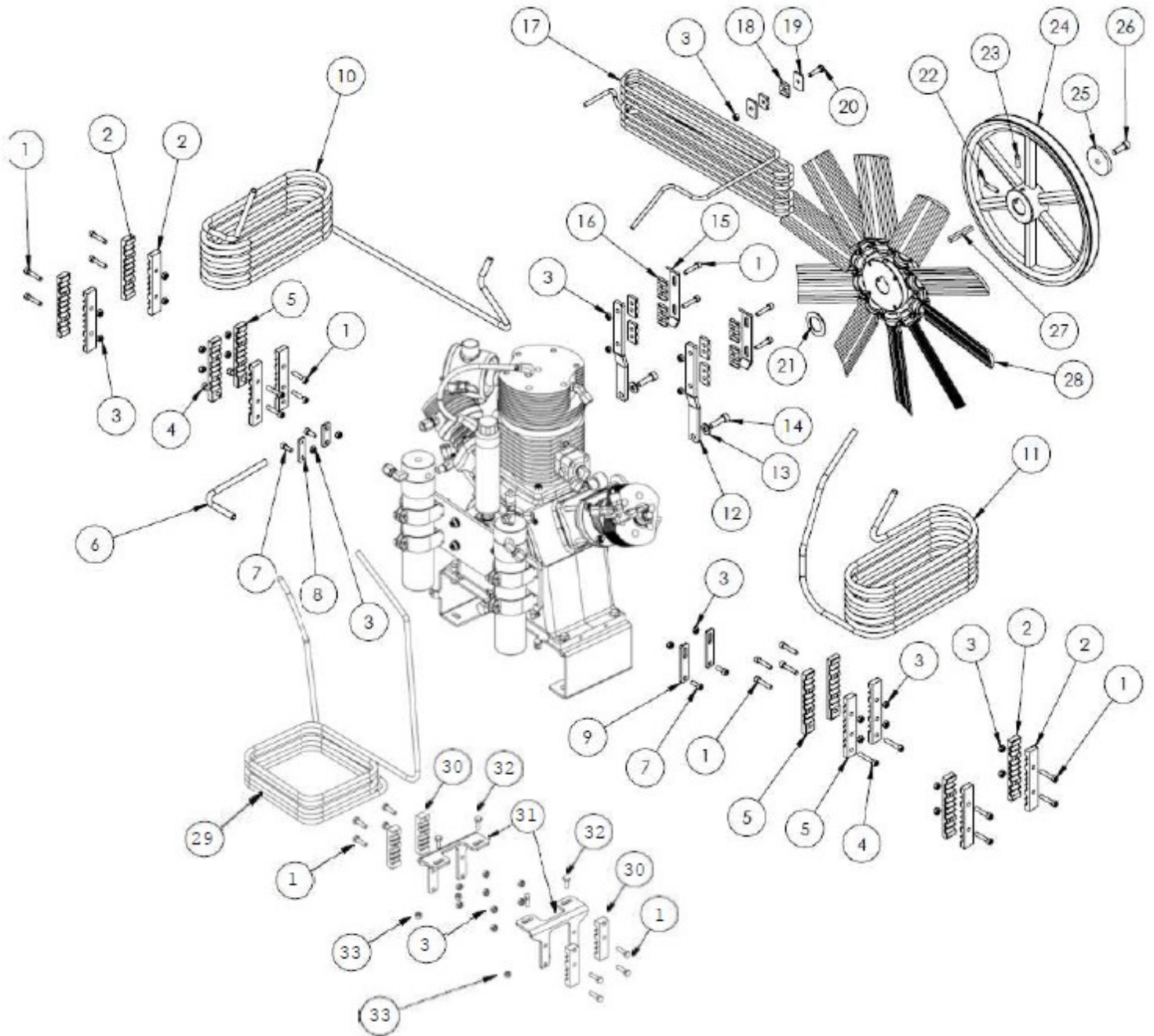
Parts table on next page



Crankcase

Reference #	Part #	Description	Qty
1	P-2560105	M8X25 SHCS	10
2	P-2520101	M8 WASHER	10
3	P-3010106	OIL TUBE	1
4	OR-B916-90	O-RING -916 BUNA 90DUR	1
5	P-3010107	OIL TUBE TOP	1
6	F-B-02162	1/4" HOSE BARB X 1/8" MNPT	1
7	OR-V016	O-RING -016 VITON 75DUR	1
8	P-3010105	OIL FILL CAP	1
9	P-3030101	CRANKCASE COVER	1
10	P-3060104	CASE COVER BEARING (OUTER RACE AND ROLLER SHOWN) (INNER RACE SHOWN WITH CRANKSHAFT ON PAGE 7)	1
11	P-2510201	SNAP RING	2
12	P-3010208	BAFFLE PLATE	1
13	OR-BH2X150	O-RING H2X150 BUNA 70DUR	2
14	F-09510	1/2" PLUG	2
15	P-2520301	M6 SPLIT LOCK WASHER	2
16	P-3010108	SIGHT GLASS TUBE	1
17	P-2560109	M6X 25 SHCS	2
18	F-09160	1/2" BALL VALVE	1
19	P-2520102	3/8" FLAT WASHER	8
20	P-2570203	3/8"X1.5" HHCS	4
21	F-03560	#4 JIC CAP	1
22	F-02131	#4 JIC MALE X 1/8" MNPT	1
23	F-02252	SIGHT GLASS FITTING	2
24	P-2530302	3/8" NYLON INSERT LOCK NUT	4
25	P-3010207	CRANKCASE RISER	2
26	P-3020101	CRANKCASE	1
27	F-02502	1/8" HH PIPE PLUG	1
28	P-2530202	M8 NYLON INSERT LOCK NUT	12
29	P-2540101	DIN 939 X 95MM STUD	8
30	P-2540102	DIN 939 X 25MM STUD	4
31	P-3060103	CASE COVER BEARING (OUTER RACE AND ROLLER SHOWN) (INNER RACE SHOWN WITH CRANKSHAFT ON PAGE 7)	1
32	P-3030102	CRANKCASE COVER	1
33	P-4030201	SHAFT SEAL 30 X 48 X 8	1

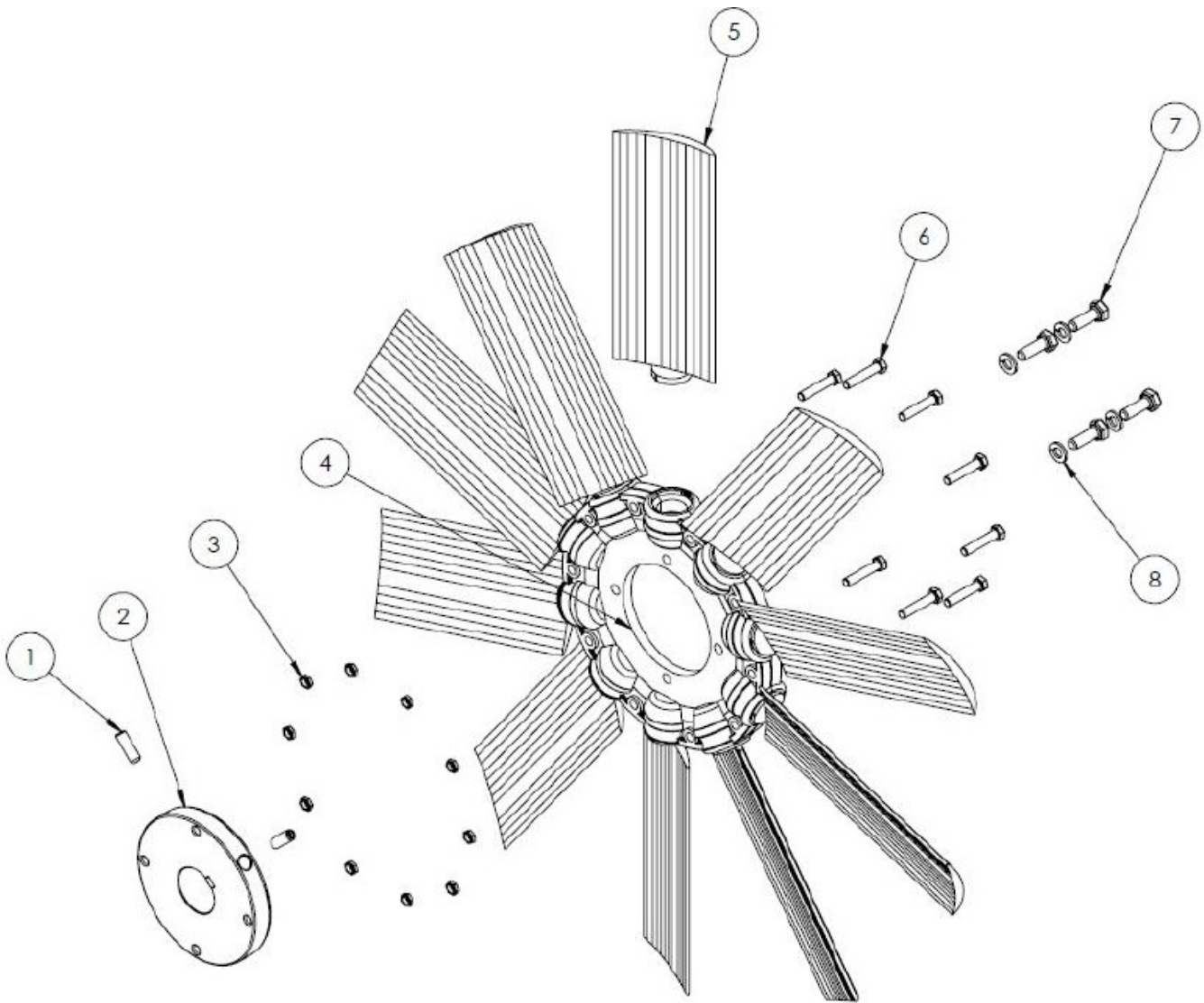
Cooling System.



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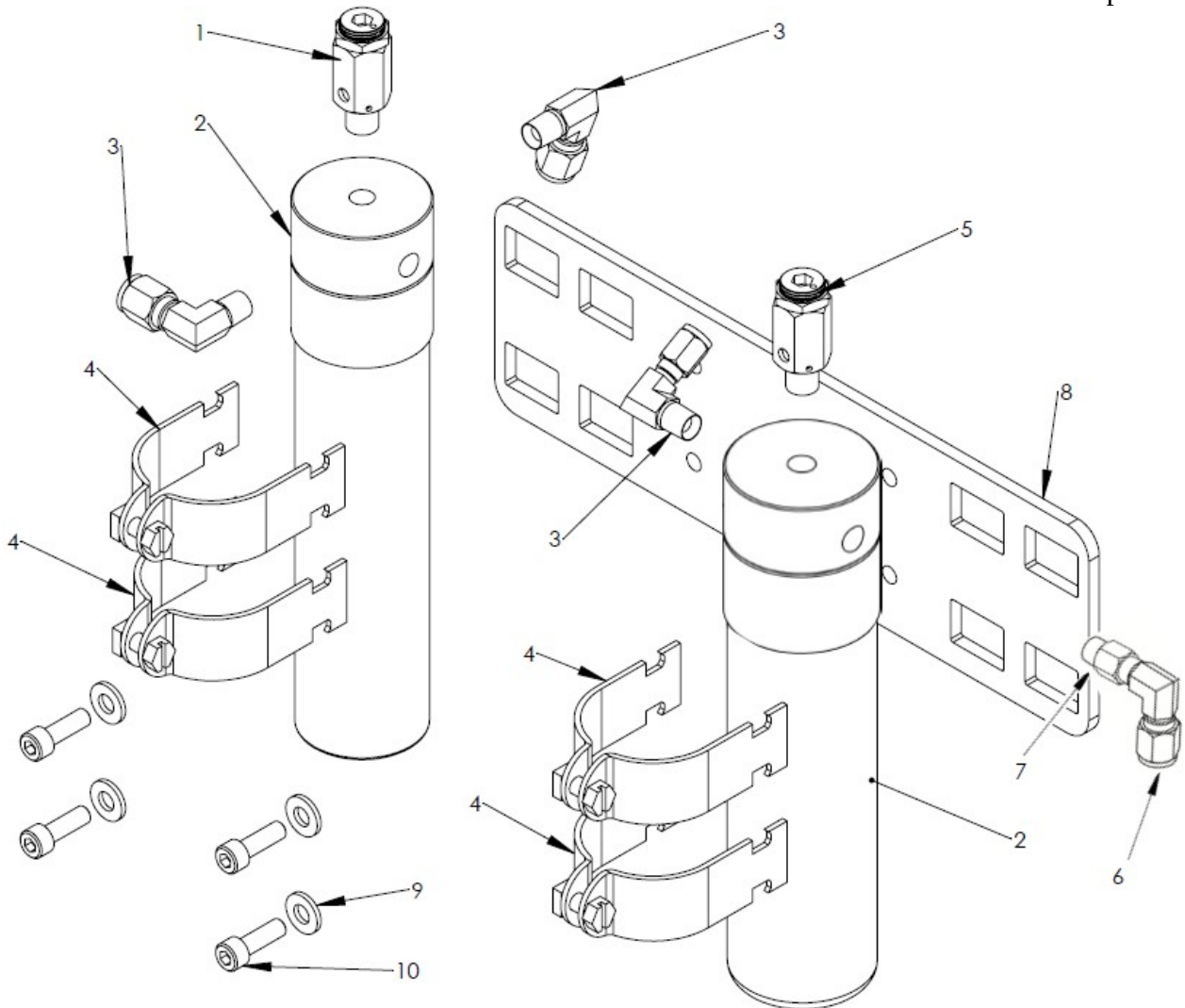
Reference #	Part number	Description	Qty
1	P-2560106	M6 x 30 SHCS	28
2	P-6020110	Intercooler Tube Clamp (Outer)	8
3	P-2530201	M6 Nylon Insert Lock Nut	37
4	P-2560107	M6 x 35 SHCS	4
5	P-6020111	Intercooler Tube Clamp (Inner)	8
6	P-6040102	L Tube (dia 0.380) Wall thickness=0.049	1
7	P-2560108	M6 x 16 SHCS	4
8	P-6020301	IC Tab 1	2
9	P-6020302	IC Tab 2	2
10	P-6020202	Intercooler Tube 3 (Stage 3- Stage 4)	1
11	P-6020251	Intercooler Tube 2 (Stage 2- Stage 3)	1
12	P-6030111	Aftercooler Bracket 1 (Inner)	2
13	P-2520101	M8 Flat Washer	2
14	P-2560103	M8 x 30 SHCS	2
15	P-6030110	Aftercooler Bracket 2 (Outer)	2
16	P-6030201	Aftercooler Plastic	8
17	P-6030101	Aftercooler Tube	1
18	P-6030202	Aftercooler Plastic Short	2
19	P-6030203	Aftercooler Tab	2
20	P-2560109	M6 x 25 SHCS	1
21	P-2520201	Shaft Spacer	1
22	P-2550104	5/16" x 1" Square Head Set Screw (cut tip)	1
23	P-2550103	5/16" x 3/4" Square Head Set Screw (cut tip)	2
24	P-3080101	Flywheel	1
25	P-2520202	Crankshaft Washer	1
26	P-2560105	M8 x 25 SHCS	1
27	P-6510104	1/4" x 1/2" x 2" Square Key	2
28	P-3070104	Fan Assembly	1
29	P-6020252	Intercooler Tube 1 (Stage 1- Stage 2)	1
30	P-602010	Intercooler Bottom Clamp	4
31	P-6020137	Intercooler Bottom Bracket	2
32	P-2570209	5/16" x 3/4" HHCS	4
33	P-2530304	5/16" Nylon Lock Nut	4

Cooling Fan



Reference #	Part #	Description	Qty
1	P-2550102 *(Before May 2013)	1/4 x 3/4 socket set screw (cup point)	2
	P-2550108 *(After May 2013)	5/16 x 3/4 socket set screw (cup point)	
2	P-3070101	Fan bushing	1
3	P-2530401	M5 nut	10
4	P-3070102	Fan hub assembly	1
5	P-3070103	Fan Blade	10
6	P-2570205	M5 x 1 HBOLT	10
7	P-2570204	1/4 x 3/4 HBOLT	4
8	P-2520310	1/4" Split Lock washer	4
FAN ASSEMBLY	P-3070104	PARTS 3,4,5 AND 6 ASSEMBLED	1

Moisture Separators



Reference #	Part number	Description	Qty
1	A-R2021	2nd Stage Relief Valve	1
2	P-6040101	Interstage Moisture Separator	2
3	F-01252	1/4" MNPT x 3/8" Tube Elbow	3
4	P-2510101	Clamps (2 1/4" OD)	4
5	A-R2015	3rd Stage Relief Valve	1
6	F-01110	1/4" FNPT x 1/2" Tube Elbow	1
7	F-01258	1/4" Hex Nipple	1
8	P-6040155	Separator Mounting Plate	1
9	P-2520101	M8 Flat Washer	4
10	P-2560105	M8 x 25 SHCS	4