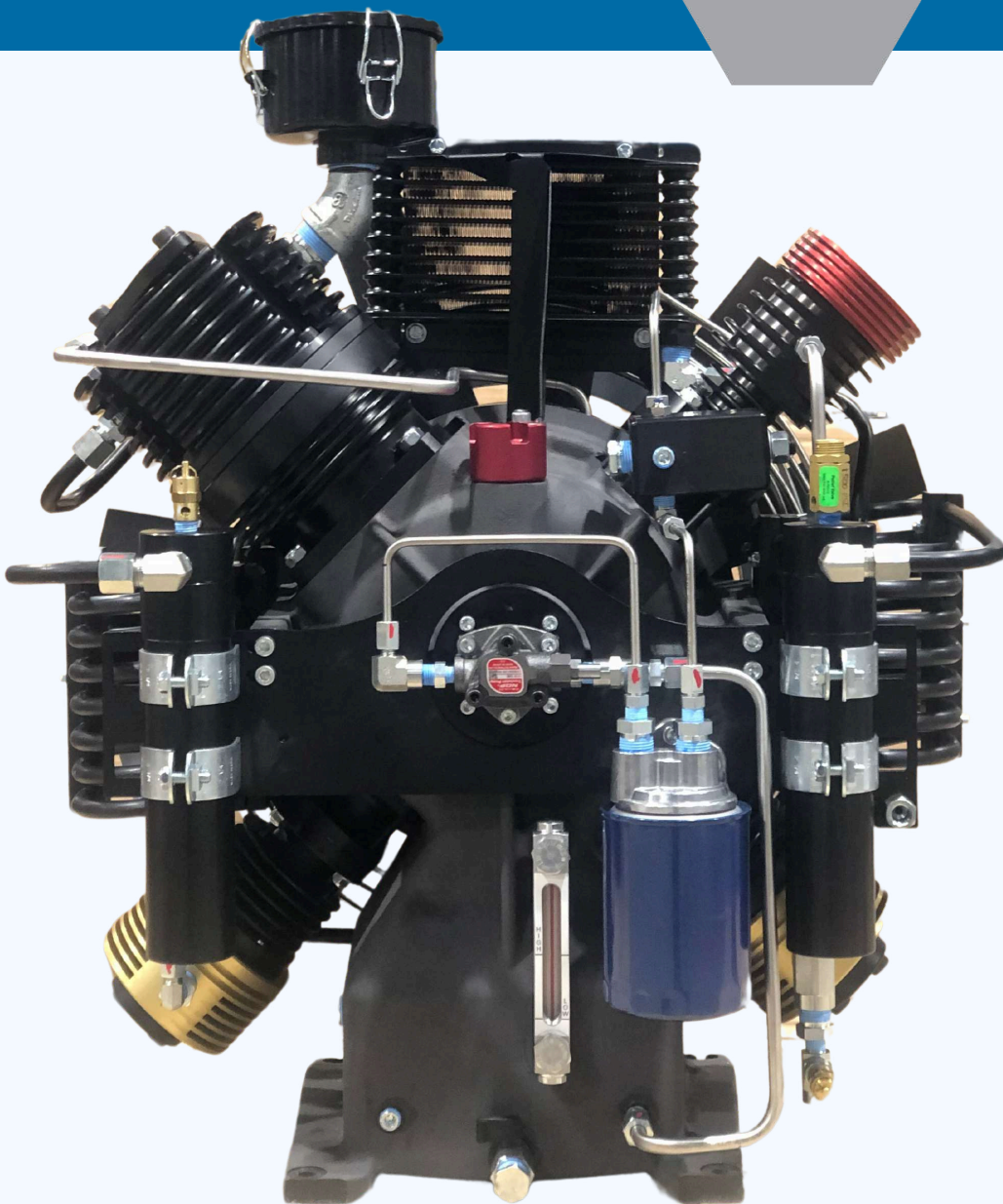
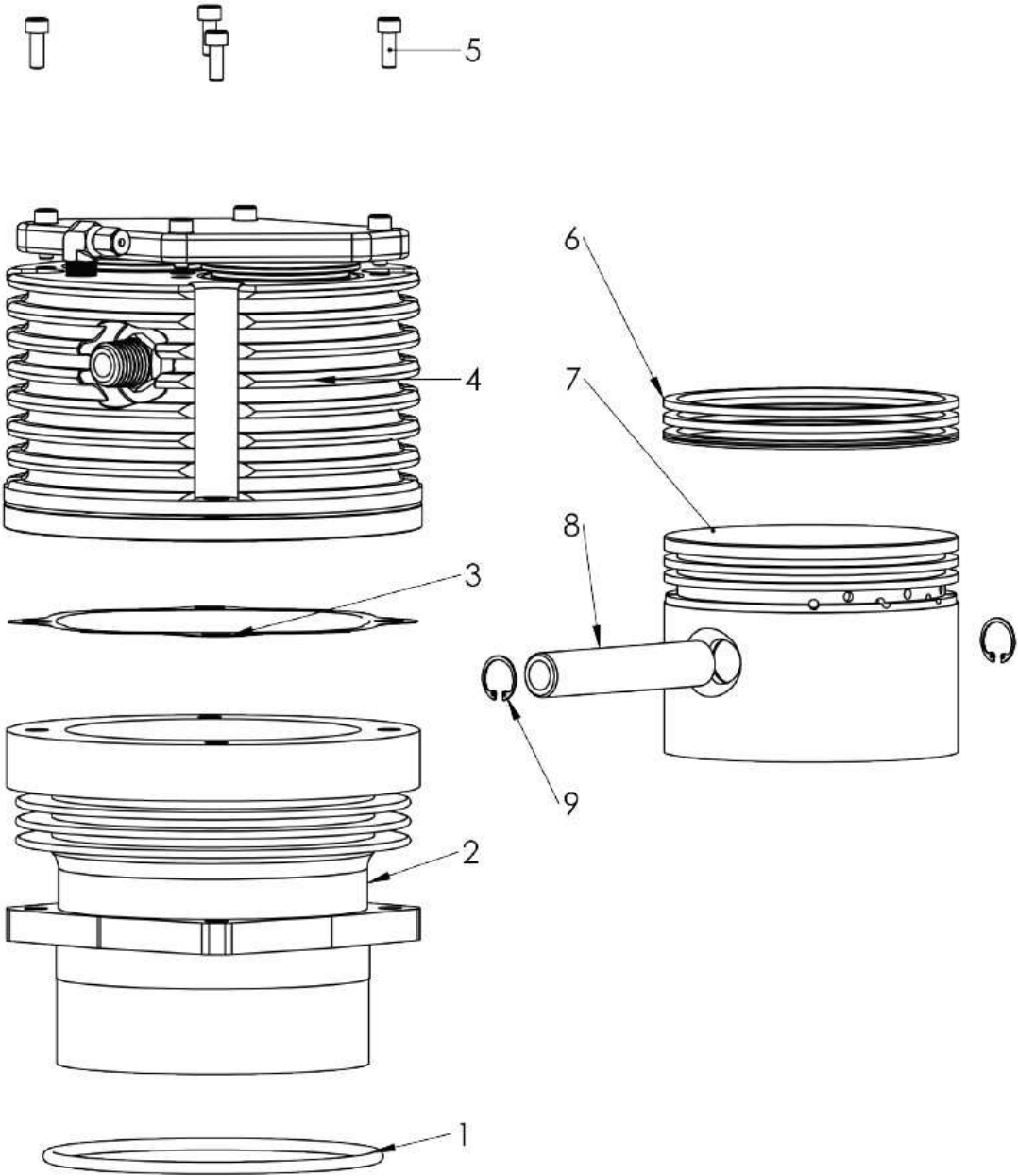




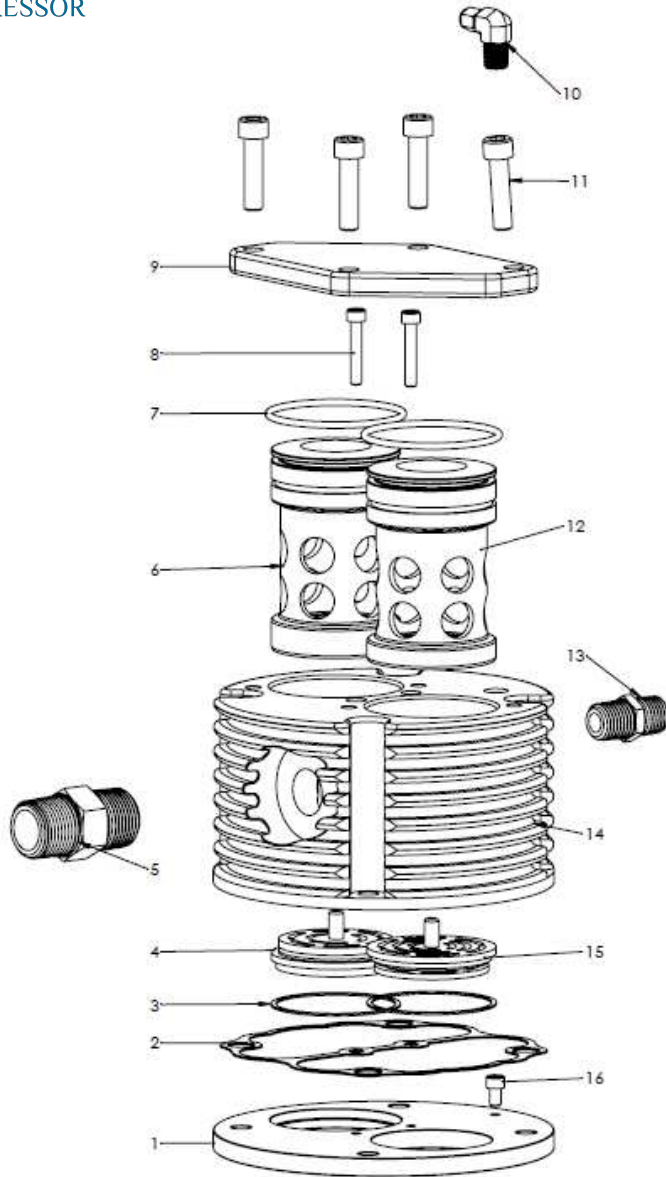
## Arctic 2500 Compressor Block Parts Manual





Reference #	Part Number	Description	Qty
1	OR-BH2X135	O Ring	1
2	P-1010201	1st Stage cylinder	1
3	P-4020211	1st Stage cylinder gasket	1
4	SC-A2500-1ST-Head	1st stage head	1
5	P-2560210	SHCS M10-1.5 x40	4
6	P-3530201	130mm Ring Set	1
7	P-3520175	130mm Piston	1
8	P-3055130	130mm Wrist pin	1
9	P-2510215	20mm Snap ring	2

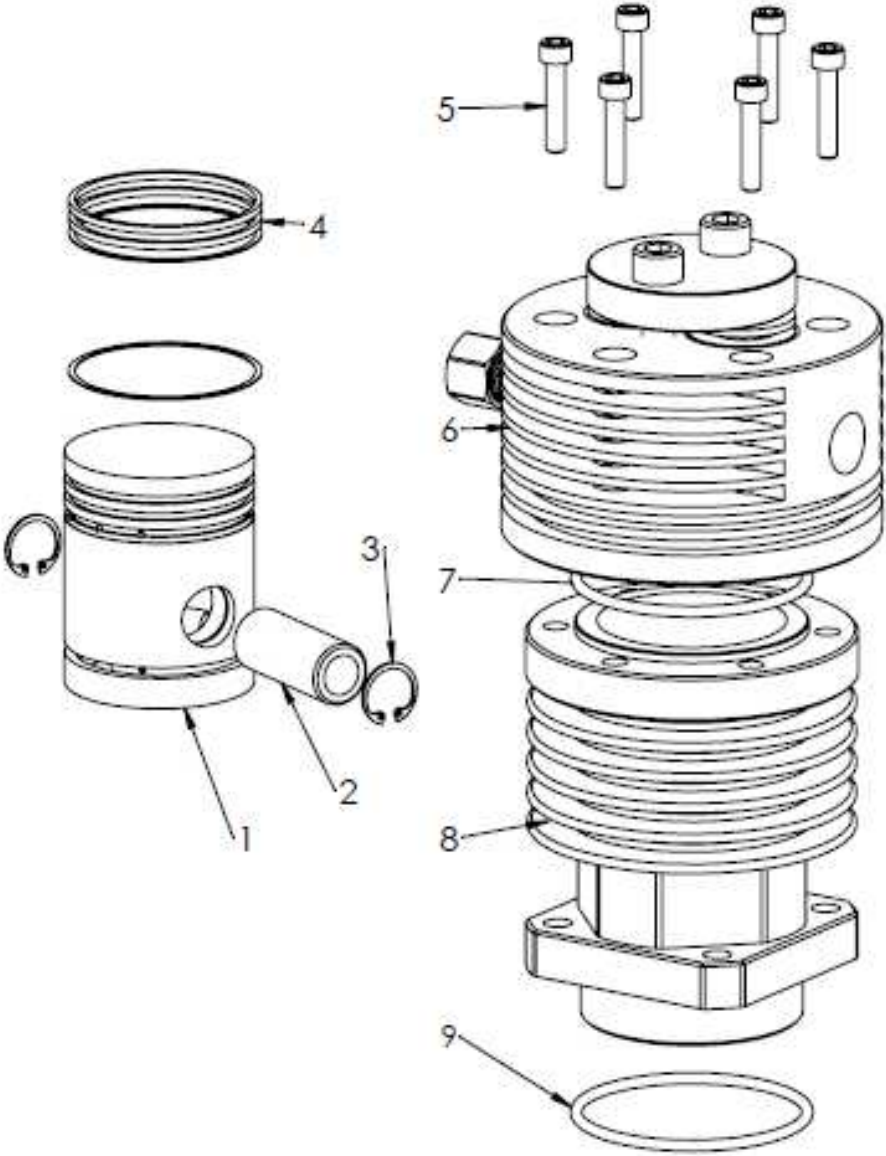
First Stage Head



Reference #	Part Number	Description	Qty
1	P-2010202	First Stage head bottom	1
2	P-4020205	First Stage head gasket	1
3	P-4020203	First Stage Copper Gasket	2
4	P-1525108	First Stage exhaust valve	1
5	F-25111	1" NPT Hex Nipple	1
6	P-2030202	First Stage exhaust valve hold down	1
7	OR-V145-90	O Ring	2
8	P-2560107	SHCS M6-1.0x35	2
9	P-2030201	First stage valve cover	1
10	F-01252	1/4 MNPT x 3/8 tube elbow	1
11	P-2560210	SHCS M10-1.5 x40	4
12	P-2030203	First stage intake valve hold down	1
13	F-02153	1/2" MNPT x 1/2" Tube Straight	1
14	P-2010201	First Stage head top	1
15	P-1525107	First stage intake valve	1
16	P-2560117	SHCS M6-1.0 x 10mm	1



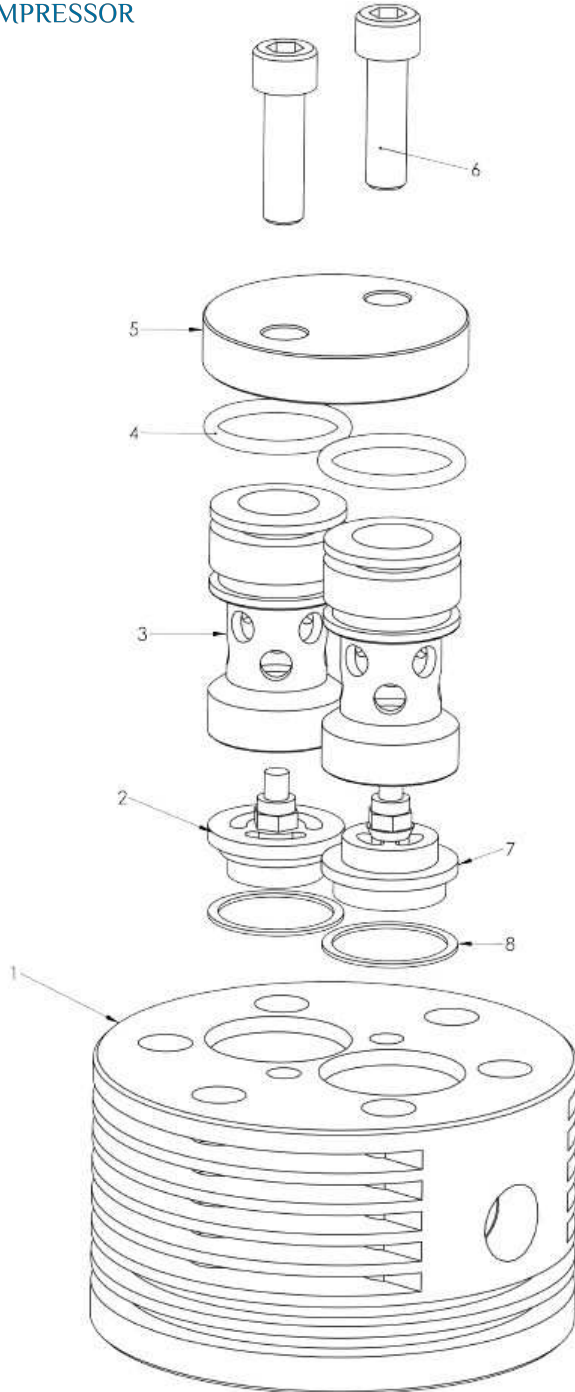
Second Stage



Reference #	Part Number	Description	Qty
1	P-3520202	60mm Piston	1
2	P-3055248	48mm Wrist pin	1
3	P-2510215	20mm Snap ring	2
4	P-3530202	60mm Ring Set	1
5	P-2560114	SHCS M8-1.25 x35	6
6	SC-A2C-2ND HEAD	Second Stage head assembly (see next page)	1
7	OR-VH2X70	O Ring	1
8	P-1010202	Second Stage cylinder	1
9	OR-BH2X70	O Ring	1



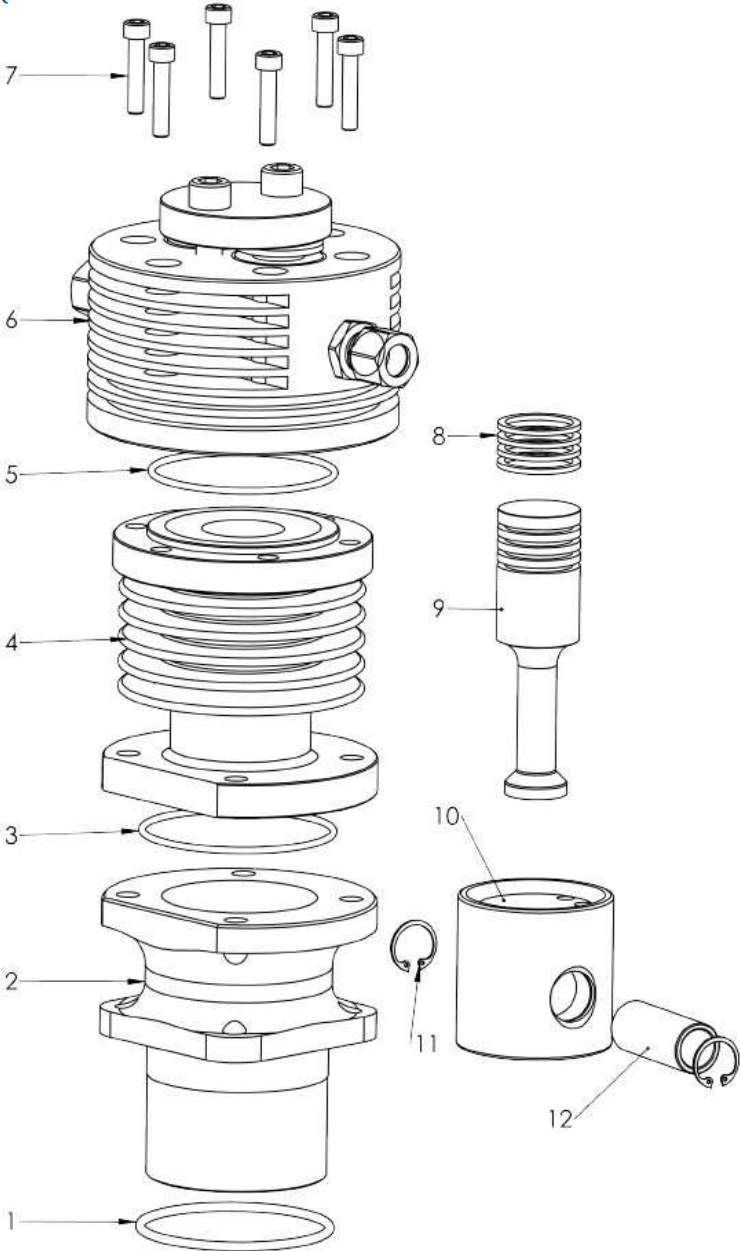
Second / Third Stage Head Assembly



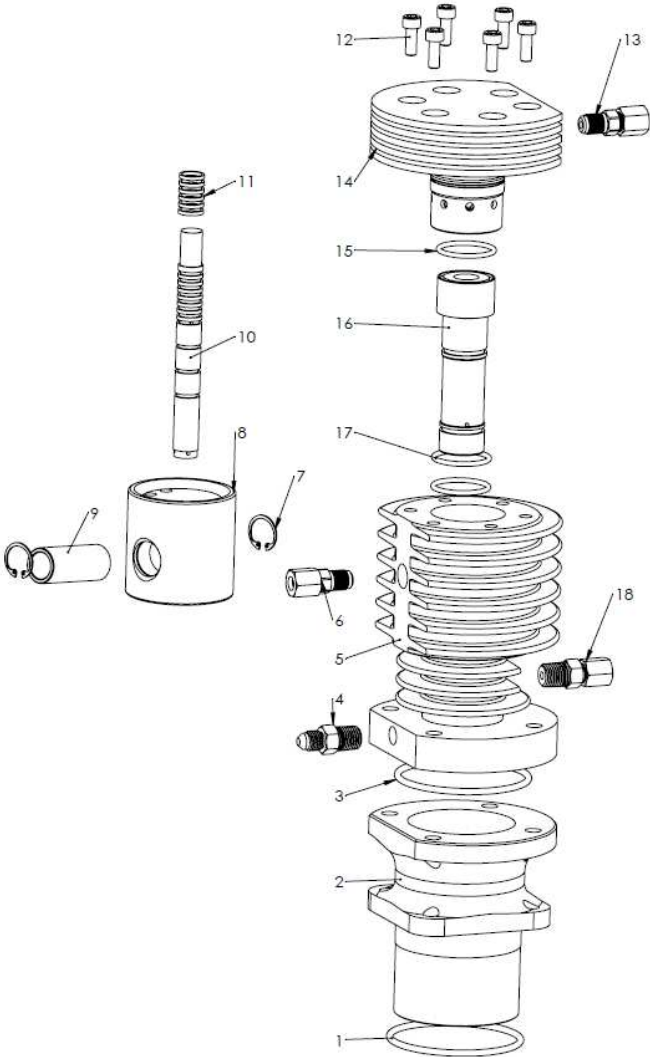
Reference #	Part Number	Description	Qty
1	P-2010125	2nd / 3rd stage head	1
2	P-1525104	2nd stage Exhaust Valve	1
	P-1525106	3rd stage Exhaust Valve	
3	P-2030135	Valve hold down	2
4	OR-V216-90	O Ring	2
5	P-2030205	Valve cover	1
6	P-2560209	SHCS M10-1.5 x30mm	2
7	P-1525103	2nd stage intake valve	1
	P-1525105	3rd stage intake valve	
8	P-4030103	copper gasket	2



Third Stage



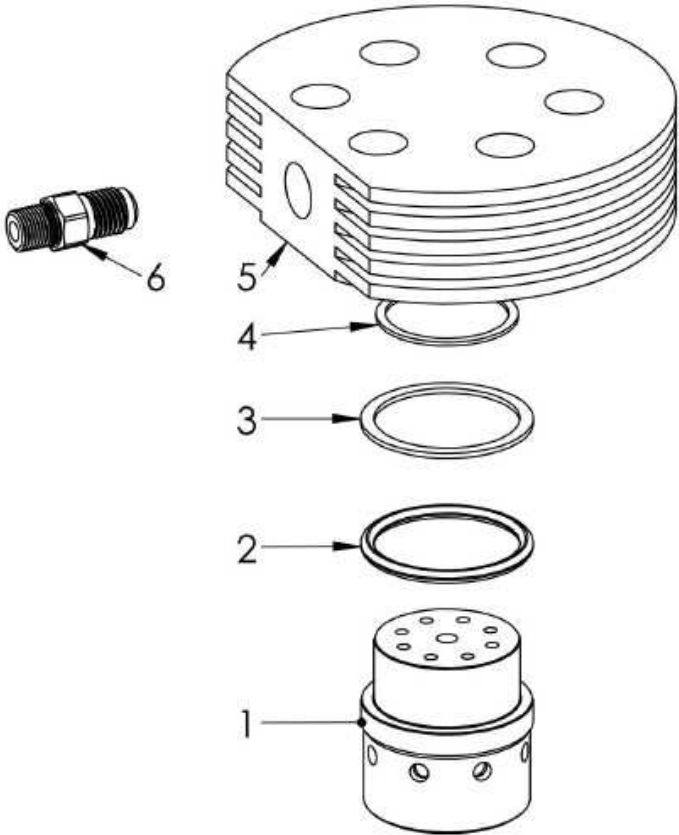
Reference #	Part Number	Description	Qty
1	OR-BH2X70	O Ring	1
2	P-1010203	60mm guide cylinder	1
3	OR-V142	O Ring	1
4	P-1010204	32mm cylinder	1
5	OR-VH2X70	O Ring	1
6	SC-A2C-3RD HEAD	3rd Stage Head Assembly	1
7	P-2560114	SHCS M8-1.25 x35	6
8	P-3530203	32mm Ring Set	1
9	P-3520203	32mm piston	1
10	P-3520960	60mm guide piston	1
11	P-2510215	20mm Snap ring	2
12	P-3055248	48mm Wrist pin	1



Reference #	Part Number	Description	Qty
1	OR-BH2X70	O Ring	1
2	P-1010203	60mm guide cylinder	1
3	OR-V142	O Ring	1
4	F-02131	1/8 MNPT x #4 JIC straight	1
5	P-1010205	Final stage cylinder	1
6	F-011511	1/4 MNPT x 3/8 Tube Straight	1
7	P-2510215	20mm Snap ring	2
8	P-3520960	60mm guide piston	1
9	P-3055248	48mm Wrist pin	1
10	P-3520204	14mm Piston	1
11	P-R-14-SET2500	14mm Ring Set	1
12	P-2560114	SHCS M8-1.25 x 35mm	6
13	F-01150	1/4 MNPT x 1/4 Tube	1
14	P-2010206	Final Stage Head Assembly	1
15	OR-V022-90	O Ring	1
16	P-3520205	14mm Final Piston Sleeve	1
17	OR-V020-90	O Ring	2
18	F-02151	1/8 MNPT x 1/4 Tube straight	1



Final Stage Head

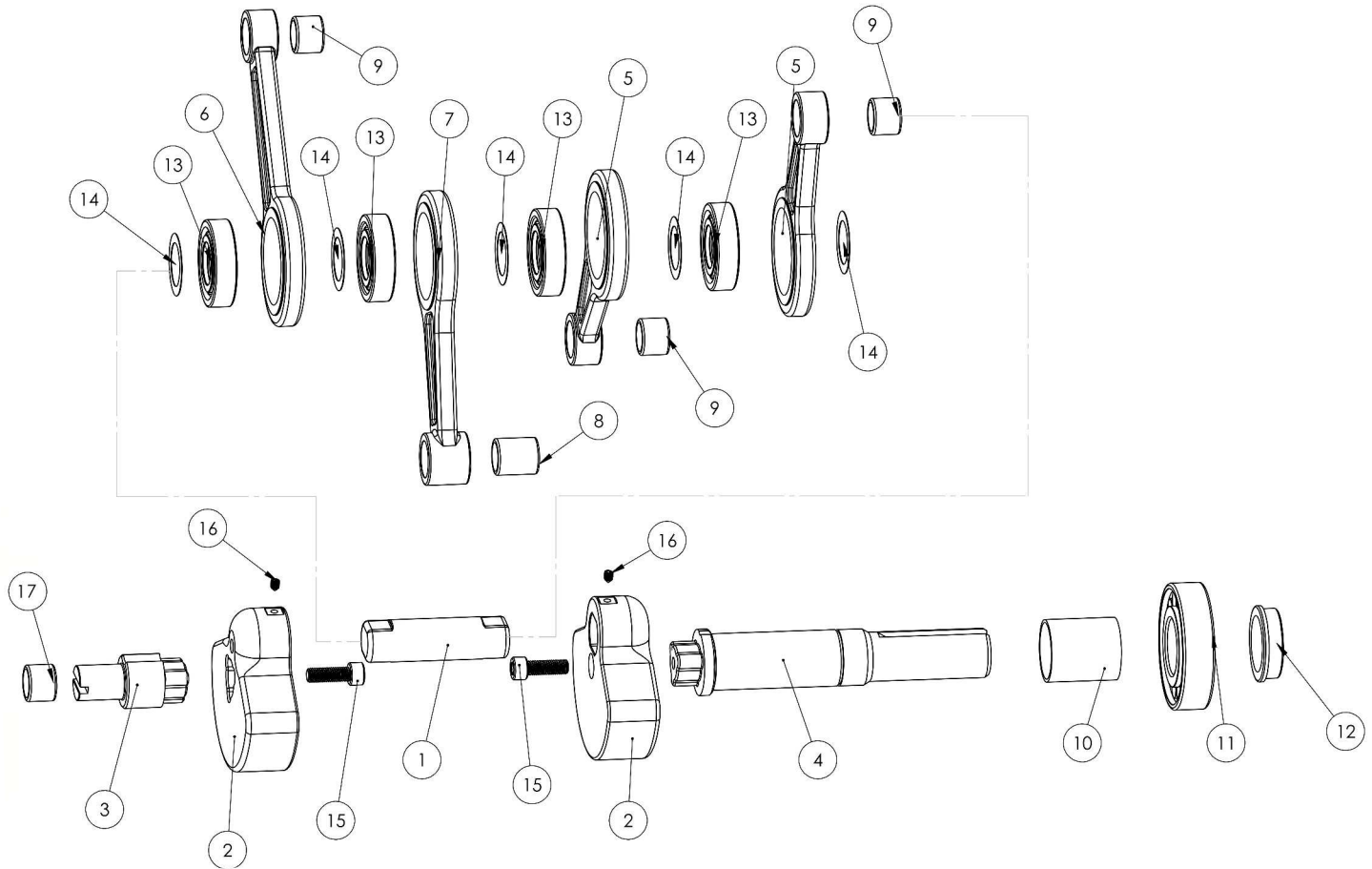


Reference #	Part Number	Description	Qty
1	P-1525115	Final Stage Valve	1
2	OR-V220-90	O Ring	1
3	OR-BU220-P	Back up ring	1
4	P-4030103	Copper Gasket	1
5	P-2020201	Final stage head	1

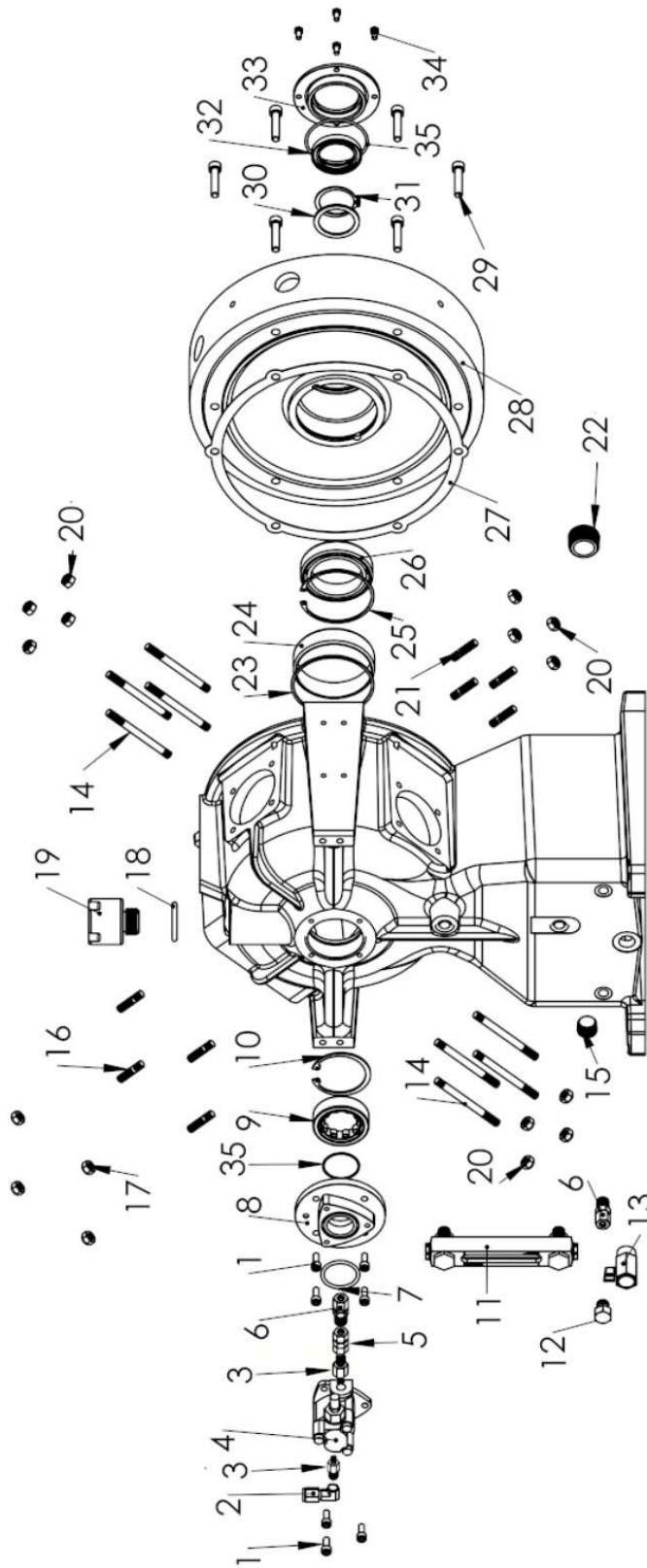




Crankshaft and Connecting Rods Assembly



Reference #	Part Number	Description	Qty
1	P-3040203	A2500 Crankshaft Pin	1
2	P-3040201	A2500 Crankshaft Weight	2
3	P-3040204	A2500 Crankshaft Oil Shaft	1
4	P-3040202	A2500 Crankshaft Drive End	1
5	P-3050201	CONNECTING ROD A2500 3&4	2
6	P-3050202	CONNECTING ROD A2500 2ND	1
7	P-3050203	CONNECTING ROD A2500 1ST	1
8	P-3060155	A2500 First Stage Pin Bearing	1
9	P-3060102	Pin Bearing (Arctic 1060, 2500)	3
10	P-3040206	A2500 Crankshaft Bearing Spacer	1
11	P-3060205	A2500 Case Cover Bearing	1
12	P-3060150	A2500 Crank Shaft Bearing 2pc	1
13	P-3060203	A2500 Crankshaft Bearing	4
14	P-2520204	A2500 Crankshaft Shim	5
15	P-2560209	SHCS M10-1.5 X 30MM	2
16	P-2550109	M6 X 8MM Set Screw	2
17	P-3060104	Oil Shaft bearing Inner race	1



Parts table on next page

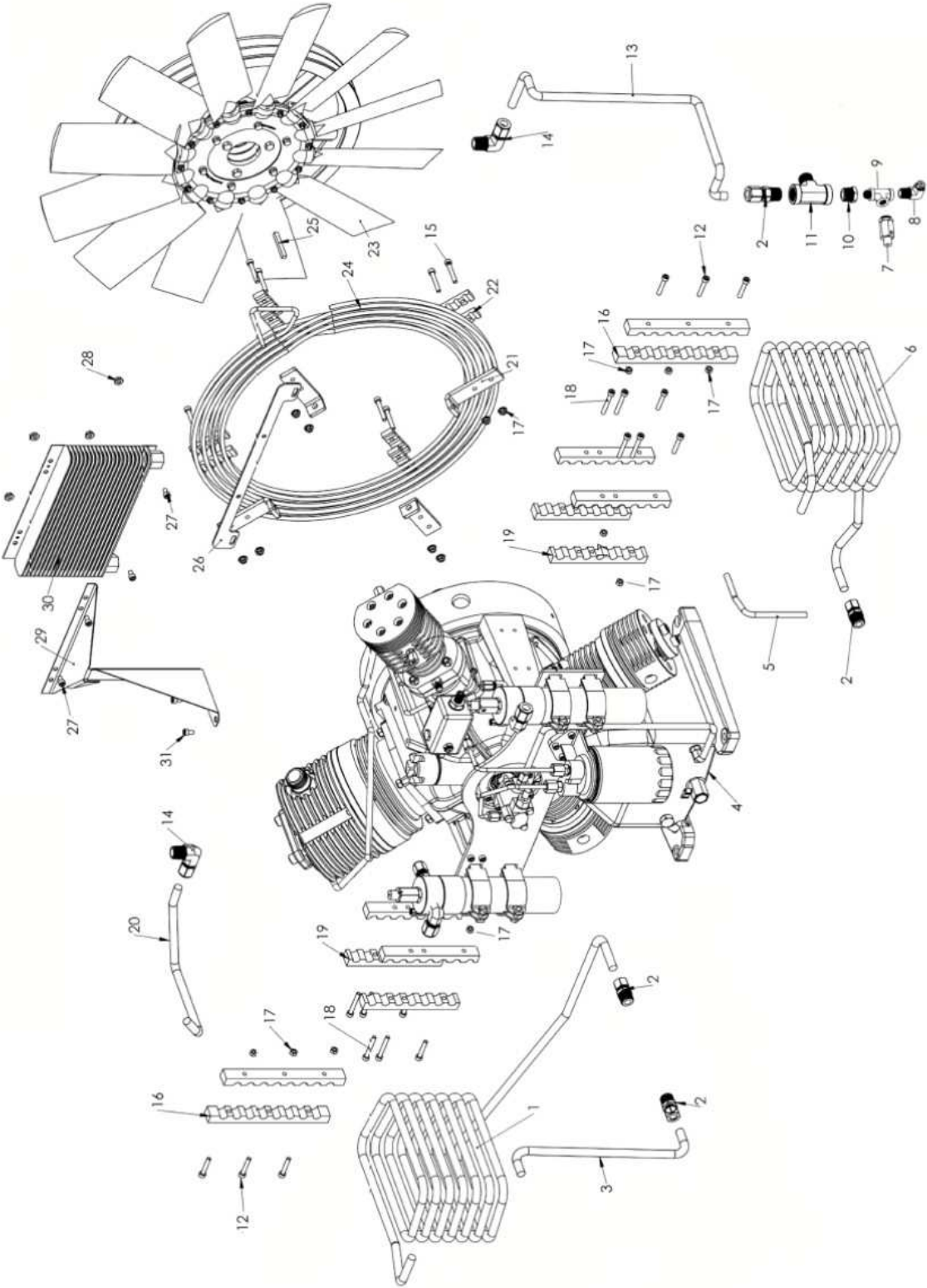


## Crankcase Assembly

Reference #	Part Number	Description	Qty
1	P-2560108	SHCS M6 x 16	7
2	F-01254	¼ FNPT x ¼ Tube elbow	1
3	F-01111	¼ MNPT x 1/8 MNPT nipple	2
4	P-3065130	A2500 Oil Pump	1
5	F-01117	¼ FNPT x ¼ FNPT coupler	1
7	OR-B029	O Ring	1
8	P-3065125	A2500 Oil Pump Plate	1
9	P-3060104	Crankcase front bearing Outer race and roller cage	1
10	P-2510501	Snap Ring	1
11	P-3065150	Oil Level Sight glass	1
12	F-01561	¼ NPT Hollow hex Plug	1
13	F-09160	1/2" NPT Ball Valve	1
14	P-2540104	DIN 939 M8 x 90 stud	8
15	F-09511	1/2" NPT Hollow Head Hex Plug	1
16	P-2540106	DIN 939 M10 x 37 stud	4
17	P-2530306	M10 -1.5 Nylon Lock nut	4
18	OR-V125-90	Oil Cap O Ring	1
19	P-3010302	A2500 Oil Cap	1
20	P-2530202	M8-1.25 nylon lock nut	12
21	P-2540102	DIN 939 M8 x 25 stud	4
22	F-09520	1" NPT Hollow Head Hex Plug	1
23	P-2510260	Case Cover inner Snap Ring	1
24	P-3060205	Case cover inner bearing Outer Race	1
25	P-2510261	Case cover Outer Snap ring	1
26	P-3060150	Case cover outer bearing outer race and roller cage	1
27	P-4020201	A2500 Case Cover Gasket	1
28	P-3030215	A2500 Crank Case Cover	1
29	P-2560114	SHCS M8 x 1.25 x 35mm	6
30	P-3060150	Case cover outer bearing inner race ring	1
31	P-2510251	Crankshaft external retaining ring	1
32	P-4030205	Crankshaft oil seal	1
33	P-3040207	A2500 Crankshaft seal retainer	1
34	P-2570205	HHCS M5-0.8 x 10mm	4
35	OR-B037	O Ring	2



Cooling System

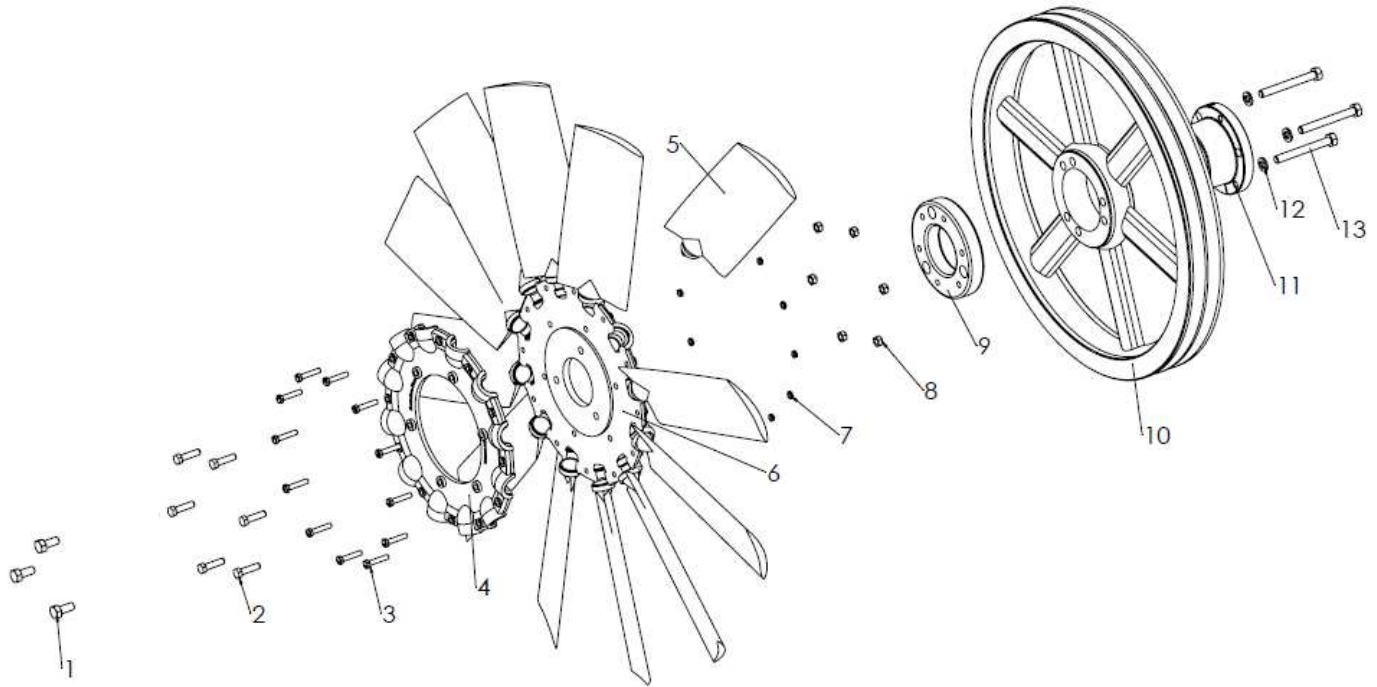


Parts table on next page



Reference #	Part Number	Description	Qty
1	P-6020404	Intercooler 2 (Stage 2 - moisture separator)	1
2	F-02153	½ MNPT x ½ Tube Straight	4
3	P-6020405	Moisture Separator - Stage 3 tube	1
4	SC-A2C-CCASEASSM	Crank Case Assembly	1
5	P-6020407	Moisture Separator – Final Stage tube	1
6	P-6020406	Intercooler 3 (Stage 3 - moisture separator)	1
7	A-R2019	1st stage relief valve	1
8	F-01256	¼ MNPT X1/8 PTC elbow	1
9	F-01410	¼ MNPT Male run tee	1
10	F-01119	½ MNPT x ¼ FNPT bushing	1
11	F-04511	½ NPT Male x Female x Female branch T	1
12	P-2560107	SHCS M6-1.0x 35mm	6
13	P-6020403	Super cooler- Stage 2 Tube	1
14	F-02254	½ MNPT x ½ Tube Elbow 90	2
15	P-2560111	SHCS M6-1.0 x 45mm	8
16	P-6020130	Intercooler Tube Clamp (outer)	4
17	P-2530201	M6 Nylon Locknut	18
18	P-2560113	SHCS M6-1.0 x 40mm	12
19	P-6020131	Intercooler Tube Clamp (inner)	8
20	P-6020401	1st Stage – Super cooler Tube	1
21	P-6030302	Aftercooler Bracket	4
22	P-6030303	Aftercooler Clamp	8
23	SC-A2C-FANFLYASSM	Fan and Flywheel Assembly	1
24	P-6030301	Aftercooler Tube	1
25	P-6510104	0.25 x 0.25 x 2 Square Key	1
26	P-6020408	Super cooler Bottom Bracket	1
27	P-2570204	HHCS ¼ – 20 x ¾	4
28	P-2530303	¼ -20 Nylon Locknut	4
29	P-6020412	Super cooler Top Brace	1
30	P-6020402	Super cooler	1
31	P-2560108	SHCS M6-1.0 x 16mm	2

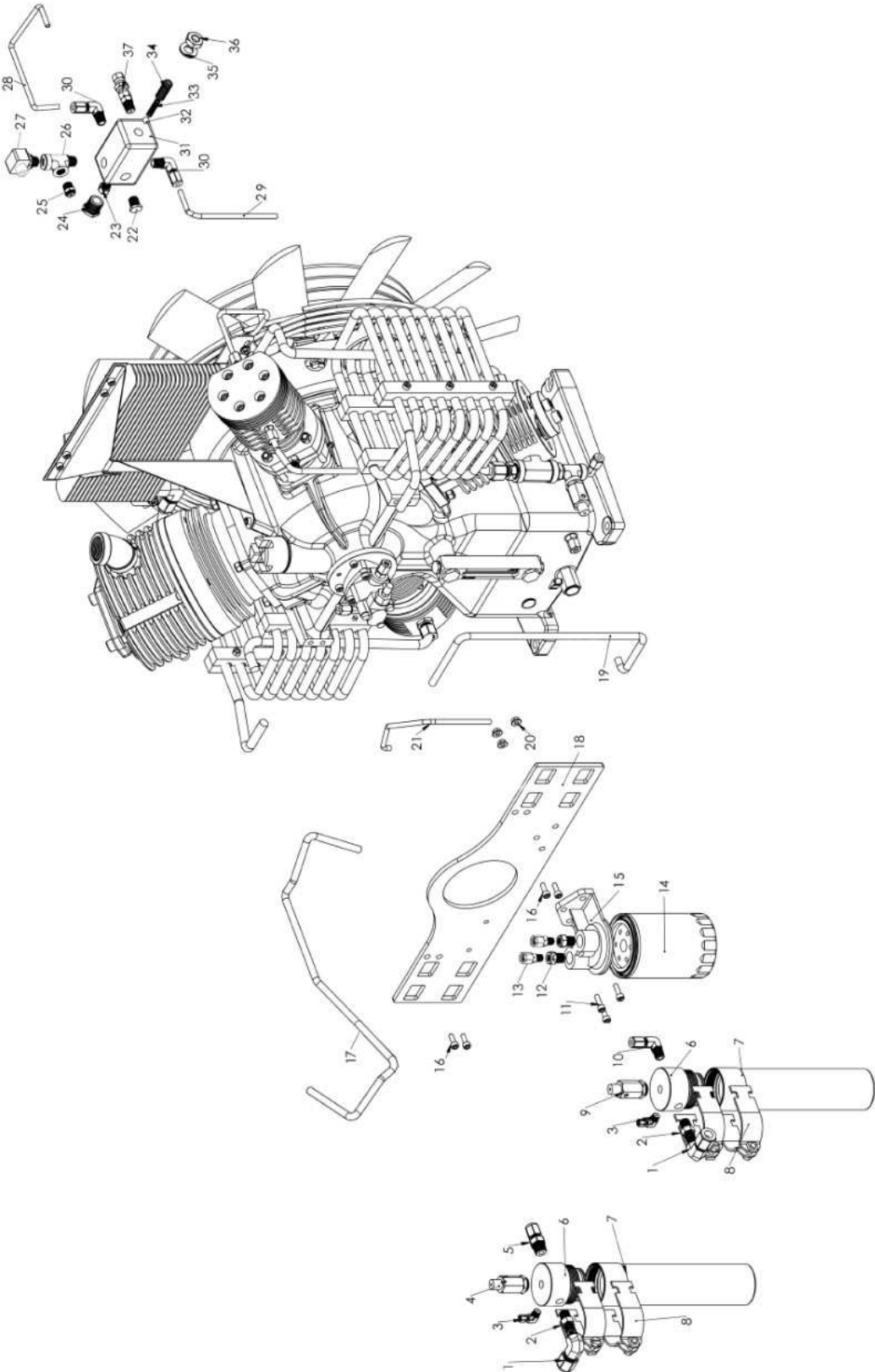
Fan and Flywheel Assembly



Reference #	Part Number	Description	Qty
1	P-2570209	HHCS 5/16-18 x 3/4"	3
2	P-3070204 Fan Assembly	HHCS 1/4-18 x 1"	1
3		HHCS M5-0.8 x 25	
4		Fan Clamp Plate	
5		Fan Blade	
6		Fan Drive Plate	
7		M5-0.8 Nylon Lock nut	
8		1/4-18 Nylon Lock Nut	
9		P-3070205	
10	P-3080201	Flywheel	1
11	M-BUSK1.375	Flywheel bushing	1
12	P-2520104	5/16" flat Washer	3
13	P-2570238	HHCS 5/16-18 x 2.75"	3



Separator Plate Assembly



Parts Table on the next page



## Separator Plate Assembly

Reference #	Part Number	Description	Qty
1	F-01258	¼ FNPT to 1/2 Tube Elbow	2
2	F-01110	¼ MNPT Hex Nipple	2
3	F-02250	1/8 MNPT x 1/8 Tube Elbow	2
4	A-R2021	2nd Stage Relief Valve	1
5	F-011511	¼ MNPT x 3/8 Tube Straight	1
6	P-6040021	Interstage moisture separator top	2
7	P-6040020	Interstage Moisture Separator	2
8	P-2510102	Separator mounting clamps	4
9	A-R2010	3rd Stage Relief Valve	1
10	F-01252	¼ MNPT x 3/8 Tube Elbow	1
11	P-2560103	SHCS M8-1.25 x 30mm	3
12	F-01119	¼ FNPT x ½ MNPT Bushing	2
13	F-01150	¼ MNPT x ¼ tube straight	2
14	P-5535201	Oil Filter	1
15	P-5535202	Oil Filter adapter	1
16	P-2560105	SHCS M8-1.25 x 25mm	4
17	P-3065215	crankcase vent tube	1
18	P-6040201	A2500 Separator Mounting Plate	1
19	P-3065203	Crankcase to Oil pump pickup tube	1
20	P-2530202	M8 -1.25 Nylon Lock nut	3
21	P-3065204	Oil Pump to Oil filter ¼ Tube	1
22	F-01560	1/4 NPT Plug	1
23	P-3065213	Oil Block Relief Valve Orifice	1
24	F-09510	½" NPT Pipe Plug	1
25	F-01159	¼ MNPT X 1/8 PTC	1
26	F-01410	¼" MNPT run tee	1
27	A-P1220	Oil pressure switch	1
28	P-3065207	Oil block to 4th stage cylinder	1
29	P-3065205	Oil filter to Oil block tube	1
30	F-01251	¼ MNPT x ¼ Tube elbow	2
31	P-3065206	Oil Block	1
32	P-3065211	Oil Block Relief Valve Ball	1
33	P-3065212	Oil Block Relief Valve Spring	1
34	P-2550106	Oil Block Relief Valve set Screw	1
35	P-3065214	Sealing Washer	1
36	P-2530415	½" hex Nut	1
37	F-01134	1/4 MNPT x F #4 JIC swivel	1