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**MODIFICATION OF WATER
THERMOSTATS**

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1. Instructions

- a. Loosen the 3 original bolts, which connect thermostat bodies using the hexagon key (3,5 mm). It is necessary to pre-heat the screws before with a hot air gun set to a temperature max. 200 to 250 °C (Fig. 1, Fig. 2). Warning, Do not overheat the rubber sealing in the thermostat. (Fig. 4)!!!

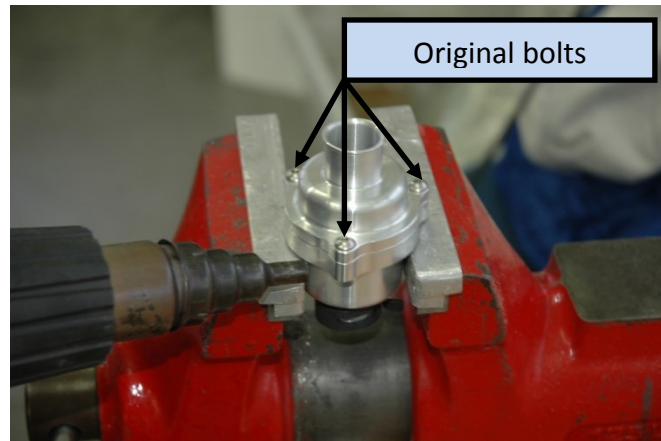


Fig. 1 Direct thermostat

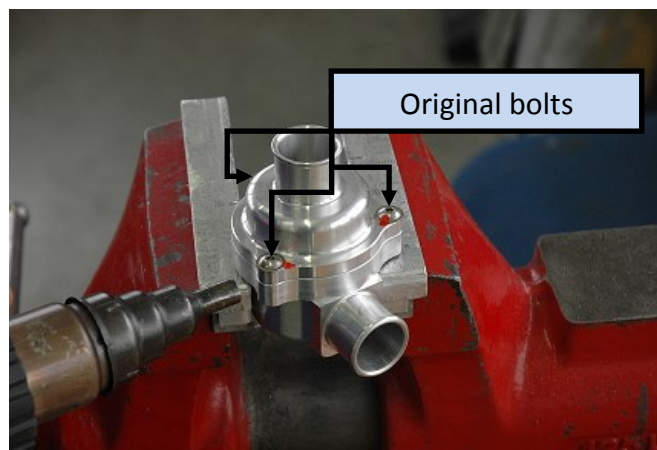


Fig. 2 Thermostat (90°)

- b. Disassemble the thermostat (Fig. 3). Thoroughly clear the surfaces using a degrease agent and a dry cloth from the sealing silicone. Use the dry cloth to clean the rubber sealing (Fig. 4).



Fig. 3 (Illustrative)



Fig. 4

- c. Remove the valve from the thermostat body using pliers (Fig. 5 – Fig. 8).

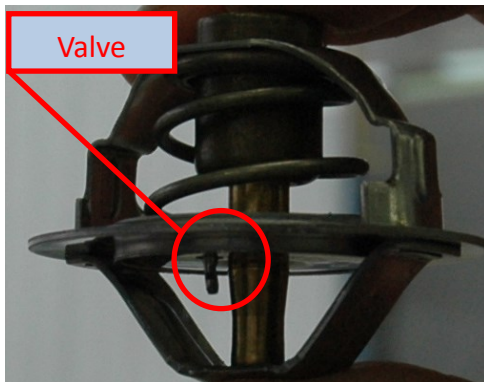


Fig. 5

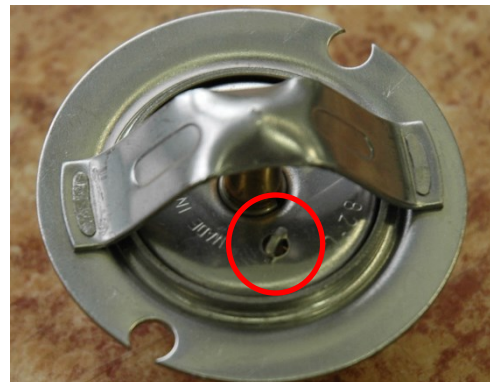


Fig. 6

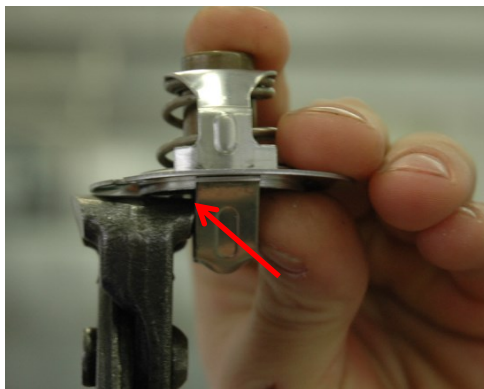


Fig. 7



Fig. 8

- d. After the valve was removed, enlarge the hole to $\text{Ø}6$ mm and drill the second hole $\text{Ø}6$ mm on the opposite side (Fig. 9, Fig. 10). Smooth the edges of holes. Clean the thermostat body and drilled holes.



Fig. 9

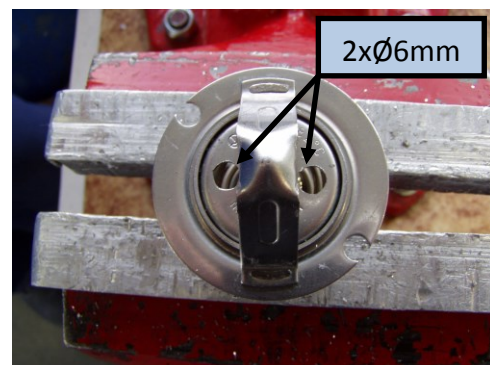


Fig. 10

- e. Clean the threads in threaded part of the thermostat body with a screw-tap M5. Use the cutting oil for this operation (Fig. 11). Degrease the threads with degrease agent.



Fig. 11 (Illustrative)

- f. Apply a fine layer of grease (Vaseline) on the both parts of the thermostat body and the rubber sealing (Fig. 12).



Fig. 12 (Illustrative)

- g. Assemble the thermostat body using new bolts M5x16 (ISO 7380-2 A2) + Loctite 243 and tighten them with 5 Nm (Fig. 13, Fig. 14).

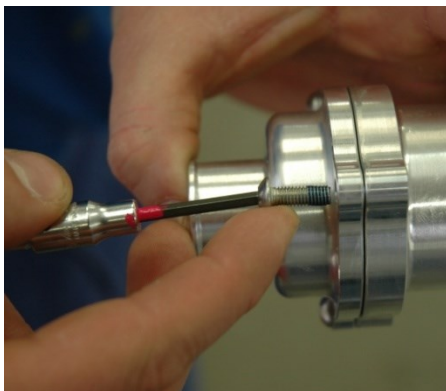


Fig. 13



Fig. 14