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**Instructions  
For  
Northern Engine Driven Fan  
Shroud  
Kits**

**CONTENTS:**

- Instruction sheet ....(1)
  - Shroud..... (1)
  - Ring 3" x 65".....(1)
  - Flat tab 3" x 7".....(1)
  - Brackets 90°.....(6)
  - Screws.....(6)
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1. Mount shroud on the radiator using tape to hold it in place, then with the fan blade removed mount the radiator and shroud assembly in the vehicle temporarily to determine the exact center location of the fan blade and mark.
  2. Remove the shroud from the radiator and mark the center location with a center punch.
  3. Measure the largest point through the fan center of the fan blade to determine the diameter. Mark the shroud using a string and a scribe or a piece of wood with two small finishing nails, a circle with a *radius* 1/4" larger than the fan blade radius. ( will produce a circle 1/2" larger than the fan blade diameter)
  4. Use a jig saw to cut the marked circle, use a hand drill to provide a starting point within the center to be removed.
  5. Smooth as necessary with a file or sandpaper.
  6. Match the circumference of the hole to the collar ring, mark and trim so there is a 1" overlap on the collar ends, trim as necessary.
  7. Rivet (not provided) the collar ring ends to form a circle then rivet the tabs evenly spaced to mount the collar ring to the shroud.
  8. For applications where the center location places the ring above the shroud, use the flat aluminum tab to cut a arc to fill the opening, attach by riveting with tabs made from extra ring material or TIG weld

