

FLEX/ RIDGID PVC WELDS

ALL WHITE PVC FLEX AND RIDGED
IS NOW: CLEANED, PRIMED,
AND GLUED ON BOTH ENDS
WHERE THE PIECES ARE WELDED
TOGETHER
(PROCESS SHOWN IMAGES 1-7)



1



2



5



3



6



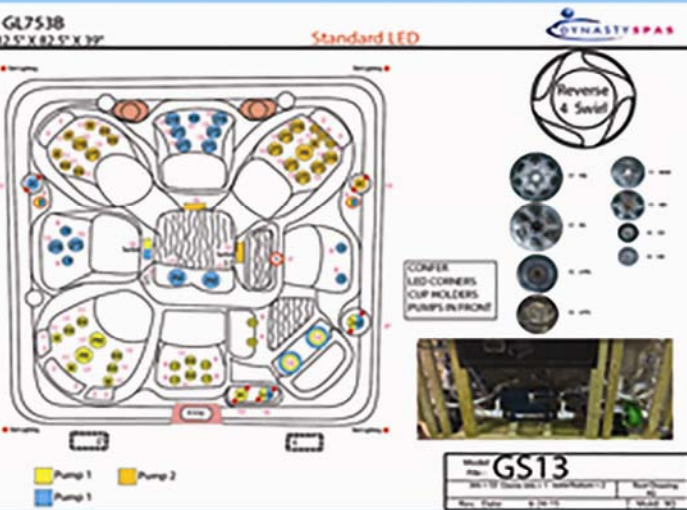
4



7

UPDATED LINE DRAWING
WITH NOTES & PICTURE

PUMP LOCATIONS



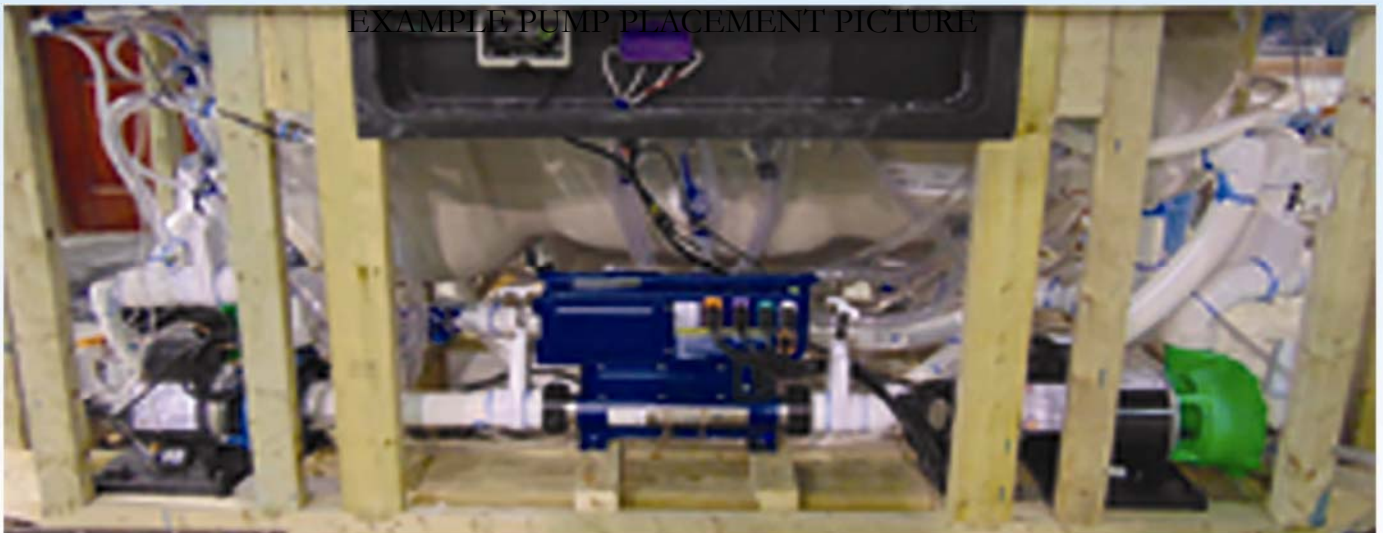
1
PUMP LOCATIONS ARE BEING UPDATED
FOR EACH MODEL TO HOUSE THE PUMPS
IN OR AS CLOSE TO THE FRONT OF
THE SPA AS POSSIBLE

DURING THE PRODUCTION PROCESS
WE ARE TAKING
PICTURES OF THE NEW
LOCATIONS (SEE IMAGE 2)
THEN ADDING THEM TO THE LINE DRAWINGS
TO ENSURE THE PUMPS ARE
POSITIONED CORRECTLY
(SEE IMAGE 1)

WATER TEST/DETAIL

WE HAVE CHANGED
TEAM LEADERS IN
WATER TEST AND DETAIL
TO IMPROVE THE QUALITY
INSPECTION PROCESS

EXAMPLE PUMP PLACEMENT PICTURE



CLEAR SILICONE APPLIED



1

INSERT AND HOLD IN CLEAN RECESS



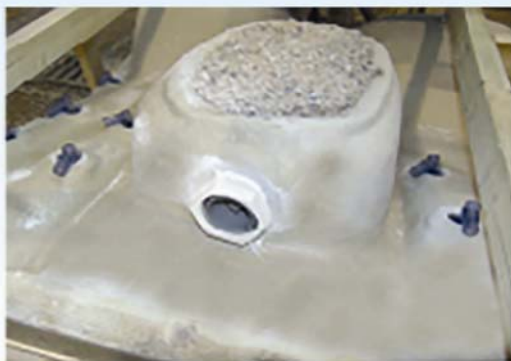
2

WHITE SILICONE APPLIED OUTSIDE



3

THREAD AND TIGHTEN NUT

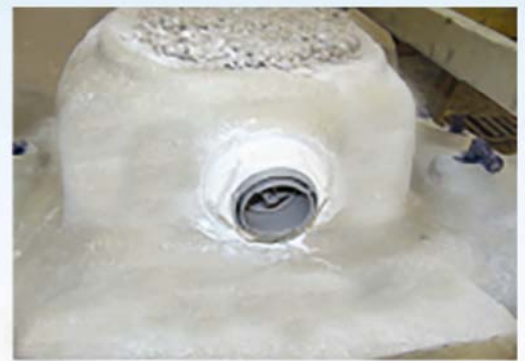


4

SUCTION INSTALLATION

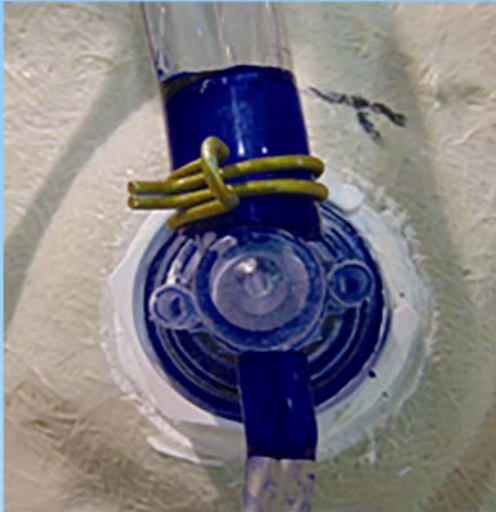
THE INSTALLATION PROCESS
OF THE SUCTIONS HAS BEEN CHANGED
COMPENSATOR RINGS AND GASKETS
HAVE BEEN REPLACED WITH EXTRA SILICONE
TO PREVENT CRACKED WALL FACE AND
PINCHED SEALS
(SEE IMAGES FOR COMPLETE PROCESS

EXCESS SILICONE SMOOTHED
TO COMPLETE SEAL



5

GLUELESS JET



1

GLUELESS MANIFOLD



MANIFOLD STATION (BEFORE) 2

PLUMBING AND MANIFOLDS

DURING THE PLUMBING PROCESS
CLEAR HOSE CONNECTIONS
WILL NO LONGER HAVE GLUE APPLIED TO THE
JET BODY CONNECTIONS
OR MANIFOLD CONNECTIONS
TO PREVENT STUCK JETS
AND BLOCKED AIRLINES.
THESE CONNECTIONS WILL BE PRIMED
THEN SECURED WITH A CLAMP
(SEE IMAGE 1&2)

THE MANIFOLD/AIRLINE PROCESS
IS BEING STREAMLINED AS WELL
THERE IS NOW A DEDICATED
STATION TO MAKE AND KIT
MANIFOLDS AND AIRLINES
TO ENSURE EACH MODEL OF
SPA IS BUILT THE SAME WAY
EVERY TIME
(SEE IMAGE 3 &4)

MANIFOLD STATION (AFTER)

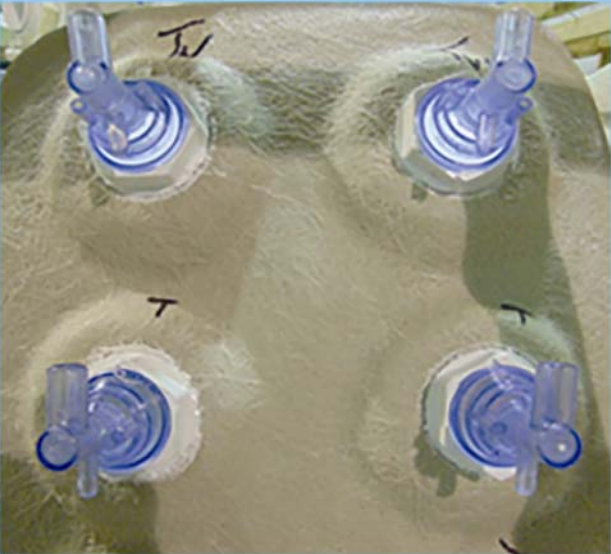


3

4



JETS w/o COMPENSATOR RINGS



NEW SILICONE



2

NECK COLLAR JETS w/ INITIALS



JET
INSTALLATION

WE HAVE REPLACED COMPENSATOR RINGS ON MOST OF OUR JETS WITH MORE SILICONE FOR A MORE RESILIENT SEAL (SEE IMAGE 1&2)

IN ADDITION TO THE IMPROVED SEAL WE HAVE ADJUSTED OUR TORQUE SETTINGS TO REDUCE JET FAILURE

| PREVIOUS | CURRENT |
|---------------------|---------------------|
| TORQUE SETTINGS: | TORQUE SETTINGS: |
| CLUSTER JETS- 6 LBS | CLUSTER JETS- 6 LBS |
| MINI JETS- 12 LBS | MINI JETS- 14 LBS |
| POLY JETS-16 LBS | POLY JETS-16 LBS |
| POWER JETS- 20 LBS | POWER JETS- 24 LBS |

JETS ARE THEN INSPECTED, ONCE VERIFIED EACH JET WILL BE INITIALED BY THE INSTALLER

COMPENSATOR RINGS WILL STILL BE USED FOR CLUSTER JETS AND NECK JETS (SEE IMAGE 3 &4)

3

4



CLUSTER JET