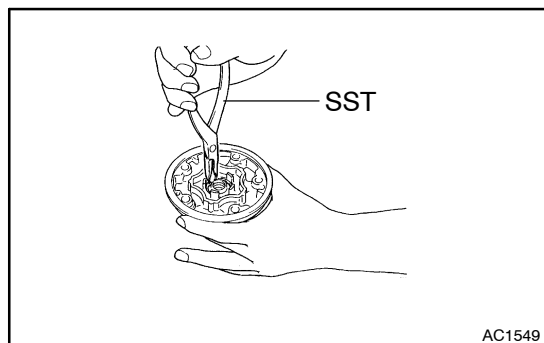


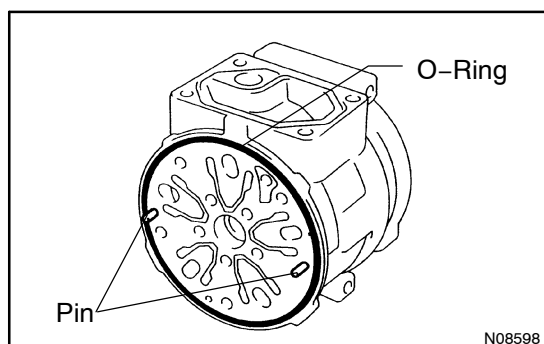
REASSEMBLY

1. ASSEMBLE COMPRESSOR

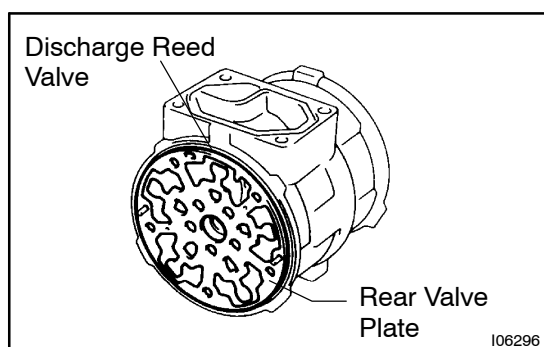
- (a) Install new shaft seal.
 - (1) Fit the shaft seal onto SST and install the shaft seal into the front housing.
- SST 07112 –85020



- (2) Using SST, install the new snap ring.
- SST 07114 –84010



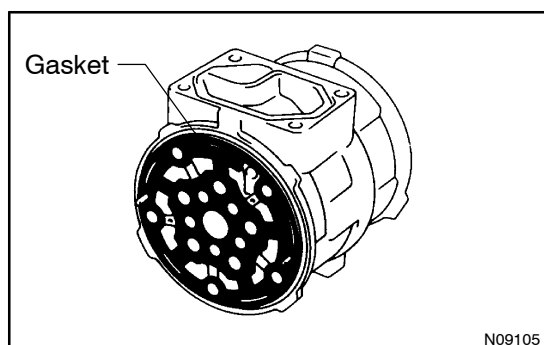
- (b) Install rear housing onto cylinder block.
 - (1) Install the 2 pins on cylinder block.
 - (2) Lubricate a new O –ring with compressor oil and install the O –ring on cylinder block.
 - (3) Install the suction reed valve over the pins in the cylinder.



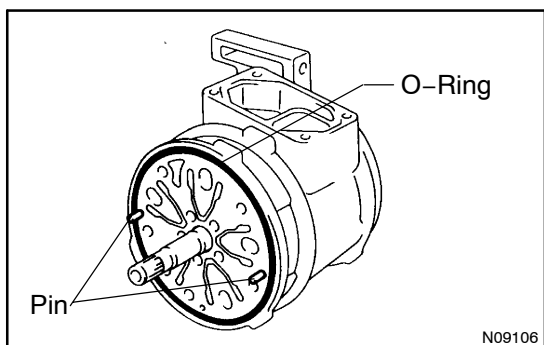
- (4) Install the rear valve plate together with the discharge valve over the pins on the cylinder block.

HINT:

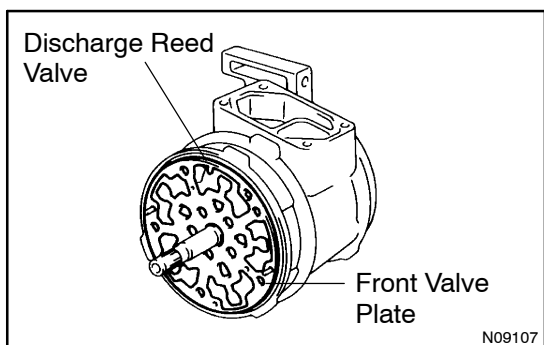
The rear valve plate is marked with an "R".



- (5) Lubricate a new gasket on the valve plate.
- (6) Install the rear housing on cylinder block.



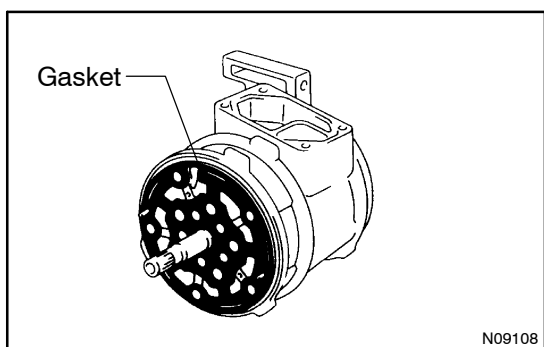
- (c) Install the front housing on cylinder block.
- (1) Install the 2 pins on cylinder block.
 - (2) Lubricate a new O -ring with compressor oil and install the O -ring in the front housing.
 - (3) Install the front suction reed valve over the pins on the cylinder block.



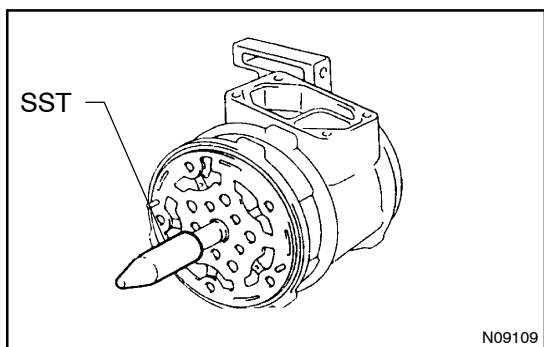
- (4) Install the front valve plate together with the discharge reed valve over the pins on the cylinder block.

HINT:

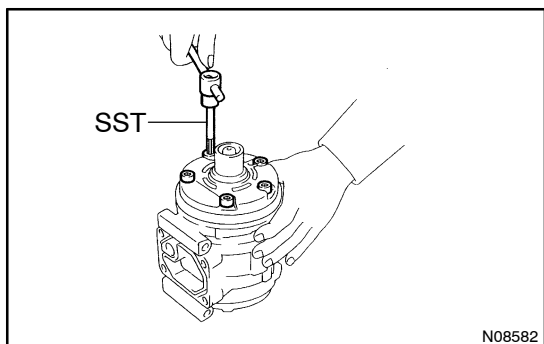
The front valve plate is marked with an "F".



- (5) Lubricate a new gasket with compressor oil and install the gasket on the valve plate.



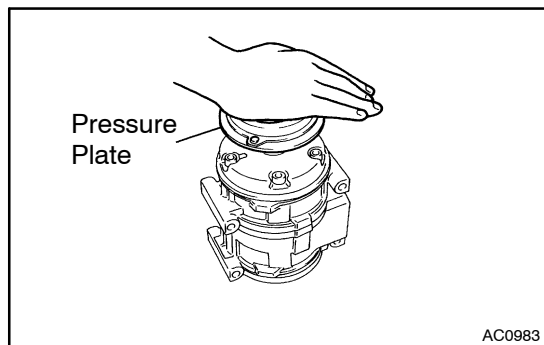
- (6) Set SST on the shaft to protect the shaft seal.
- (7) Install the front housing on the cylinder block.
- (8) Remove SST from the shaft.



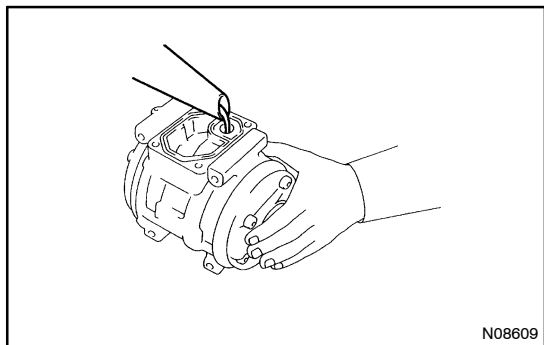
- (9) Using SST and torque wrench, gradually tighten the 5 through bolts with 5 new washers 2 or 3 times.

SST 07110 -61050

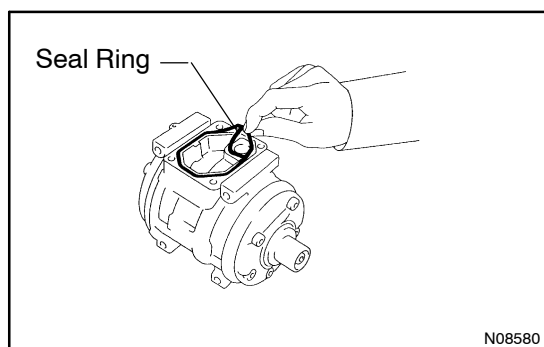
Torque: 25 N·m (250 kgf·cm, 18 ft·lbf)



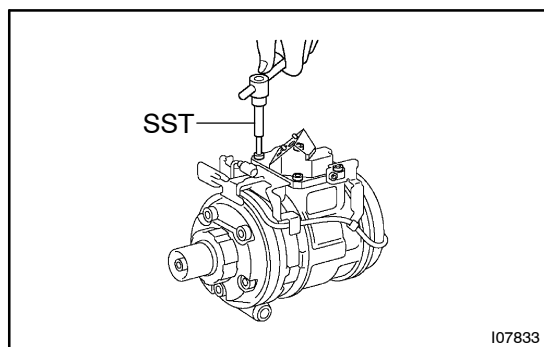
- (d) Install the felt.
- (1) Set the felt with felt holder to front housing.
 - (2) Using a pressure plate of magnetic clutch, install the felt.



- (e) Pour compressor oil into compressor.
Add the same quantity of oil as is removed, plus 20 cc (0.68 fl.oz.) into the compressor.
Compressor oil: ND –OIL 8 or equivalent



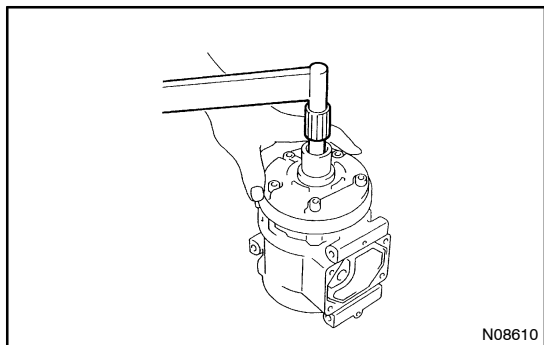
- (f) Install the service valve.
- (1) Lubricate a new seal ring with compressor oil and install the seal ring on cylinder block.



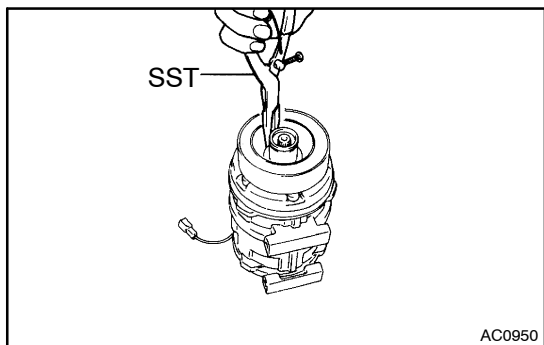
- (2) Using SST and torque wrench, install the service valve with 4 bolts.

Torque: 25 N·m (250 kgf·cm, 18 ft·lbf)

- (3) Connect the connector terminal to the connector housing.
- (4) Connect the connector and connector clamp.



- (g) Check shaft starting torque.
Torque: 2.9 N·m (30 kgf·cm, 26 in·lbf)



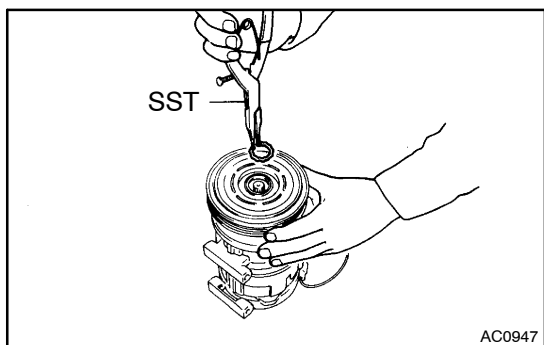
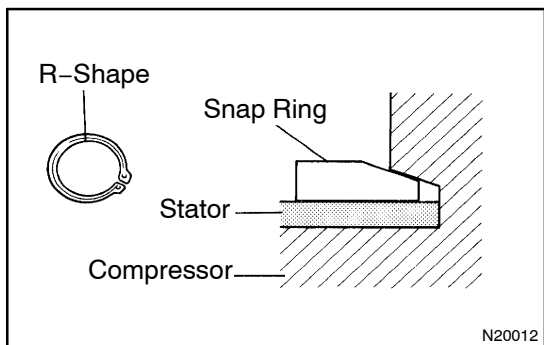
2. ASSEMBLE MAGNETIC CLUTCH

- (a) Install the stator.
- (1) Install the stator on compressor.
 - (2) Using SST, install the new snap ring.
- SST 07114 -84020

NOTICE:

The snap ring should be installed so that its beveled side faces up.

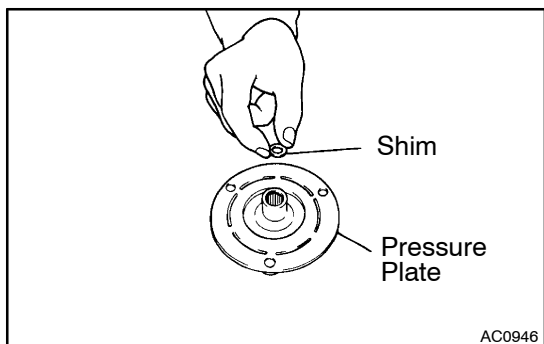
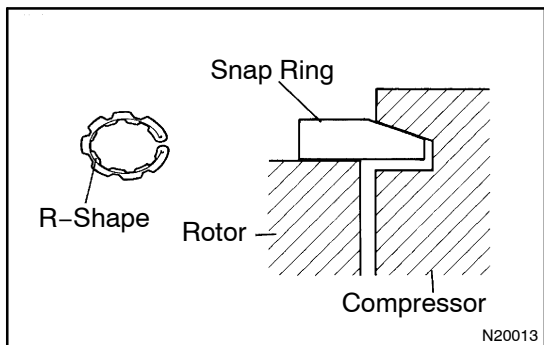
- (3) Connect the stator lead wire to the compressor.



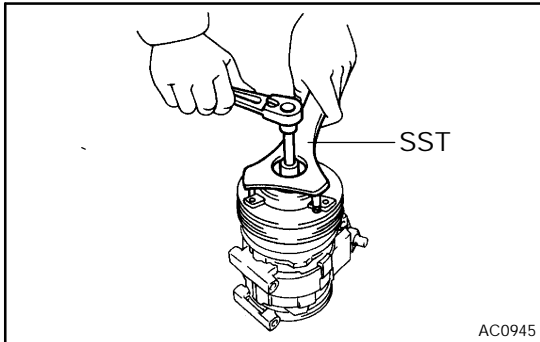
- (b) Install the rotor.
- (1) Install the rotor on the compressor.
 - (2) Using SST, install the new snap ring.
- SST 07114 -84020

NOTICE:

The snap ring should be installed so that its beveled side faces up.



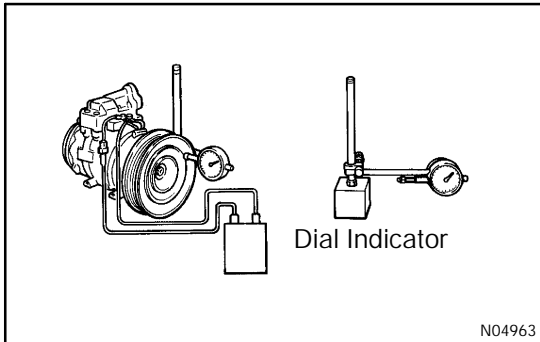
- (c) Install the pressure plate.
- (1) Install the shims to the pressure plate.
 - (2) Install the pressure plate on the rotor.



- (3) using SST and a torque wrench, install the shaft bolt.

Torque: 13.2 N·m (135 kgf·cm, 9 ft·lbf)

SST 07112-76060



3. AFTER REASSEMBLY, CHECK MAGNETIC CLUTCH CLEARANCE

- (a) Set the dial indicator to the pressure plate of the magnetic clutch.
- (b) Connect the magnetic clutch lead wire to the positive (+) terminal of the battery.
- (c) Check the clearance between the pressure plate and rotor when connecting the negative (-) terminal to the battery.

Standard clearance:

$0.5 \pm 0.15 \text{ mm}$ ($0.020 \pm 0.0059 \text{ in.}$)

If the clearance is not within the standard clearance, adjust the clearance using shims to obtain the standard clearance.

Shim thickness:

0.1 mm (0.004 in.)

0.3 mm (0.012 in.)

0.5 mm (0.020 in.)