

REASSEMBLY

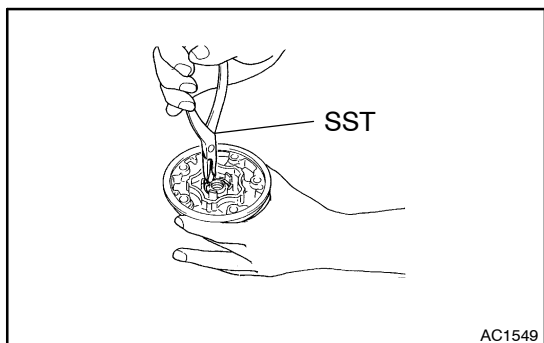
1. ASSEMBLE COMPRESSOR

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

SST 07112-85020

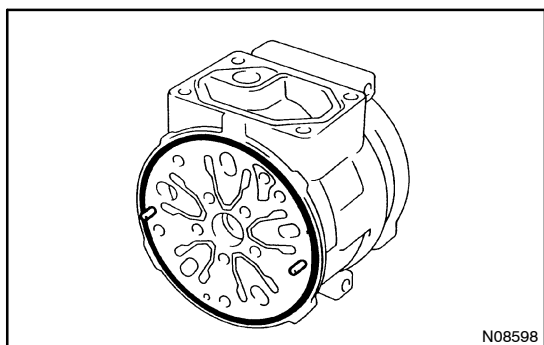
HINT:

Clean up the surface of the shaft seal with compressor oil.



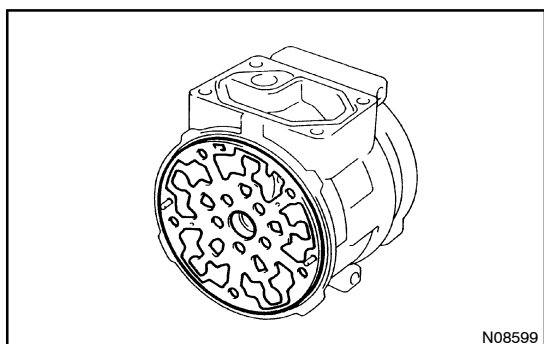
- (2) Using SST, install the snap ring.

SST 07114-84010



- (b) Install rear housing on cylinder block.

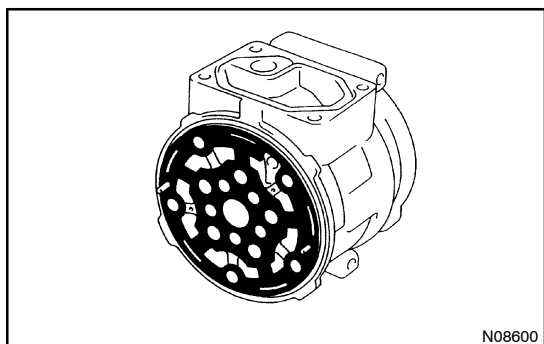
- (1) Install 2 pins on cylinder block.
- (2) Lubricate a new O-ring with compressor oil and install the O-ring on cylinder block.
- (3) Install the suction reed valve over the pins on the cylinder.



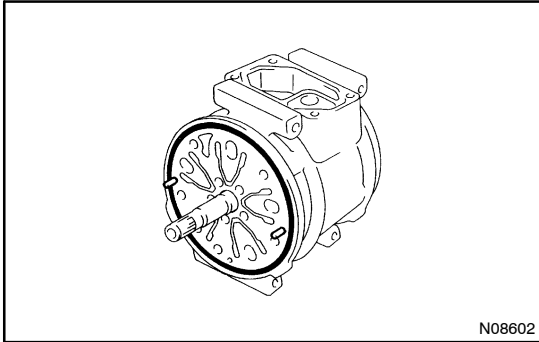
- (4) Install the rear valve plate together with the discharge valve over the pins on the cylinder block.

HINT:

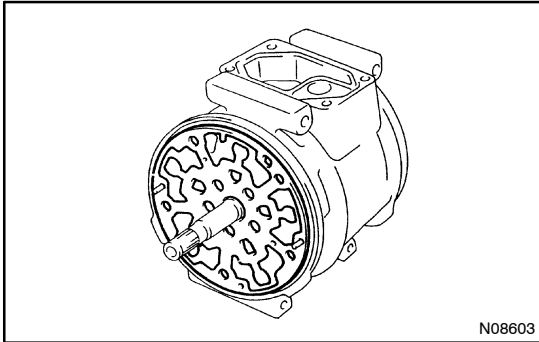
The rear valve plate is marked with an "R".



- (5) Lubricate a new gasket with compressor oil and install the gasket on the valve plate.
- (6) Install the rear housing on cylinder block.



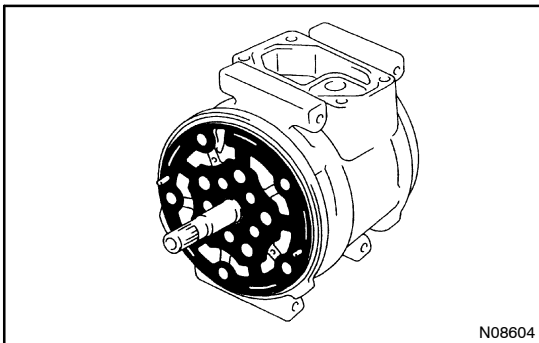
- (c) Install the front housing on cylinder block.
- (1) Install the 2 pins on cylinder block.
 - (2) Lubricate a new O-ring with compressor oil and install the O-ring on cylinder block.
 - (3) Install the front suction reed valve over the pins on the cylinder block.



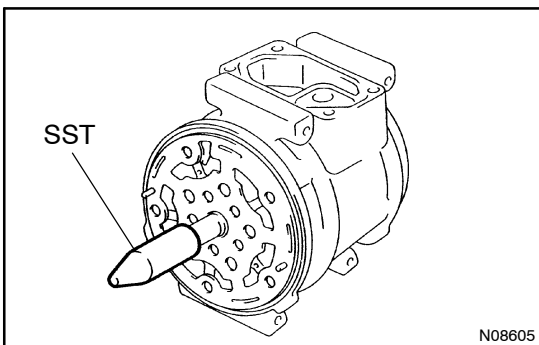
- (4) Install the valve plate together with the discharge reed valve over the pins on the cylinder block.

HINT:

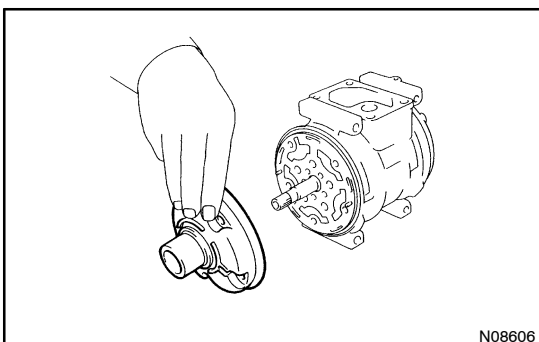
The front valve plate is marked with an "F".



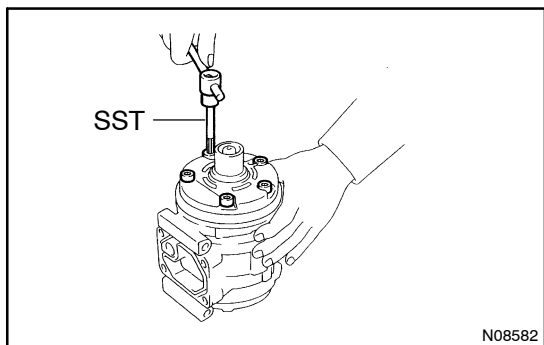
- (5) Lubricate a new gasket with compressor oil and install the gasket on the valve plate.



- (6) Set SST on the shaft to protect the lip seal.



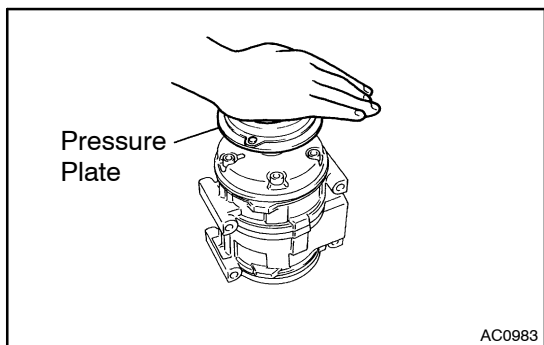
- (7) Install the front housing on the cylinder block.
- (8) Remove SST from the shaft.



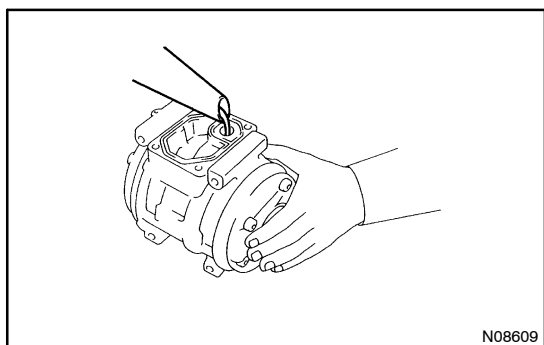
- (9) Using SST and torque wrench, gradually tighten the 5 through bolts 2 or 3 times.

SST 07110-61050

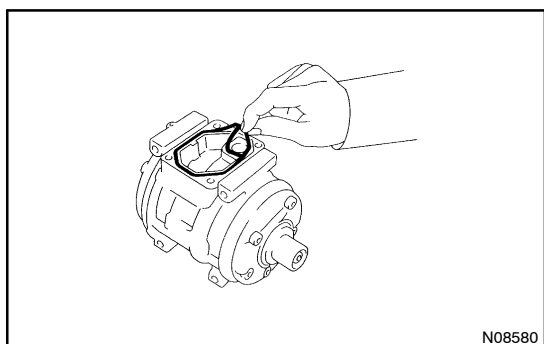
Torque: 25 N·m (250 kgf·cm, 18 ft·lbf)



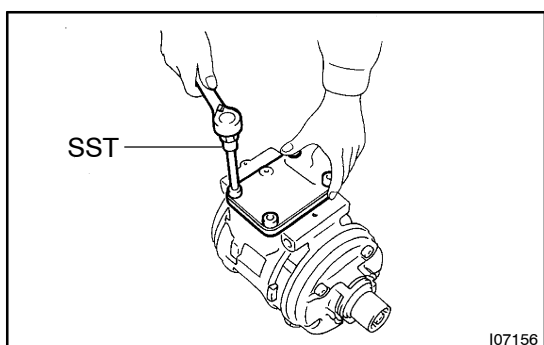
- (d) Install the felt.
- (1) Set the felt with felt holder to front housing.
 - (2) Using pressure plate of magnetic clutch, install the felt.



- (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.



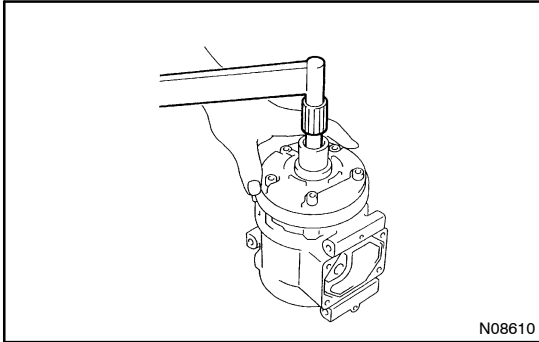
- (f) Install the service valve.
- (1) Lubricate a new seal ring with compressor oil and install the seal ring on cylinder block.



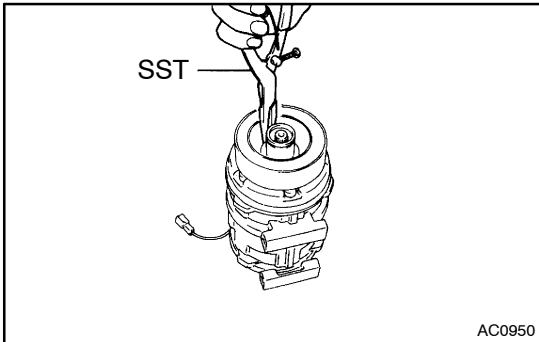
- (2) Using SST and torque wrench, install the service valve with the 4 bolts.

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

- (3) Connect the connector.

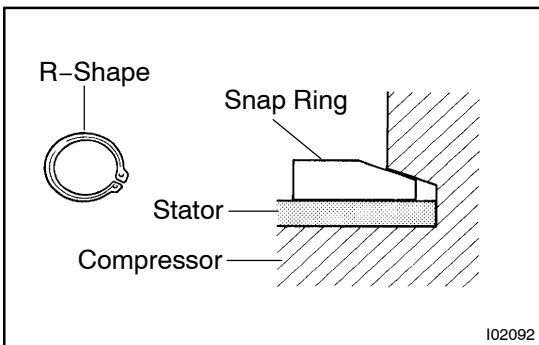


- (g) Check shaft starting torque.
Torque: 2.9 N·m (30 kgf·cm, 26 in.·lbf)



2. ASSEMBLE MAGNETIC CLUTCH

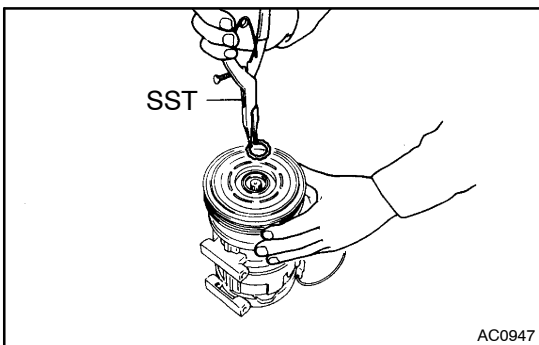
- (a) Install the stator.
 (1) Install the stator on compressor.
 (2) Using SST, install the new snap ring.
 SST 07114-84020



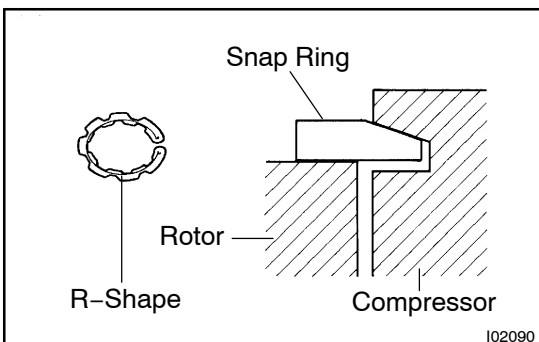
NOTICE:

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

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

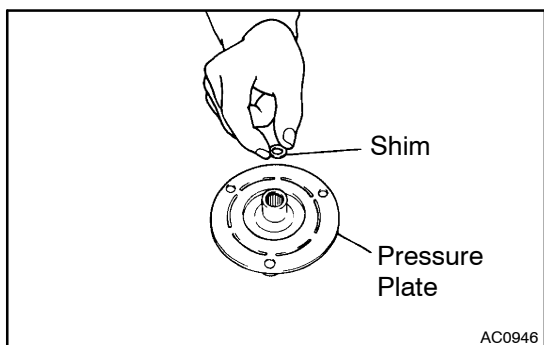


- (b) Install the rotor.
 (1) Install the rotor on compressor.
 (2) Using SST, install the new snap ring.
 SST 07114-84020

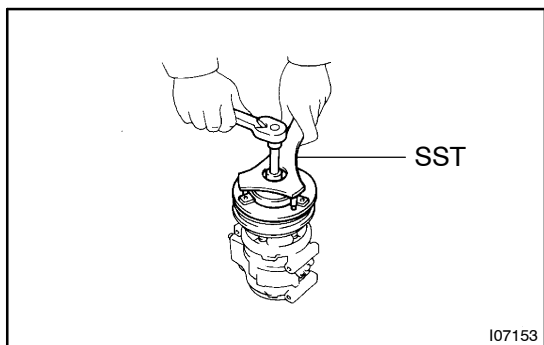


NOTICE:

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



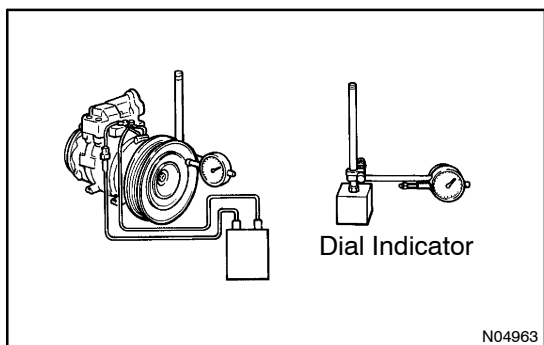
- (c) Install the pressure plate.
 (1) Install the shims to pressure plate.



- (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. INSPECT 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 ± 0.15 mm (0.020 ± 0.0059 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.)