

## REASSEMBLY

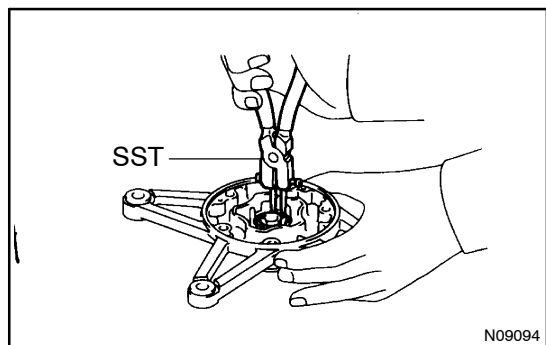
### 1. G.C.C. Countries Only:

#### ASSEMBLE COMPRESSOR

#### (a) Install new shaft seal.

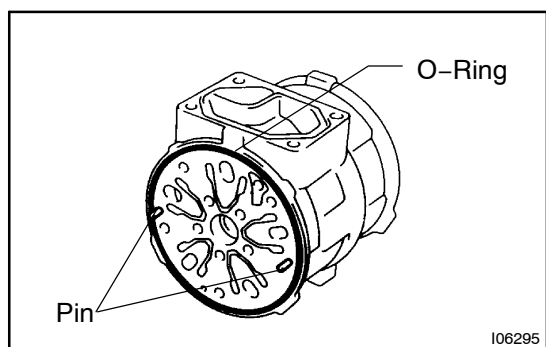
- (1) Fit the shaft seal onto SST and install the shaft seal into the front housing.

SST 07112-85020



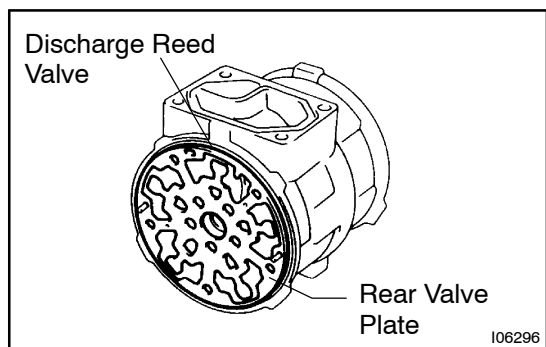
- (2) Using SST, install the new snap ring.

SST 07114-84010



#### (b) Install rear housing onto cylinder block.

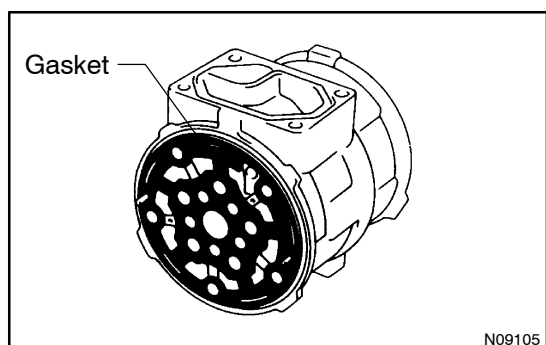
- (1) Install the 2 pins on cylinder block.
- (2) Lubricate a new O-ring with compressor oil and install the O-ring on cylinder block.
- (3) Install the suction reed valve over the pins in the cylinder.



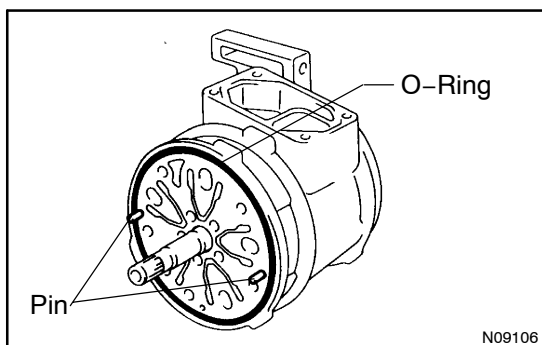
- (4) Install the rear valve plate together with the discharge valve over the pins on the cylinder block.

#### HINT:

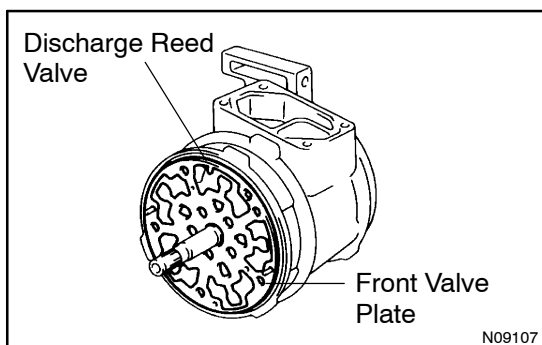
The rear valve plate is marked with an "R".



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



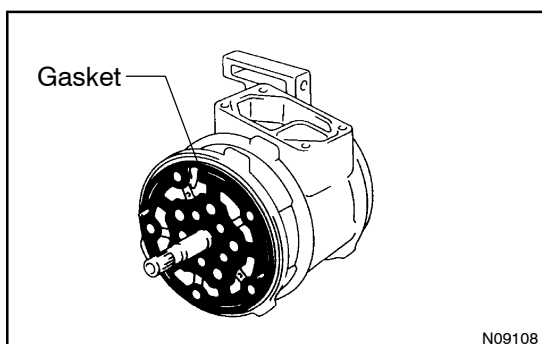
- (c) Install the front housing on cylinder block.
- (1) Install the 2 pins on cylinder block.
  - (2) Lubricate a new O-ring with compressor oil and install the O-ring in the front housing.
  - (3) Install the front suction reed valve over the pins on the cylinder block.



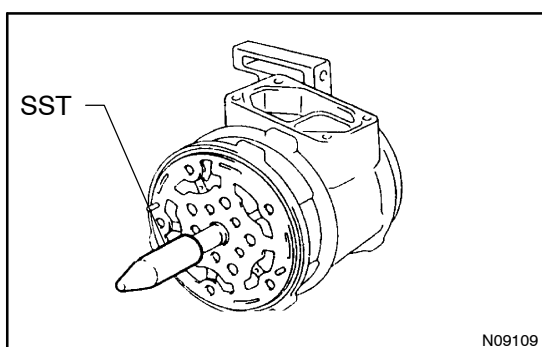
- (4) Install the front valve plate together with the discharge reed valve over the pins on the cylinder block.

HINT:

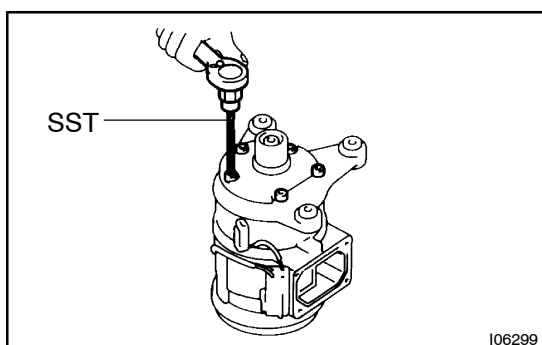
The front valve plate is marked with an "F".



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



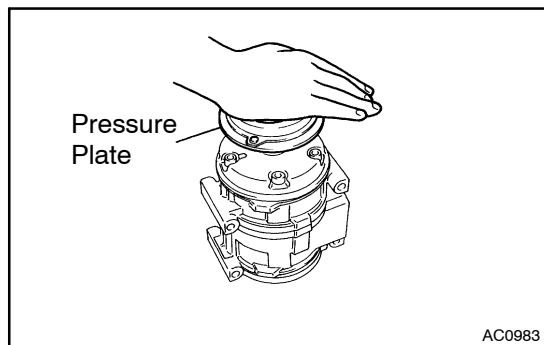
- (6) Set SST on the shaft to protect the shaft seal.
- (7) Install the front housing on the cylinder block.
- (8) Remove SST from the shaft.



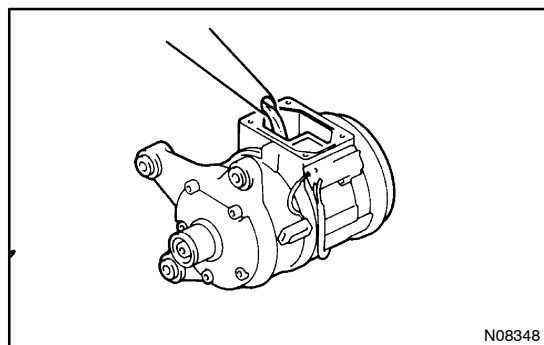
- (9) Using SST and torque wrench, gradually tighten the 5 through bolts with 5 new washers 2 or 3 times.

SST 07110-61050

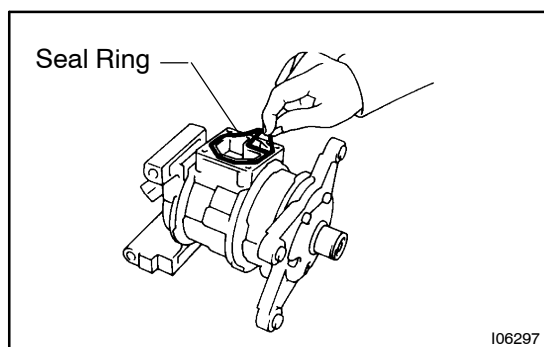
**Torque: 25 N·m (250 kgf·cm, 18 ft·lbf)**



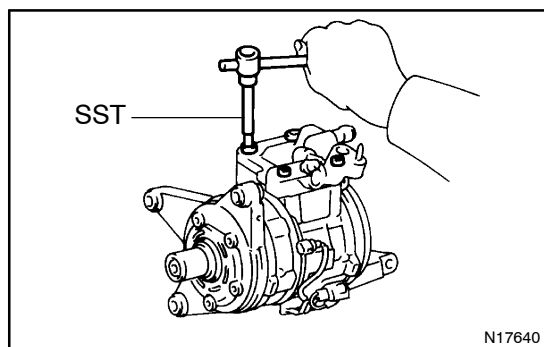
- (d) Install the felt.
- (1) Set the felt with felt holder to front housing.
  - (2) Using a pressure plate of magnetic clutch, install the felt.



- (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**



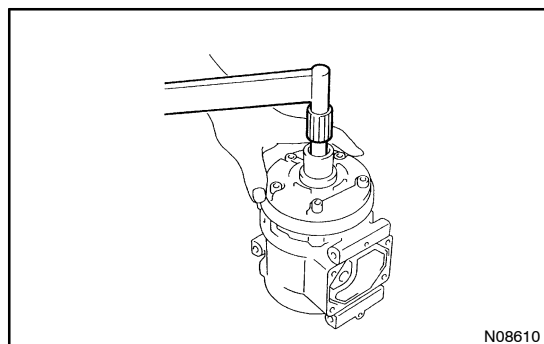
- (f) Install the service valve.
- (1) Lubricate a new seal ring with compressor oil and install the seal ring on cylinder block.



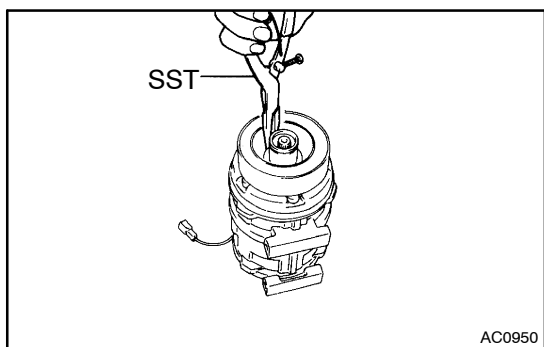
- (2) Using SST and torque wrench, install the service valve with 4 bolts.

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

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



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



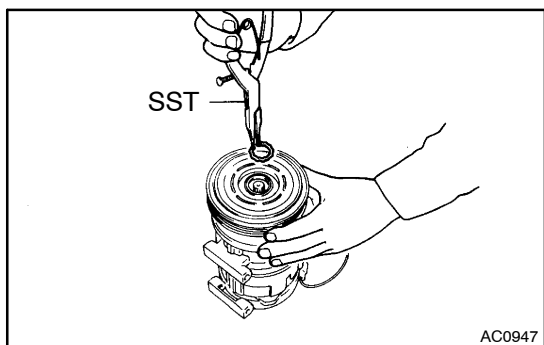
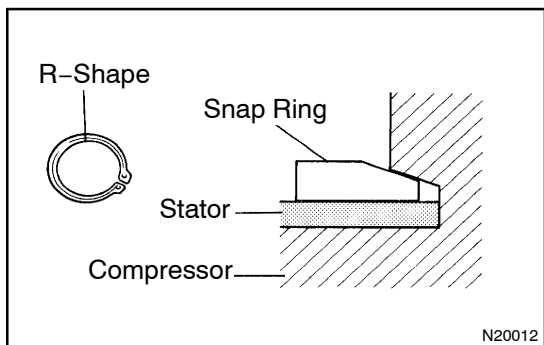
## 2. ASSEMBLE MAGNETIC CLUTCH

- (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.

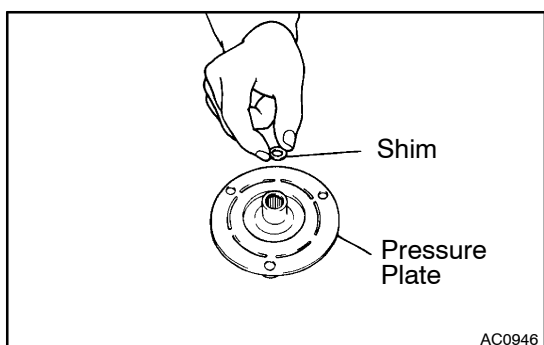
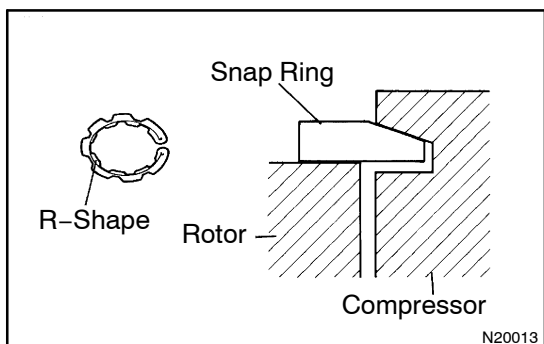
- (3) Connect the stator lead wire to the compressor.



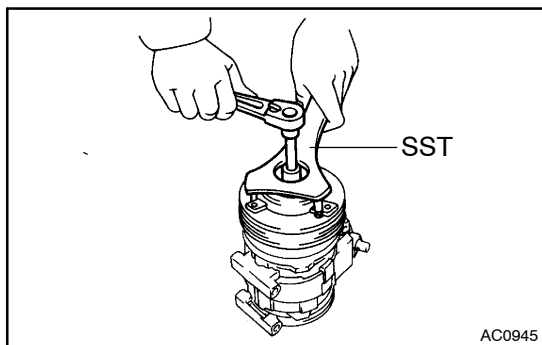
- (b) Install the rotor.
- (1) Install the rotor on the compressor.
  - (2) Using SST, install the new snap ring.
- SST 07114-84020

### NOTICE:

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



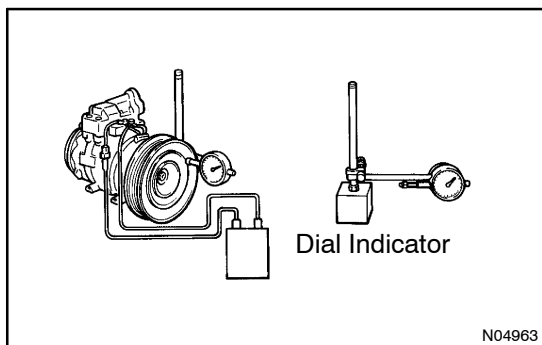
- (c) Install the pressure plate.
- (1) Install the shims to the pressure plate.
  - (2) Install the pressure plate on the rotor.



- (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 ± 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.)**