

all copper dust. Clean shaft of any grease that may have accumulated copper dust.

- (6) Remove three screw and washer assemblies (164) and retainer plate (165) from DE frame (3).
- (7) Inspect DE ball bearing assembly (4). If bearing appears dry or if rotor assembly (8) did not turn smoothly when checked during DE frame disassembly, remove and replace bearing. Bearing is permanently lubricated. Do not attempt to add grease.

IMPORTANT POINTS - ASSEMBLY

1. DE FRAME AND COMPONENTS

(1) Install or Connect

- a. DE ball bearing assembly (4) and retainer plate (165) to DE frame (3) with three screw and washer assemblies (164).

Tightening Torque:

3.0 N·m (31 kgf·cm, 26 lbf·in)

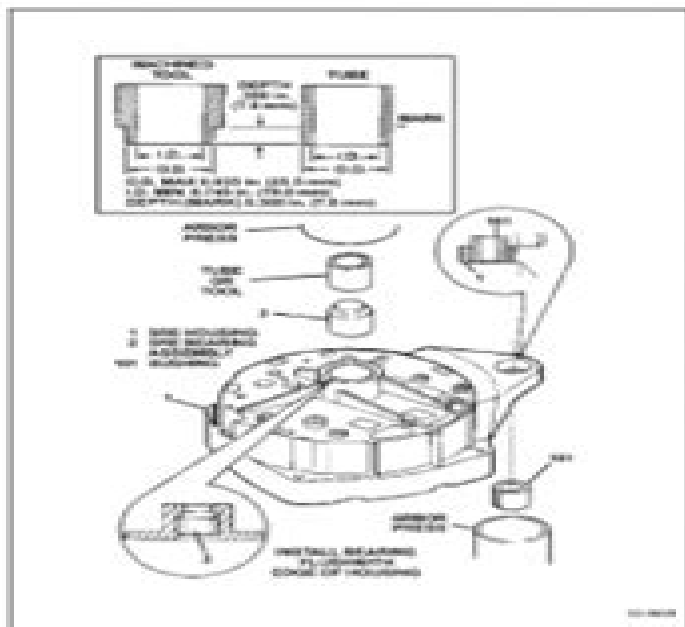
- b. Rotor assembly (8) into DE housing (3) assembly.
- c. Fan (11), pulley, washer (163), and hexagon nut (162) onto rotor assembly (8) shaft.

Tightening Torque:

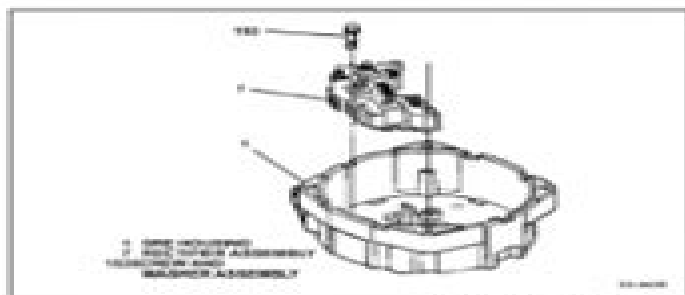
100 N·m (1,020 kgf·cm, 75 lbf·ft)

NOTICE

Hold shaft with 5/16" hexagonal wrench in socket end or wrap rotor assembly in shop cloth and tighten in vise just enough to hold while tightening hexagon nut.



CAUTION 1061100024



CAUTION 1061100025

2. SRE HOUSING AND COMPONENTS

(1) Install or Connect

- a. Lightly lubricate outside surface of bushing (161). Press bushing into hole in lug on SRE housing (1). Install bushing flush with inside of lug to allow maximum distance between two hinge lugs for mounting. Final position of hinge bushing will be adjusted during installation.
- b. SRE roller bearing assembly (2) into SRE housing (1). Use suitable tube or tool to press SRE roller bearing in position, flush with outside lip of SRE housing. Cover opening in bearing with piece of tape to prevent dirt from entering during rest of procedure.
- c. Rectifier assembly (7) to SRE housing (1) assembly. Install one screw and washer assembly (153) through rectifier assembly grounded heat sink into SRE housing. Finger tighten.

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M Carnoy



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