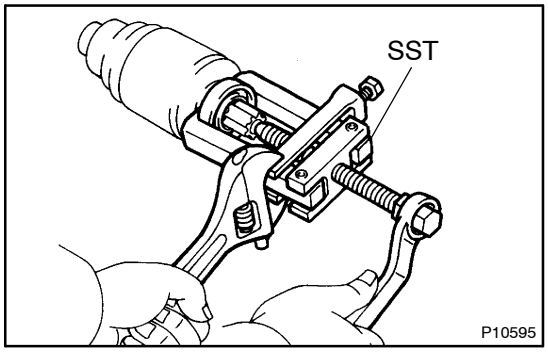
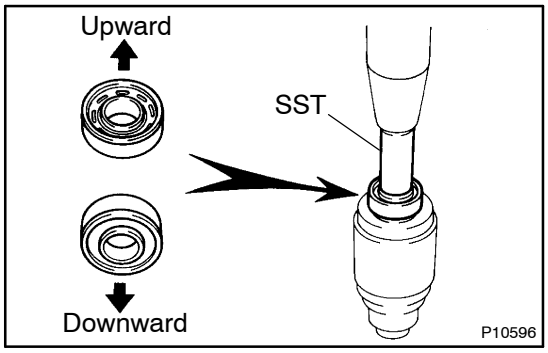
ST052–05



REPLACEMENT

1. REPLACE FRONT BEARING

(a) Using SST, remove the bearing.
SST 09286–46011

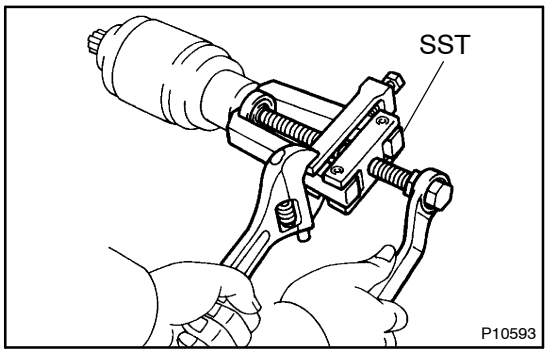


(b) Using SST and a press, press in a new bearing.

NOTICE:

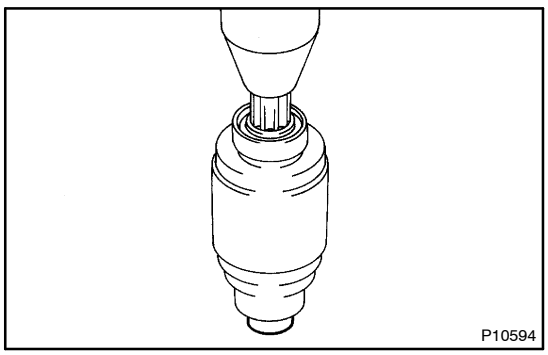
Be careful of the bearing installation direction.

SST 09820–00031

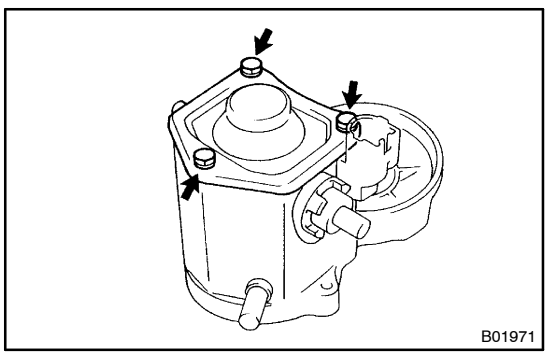


2. REPLACE REAR BEARING

(a) Using SST, remove the bearing.
SST 09286–46011

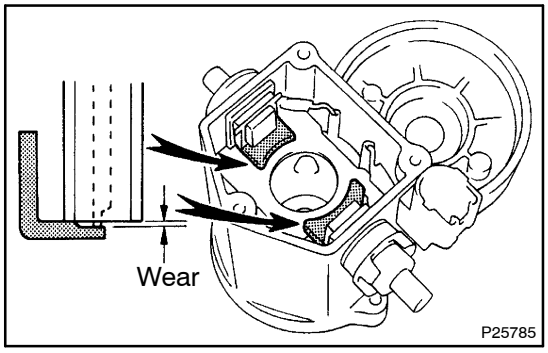


(b) Using a press, press in a new rear bearing.



3. REPLACE MAGNETIC SWITCH TERMINAL PARTS

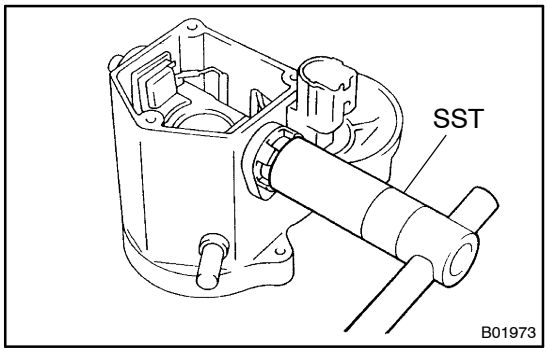
(a) Remove the 3 bolts, end cover, gasket and plunger.



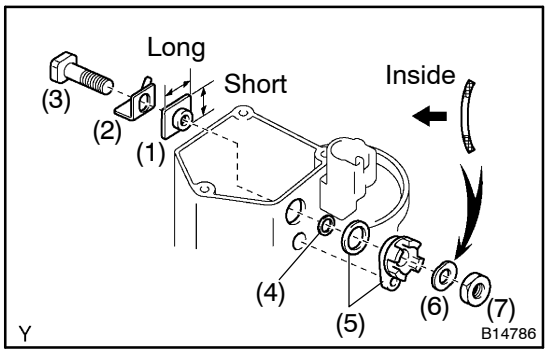
(b) Using vernier calipers, measure the contact plate for depth of wear.

Maximum wear: 0.9 mm (0.035 in.)

If the depth of wear is greater than the maximum, replace the contact plate.



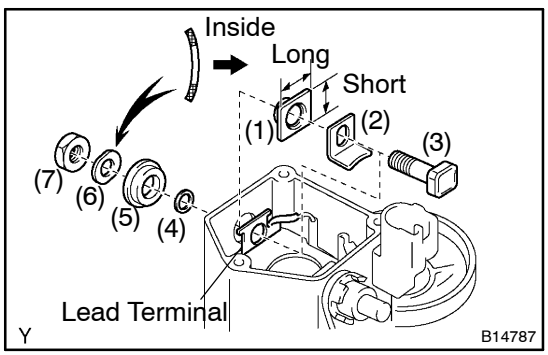
(c) Using SST, remove the terminal C and 30 kit parts.
SST 09810–38140



(d) Temporarily install new terminal 30 kit parts.
(1) Terminal insulator (inside)
(2) Contact plate
(3) Terminal bolt
(4) O–ring
(5) Packing and terminal insulator (outside)
(6) Wave washer
(7) Terminal nut

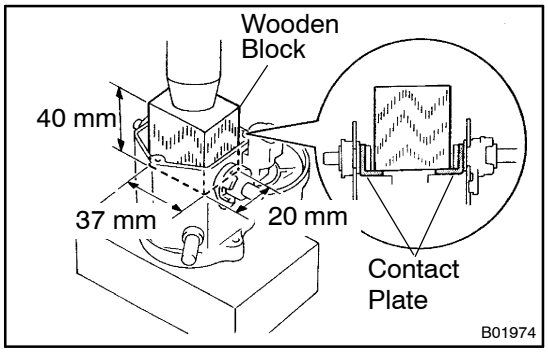
NOTICE:

Be careful to install the terminal insulators and wave washer in the correct direction.



(e) Temporarily install new terminal C kit parts.
(1) Terminal insulator (inside)
(2) Contact plate
(3) Terminal bolt
(4) O–ring
(5) Terminal insulator (outside)
(6) Wave washer
(7) Terminal nut

NOTICE:
Be careful to install the terminal insulators in the correct direction.



(f) Tighten the terminal nut

(1) Put a wooden block on the contact plate and press it down with a hand press.

Dimensions of wooden block:
20 x 37 x 40 mm (0.79 x 1.46 x 1.57 in.)
Press force:
981 N (100 kgf, 221 lbf)

NOTICE:

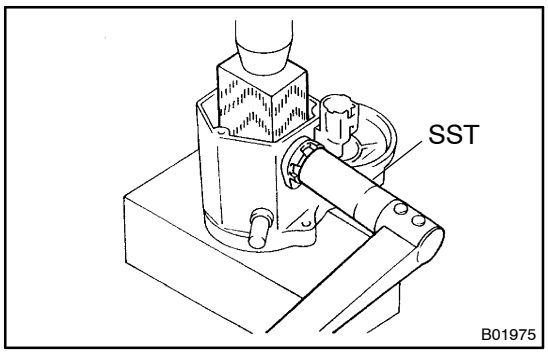
- **Check the diameter of the hand press ram. Then calculate the gauge pressure of the press when 981 N (100 kgf, 221 lbf) of force is applied.**
  Gauge pressure:

$$(\text{kgf/cm}^2) = \frac{100\ \text{kgf}}{\left(\frac{\text{Ram diameter (cm)}}{2}\right)^2 \times 3.14\ (\pi)}$$

$$(\text{psi}) = \frac{221\ \text{lbf}}{\left(\frac{\text{Ram diameter (in.)}}{2}\right)^2 \times 3.14\ (\pi)}$$

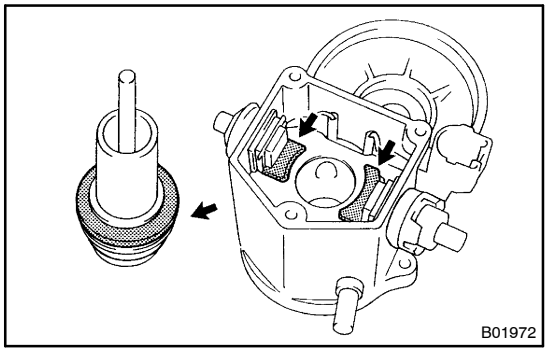
(kPa) = (kgf/cm^2) x 98.1
(kPa) = (psi) x 6.9

- **If the contact plate is not pressed down with the specified pressure, the contact plate may tilt due to coil deformation or the tightening of the nut.**



(2) Using SST, tighten the nuts to the specified torque.
SST 09810–38140
Torque: 17 N·m (173 kgf·cm, 13 ft·lbf)

NOTICE:
If the nut is over tightened, it may cause cracks on the inside of the insulator.



(g) Clean the contact surfaces of the remaining contact plate and plunger with a dry shop rag.

(h) Reinstall the plunger, new gasket, end cover and lead clamp with the 3 bolts.
Torque: 2.5 N·m (26 kgf·cm, 22 in.·lbf)