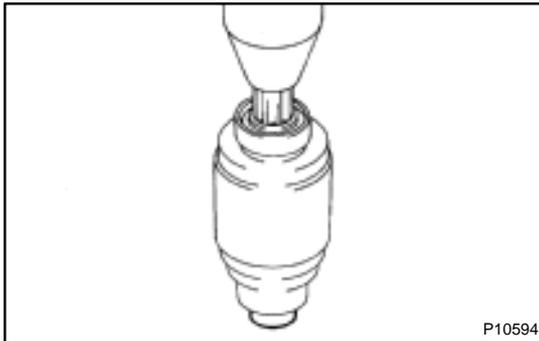


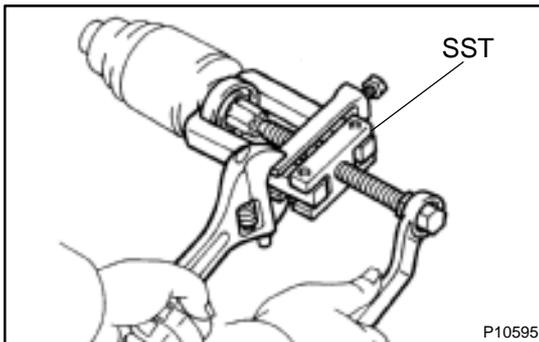
## REPLACEMENT

### 1. REPLACE FRONT BEARING

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

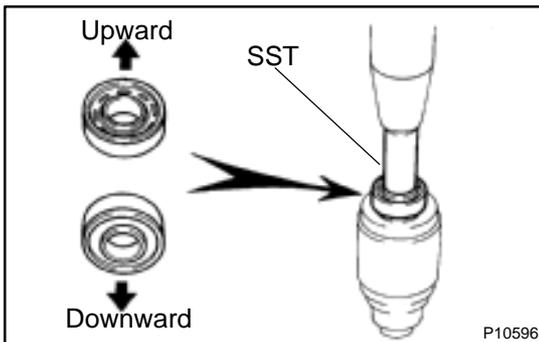


- (b) Using a press, press in a new bearing.



### 2. REPLACE REAR BEARING

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

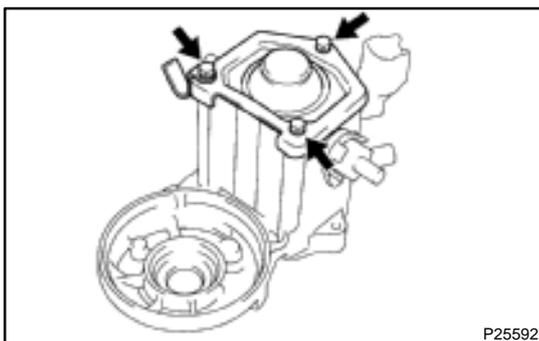


- (b) Using SST and a press, press in a new bearing.

#### NOTICE:

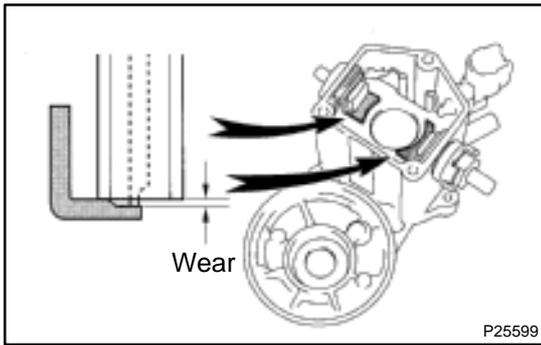
**Be careful of the bearing installation direction.**

SST 09820-00030



### 3. REPLACE MAGNETIC SWITCH TERMINAL KIT PARTS

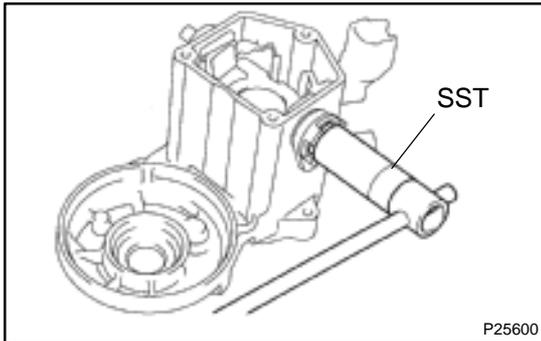
- (a) Remove the 3 bolts, lead clamp (1.8 kw) end cover, gasket and plunger.



- (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) Remove the terminal kit parts.

- (1) Using SST, loosen the terminal nuts.

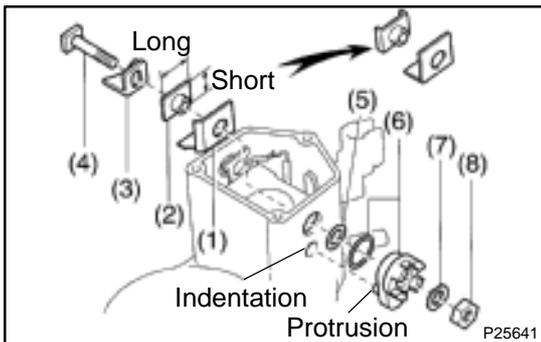
SST 09810-38140

- (2) Terminal C:

Remove the terminal nut, wave washer, terminal insulator (outside), O-ring, terminal bolt, contact plate and terminal insulator (inside).

- (3) Terminal 30:

Remove the terminal nut, wave washer, terminal insulator (outside), packing, O-ring, terminal bolt, contact plate, terminal insulator (inside) and insulation paper.



- (d) Temporarily install these new terminal 30 kit parts:

- (1) Insulation paper  
(2) Terminal insulator (inside)

**NOTICE:**

**Be careful to install the terminal insulator (inside) in the correct direction.**

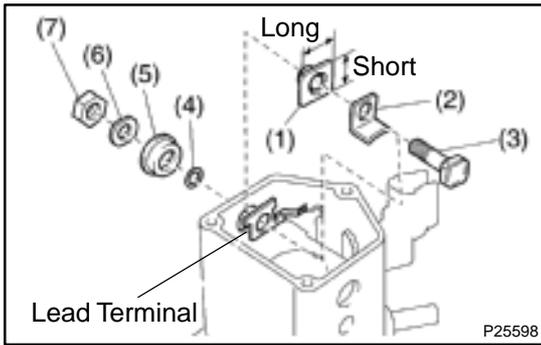
- (3) Contact plate  
(4) Terminal bolt  
(5) O-ring  
(6) Packing and terminal insulator (outside)

Install the packing to the terminal insulator, and install them.

**HINT:**

Match the protrusion of the insulator with the indentation of the housing.

- (7) Wave washer  
(8) Terminal nut



(e) Temporarily install these new terminal C kit parts:

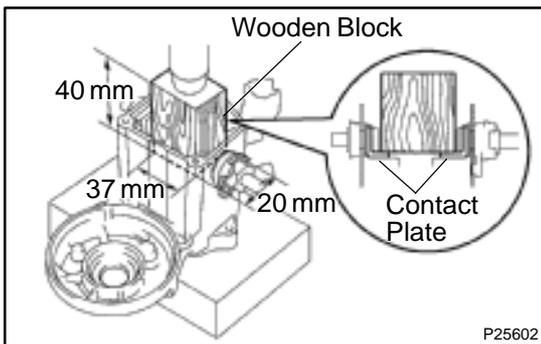
- (1) Terminal insulator (inside)

**NOTICE:**

**Be careful to install the terminal insulator (inside) in the correct direction.**

- (2) Contact plate
- (3) Terminal bolt
- (4) O-ring
- (5) Terminal insulator (outside)
- (6) Wave washer
- (7) Terminal nut

(f) Temporarily tighten the terminal nuts.



(g) Tighten the terminal nuts.

- (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:**

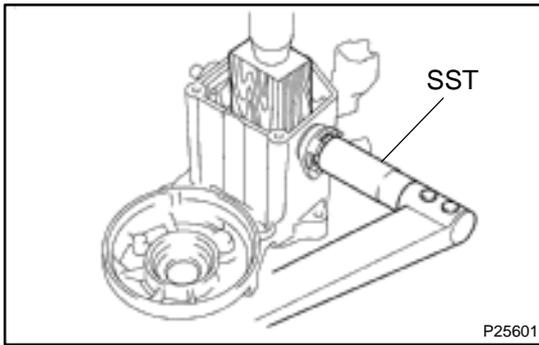
$$(\text{kgf/cm}^2) = \frac{100 \text{ kgf}}{\left(\frac{\text{Ram diameter (cm)}}{2}\right)^2 \times 3.14 (\pi)}$$

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

$$(\text{kPa}) = (\text{kgf/cm}^2) \times 98.1$$

$$(\text{kPa}) = (\text{psi}) \times 6.9$$

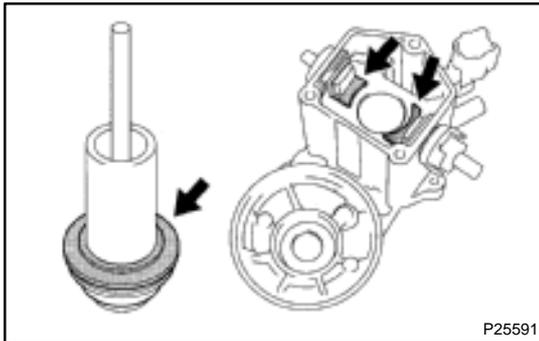
- If the contact plate is not pressed down with the specified pressure, the contact plate may tilt due to coil deformation or the tightening of the nut.



- (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.**



- (h) Clean the contact surfaces of the remaining contact plate and plunger with a dry shop rag.  
 (i) Reinstall the plunger, a new gasket, the end cover and lead clamp (1.8 kW) with the 3 bolts.

**Torque:**

**2.5 N·m (25 kgf·cm, 22 in.-lbf) for 1.4 kW**

**3.6 N·m (37 kgf·cm, 32 in.-lbf) for 1.8 kW**