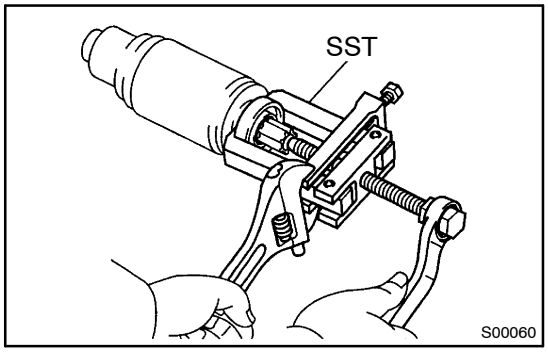
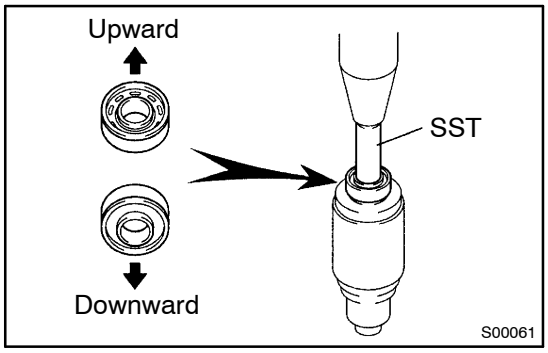
ST05C–03

REPLACEMENT



1. REPLACE FRONT BEARING

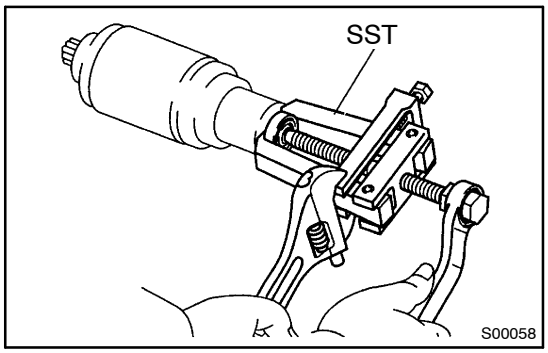
(a) Using SST, remove the bearing.
SST 09286–46011



(b) Using SST and a press, press in a new bearing.
SST 09820–00030

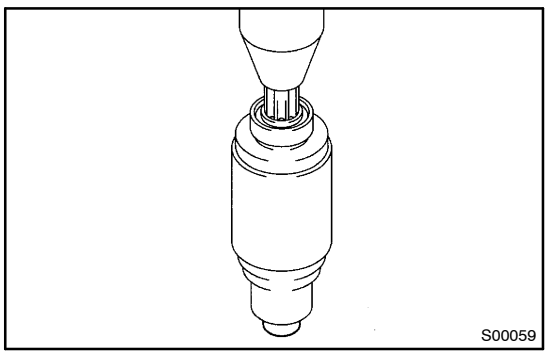
NOTICE:

Be careful of the installation direction.

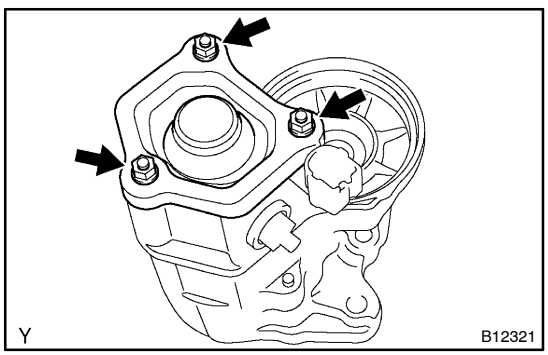


2. REPLACE REAR BEARING

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



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

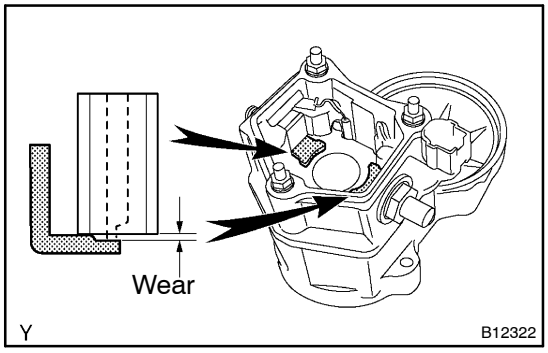


3. REPLACE MAGNETIC SWITCH TERMINAL KIT PARTS

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

NOTICE:

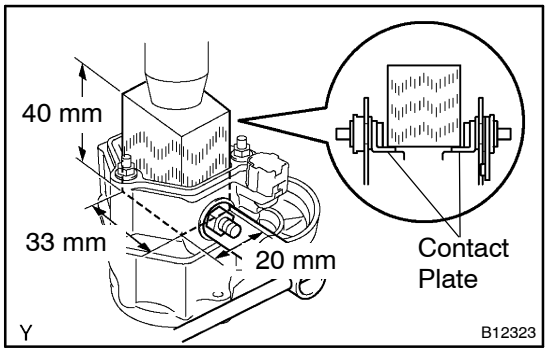
Do not loosen the 3 stud bolts.



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

Dimensions of wooden block:
20 x 33 x 40 mm (0.79 x 1.30 x 1.57 in.)
Press force: 981 N (100 kgf, 221 lbf)

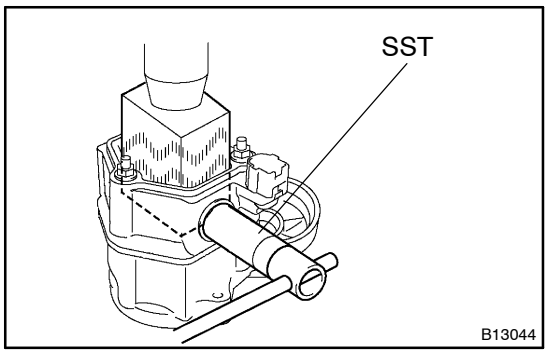
NOTICE:

- **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:

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

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

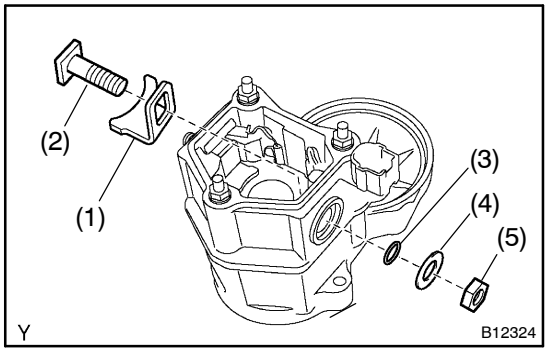
  (kPa) = (kgf/cm^2) x 98.1
  (kPa) = (psi) x 6.9
- **If the contact plate is not pressed down with the specified pressure, the contact plate may tilt due to coil deformation or the tightening of the nut.**



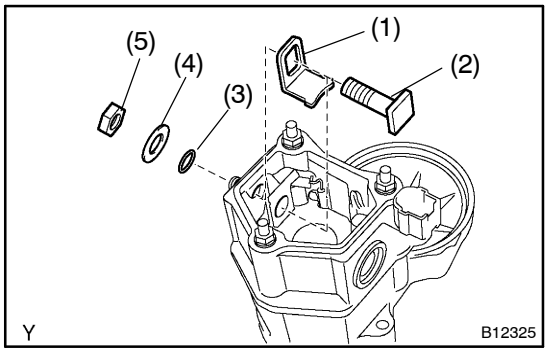
(2) Using SST, loosen the terminal nuts.
SST 09810–38140

(3) Terminal C:
Remove the terminal nut, washer, O–ring, terminal bolt and contact plate.

(4) Terminal 30:
Remove the terminal nut, washer, O–ring, terminal bolt and contact plate.

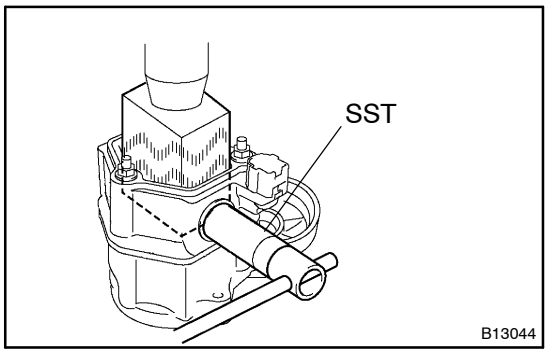


(d) Temporarily install these new terminal 30 kit parts:
(1) Install the new contact plate.
(2) Install the new terminal bolt.
(3) Install the new O–ring.
(4) Install the new washer.
(5) Install the new terminal nut.



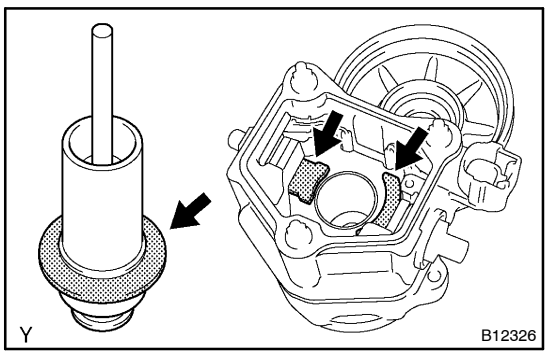
(e) Temporarily install these new terminal C kit parts:
(1) Install the new contact plate.
(2) Install the new terminal bolt.
(3) Install the new O–ring.
(4) Install the new washer.
(5) Install the new terminal nut.

(f) Temporarily tighten the terminal nuts.

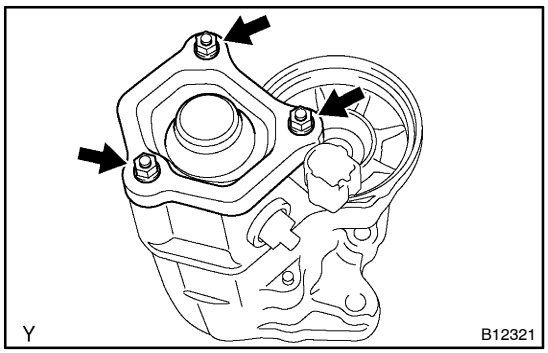


(g) Tighten terminal nuts.
(1) Put a wooden block on the contact plate and press it down with a hand press.
(2) Using SST, tighten the nuts to the specified torque.
SST 09810–38140
Torque: 17 N·m (173 kgf·cm, 13 ft·lbf)

NOTICE:
If the nut is over tightened, it may cause cracks on the plastic frame.



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



(i) Reinstall the plunger, a new gasket and end cover with the 3 nuts.
Torque:
1.4 kW: 2.5 N·m (25 kgf·cm, 22 in.·lbf)
2.0 kW: 3.6 N·m (37 kgf·cm, 32 in.·lbf)