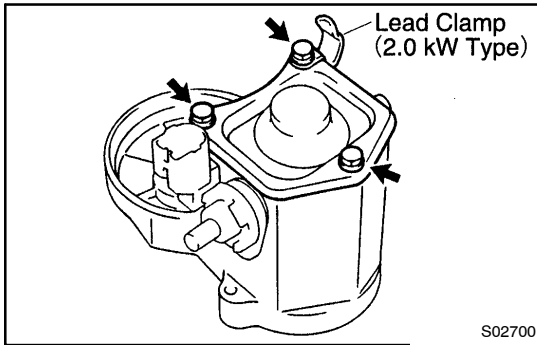
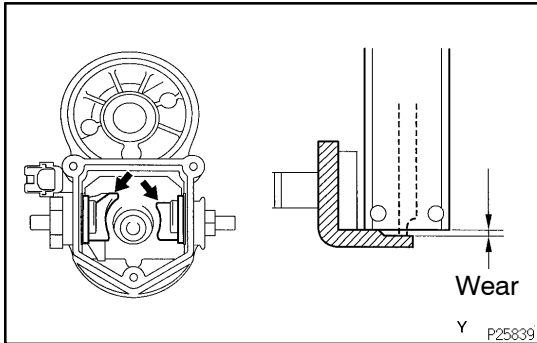




REPLACEMENT

1. REMOVE MAGNETIC SWITCH END COVER

Remove the 3 bolts, lead clamp (2.0 kW type), end cover, gasket and plunger.

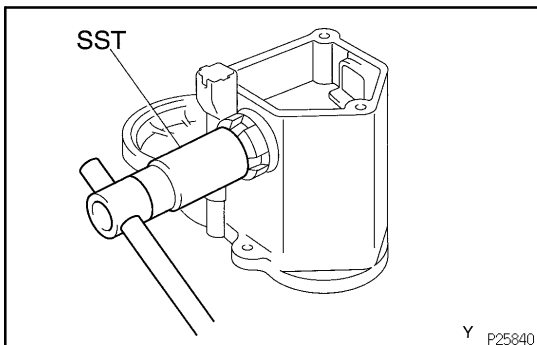


2. INSPECT CONTACT PLATE FOR WEAR

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.



3. REMOVE TERMINAL KIT PARTS

(a) Using SST, loosen the terminal nuts.

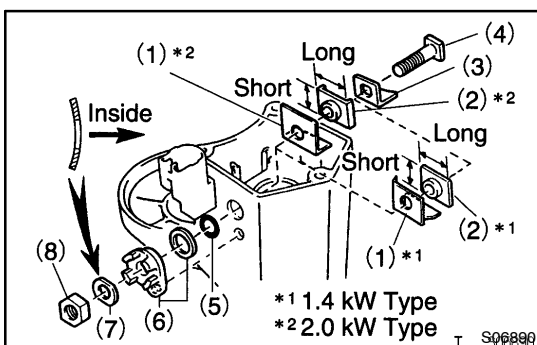
SST 09810-38140

(b) Terminal C:

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

(c) Terminal 30:

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



4. REINSTALL TERMINAL KIT PARTS

(a) Install the new parts to the terminal 30.

(1) Install the insulation paper.

(2) Install the terminal insulator (inside).

(3) Install the contact plate.

(4) Install the terminal bolt.

(5) Install the O-ring.

(6) Install the packing to the terminal insulator (outside), and install them.

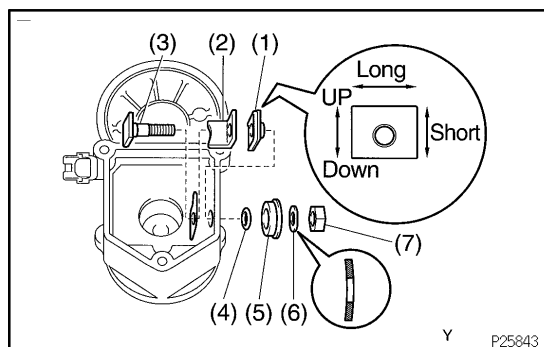
HINT:

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

- (7) Install the wave washer.
- (8) Install the terminal nut.

NOTICE:

Be careful to install the terminal insulators (inside) and wave washers in the correct direction.

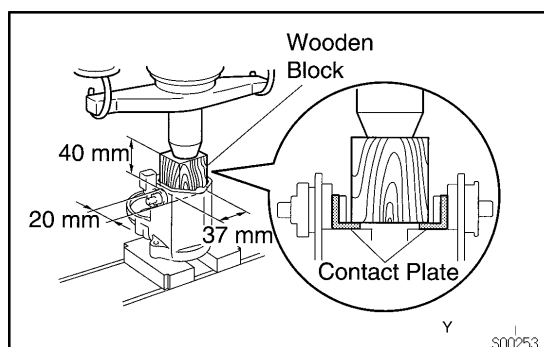


- (b) Install the new parts to the terminal C.
 - (1) Install the terminal insulator (inside).
 - (2) Install the contact plate.
 - (3) Install the terminal bolt.
 - (4) Install the O-ring.
 - (5) Install the terminal insulator (outside).
 - (6) Install the wave washer.
 - (7) Install the terminal nut.

NOTICE:

Be careful to install the terminal insulators (inside) and wave washers in the correct direction.

- (c) Temporarily tighten the terminal nuts.

**5. TIGHTEN TERMINAL NUT**

- (a) 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:

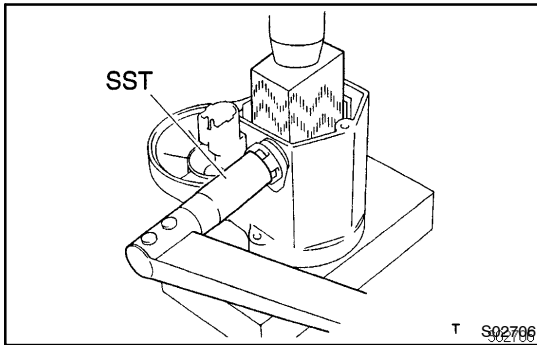
$$(\text{kgf/cm}^2) = \frac{100 \text{ kgf}}{\left(\frac{\text{Ram diameter (cm)}}{2} \right)^2 \times 3.14 (\pi)}$$

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

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

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

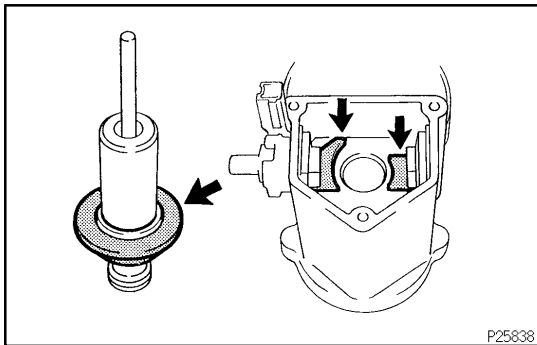
V06796



- (b) Using SST, tighten the nuts to the specified torque.
 SST 09810-38140
Torque: 17 N·m (173 kgf·cm, 12 ft·lbf)

NOTICE:

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



6. CLEAN CONTACT SURFACES OF CONTACT PLATE AND PLUNGER

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

7. REINSTALL MAGNETIC SWITCH END COVER

Install the plunger, new gasket, end cover and lead clamp with the 3 bolts.

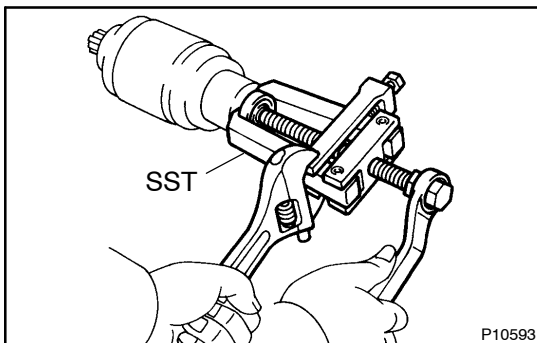
Torque:

1.4 kW type: 2.5 N·m (25 kgf·cm, 22 in·lbf)

2.0 kW type: 3.6 N·m (37 kgf·cm, 32 in·lbf)

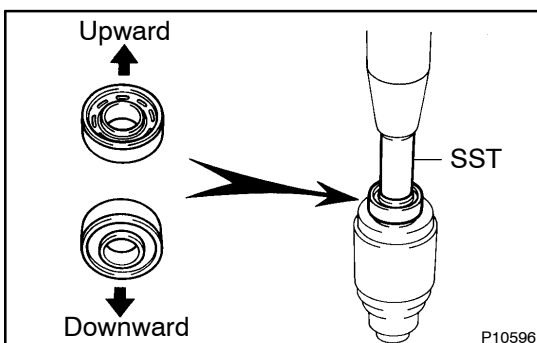
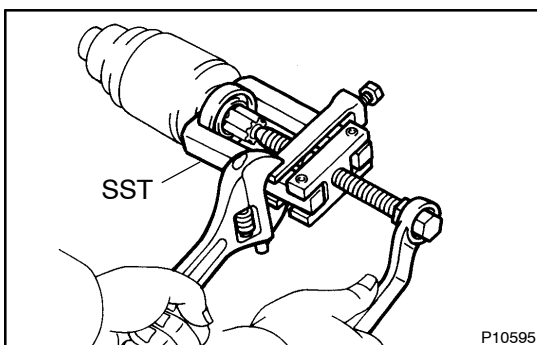
8. REPLACE REAR BEARING

- (a) Using SST, remove the bearing.
 SST 09286-46011
 (b) Using a press, press in a new bearing.



9. REPLACE FRONT BEARING

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



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

NOTICE:

Be careful of the bearing installation direction.

SST 09820-00030