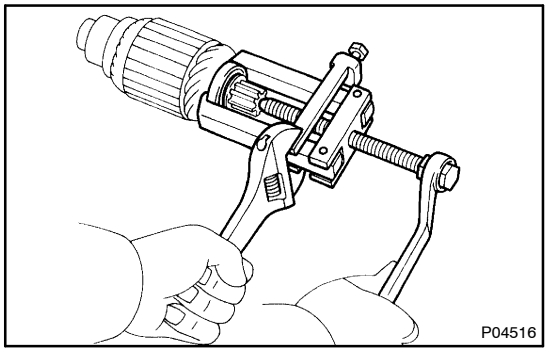
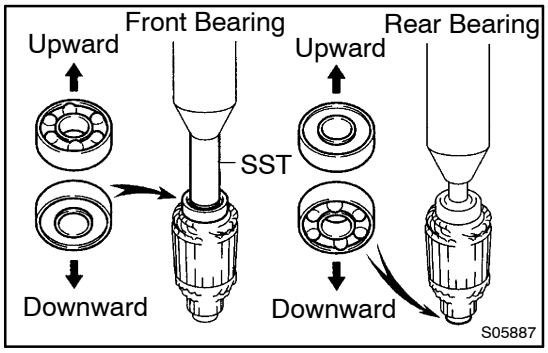
ST0OF–02

# REPLACEMENT




**1. IF NECESSARY, REPLACE BEARING**

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




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

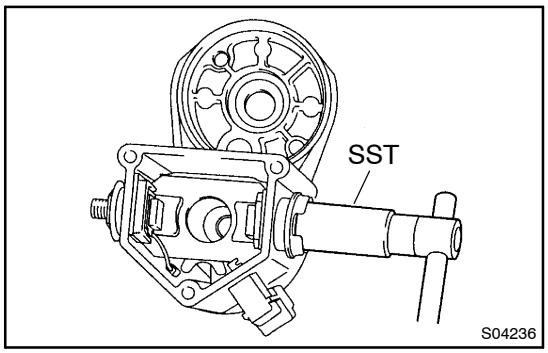
(c) Using a press, press in a new rear bearing.

**NOTICE:**

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

**2. REMOVE MAGNETIC SWITCH END COVER**

Remove the 3 bolts, end cover, gasket and plunger.

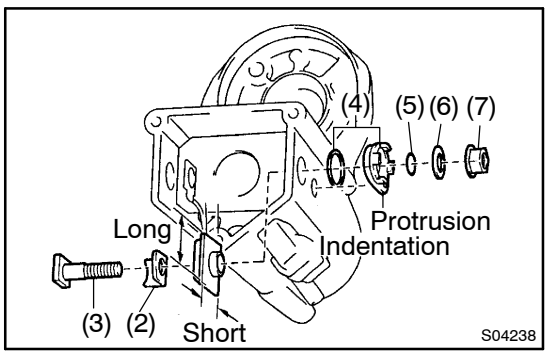



**3. REMOVE TERMINAL KIT PARTS**

(a) Using SST, loosen the terminal nuts.
SST 09810–38170

(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, washer, terminal insulator (outside), packing , O–ring, terminal bolt, contact plate, terminal insulator (inside) and insulation paper.




**4. REINSTALL TERMINAL KIT PARTS**

(a) Install these new parts:

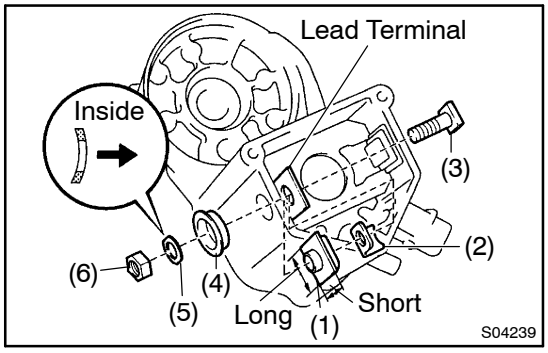
(1) Terminal 30:
(1) Terminal insulator (inside)
(2) Contact plate
(3) Terminal bolt
(4) Packing and terminal insulator (outside)
(5) O–ring
(6) Washer

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

(7) Terminal nut

**NOTICE:**

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




(2) Terminal C:
(1) Terminal insulator (inside)
(2) Contact plate
(3) Terminal bolt
(4) Terminal insulator (outside)
(5) Wave washer
(6) Terminal nut

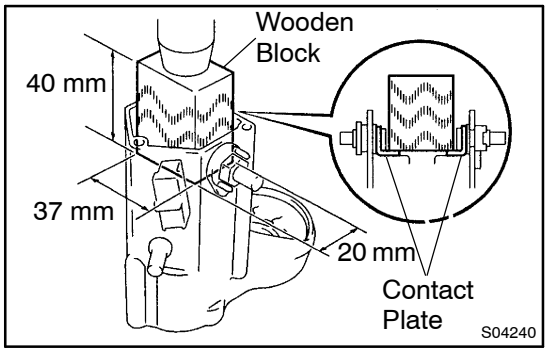
**NOTICE:**

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

(b) Temporarily tighten the terminal nuts.

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

**Dimensions of wood block:**
**20 x 37 x 40 mm (0.97 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 applied.**
  **Gauge pressure**

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

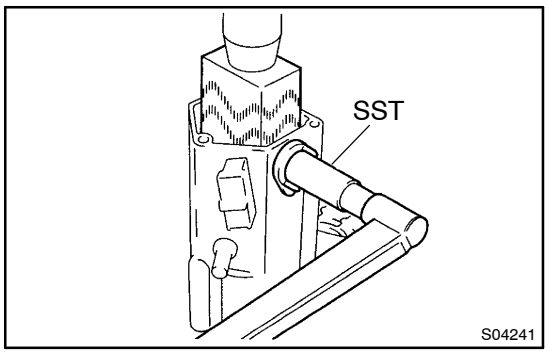
$$(\text{psi}) = \frac{221\ \text{lbf}}{\left(\frac{\text{Ram diameter (in.)}}{2}\right)^2 \times 3.14\ (\pi)}$$

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

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

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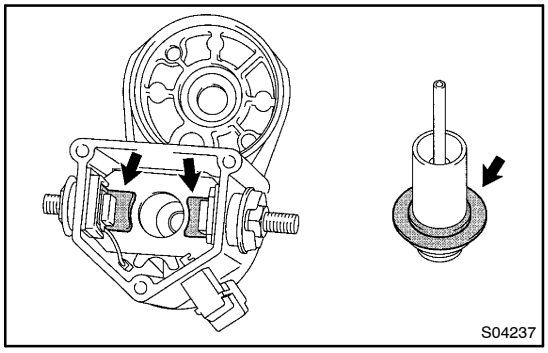
- **If the contact plate is not pressed down with the specified pressure, the contact plate may tilt due to coil deformation or the tightening of the nut.**




(d) Using SST, tighten the nuts to the specified torque.
SST 09810–38170
**Torque: 17 N·m (170 kgf·cm, 12 ft·lbf)**

**NOTICE:**

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




**5. CLEAN CONTACT SURFACES OF CONTACT PLATE AND PLUNGER**

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

**6. REINSTALL MAGNETIC SWITCH END COVER**

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

**Torque: 3.6 N·m (36 kgf·cm, 32 in.·lbf)**