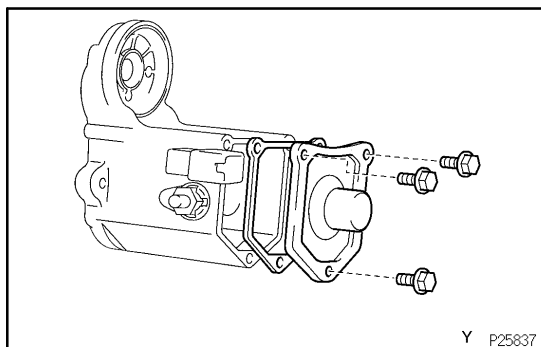
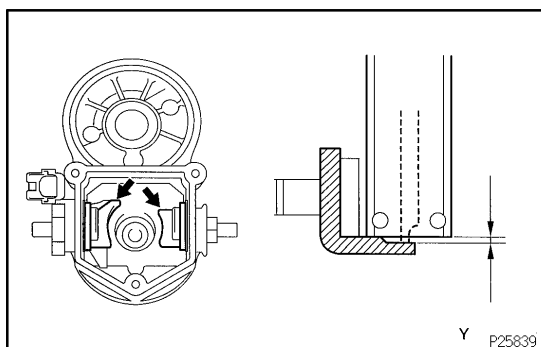




## REPLACEMENT

### 1. REMOVE MAGNETIC SWITCH END COVER

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

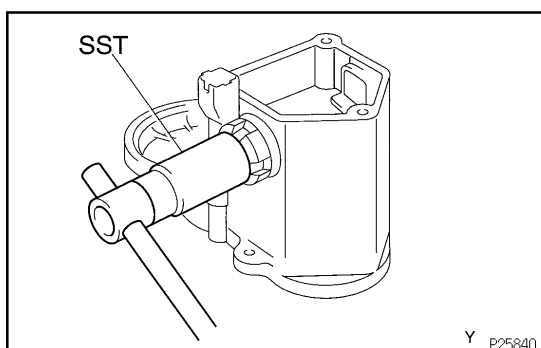


### 2. INSPECT CONTACT PLATE FOR WEAR

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.

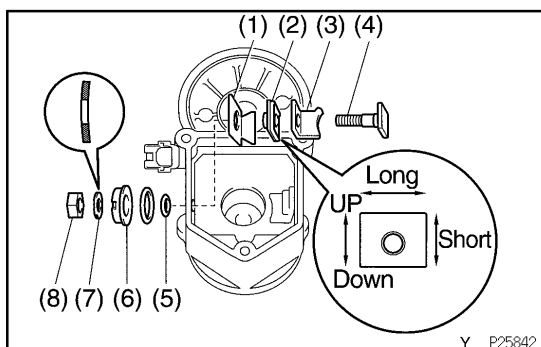
SST 09810-38140

(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) Terminal 30:

Install these new parts:

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

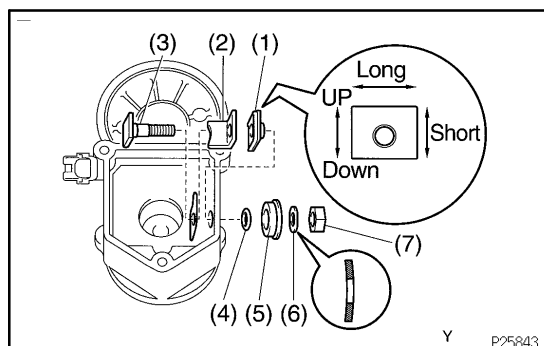
**HINT:**

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

- (7) Wave washer  
(8) Terminal nut

**NOTICE:**

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

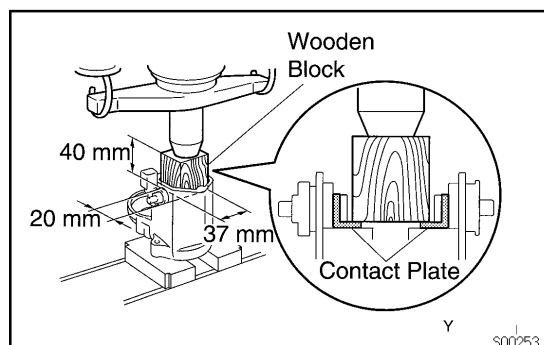


- (b) Terminal C:  
Install these new parts:
- (1) Terminal insulator (inside)
  - (2) Contact plate
  - (3) Terminal bolt
  - (4) O-ring
  - (5) Terminal insulator (outside)
  - (6) Wave washer
  - (7) Terminal nut

**NOTICE:**

**Be careful to install the terminal insulators (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:

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

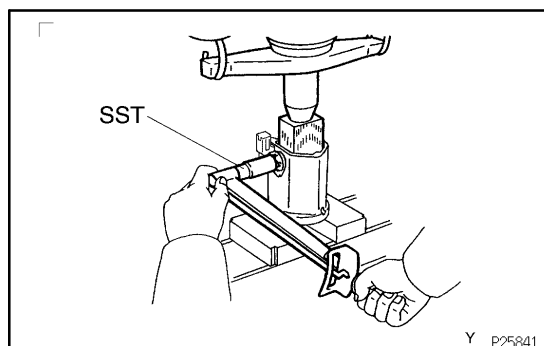
$$(\text{psi}) = \frac{221 \text{ lbf}}{\left( \frac{\text{Ram diameter (in.)}}{2} \right)^2 \times 3.14 (\pi)}$$

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

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

V06796

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.

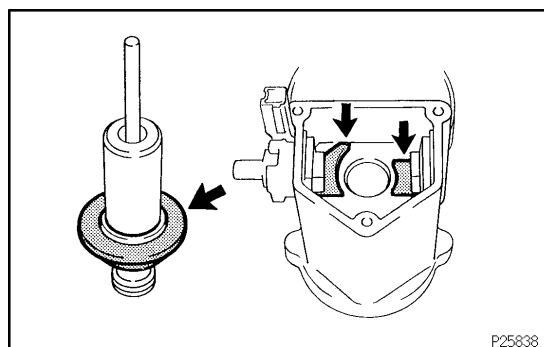


- (b) Using SST, tighten the nuts to the specified torque.  
SST 09810-38140

**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)**