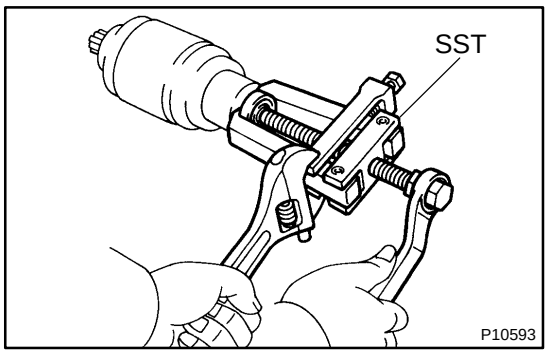
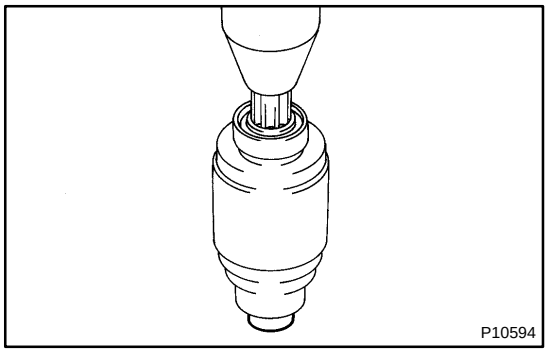
ST0HY–02

# REPLACEMENT

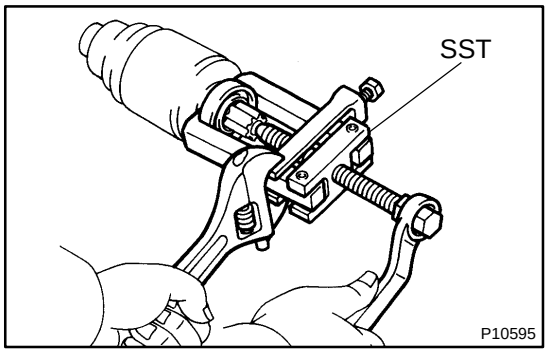



**1. REPLACE FRONT BEARING**

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

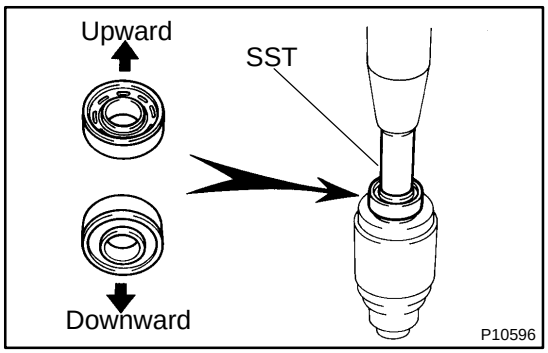



(b) Using a press, press in a new bearing.




**2. REPLACE REAR BEARING**

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

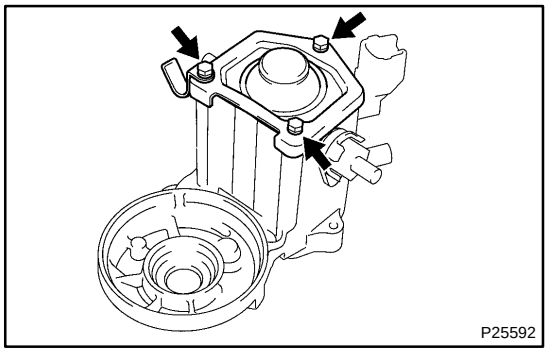



(b) Using SST and a press, press in a new bearing.

**NOTICE:**

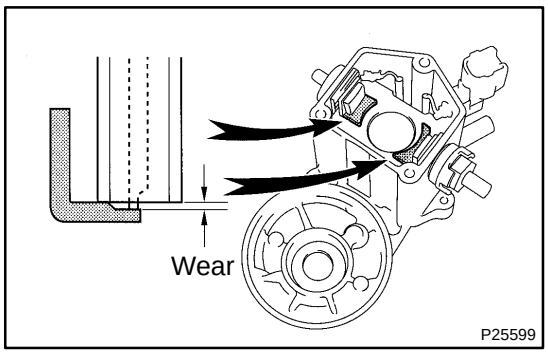
**Be careful of the bearing installation direction.**

SST 09820–00031




**3. REPLACE MAGNETIC SWITCH TERMINAL KIT PARTS**

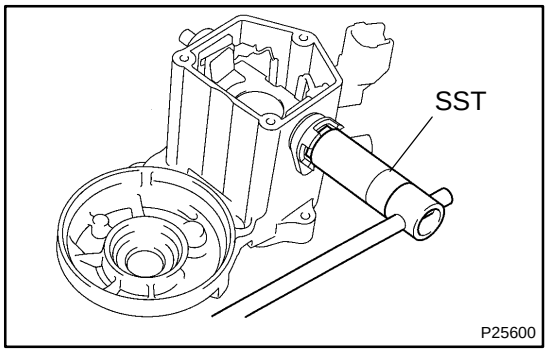
(a) Remove the 3 bolts, lead clamp (1.8 kw) end cover, gasket and plunger.




(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.

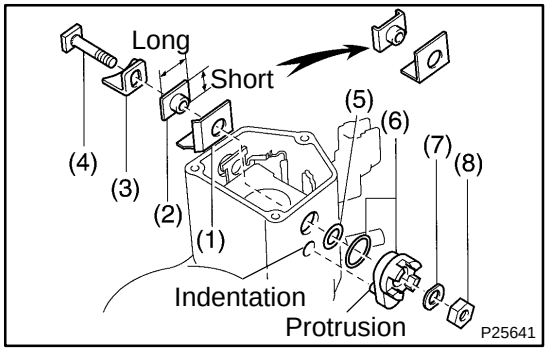
SST 09810–38140

(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)

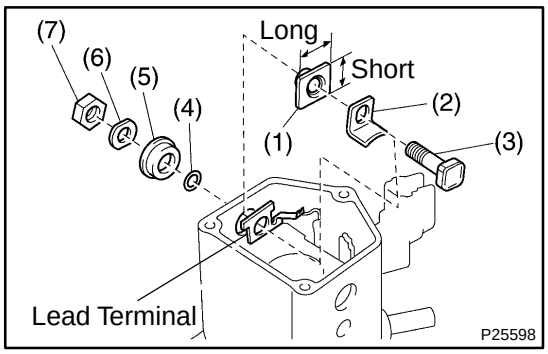
Install the packing to the terminal insulator, and install them.

HINT:

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

(7) Wave washer

(8) Terminal nut



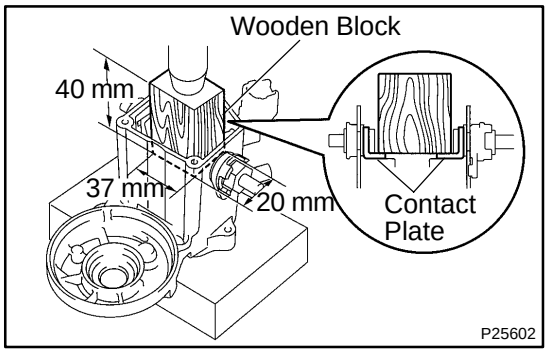

(e) Temporarily install these new terminal C kit parts:
(1) Terminal insulator (inside)

**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:**

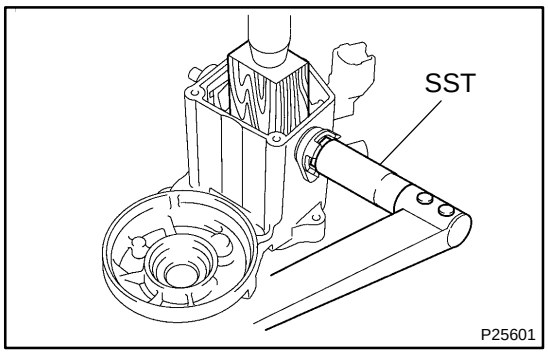
$$(\text{kgf/cm}^2) = \frac{100\ \text{kgf}}{\left(\frac{\text{Ram diameter (cm)}}{2}\right)^2 \times 3.14\ (\pi)}$$

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

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

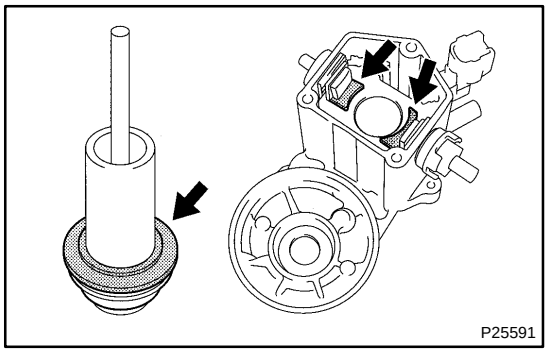
$$(\text{kPa}) = (\text{psi}) \times 6.9$$

- **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 clanp (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**