

GP - Motor-to-Bearing Housing O Ring Replacement

Assuming the compressor is already pulled down and exposed to atmosphere, perform the following:

1. Remove the discharge and suction service valves.
2. Disconnect the solenoid valve coils, high pressure cutout switch flare, and oil line at the bearing housing.
3. Loosen all the bolts at the motor-bearing housing mating surface. The oil filter housing bolts do not need to be removed.
4. Use an impact wrench to loosen the motor rotor bolt.
5. Loosen the rotor bolt and bearing housing bolts enough so the O ring can be removed, and the O ring groove inspected for damage. Clean the groove and mating surfaces
6. Cover all sharp edges with smooth plastic or cardboard, and slightly stretch the new O ring over the bearing housing. It is important that the new O ring not rub against any rough or sharp edges.
7. Put a thin film of gasket eliminator such as Loctite 515 on the new O ring and install.
8. Reassemble the motor and bearing housings. Install the motor-rotor bolt with one or two drops of Loctite 271 and torque to 150 ft-lb.
9. Torque the motor-bearing housing bolts to 170 ft-lb.
10. Install new gaskets and replace the suction and discharge service valves. Torque to 175 ft-lb.

<u>Qty</u>	<u>Part Number</u>	<u>Description</u>
1.....	GKT 3271	Suction Cover Gasket
1.....	RNG 1436	Motor-to-Bearing Housing O Ring
1.....	GKT 2704	Suction Service Valve Gasket (for 35-40 ton compressors)
<u>OR</u> 1.....	GKT 2706	Suction Service Valve Gasket (for 50-60 ton compressors)
1.....	GKT 2704	Discharge Service Valve Gasket
3.....	RNG 1397	Female Unload Solenoid Valve O rings
4.....	GKT 1612	Male Load/Unload Solenoid Valve Gaskets (2 per solenoid)