



INTER-OFFICE LETTER

TO	MR. W. A. BARNES	ATLANTA	(A)	FROM	M. A. LEWIS	DATE	11/2/70
	MR. D. BIBBINS	TR-20	(A)				
	MR. DUNCAN COCHRANE	BRAMALEA	(A)	OFFICE	MS SERVICE ENGINEERING		
	MR. F. A. DELEIN	LOS ANGELES	(A)				
	MR. JAMES ENANDER	CHICAGO	(A)	SUBJECT	19 SERIES MACHINES		
	MR. L. M. FORSS	A & R	(A)		SPARK PLUG STYLE OIL		
	MR. R. LANGONE	NEW YORK	(A)		<u>PUMP TERMINALS</u>		
	MR. J. L. NEVA	DALLAS	(A)				
							FIELD EXPERIENCE REPORT 70-4
	MR. H. E. GRIFFIN	LOS ANGELES	(C)				
	MR. H. A. JOHNSON	DALLAS	(C)				
	MR. R. JOHNSTON	TR-20	(C)				
	MR. R. T. MITCHELL	CHICAGO	(C)				
	MR. J. MOSES	ATLANTA	(C)				
	MR. A. M. PETOSA	NEW YORK	(C)				
	MR. R. VAN DERPOOL	A & R	(C)				
	MR. M. WARDLE	BRAMALEA	(C)				
	MR. WILLIAM GROTH	TR-20	(C)				

As a part of a priority program to eliminate leak sources on subject machines, the oil pump terminals on the 19EA have been changed from the 19D13-742 bushing seal style to a spark plug style, 19EA41-2082. This change will eventually affect the 19DG machine.

19D13-742 terminals on 19D, 19DA, 19DG, and 19EA oil pumps can be removed and with some rework, the 19EA41-2082 can be installed on these machines. This rework involves removal of the oil pump assembly from the machine and tapping the existing 7/16 holes with a 1/4" pipe tap. It is suggested that any such rework be on a planned basis; that is, when a machine is down for some reason, or on an "on hand" oil pump as a "rainy day" project.

Installation instructions are enclosed for 19D series oil pumps. On a 19EA oil pump assembly the procedure is similar but a little easier. Remove the oil pump and cover assembly, remove the oil pump, and tap the 7/16 holes in the cover.

These terminals can also replace the 19D11-742 terminals used on 19D Ideal Motors for bringing out the bearing and motor thermostat leads, the 19C47-582 oil pump terminals, and the 19C37-582 bearing and motor thermostat terminals.

The Baltimore, Philadelphia, and Los Angeles Offices have tried out these terminals and have given us much help by providing us with detailed reports of their installation experience.

MAL/bq
Enclosure

FILE INSTRUCTIONS: COMPRESSOR, DRIVER, GEARS

For Replacing 19D13-742 Terminals on 19D Series
Oil Pumps with 19EA41-2082 Spark Plug Style

Material Required:

- 3 - 19EA41-2082 Terminals
- 3 - Stakon Spade Terminal Lugs
- Electrical Tape
- Loctite*
- 1/4 - 18 Pipe tap

Procedure:

- 1) Disconnect and remove oil pump assembly.
- 2) Remove oil filter, drain out excess oil.
- 3) Remove oil pump motor and disconnect the leads.
- 4) Remove cooling coil, shield, and baffle.
- 5) Remove top terminal hardware, Items 1 through 6, on all three terminals.
- 6) Clip leads, Item 8, off bottom of terminal, Item 7. It is important that this lead is cut off as close to the bottom of the terminal as possible. If this is not done the lead will be too short.
- 7) After all three leads are off, remove terminal feedthrus by driving them through the casting. Remove Items 9 and 10 by driving them through (they are probably sealed in with glyptal).
- 8) Push one of the wires up through one of the holes.
- 9) Strip exactly 1/4" insulation from the wire.
- 10) Crimp a 1/4" spade lug to the wire.
- 11) Repeat steps 8 through 10 for the other two wires, push wires back through holes out of the way.
- 12) Tap the three 7/16" holes with 1/4" pipe tap.
- 13) Treat the pipe threads on the new terminals with Loctite* and install the terminals in the newly tapped holes. Flat of one terminal must be facing adjacent terminal in order to install it.
- 14) Fasten to spades on bottom of terminal as shown in accompanying sketch. Check to make sure the leads are dressed away from each other.

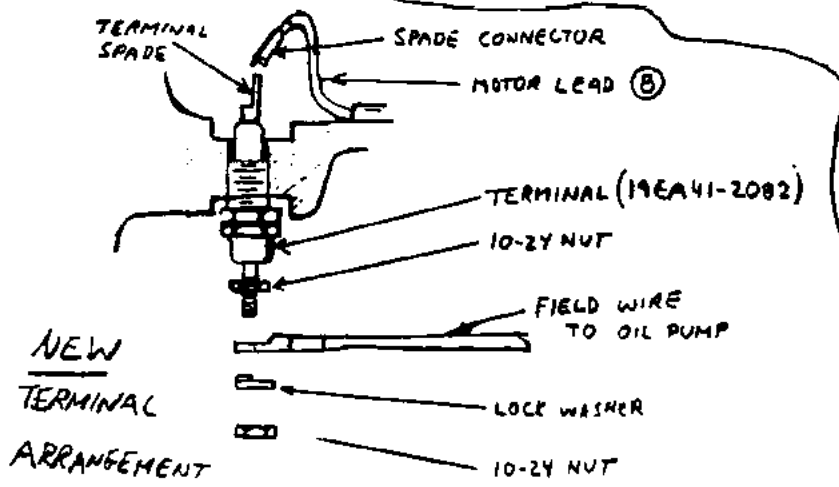
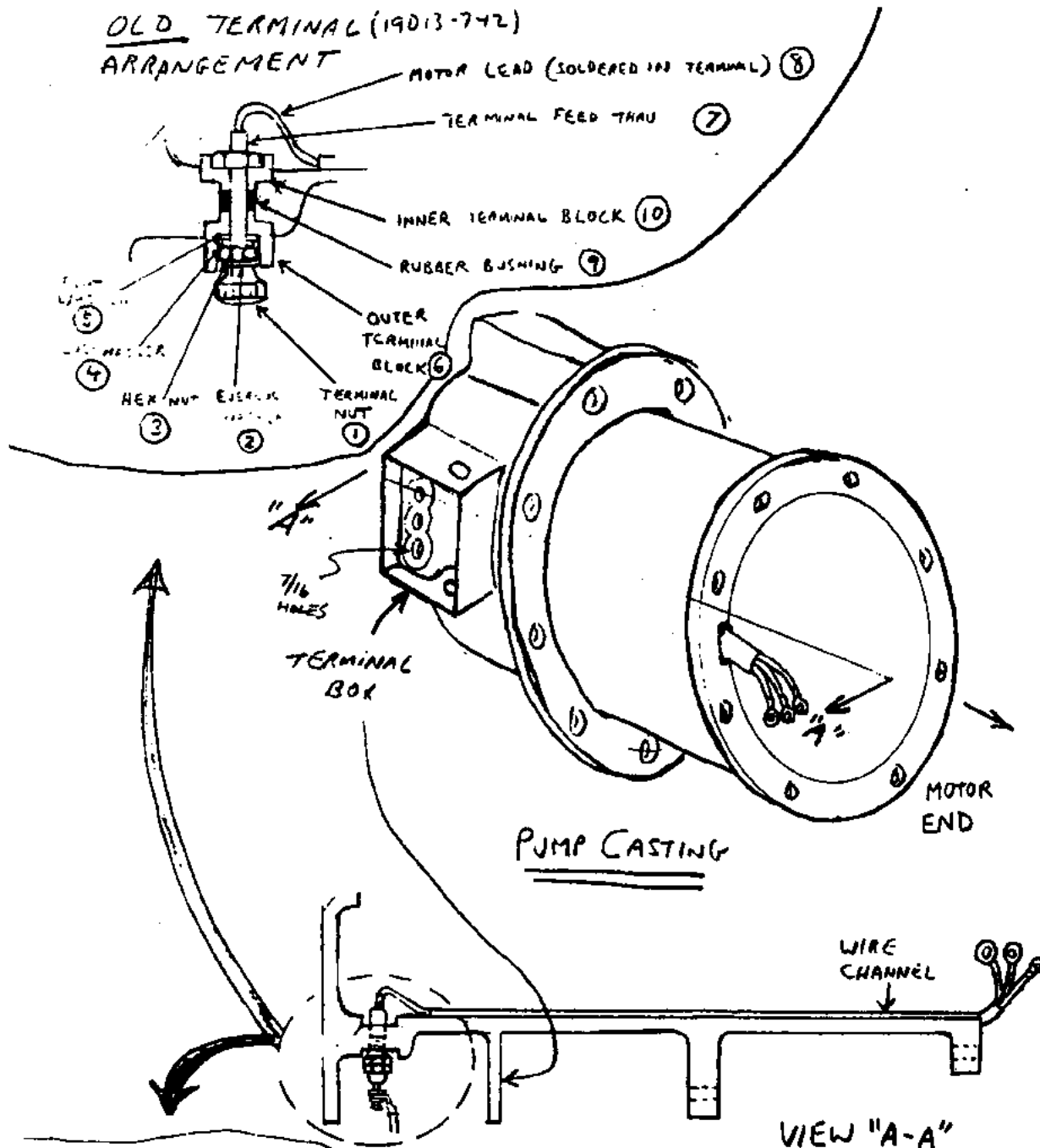
- 15) Reassemble pump and reinstall in the machine.
- 16) Wire field wires to new terminals. Check pump for proper rotation. If oil pressure does not build up when oil pump is energized, reverse two of the leads on the terminals. Insulate the terminals with electrical tape.

* We recommend Loctite "Teflon Filled Pipe Sealant", but refrigerant grade may be used. Insure that internal and external threads are clean and treated with "Locquik" primer.

MAL/bq

10/26/70

OLD TERMINAL (19D13-742)
ARRANGEMENT



INSTALLATION
INSTRUCTIONS
FER 70-4
PAGE 3