UNITED TECHNOLOGIES CARRIER	Commercial Division Carrier Corporation	BULLETIN: CA-SB-19-D-64-17 DATE: 2/7/64 PAGE: 1 OF: 3
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SUBJECT: **REMOVING THE 19D COMPRESSOR**		

PURPOSE: To forward instructions for removing the 19D compressor where necessary to facilitate rigging the 19D machine assembly.

MACHINES AFFECTED: All standard 19D machines in sizes 19D-107 through 19D-397.

PROCEDURE: These instructions are provided as a guide when removing a 19D compressor from aton the unishell cooler-condenser.

Prior to starting the dis-assembling, be sure that the dis-assembly area is clean and that clean rags are available for wiping and for covering machine openings. Follow these instructions step by step.

A. BREAKING MACHINE VACUUM

The machine assembly is shipped with a vacuum on the refrigerant side. Break this vacuum with nitrogen or dry air through the refrigerant charging valve at the bottom of the unishell. If moist air is used to break vacuum, the machine must be dehydrated after re-assembly. Moist air left in the machine can cause considerable damage to metal parts.

B. DISCONNECTING THE SUCTION ELBOW

1. Remove the molded fiberglas cover over the dresser coupling on the unishell side. The fiberglas cover has self-tapping screws holding the two halves together. The seam between the two halves and the screws are covered with a strip of tape.

2. Mark the location of the dresser coupling rings, coupling bolts and stay-rods to assist in re-assembly. Remove the bolts and stay-rods.

   NOTE: On machine sizes 19D-255 through 19D-397, four (4) pipe plugs are installed on the suction dresser coupling in lieu of stay-rods.

3. The above will make it possible for the elbow to be removed with the compressor causing minimum damage to the 3/4" foam insulation.

C. DISCONNECTING THE COMPRESSOR

1. Piping

   a. Disconnect the discharge dresser coupling in a manner similar to Section B above. Cover the exposed openings.

   b. Disconnect and remove a section of labyrinth gas piping from valve to top of unishell. Cover the openings.

   c. Cut and remove the insulating tape on the motor cooling line at the tee. Disconnect this line at the tee. Cover the openings.

   d. Remove the fiberglas covers over both couplings on the motor cooling return line. Disconnect and remove this coupling elbow and straight coupling. Do not damage gaskets. Remove the short section of insulated pipe between the couplings.

      NOTE: A small spring-loaded back pressure valve will be exposed inside the lower couplings. Leave the valve in place and cover the openings.

2. Wiring

   a. Remove box cover which houses the oil pressure differential switches. Remove terminal box cover on unishell behind console.

   b. Disconnect the wires at the unishell terminal box that go to the oil pressure switch box. Be sure each wire is identified. Disconnect flexible conduit containing these wires.

c. Disconnect linkage connector and linkage rod at the vane motor. Do not remove the linkage crank.

d. Remove three capscrews holding the vane motor to the venturi bracket.

e. Loosen both ends of the rigid conduit; then swing the vane motor and conduit down to the top of the unishell. This will permit removal of compressor without cutting or disconnecting any wires at the vane motor.

D. REMOVING THE COMPRESSOR AND ELBOW

1. Before lifting the compressor from the unishell, mark the exact location of the steel compressor base plate in relation to its mating base on the unishell.

2. Remove the four (4) base plate hold-down bolts.

NOTE: Do not disturb the hold-down bolts and isolation pads between the compressor feet and steel base plate.

3. When lifting the compressor, use the lifting eye on top of the motor shell and a wire sling around the underside of the discharge volute.

NOTE: The metal tag on the motor shell lifting eye which states "DO NOT USE FOR RIGGING" is to discourage use of the eye for lifting the entire machine assembly. It can be used for lifting the compressor and elbow only.

4. Cover the suction opening at the unishell.

E. REPLACING THE COMPRESSOR AND ELBOW

1. Use the reverse procedure for replacing the compressor.

2. Insure that all pipe connections are tight. When re-assembling the dresser couplings, clean the gasket sealing surfaces with a rag.

3. Line up the suction elbow dresser coupling. Install the coupling bolts and stay-rods. (Four pipe plugs on machine sizes 19D-255 through 19D-397). Tighten evenly to the location marks with a torque of 45 - 50 foot-pounds.