



**UNITED
TECHNOLOGIES
CARRIER**

Commercial Division
Carrier Corporation

BULLETIN: CA-SB-19-C-77-87
DATE: 11/15/77
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SERVICE BULLETIN

SUBJECT:

HIGH STRENGTH STEEL STAYBOLTS

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PURPOSE

To inform the field that the staybolts used to hold Dresser flexible couplings in place on 19C machines must be high strength steel, and that staybolt kits are available from the Service Parts Center.

MACHINES AFFECTED

All 19C machines.

BACKGROUND

It has come to our attention that, on some installations, substitutions may have been made in the staybolt material used on Dresser flexible couplings that connect the suction elbow to the cooler and compressor. The substitution of a commercial-grade bolt reduces the safety margin in the strength of the joint, and could result in a possible premature failure should the machine be inadvertently pressurized above its normal test pressure, as stated in the Operating and Maintenance Instructions.

PROCEDURE

For the convenience of service, kits including staybolts, nuts and washers are stocked in the Service Parts Center. The bolts in these kits are stamped with an "8" on each end to indicate that they are made of high strength, Grade 8 steel.

Whenever 19C suction elbow flexible couplings are serviced, examine the ends of the staybolts and the staybolt brackets. Staybolts should be stamped on each end with an "8", and the staybolt bracket should have a 1/2 inch thick rectangular backup washer. If not, replace them with the correct parts from the following kits:

<u>Machine</u>	<u>Staybolt Kit Part No.</u>
19C - R113, R11	19C660001
19C - R114	19C660002

Installation instructions are included with these kits.



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STAYBOLT INSTALLATION INSTRUCTIONS

Package Part No. 19C660001 for 19C R-11, R-113
" " " 19C660002 for 19C R-114

The arrangement on page 2 is typical for 19C R-114 machines. They have four staybolts on each end of the suction elbow. R-11 and R-113 machines have two staybolts at each end of the 12 o'clock and 6 o'clock positions.

CAUTION: *If the machine assembly has refrigerant in it, change one staybolt at a time. Do not remove all staybolts at the same time.*

1. Remove an existing staybolt and discard it.
2. Position new staybolt, nuts, round and square washers exactly as shown on page 2. Install Nut C if there is room on the cooler-end coupling.
3. Tighten Nuts A and B (leave all other nuts loose) until the flexible coupling flange just starts to deform.
4. Tighten the remaining nuts until they are snug.
5. Repeat Steps 1 through 4 for the remaining staybolts.

NOTE: For R-114 machines only, the bolt holes in the flexible coupling flanges must be enlarged to accept the new 3/4-inch staybolts. (The original ones were 5/8-inch.) Also, it may be necessary to cut one staybolt (at cooler 3 o'clock position) and assemble that staybolt with a special coupling (Item 5) because of the length of the bolt.



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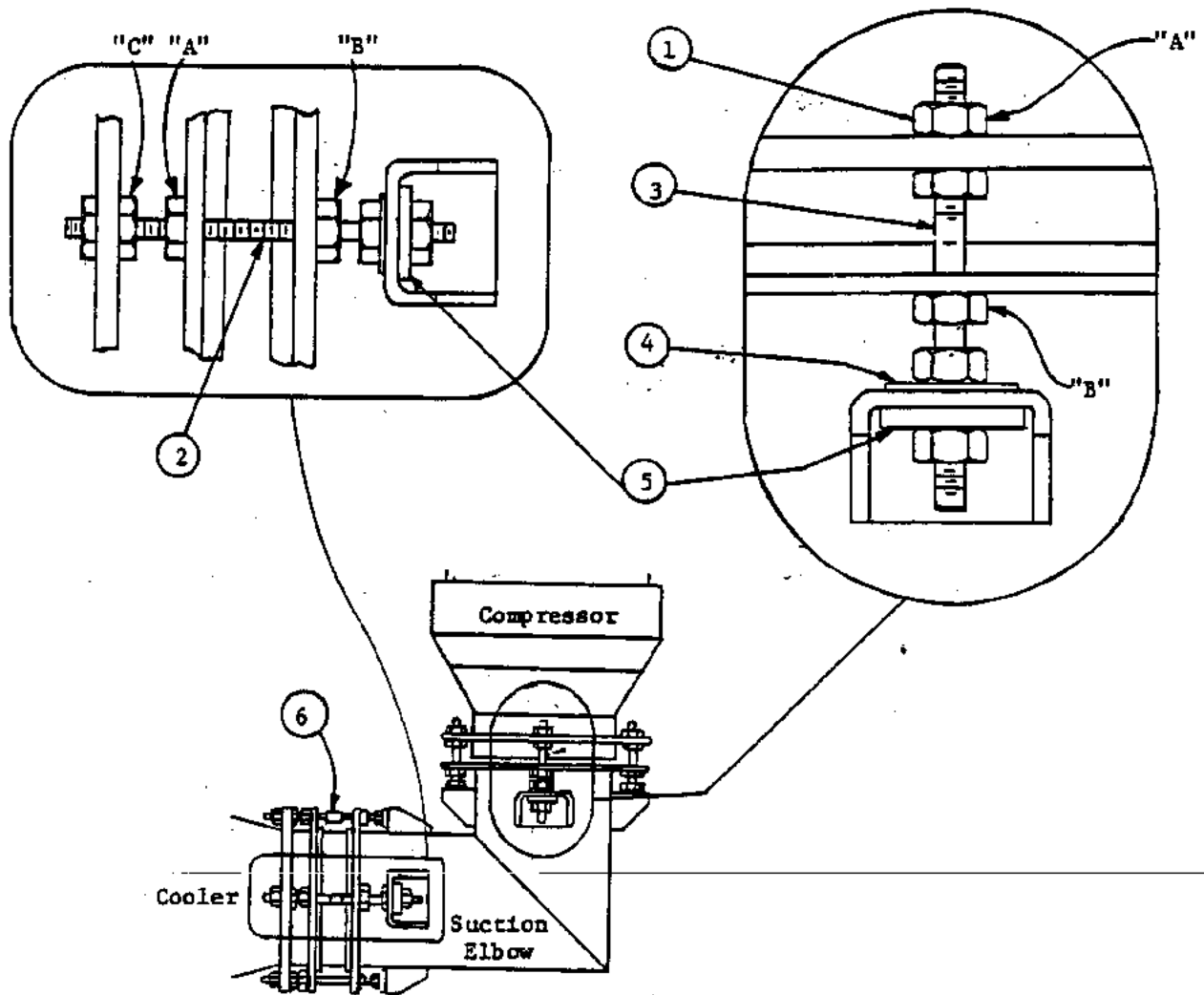
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Item	Package Part No.		Description
	19C660001 for R-11, -113	19C660002 for R-114	
	Quantity	Quantity	
1	24		5/8-11 Hex Nut
		48	3/4-10 Hex Nut
2	2		5/8-11 Threaded Rod, 22" long
		4	3/4-10 Threaded Rod, 22" long
3	2		5/8-11 Threaded Rod, 13" long
		4	3/4-10 Threaded Rod, 13" long
4	4		5/8" Round Washer
		8	3/4" Round Washer
5	4		Square Washer with 3/4" Hole
		8	Square Washer with 7/8" Hole
6	-		
		1	Coupling
7	1	1	Instruction Sheet