



Title: **INSTALLATION OF THE 19DK/DM SERVICE TABLE**

Number: C9009  
Date: 6/25/90  
Supersedes: NONE  
Date:

Models Affected: 19DK/DM Unishell Machines Only  
P/N: 19DK - DM - T100

**NOTE:** The Service Table is for use with 19DK or 19DM Unishells ONLY!  
This platform is NOT applicable for 19DR Centrifugals.

**CAUTION!**

**IT IS IMPORTANT TO FOLLOW ALL INSTRUCTIONS EXACTLY!  
FAILURE TO FOLLOW INSTRUCTIONS CAN RESULT IN INJURY TO PERSONNEL  
OR MACHINE DAMAGE!**

**I. PREPARATION**

- 1.1 Remove refrigerant from machine. Drain oil. (See Startup, Op. & Maintenance Instructions).
- 1.2 Disconnect oil and refrigerant lines & electrical lines connected to motor and base assembly.
- 1.3 Cut motor wobble foot spot welds at unishell bolting flange -- remove wobble foot.
- 1.4 Force wooden wedges under the discharge volute.
- 1.5 Open volute/base veeband joint.

**II. INSTALL AND ASSEMBLE SERVICE TABLE**

- 2.1 Place front part of table (Item 2, SK 102186) on top of the shell & the support bars welded to the motor end gussets. The bolt-down end of the table is to rest on the gussets.
- 2.2 Place rear part of the table (Item 1) on the machine, with spacer (Item 3) on the tube sheet.
- 2.3 Bolt the two parts together.
- 2.4 Line up hold down bolt holes with holes on support bars. The hold down holes are the counter sunk holes.

**NOTE:** For service, the compressor will be pulled back onto the table & rotated either left or right about one of the compressor hold down bolts, depending on machine accessibility. The centerline of the table should be located offset from the compressor support centerline in the direction of the intended rotation.

- 2.5 Insert table hold down bolts, assemble loosely with washer & nut.
- 2.6 Jack up table, using the leveling jack bar screws. Line up top of table with top of compressor base.
- 2.7 With tube sheet spacer bar bolts loose, move bars until contact is made between bar shoulder and the tube sheet. Tighten the bolts. Level the table with the spacer bar jack screws.

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Approved By: Alan Johnson

*Alan Johnson*

- 2.8 Tighten table hold down bolts.
- \*\*2.9 MOUNT STABILIZER BAR ASSEMBLY (Item 4) on compressor oil drain flange. THE BAR IS TO KEEP THE COMPRESSOR FROM TIPPING! Adjust leveling foot (Item 13) to contact table.
- 2.10 Install pry bar supports (Item 11) on table surface. The support bars are to parallel the compressor. Extend beyond the table, on both sides of the compressor.

### III. SERVICE THE COMPRESSOR

- 3.1 Slide compressor back on the compressor base, using pry bar rested against pry bar support and vertical surfaces of the compressor base casting. Slide compressor back to a position where the hold down bolt hole of the compressor foot nearest to the volute lines up with the rear bolt hole on the support.
- 3.2 Place a hold down bolt into the compressor foot on the discharge side. Secure it with a nut, hand tight.
- 3.3 Rotate the compressor around the bolted foot until impeller becomes directly accessible. (Approx. 45 deg.).

### IV. REASSEMBLE COMPRESSOR

- 4.1 Realign compressor to parallel machine centerline.
- 4.2 Remove bolt from compressor foot.
- 4.3 Slide compressor forward to engage the volute vee joint, using pry bar & pry bar support.
- 4.4 Make up base/volute joint.
- 4.5 Bolt down compressor feet.
- 4.6 Remove stabilizing bar assembly from the compressor oil drain flange.

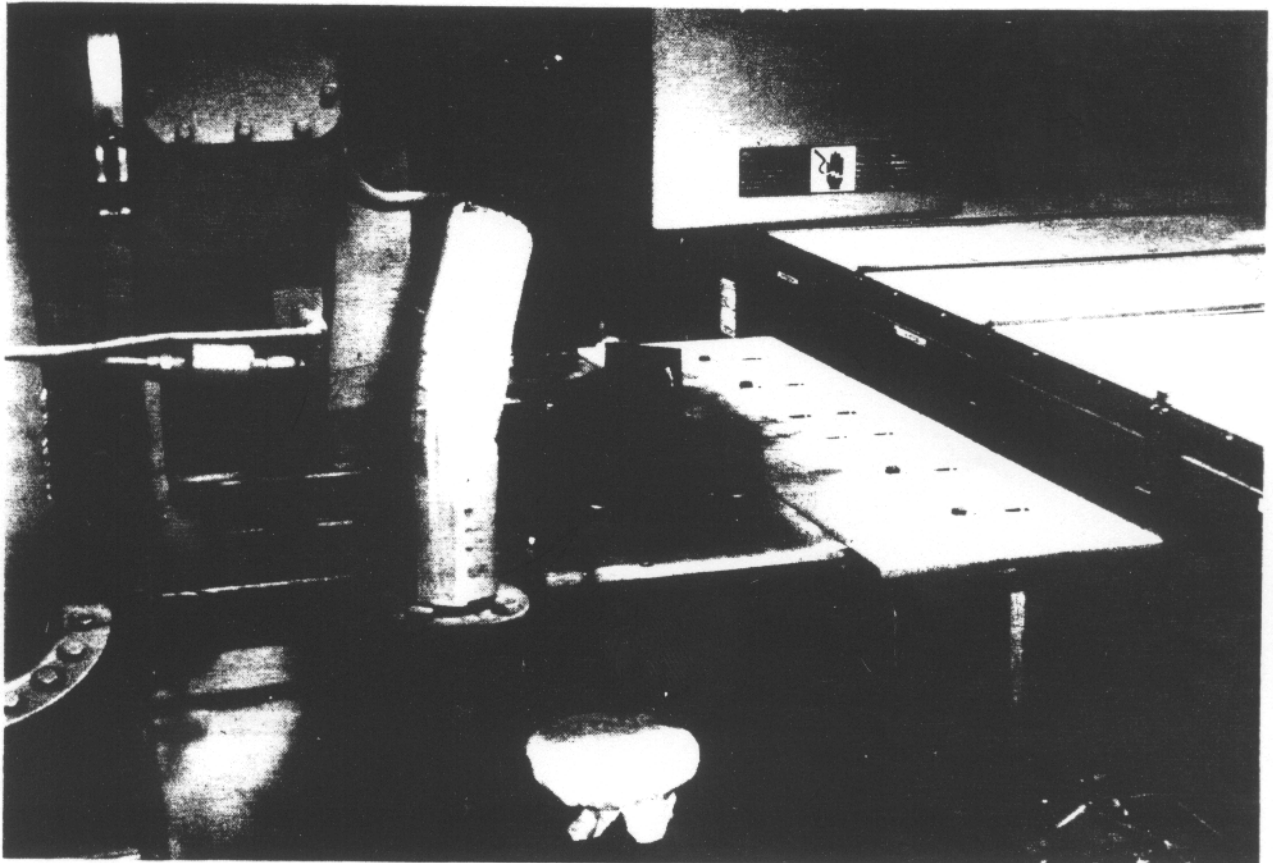
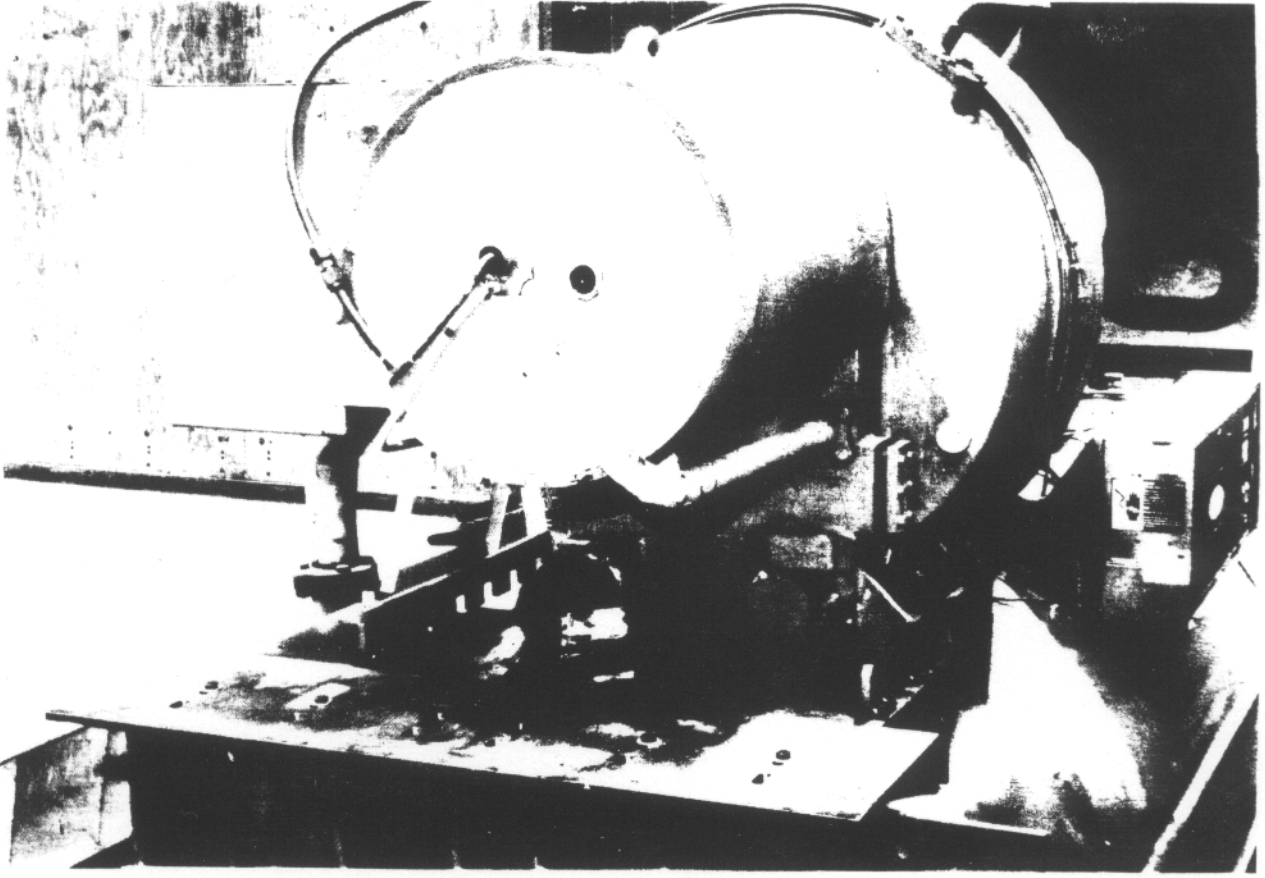
### V. DISASSEMBLE SERVICE TABLE

- 5.1 Loosen table hold down bolts.
- 5.2 Unbolt the table splitline flange.
- 5.3 Remove rear table assembly.
- 5.4 Remove front table assembly.

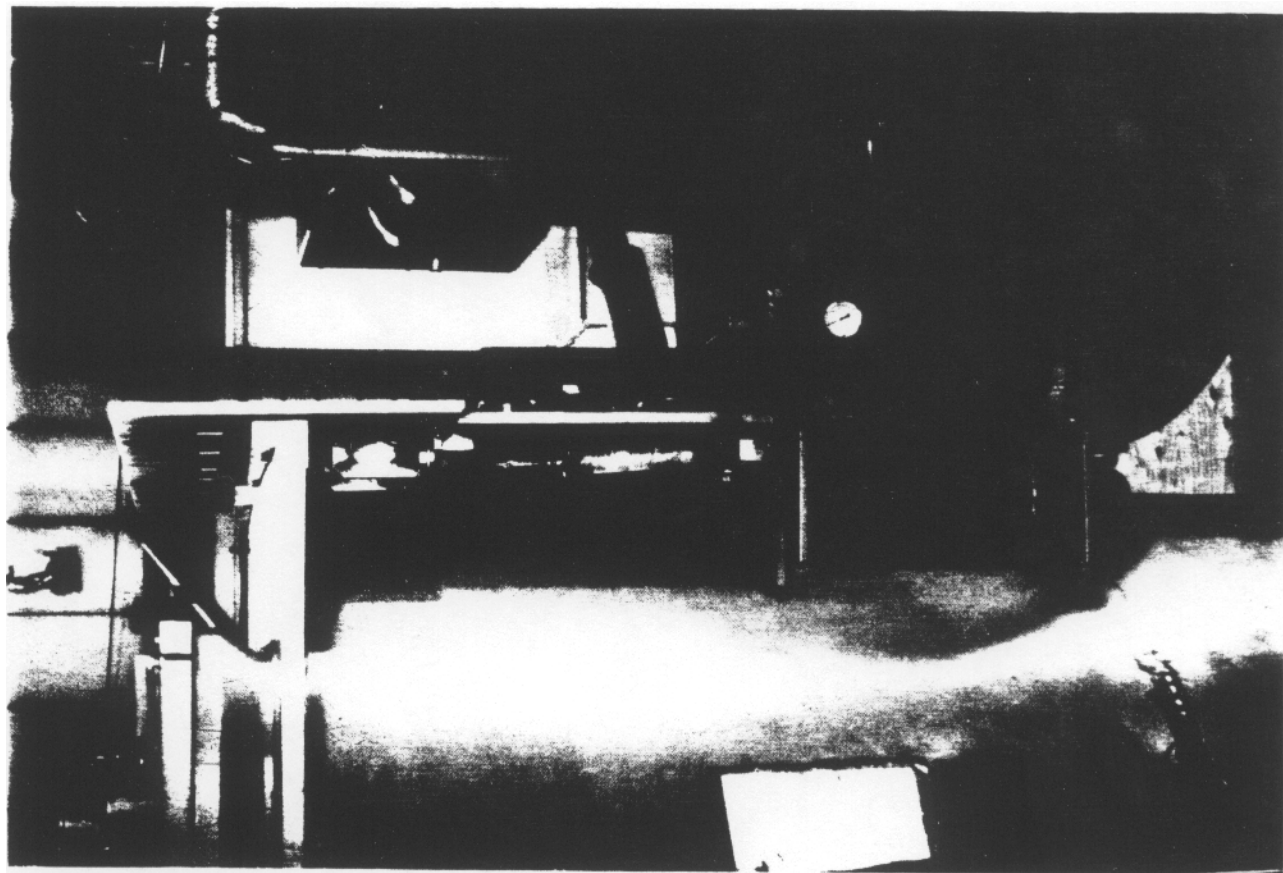
### VI. FINISH THE JOB

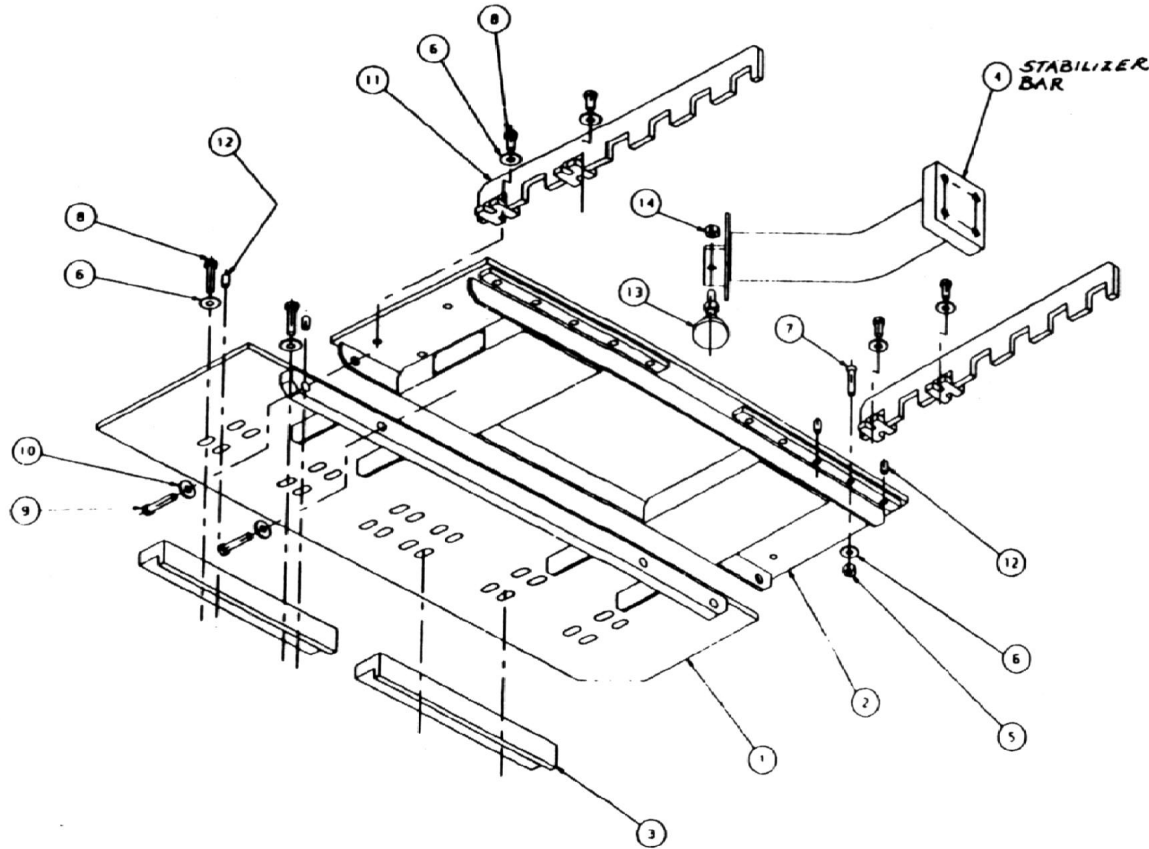
- 6.1 Remake oil and refrigerant drain lines.
- 6.2 Remake wobble foot, bolt & tack to flange.
- 6.3 Leak test, dehydrate & charge machine per Startup, Operation & Maintenance Instructions.

(Refer to hard copy of bulletin for sketch of service table).



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VIEW LOOKING UP FROM BOTTOM OF THE PLATE

ITEM	QTY	DESCRIPTION
1	1	SERVICE PLATE ASS'Y 10M DWS SK-102106 SH-20
2	1	SERVICE PLATE ASS'Y 10M DWS SK-102106 SH-21
3	2	SUPPORT BAR 10M DWS SK-102106 SH-60
4	1	SUPPORT FOOT ASS'Y 10M DWS SK-102106 SH-22
5	2	1/2"-13 UNC 20 HEX NUT
6	10	1/2" FLAT WASHER
7	2	1/2"-13 UNC 3A X 2 1/4" LG FLAT HD SOC SCR
8	8	1/2"-13 UNC 2A X 1 1/2" LG HEX HD CAP SCR
9	4	5/8"-11 UNC 2A X 2" LG HEX HD CAP SCR
10	4	5/8" SAE WASHER
11	2	PRY BAR SUPPORT ASS'Y 10M DWS SK-102106 SH-40
12	8	1/2"-13 UNC 3A X 1" LG OVAL POINT SET SCR
13	1	LEVELING FOOT, VLIER P/N P3005
14	1	JAM NUT 5/8-11 UNC 2A

D	FILED IN CHANGE NO. 1204-02	EC		
C	INDEX 2 3/4" DIA TO 1/2" DIA	EC		
B	INDEX ITEM NO 13 & 14	EC		
A	INDEX ITEM NO 12	EC		
REV	CHANGE	BY	DATE	APP'D
 <b>UNITED TECHNO-DIES LIMITED</b> <b>SKETCH</b>				
TITLE: 150K-0M COMPRESSOR SERVICE TOOL				MADE BY SUPPLIERS DATE 12-2-08
APPROVALS: [Signature]				APP'D
SCALE: NONE				SK-102106 SHEET 1 of 6