



## SERVICE BULLETIN

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**Title:** 19D Series Motor Shaft & Gear Assembly

**Models Affected:** All 19D Series

**Number:** C9208A

**Date:** 8/19/92

**Supersedes:** C9208

**Date:** 3/18/92

**Purpose:**

To inform the field that the factory is using multi-tang lockwasher's to retain bull-gear locknuts.

**File Instructions: Compressor–Motor Assembly**

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## Background:

Gear locknuts have been staked in the past to keep them from loosening. The factory started using a multi-tang lockwasher that locks the nut to a keyway in the shaft in early '92. If a locknut is removed to replace the rotor or gear, it is recommended that the new lockwasher which is applicable to all 19D Series compressors be installed.

## Procedure:

Tighten locknut to specified torque and back off just enough to align one locknut slot with a lockwasher/tang. Bend tang into slot.

	Lockwasher P/N	Locknut Torque
<b>19D11 -</b>	AU 46AA 601	210 # ft.
<b>19D21 -</b>	AU 46AA 601	250 # ft.
<b>19D31 -</b>	AU 46AA 721	275 # ft.

**Hint:** Removing the original staked locknut can be difficult. It is helpful to drill into the staking impression to remove most of the displaced metal.

