SERVICE BULLETIN

Title: **19XL/XT, 19EX, 19XR/XRT**
High Voltage Terminal Installation
Models Affected:

Number: **C9619**
Date: **7/05/96**
Supersedes: **New**
Date:

Purpose:

Procedure for assembling and installing the new ceramic high voltage terminals (See figure 1). Part number 02XB05003001.

File: Compressor-Motor-Drive-Gears

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Background:

Production has now made the change to the new ceramic terminal on 19 series high voltage motors. These replace the plastic terminals whose installation was outlined in C9504. The following procedure is for the assembly and installation of the new ceramic high voltage terminal only.

General Information:

The new ceramic terminal can be used as a direct replacement for the plastic terminal without changing the stud. Replacement terminal studs are available if necessary through RCD. The part number is 19XR660019 (see figure 2). The hole in the end of the stud is .25 in. (6.4 mm) diameter by .5 in. (12.7 mm) deep. It maybe necessary to enlarge it to accommodate larger wires. This stud also requires a 2 bolt connector lug (part number 02XB05002901) for making electrical connections to the terminal.

Installation:

1. Inspect and clean the terminal and the machined mating surface of the motor shell or terminal plate with emery cloth or fine sand paper to ensure a leak tight assembly. Lubricate insulator o-ring and mating surface with o-ring lubricant (Parker Super O lube).
2. Slide insulator over the motor lead and thread insulator into motor housing. Torque insulator to 50 ft-lbs (68 Newton-Meters).
3. Lubricate terminal stud o-ring and slide the o-ring over the threaded portion of copper stud, then install the copper sleeve.

IMPORTANT: The copper sleeve which contacts the o-ring, packaged with the terminal, has been selected to properly fit the ceramic terminal body inside diameter. Do not mix terminal insulators and sleeves, use only the sleeve provided with each individual terminal.

4. Slide the copper washer over the stud and next to the copper sleeve. (If replacing an old plastic terminal and not the terminal stud two washers will be necessary because of the difference in length between the two insulators.)
5. Install the brass jam nut and tighten against the washer(s) to a maximum of 3 ft-lbs (4 Newton-Meters) while holding copper stud. This will seat copper washer against insulator and draw internal shoulder on copper stud against the internal edge of insulator.
6. If leakage occurs after the terminal is assembled, then the parts are defective and should be replaced. Do not over tighten in an attempt to eliminate leaks.

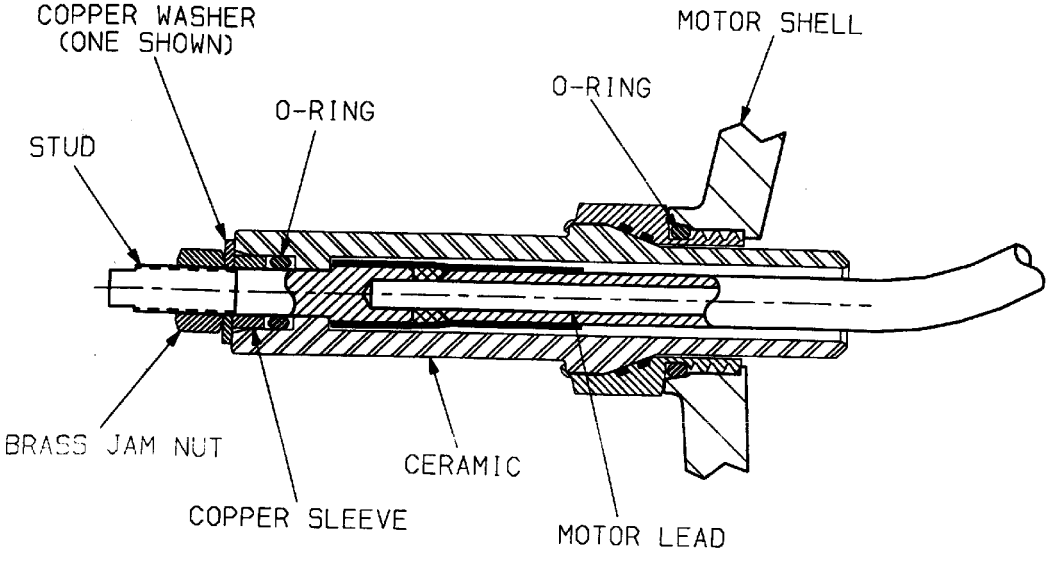
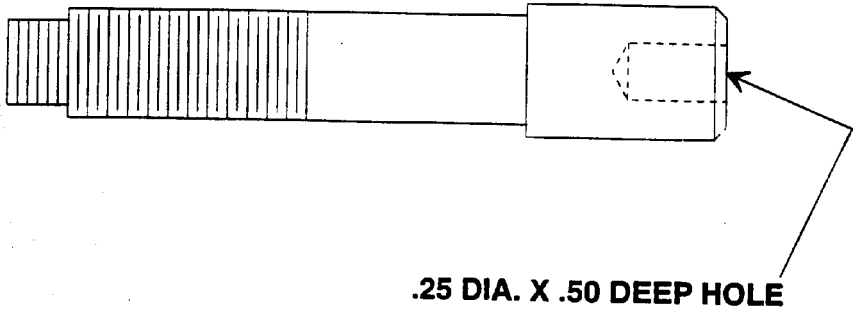


Figure 1 — Hi Voltage Terminal Detail



DUE TO THE DIFFERENT POSSIBLE GAUGES OF THE MOTOR LEADS ENLARGEMENT OF THE .25 DIA. HOLE IN THE STUD MAY BE REQUIRED TO SUIT HEAVIER GAUGE MOTOR LEADS.

Figure 2 — Terminal Stud