



SERVICE BULLETIN

Title: 19XL Motor End Bell O-Ring
Models Affected: 19XL

Number: C9637
Date: 10/23/96

Purpose:

To clear up confusion concerning the motor end bell O-ring during a motor stator replacement on the 19XL line of centrifugal chillers.

File: Specified Parts

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Background:

The original 19XL centrifugal chillers were released with a cast iron motor end bell. This cast end bell had a machined O-ring groove around the inboard side to provide for a seal against the motor stator housing. The part number of cast end bell is 02XB35001001 and the O-ring used to provide the seal is KK71EW470. In September of 1995 a change was made to the design of the end bell. The end bell changed from an intricate cast iron design to a more straightforward section of steel. The part number of the steel end bell is 02XB35032501. To eliminate extra processing steps on the steel end bell the O-ring groove was moved from the end bell to the motor stator housing. A new O-ring was selected, part number KK71EW471.

Information:

With the changes described above the possibility exists of replacing a motor stator on an old 19XL (without an O-ring groove) with a new stator that has an O-ring groove machined in it. The new stator and the old cast end bell have been designed such that the grooves do not align with each other hence the different O-ring part numbers. If this situation does occur it is perfectly acceptable to use either the KK71EW470 or the KK71EW471. If the existing O-ring is suitable for reuse it is acceptable in the application. If a replacement is needed I suggest using the KK71EW471 because it is mounted to the stator and you don't have to worry about the O-ring moving while rigging the cover back into place. When replacing a stator on a chiller built after September of 1995 the only choice is using the KK71EW471, so it also covers more applications. Refer to the [table](#) below for application.

O-Ring Application Table

Application	KK71EX470	KK71EW471
Old Stator & Old End Bell	Acceptable	Unacceptable
New Stator & Old End Bell	Acceptable	Acceptable
New Stator & New End Bell	Unacceptable	Acceptable