



## SERVICE BULLETIN

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**Title:** 23XL Frame 4 Slide Rod Change

**Models Affected:** 23XL

**Number:** C9709

**Date:** 4/15/97

**Supersedes:** New

### **Purpose:**

This bulletin is to advise the field that after October, 1996, a new capacity slide rod with adjustable locknuts was introduced on 23XL frame 4, fixed V.I. compressor.

**File:** Compressor

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**Approved By:** Alan M. Johnson

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## Compressor Affected:

D40 and D60 only.

Compressor starting s/n 5096V - - - - .

## Reference:

Bulletin C9602A.

## Recommendation:

To improve long term reliability, the latest design adjustable locknuts should be installed on compressor built prior to November 1996 which experience premature locknut failures.

## Procedure:

1. Apply 3 drops of green Loctite (Retaining Compound) to the male threads, on both ends of the capacity shaft, at 120 degree increments.
2. Remove the 4 set screws from both locknuts. Install both locknuts and torque the main body to 75 ft-lbs (102 Nm). Two locknut sockets p/n TS-144504D (see sketch) will be required.
3. Apply 1 drop of green Loctite on each set screw and reinstall set screws into the main nut body.
4. Torque the four set screws, in an even pattern, to 32 in-lb (4 Nm).

**Note:** Make sure all parts are clean and degreased as per Loctite's instructions.

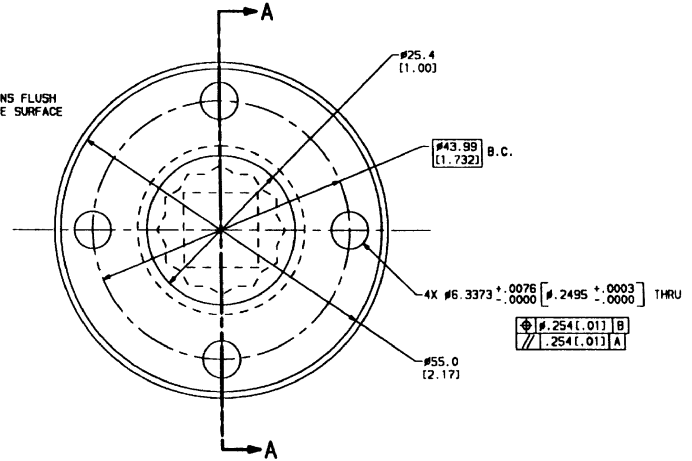
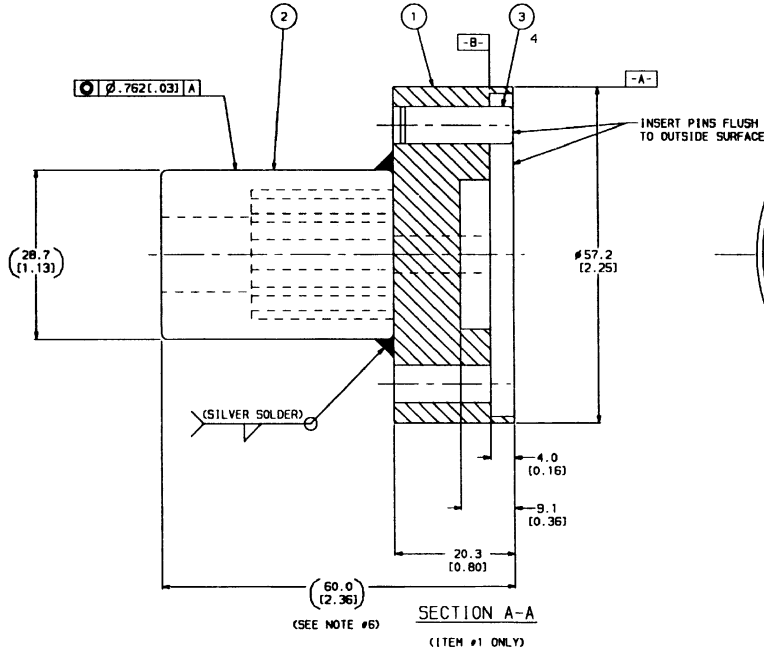
## Parts:

Compressor size —	D60	D40
Slide rod p/n	1TD0216D	1TD0213D
Adjustable locknut p/n (2 required)	KT51HZ100	KT51HZ100
Loctite 603 — Loctite p/n 21440 for 10ml bottle		
Other acceptable Loctite 675 & Loctite 609		

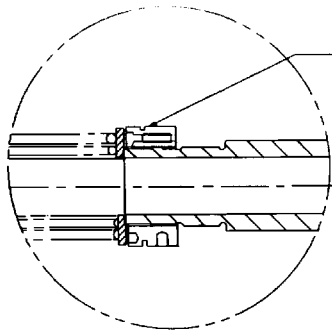
NOTES:

1. ALL DIMENSIONS ARE IN MILLIMETERS WITH DECIMAL INCH EQUIVALENT IN [ ].
2. REMOVE ALL BURRS.
3. BREAK ALL SHARP EDGES FORMED BY TOOL MACHINED SURFACES .25 [0.01] X 45° CHAMFER OR .25 [0.01] RADIUS.
4. ALL MACHINED SURFACES TO 500μ IN. UNLESS OTHERWISE SPECIFIED.
5. CLEANLINES PER ENGRG REQMT.
6. BASED ON USE OF A STANDARD 1/2" DRIVE SOCKET.
7. USAGE INTENDED FOR INSTALLATION & REMOVAL OF SPIEIH LOCKNUT, METRIC SERIES MSR, SIZE 35 X 1.5.

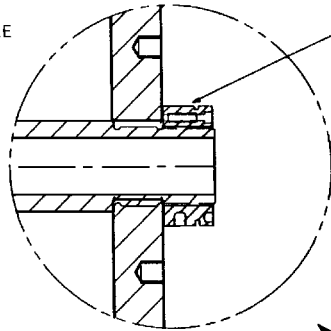
ITEM	QTY	DESCRIPTION
1	1	BODY — 4340 ALLOY STEEL OR A2 TOOL STEEL
2	1	SOCKET — 1/2" DRIVE
3	4	DOWEL PIN — $\phi 1/4"$ X .75 LG. HARDEN STEEL



LOCKNUT SOCKET  
(TD. FIXED COMPR)



ADJUSTABLE  
LOCKNUT



ADJUSTABLE  
LOCKNUT

SPRING  
RETAINER

SPRING

CAPACITY  
SLIDE ROD

