



SERVICE BULLETIN

Title: 19XR High Speed Shaft Change
Models Affected: 19XR Frame 3 and 4

Number: C9718
Date: 10/30/97
Supersedes: New

PURPOSE:

To inform the field of a change in the diameter of the high speed shafts on frame 3 and frame 4 19XR compressors.

File: Specified Parts

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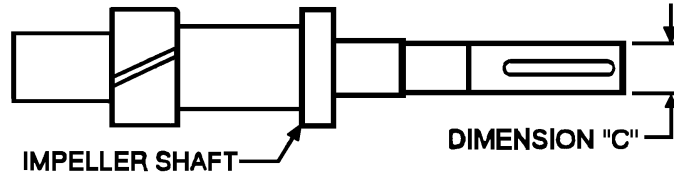
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GENERAL INFORMATION:

The initial release of the smaller capacity frame three and frame four 19XR compressors were released with a high speed shaft that measured 1.15" at the impeller mounting end of the shaft. As further testing was completed on larger tonnage frame three and four compressors it was found that the impeller could deflect during operation. To increase the overall strength of the shaft the diameter was changed to 1.37". Approximately 8/97 all production units utilized the new large diameter shaft.

SERVICE PARTS:

Service parts only stocks the new larger diameter shaft and associated impellers for frame three and frame four compressors. When ordering replacement parts it will be necessary to check the diameter of the shaft (see Figure 1) before ordering the parts needed for the repair (i.e., if the machine has a small diameter shaft and either the shaft or impeller needs to be replaced, a new shaft, impeller spacer, and shim pack, etc. will need to be ordered).



IF DIMENSION "C" = 1.37" YOU HAVE THE LARGER DIAMETER SHAFT
IF DIMENSION "C" = 1.15" YOU HAVE THE SMALLER DIAMETER SHAFT

Figure 1
High Speed Shaft

The table below outlines the large diameter high speed assembly part numbers along with the other associated parts that will need to be ordered if replacing a small diameter with a large diameter. The large diameter shaft will work with a small diameter thrust housing assembly.

Table 1 — Large Diameter Parts List

PART NAME	FRAME 3 COMPRESSOR	FRAME 4 COMPRESSOR
HI SPD BRG & SHAFT ASSY 60 HZ	02XR34000201	02XR44000701
HI SPD BRG & SHAFT ASSY 50 HZ	02XR34000202	02XR34000702
HIGH SPEED SHAFT 60 HZ	02XR35008401	02XR45008601
HIGH SPEED SHAFT 50 HZ	02XR35008402	02XR45008602
SPACER	02XR35006801	02XR35006801
KEYS	(2) 02XR35005701	(2) 02XR45006502
ROLL PIN	(2) AX14CA064	(2) AX14CA096
IMPELLER NOSE PIECE	02XR35008701	02XR45009201
IMPELLER CAP SCREW	AA44AA269	AA44AA267
IMPELLER WASHER	02XB05002701	02XB05002702
SHIM	02XR35008601	02XR35006901
IMPELLER	CONTACT RCD	CONTACT RCD