



VIEW C — HIGH SPEED SHAFT RING SEAL

⚠ CAUTION

USE COPPER CONDUCTORS ONLY
UTILISEZ DES CONDUCTEURS EN CUIVRE SEULMENT

ALWAYS USE 2 WRENCHES TO TIGHTEN.

- TERM INSULATOR TO MOTOR — 15–35 ft. lb.
- BRASS NUT TO TERM INSULATOR — 3 ft. lb. max
- ADAPTOR TO TERM STUD — 30–35 ft. lb.
- LUG BOLTS (1/2") — 32–45 ft. lb.

Insulate entire connection with electrical insulation including 1 inch of cable insulation and 1 inch of the term insulator.

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USE COPPER CONDUCTORS ONLY
UTILISEZ DES CONDUCTEURS EN CUIVRE SEULMENT

ALWAYS USE 2 WRENCHES TO TIGHTEN.

- TERM INSULATOR TO MOTOR — 15–35 ft. lb.
- CABLE LUG NUTS — 40–45 ft. lb.

Insulate entire connection with electrical insulation including 1 inch of cable insulation and 1 inch of the term insulator.

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MOTOR LEAD INSTALLATION LABELS

19XRV COMPRESSOR ASSEMBLY TORQUES

ITEM	COMPRESSOR	FRAME 2	FRAME 3	FRAME 4	FRAME 4	FRAME 5
	Code	201-299	321-390, 3ZZ	421-490	4B1-4W8	501-600
	DESCRIPTION	Fixed Diffuser	With Rolling Element Bearings	Fixed Diffuser	Split Ring Diffuser	Split Ring Diffuser
1	Oil Heater Retaining Nut — ft-lb (N*m)	N/A	18-22 (25-30)	18-22 (25-30)	18-22 (25-30)	18-22 (25-30)
2	Bull Gear Retaining Bolt — ft-lb (N*m)	80-90 (108-122)	80-90 (108-122)	80-90 (108-122)	80-90 (108-122)	80-90 (108-122)
3	Demister Bolts — ft lb (N*m)	15-19 (20-26)	15-19 (20-26)	15-19 (20-26)	15-19 (20-26)	15-19 (20-26)
4	Impeller bolt Torque — ft-lb (N*m)	32-48 (43-65)	55-60 (75-81)	55-60 (75-81)	55-60 (75-81)	160-225 (217-305)

Fig. 48 — Compressor Fits and Clearances (cont)