


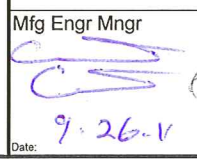

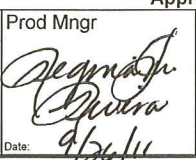

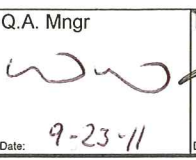




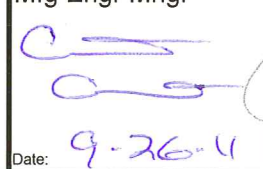
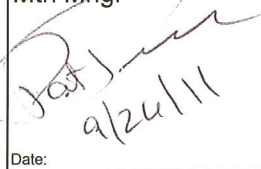
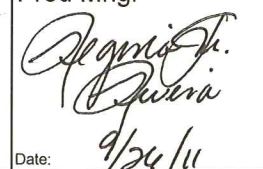
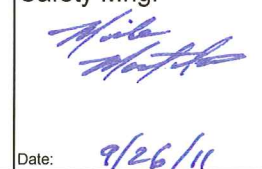
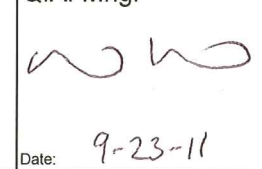
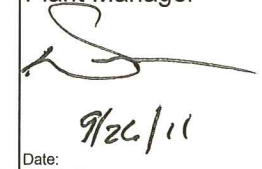


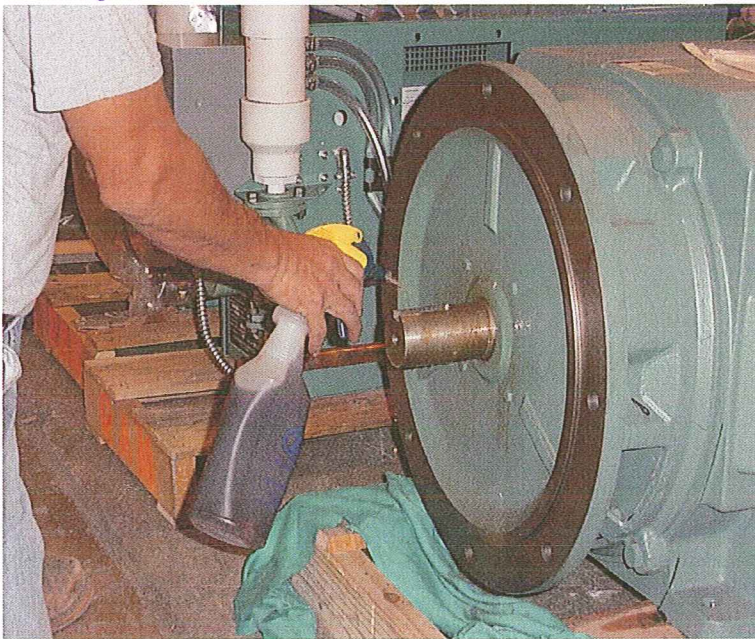
| Johnson Controls | | | OPERATIONAL METHOD SHEETS | | | | | | |
|-----------------------------|--------------------------|--------------------------|---|---|---|---|---|---|---|
| PROCESS: MOTOR INSTALLATION | | |  CHECK  WORK CONTENT  VERIFY | Approvals | | | | | |
| STATION#: FINAL ASSY | O.M.S.#: OMS - 012 | Orig Rel Date: 8-12-2002 | | Mfg Engr Mngr | Mtrl Mngr | Prod Mngr | Safety Mngr | Q.A. Mngr | Plant Manager |
| PAGE: 1 of 3 | REV #: 002 | REV Date: 9-23-2011 | |  |  |  |  |  |  |
| Q.E. SIGN: WC | Originator: Weylon Crisp | Revised By: W. Crisp | | Date: 9-26-11 | Date: 9/26/11 | Date: 9/26/11 | Date: 9/26/11 | Date: 9-23-11 | Date: 9/26/11 |

This process map will define and illustrate the steps to follow while installing motors on YK & SYK units.

1. Verify motor part number vs. Bill of Material to ensure that you have the correct motor.
2. Clean flanges on motor and compressor, also clean motor shaft and boltholes.
3. Insert studs on compressor to correct dimension on drawing, use Loctite AV to secure stud.
 - a. Center punch last thread to ensure stud does not turn during nut installation.
4. Fabricate top portion of motor bracket per sketch on page 2.
5. Paint the bottom of motor foot supports with primer in aerosol cans.
6. **Using 1/4" block in place of shims, bolt top portion of bracket to motor per drawing note requirements.**
****Reliance motors will have special block thickness requirements, see drawing for details.****
Mounting block will be removed and replaced with shims, see step 10.
7. Install motor to compressor. Motor must be level and flush to face of compressor before installing nuts.
DO NOT PUT STRAIN ON MOTOR WHEN TIGHTENING.
8. Tighten motor to compressor.
9. Fabricate bottom portion of motor bracket and weld to unit and top portion of bracket (YK units only).
10. **After welding has cooled, remove block and install shims to obtain a snug fit (+/- 1/32)**
11. **Final shim pack height must be 1/8" - 3/8". Final shim pack height under both motor feet must be equal or within +/- 1/16" of each other and oriented identically. No tape to be used to hold shim packs together.**
12. Ensure that all welds are stamped with welder ID, of correct size, clean, free of undercut and BB's and prime prior to leaving operation.
13. Torque motor foot supports and shims to specifications per drawing.
14. Stamp motor data plate and attach to motor (Horsepower, Amps, RPM, Volts, FLA and LRA).
15. Make sure all sign offs are done prior to completing operations.

See OMS-105 for Motor/Compressor Mis-alignment Verification.

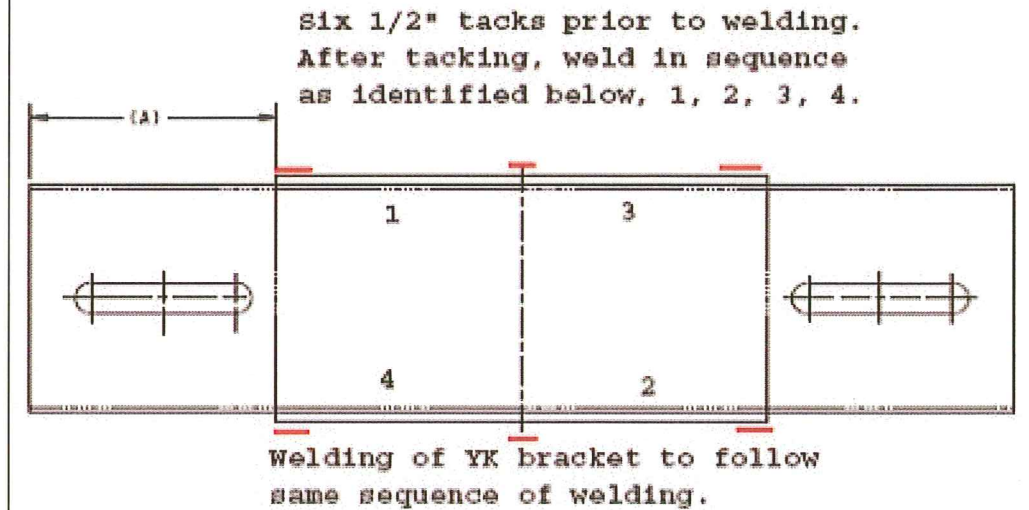
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|-----------------------------|--------------------------|--------------------------|---|--|--|---|---|---|---|---|---|
| PROCESS: MOTOR INSTALLATION | | |  CHECK |  WORK CONTENT |  VERIFY | Approvals | | | | | |
| STATION#: FINAL ASSY | O.M.S.#: OMS - 012 | Orig Rel Date: 8-12-2002 | | | | Mfg Engr Mngr | Mtrl Mngr | Prod Mngr | Safety Mngr | Q.A. Mngr | Plant Manager |
| PAGE: 2 of 3 | REV #: 002 | REV Date: 9-23-2011 | | | |  |  |  |  |  |  |
| Q.E. SIGN: WC | Originator: Weylon Crisp | Revised By: W. Crisp | | | | Date: 9-26-11 | Date: 9/24/11 | Date: 9/24/11 | Date: 9/26/11 | Date: 9-23-11 | Date: 9/26/11 |



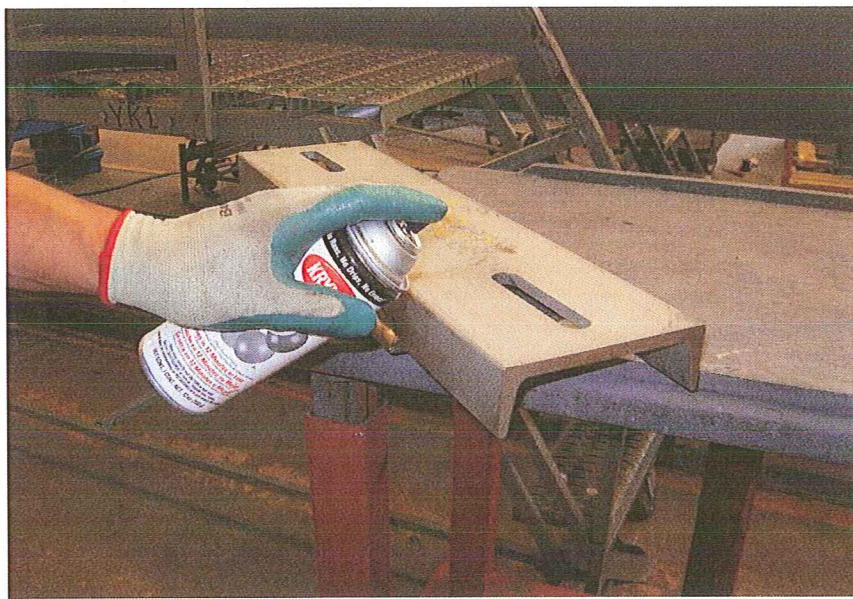
Clean flanges, motor & compressor and insert studs using Loctite.



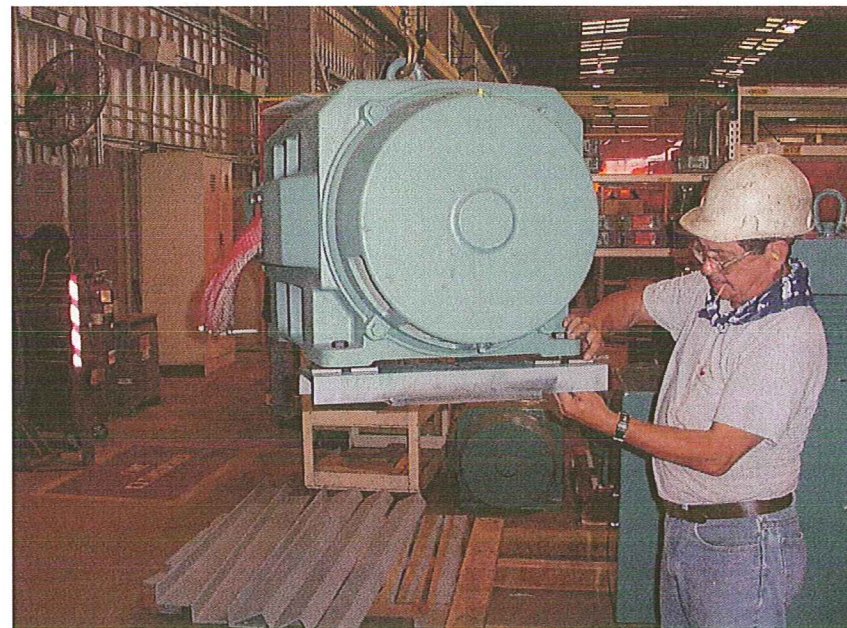
Fabricate top portion of bracket. 1/4" block to be used during this operation, shim packs to be installed during step 10.



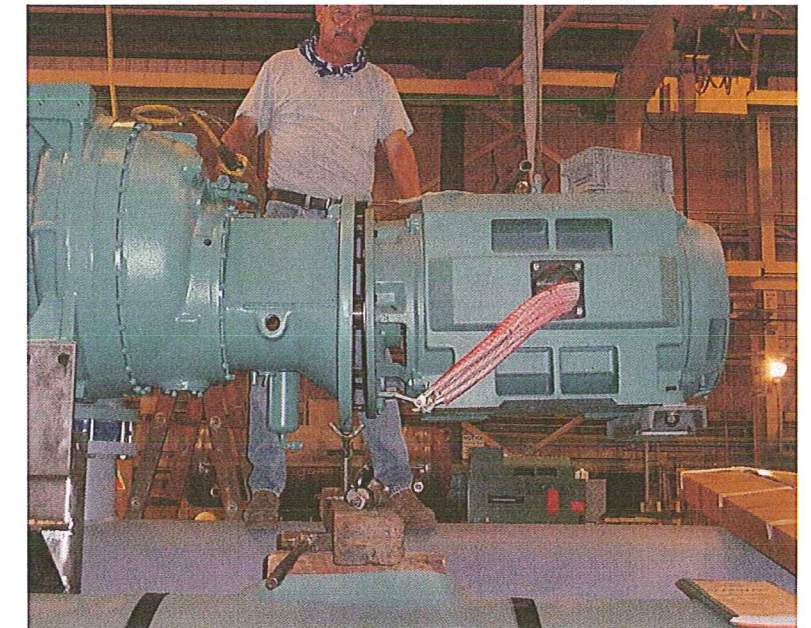
Weld sequence to be followed for both YK and SYK brackets, regardless of pre-assembled components or not.



Prime bracket before installation. Prime bottom of foot supports on motor prior to installation.





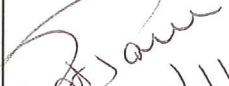




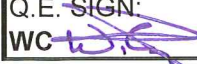


Bolt top portion of bracket using 1/4" block.



Bolt motor to compressor. For SYK, this operation will be performed on the floor prior to lifting on to the unit.

OPERATIONAL METHOD SHEETS

| | | | | | | | | | | | |
|---|--------------------------|--------------------------|---|--|--|---|---|---|---|---|---|
| PROCESS: MOTOR INSTALLATION | | |  CHECK |  WORK CONTENT |  VERIFY | Approvals | | | | | |
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| PAGE: 3 of 3 | REV #: 002 | REV Date: 9-23-2011 | | | |  |  |  |  |  |  |
| Q.E. SIGN:  | Originator: Weylon Crisp | Revised By: W. Crisp | | | | Date: 9-26-11 | Date: 9/26/11 | Date: 9/24/11 | Date: 9/26/11 | Date: 9-23-11 | Date: 9/26/11 |



Tighten motor to compressor.



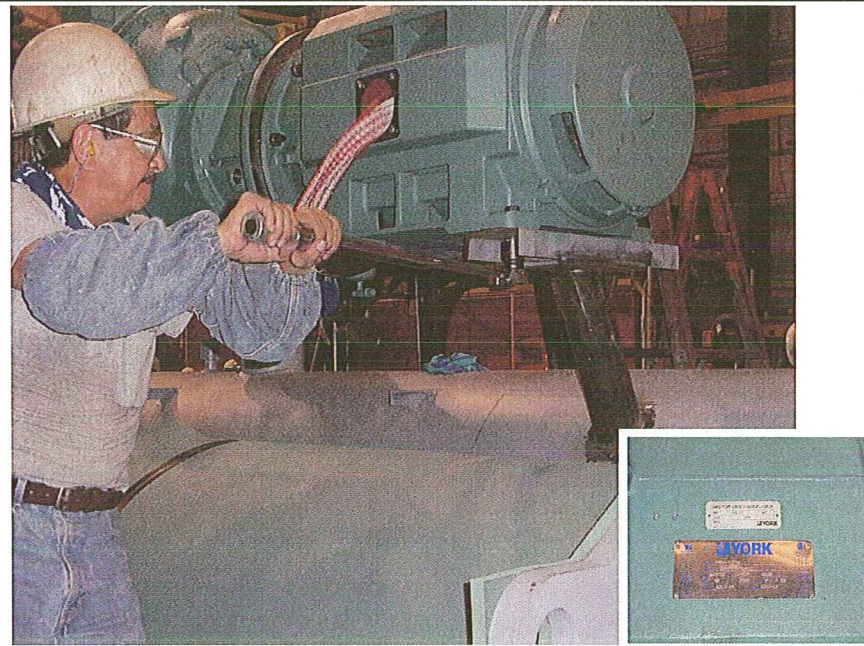
Bottom portion of bracket.



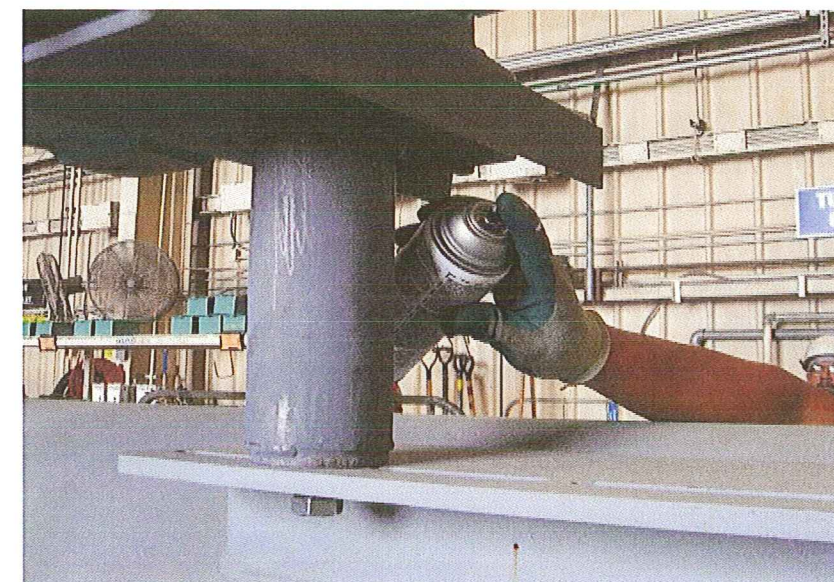
Bottom portion, continuation.



Clean and stamp welds. Allow welds to cool prior to proceeding. All welds to be coated with primer.



Install shims and torque foot supports, see notes for shim thickness requirements. **Shims to be oriented identically.** Stamp data plate and attach.



Prime bracket after installation and complete all sign offs.