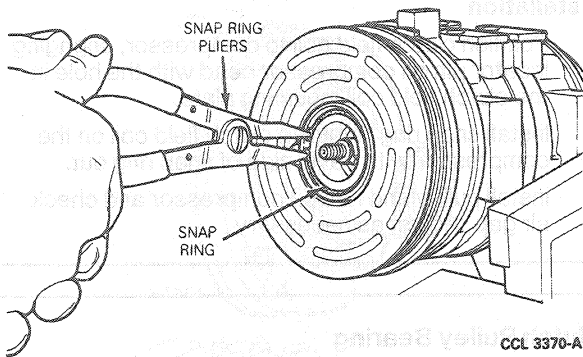


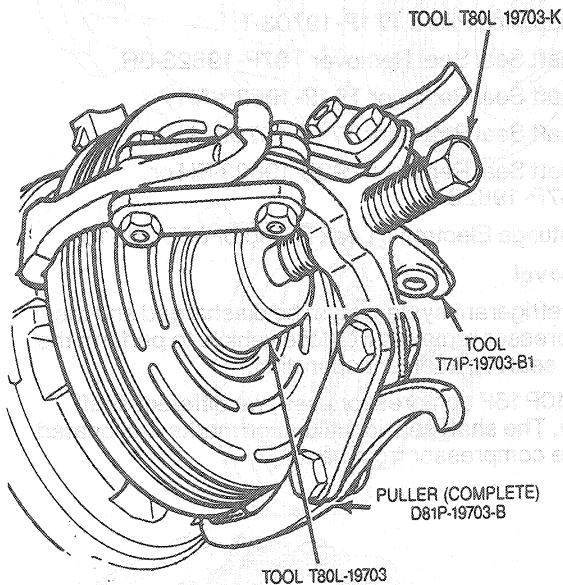
REMOVAL AND INSTALLATION (Continued)

Pulley Snap Ring— Removal



4. Pull pulley and bearing assembly from compressor. If pulley and bearing assembly cannot be removed by hand, use Shaft Protector T80L-19703-G and Pulley Puller D81P-19703-B or T71P-19703-B to remove pulley.

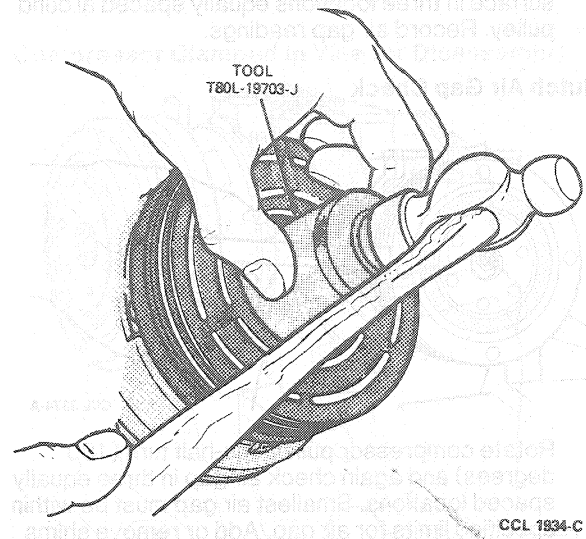
Removing Clutch Pulley with Puller



Installation

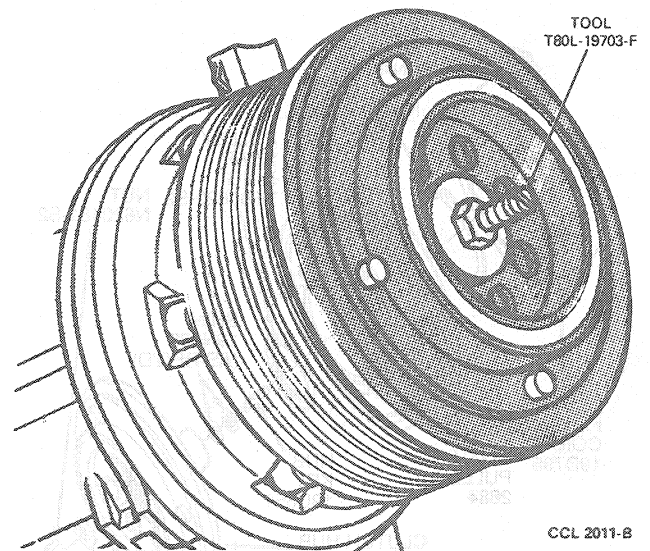
1. Clean the pulley bearing surface of the compressor head to remove any dirt or corrosion.
2. Install pulley and bearing on compressor. The bearing is a slip fit on compressor head and, if properly aligned, should slip on compressor head. If difficulty is encountered installing pulley, gently tap pulley on compressor using Pulley and Bearing Tool T80L-19703-J. Ensure the pulley bearing is aligned with compressor head.

Clutch Pulley— Installation



3. Install pulley retaining snap ring with bevel side of snap ring out.
4. Install clutch hub on compressor shaft using two thickest shims of shim pack between clutch hub and end of compressor shaft. Ensure shaft key is aligned with keyway of clutch hub. Use Hub Driven Plate Replacer T80L-19703-F to press hub on compressor shaft, if necessary. **DO NOT ATTEMPT TO DRIVE THE HUB ON THE COMPRESSOR SHAFT** as damage to compressor will result. Use only specified tool if hub will not easily slide on compressor shaft.

Clutch Hub— Installation



5. Install hub lock washer and retaining nut on compressor shaft. Tighten nut to 13-20 N·m (10-14 lb-ft). **DO NOT USE AIR TOOLS.**