

MAJOR SERVICE OPERATIONS (Continued)

Cleaning and Inspection

Clean all components in clean solvent and allow to dry. **Do not blow dry the valve plates or reed valves with compressed air.** Repeat the cleaning process using new cleaning solvent if necessary.

Inspect the cylinder bores for scratches, corrosion or other signs of damage or wear. Replace compressor if any of these conditions exist.

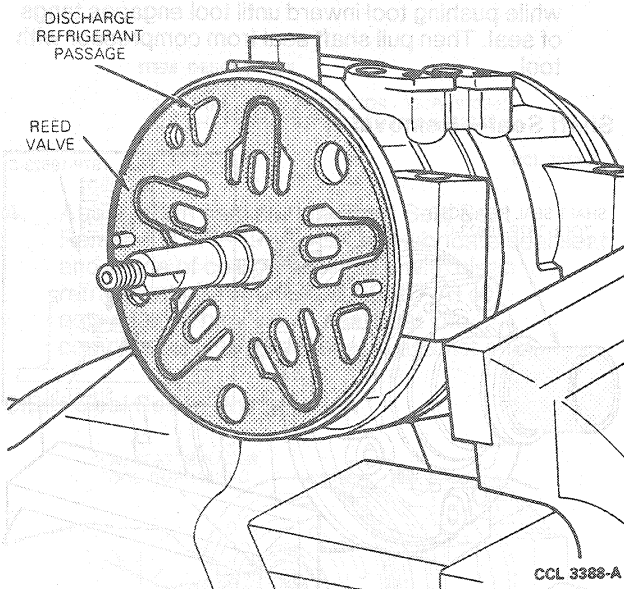
Inspect valve plates for scratches, corrosion or signs of wear or damage. Replace the compressor if valve plate damage is found.

Inspect the reed valves for cracks, scratches, deformation and corrosion. Replace the compressor if reed valve damage is found.

Assembly

1. Install two dowel pins in front dowel pin holes of the cylinder assembly.
2. Lubricate head O-ring and place it in groove on front of cylinder assembly.
3. Lubricate front reed valve with clean refrigerant oil and place it in position on front of cylinder assembly. Ensure the reed valve is properly positioned on cylinder assembly as shown in the following illustration.

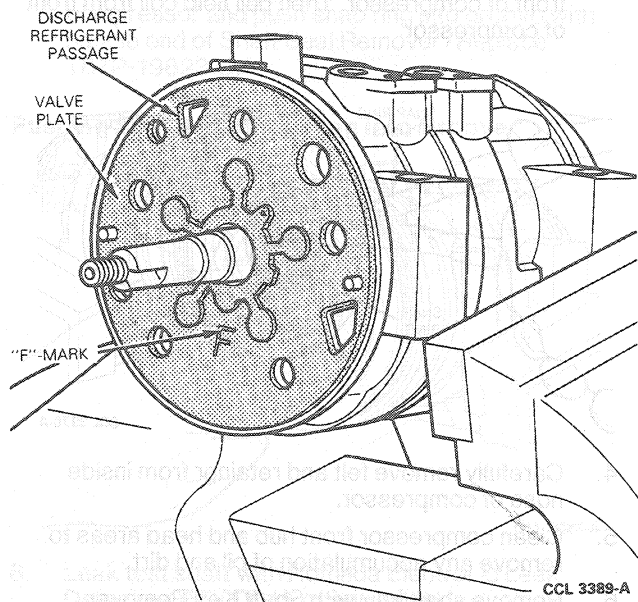
Reed Valve Installed



NOTE: The front and rear reed valves are identical and interchangeable.

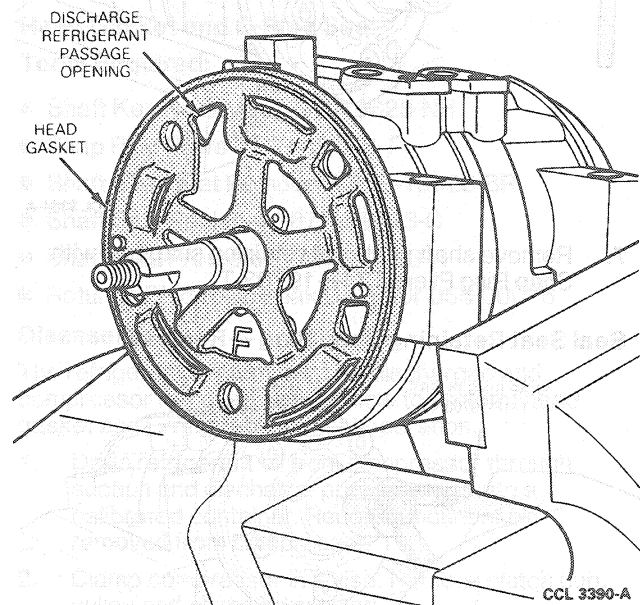
4. Lubricate front valve plate (marked with an "F") and place it in position on cylinder assembly. The "F" mark must be showing when the valve plate is properly installed.

Front Valve Plate Installation



5. Lubricate front head gasket and place it in position on the cylinder assembly. The front and rear head gaskets are not interchangeable so it is essential that the correct gasket is used. The raised portions of the gasket must be positioned away from the cylinder assembly and the gas passage opening must be positioned to the left of center as shown in the following illustration.

Head Gasket Installation



6. Position front head to cylinder assembly aligning dowel pins with dowel pin holes in front head.
7. Install dowel pins in dowel pin holes at rear of cylinder assembly.