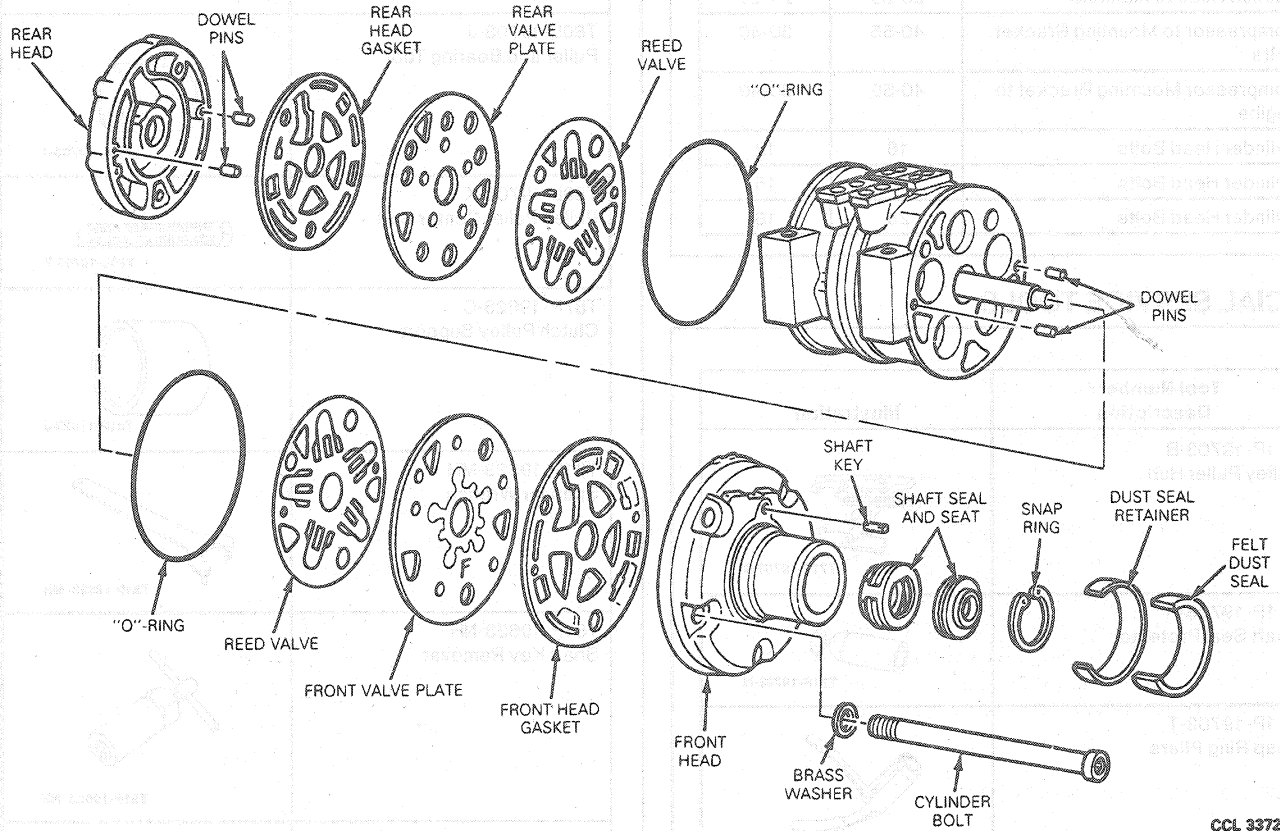


**MAJOR SERVICE OPERATIONS (Continued)**

- 20. Install shaft key with rounded end inward.
- 21. Pour new refrigerant oil into the compressor. Refer to Adding Refrigerant Oil, During Compressor Replacement, as outlined.

- 22. Rotate compressor shaft about 10 revolutions to distribute oil through compressor and around shaft seal. Then leak test the shaft seal with Rotunda Electronic Leak Detector 055-00015 or equivalent.
- 23. Install a new felt strip and retainer into nose of compressor.



CCL 3372-A

- 24. Install clutch field coil with beveled side of snap ring out.
- 25. Install clutch pulley with bevel of snap ring out. Then install shims and clutch hub as outlined.

**Head Replacement**

If it is necessary to replace the front or rear head, refer to Head Gasket and O-Ring Seal, Disassembly.

**SPECIFICATIONS**

**NOTE:** Drive belt tension is maintained by an automatic tensioner. No adjustment is required.

**COMPRESSOR SPECIFICATIONS**

Description	Specification
Type 10P15F (10 Cylinder)	Swashplate, 5 Double Acting Pistons, Axial
Displacement	153cc (9.33 CID)
Rotation	Clockwise
Rotation Torque (Maximum Manifold Removed)	10 N·m (7 Lb·Ft)
Refrigerant Oil Type	ESH-M2C31-A2
System Capacity	8 Fluid Ounces
Part No.	E73Z-19577-A Motorcraft YN-9
Magnetic Clutch Air Gap Between Pulley & Hub	0.021-0.036 inch
Current Draw	4.67 Amps @ 12.8 Volts
Run-out (Maximum)	0.02 Inch Radial or Axial