

Assembly instructions for electromagnetic clutches series LA18



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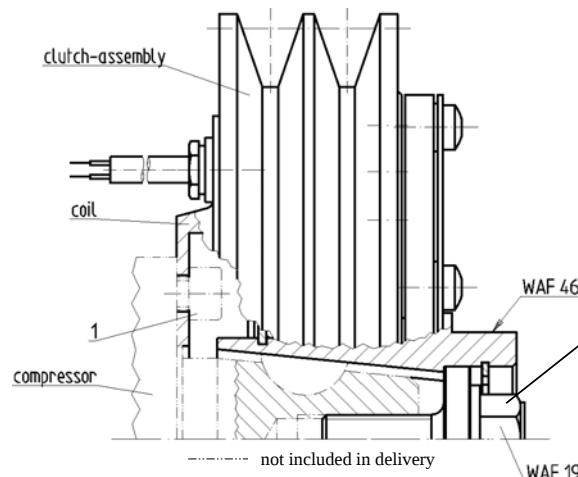
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BOCK
FK4



Assembly instruction:

1. Dismantle 3 filister head cap screws M8 (1) at the bearing flange.
2. Attach coil to bearing flange with 3 filister head cap screws M8 (1) (screws **have to be the same lenght as the dismantled screws**). Connect cable in a way that avoids contact with hot components.
 $t_{\max} = 105^{\circ}\text{C}$
3. **Remove circlip and holding-down bolt** from clutch-assembly. Slide clutch-assembly onto compressor shaft. Look through the center-hole for a correct position of the compressor shaft key in the rotor-keyway. Rotor should turn freely **without touching the coil**. Insert and tighten holding-down bolt M12 (tightening torque $M_a = 85 \text{ Nm}$, $M_a = 63 \text{ lbs.ft}$). Hold down the hub with an open-end wrench WAF46. Insert circlip.
4. Connect cable. The connection is independent of polarity.
Voltage $\pm 10\%$ of rated voltage.



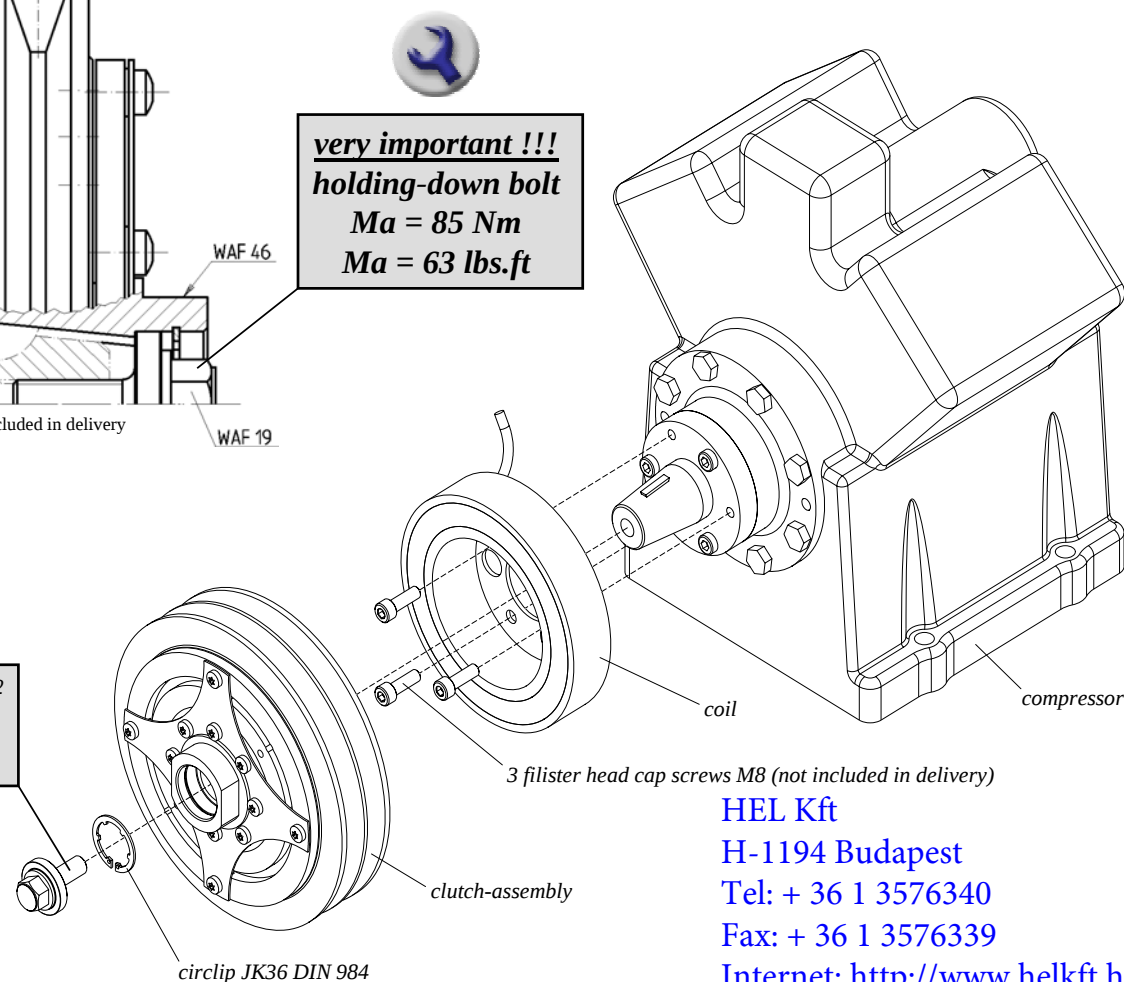
very important !!!
holding-down bolt
 $M_a = 85 \text{ Nm}$
 $M_a = 63 \text{ lbs.ft}$

Disassembly instruction:

For disassembly **grease** circlip (do not remove circlip) and turn the holding-down bolt left to loosen. Hold down the hub with an open-end wrench WAF46. In this way the clutch will be disconnected from the cone-shaft.

! **With any other method of disassembly (press or hammer)**
you risk a damage of the clutch. Clutch damages in this mode
• **are outside any warranty.** !

holding-down bolt M12
 $M_a = 85 \text{ Nm}$
 $M_a = 63 \text{ lbs.ft}$



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