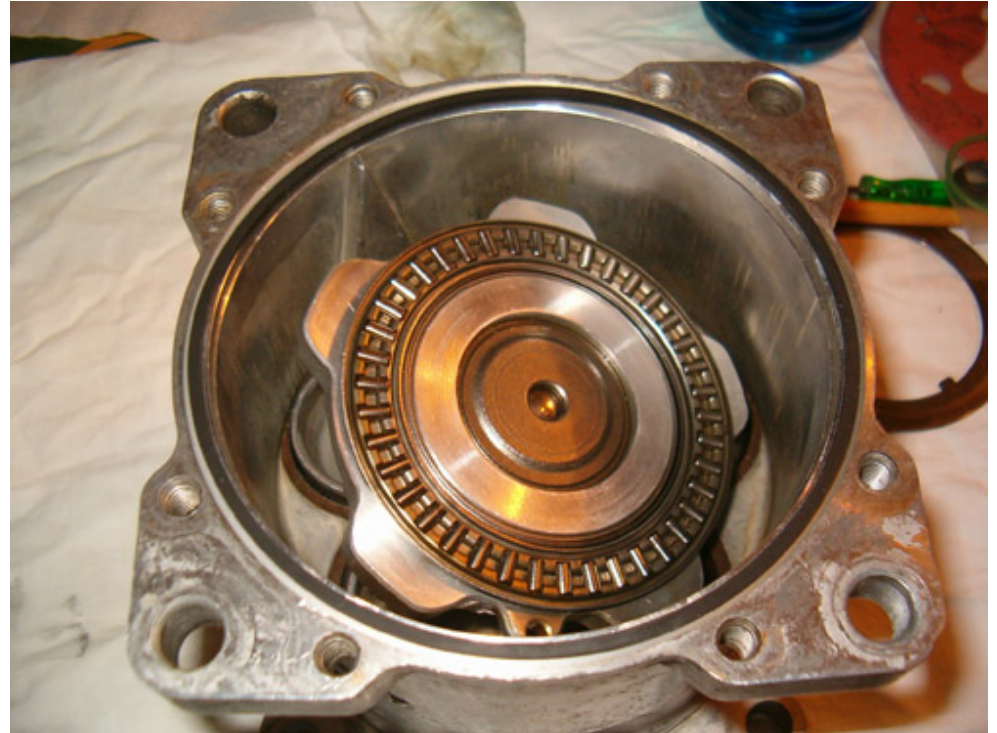


Compressor Assembly - Front Part

Now that the compressor parts are clean and shiny let's start assembly. You will need a clean working environment, many clean textiles and of course new ester refrigerant oil.



left to right: compressor body, piston shaft, piston assembly



Insert piston assembly into compressor body. This is a little tricky job but not impossible.



It should look like this...



front part close - up (pulley side)



front part close - up (interior side)



Insert shaft into front part body. Be careful not to miss the bearing



Install new gasket on compressor body and apply some drops of clean refrigerant oil in the groove



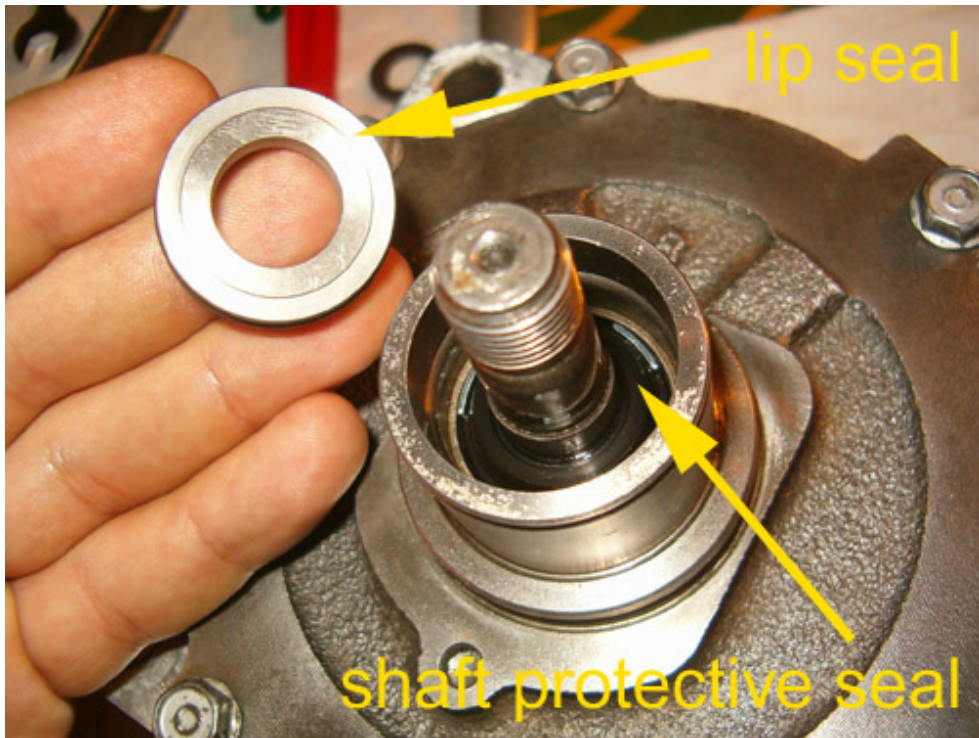
Gradually tighten the screws in cross order



New shaft protective seal (left) and lip seal with O-ring (right)



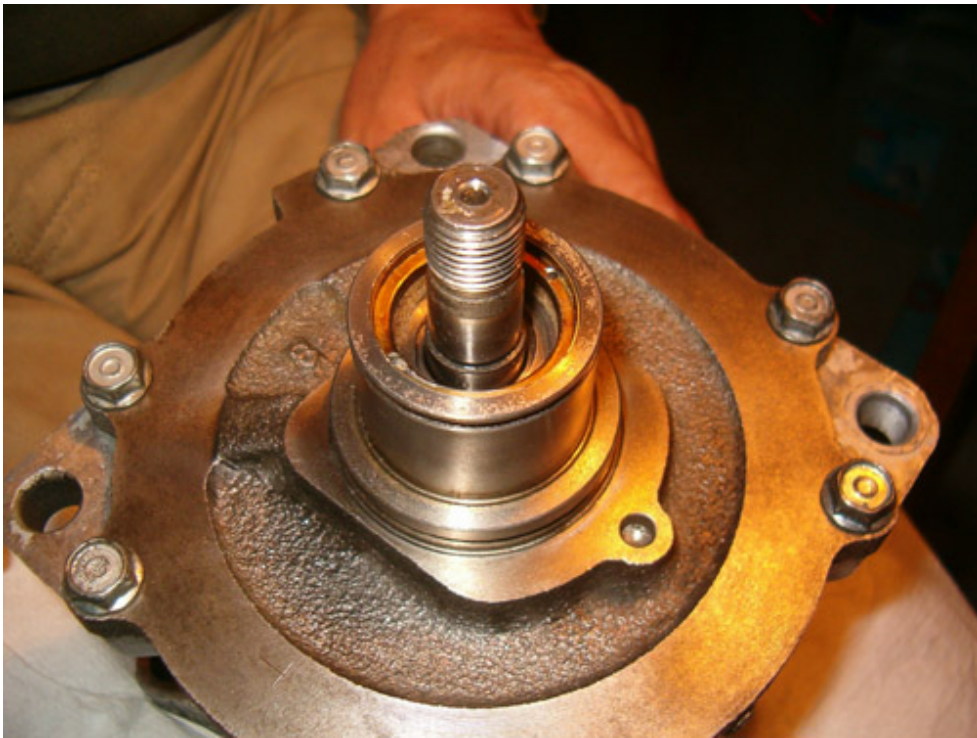
Be sure to dip both parts into clean ester oil



Insert shaft protective seal and then lip seal ...



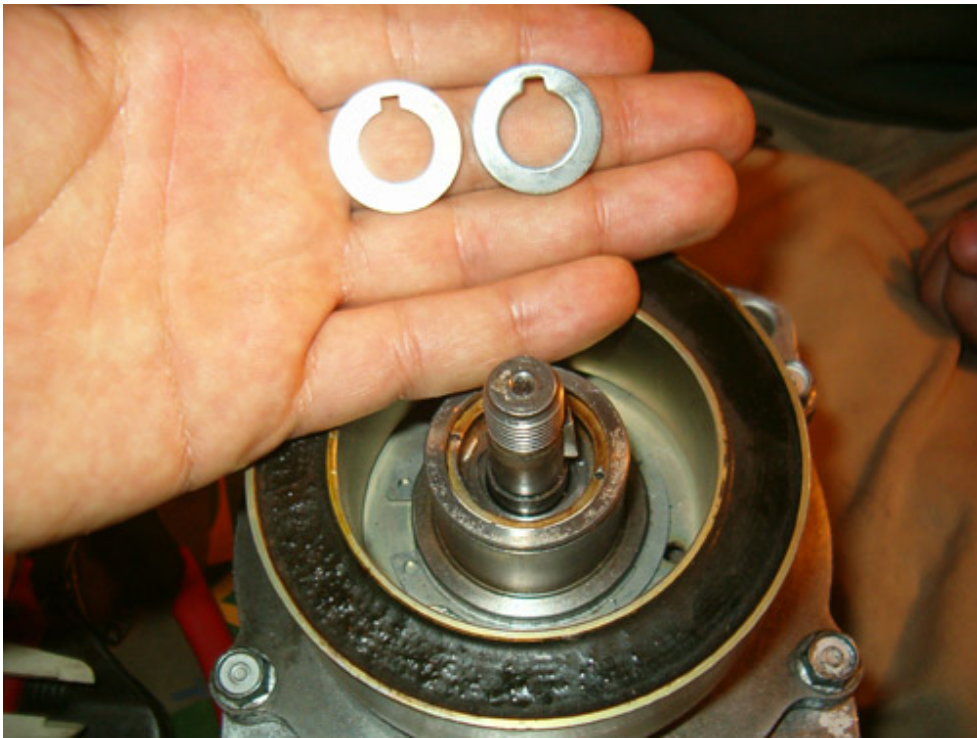
... lock ring to keep everything together ...



... and don't forget the felt ring.



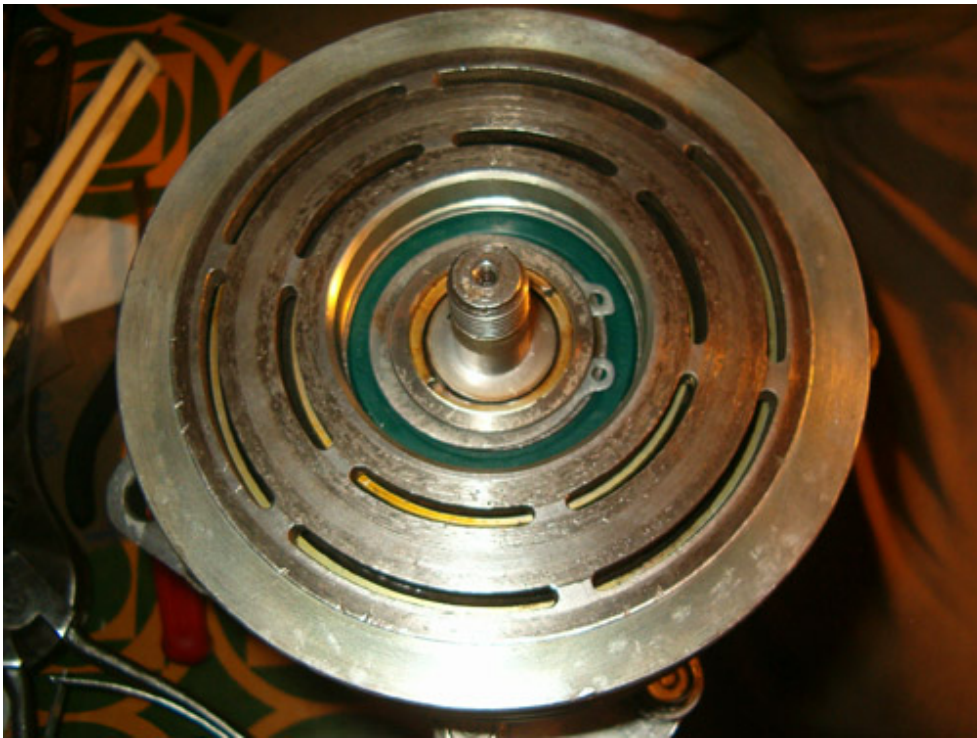
Mount the electromagnetic coupling with the respective lock ring ...



... and the washers which actually adjust the air gap between pulley and pressure plate



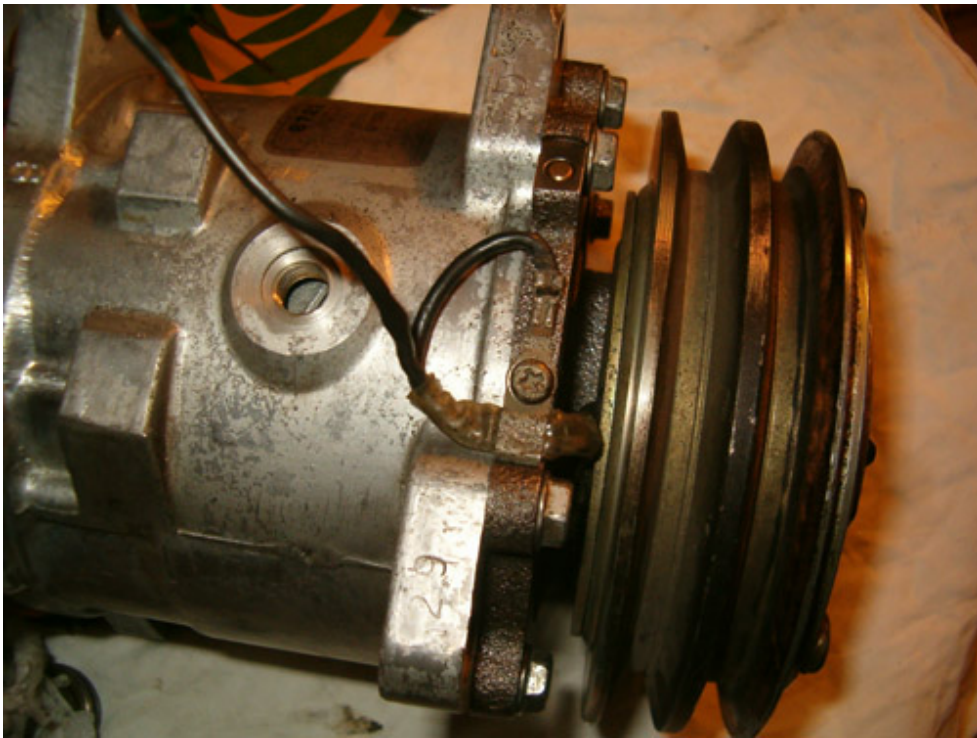
Punch the pulley with the rubber hammer in order to fit in place ...



...until there is enough room for the lock ring to fit inside the groove



Measure the air gap between the pulley and pressure plate. It should be between 0.4 - 0.8 mm. If not then proceed adding or removing washers as seen above.



Finally restore clutch wiring clamp

Let's now move on assembling the rear part of the compressor.