



INSTRUCTIONS FOR ARMATURE REMOVAL FROM GEAR CASE AND INSTALLATION OF BEARING RETAINER 1200DI, 1203DI, 1216DI, 1267DI AND 1274A THRU 1279A

The armature assembly is secured in the gear case by a shrink fit on the front armature bearing.

In order to remove the armature from the gear case, it is necessary to heat the gear case to approximately 200°F in the bearing bore area.

Ideally, the gear case should be heated with a heat gun, such as the SIOUX Cat. No. 1403, directing the heat to the bearing bore area for a few minutes, then tapping the gear case with a soft blow hammer while holding the armature. On units with the metal fan, the direction of heat can be from the armature side of the gear case. On units with the plastic fan, the threaded spindle and large gear must be removed along with the grease. The direction of heat must then be from the gear case cavity, so as to prevent damage to the plastic fan.

WARNING

- 1) TO AVOID INJURY, USE HEAVY INSULATED GLOVES WHEN HANDLING HOT PARTS.
- 2) DO NOT USE OPEN FLAME TO HEAT ASSEMBLY.
- 3) DO NOT USE HEAT GUN IN PRESENCE OF FLAMMABLE MATERIALS.

ALLOW TIME FOR THE PARTS TO COOL BEFORE PROCEEDING.

For the 1200DI, 1203DI, 1216DI, and 1267DI: Remove the pinion gear and front bearing.

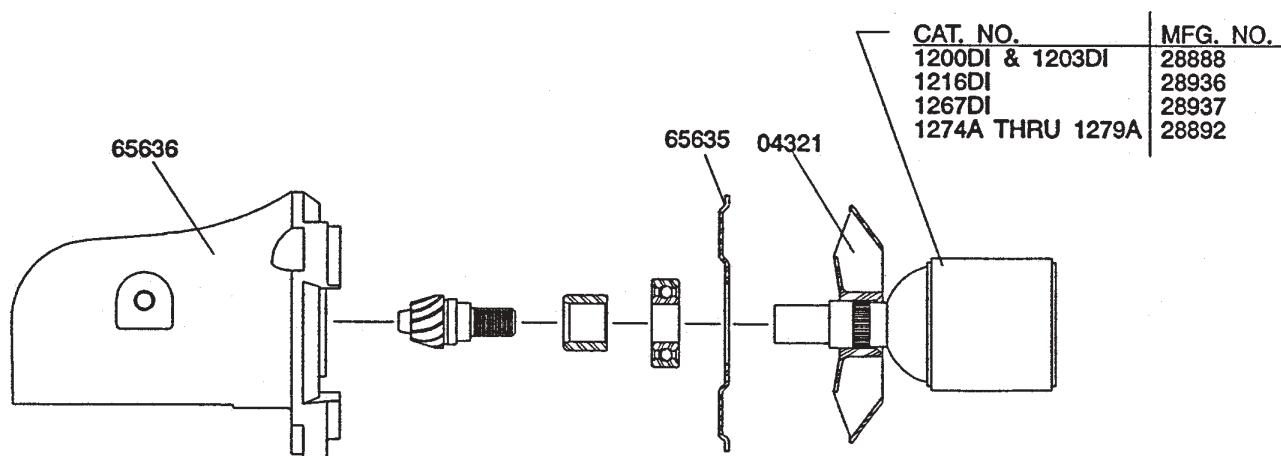
For the 1274A, 1275A, 1276A, 1277A, and 1279A: Remove the pinion gear, spacer, and front bearing.

Install the 65635 bearing retainer between the armature and bearing (CAUTION! PLACE RECESSED SIDE OF RETAINER AGAINST BEARING, REFER TO ILLUSTRATION.)

Reinstall the pinion gear or the pinion gear and spacer on the armature and torque to 25-27 ft-lbs.

Install the armature assembly in the gear case, aligning the tabs of the bearing retainer between the ears of the gear case.

Install the armature and gear case into the housing and secure with (4) screws.



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