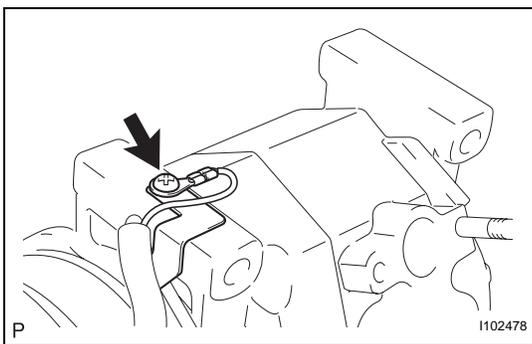


## REASSEMBLY

### 1. INSTALL COOLER BRACKET

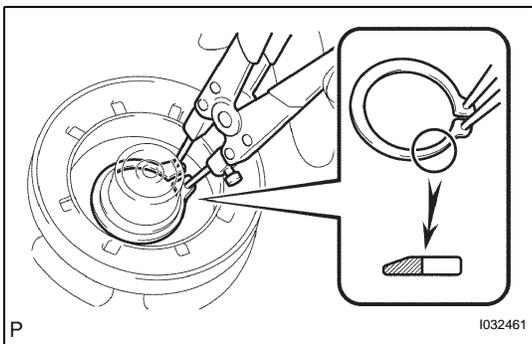
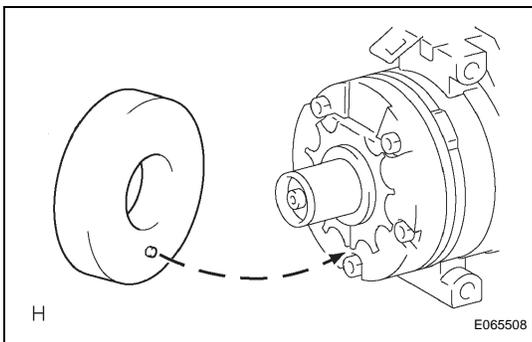
- (a) Install the cooler bracket with the screw.



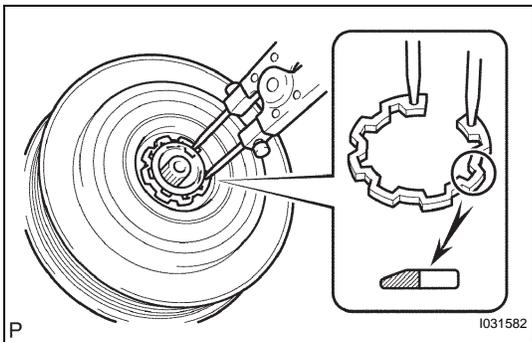
### 2. INSTALL MAGNET CLUTCH ASSEMBLY

**SST 09960-10010 (09962-01000, 09963-00500)**

- (a) Install the magnet clutch stator with the parts shown in the illustration matched.



- (b) Using a snap ring expander, install a new snap ring with the chamfered side facing up.
- (c) Connect the connector.

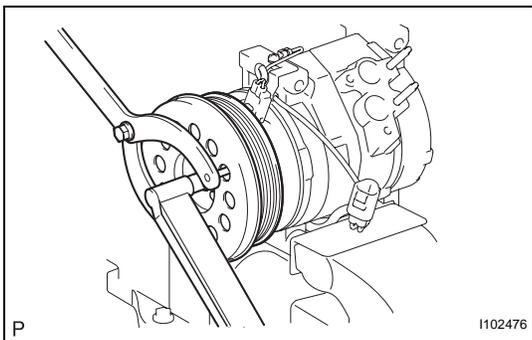


- (d) Using SST, install the magnet clutch rotor and a new snap ring with the chamfered side facing up.

**NOTICE:**  
Do not damage the seal cover of the bearing when installing the snap ring.

- (e) Install the compressor spacer and magnet clutch hub.

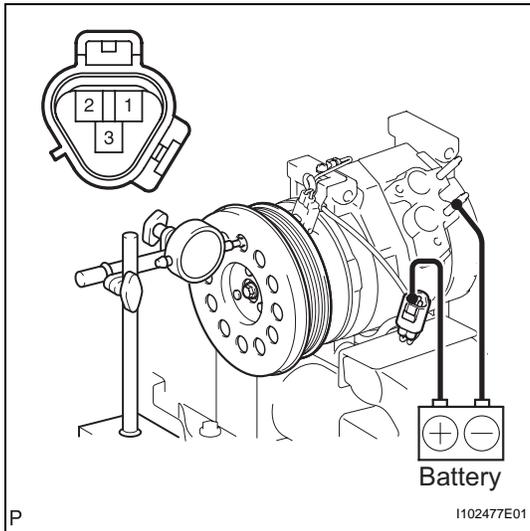
**NOTICE:**  
Do not change the combination of the compressor spacer used before disassembly.



- (f) Using SST, hold the magnet clutch hub and install the bolt.

**SST 09960-10010 (09962-01000, 09963-00500)**  
**Torque: 18 N\*m (184 kgf\*cm, 13 ft.\*lbf)**

**NOTICE:**  
Make sure that there is no foreign matter or oil on the compressor shaft, bolt, and clutch hub.



### 3. INSPECT MAGNET CLUTCH CLEARANCE

- (a) Clamp the cooler compressor in a vise.
- (b) Set the dial indicator to the magnet clutch hub.
- (c) Connect the battery positive lead to terminal 3 (MG+) of the magnet clutch connector and the negative lead to the earth wire. Turn the magnet clutch on and off and measure the clearance.

#### Standard clearance:

**0.35 to 0.60 mm (0.014 to 0.024 in.)**

If the measured value is not within the standard clearance, remove the magnet clutch hub and adjust the clearance using compressor spacer to obtain the standard clearance.

#### Compressor spacer thickness:

**0.1 mm (0.004 in.)**

**0.3 mm (0.012 in.)**

**0.5 mm (0.020 in.)**

#### NOTICE:

**Adjustment should be performed with 3 or less magnet clutch washers.**

- (d) Remove the cooler compressor from the vise.

## INSTALLATION

### 1. ADJUST COMPRESSOR OIL

- (a) When replacing the compressor with a new one, gradually discharge the refrigerant gas from the service valve. Then drain the following amount of oil from the new compressor before installation, so that the amount of oil contained in it is the same as that in the compressor to be replaced.

#### HINT:

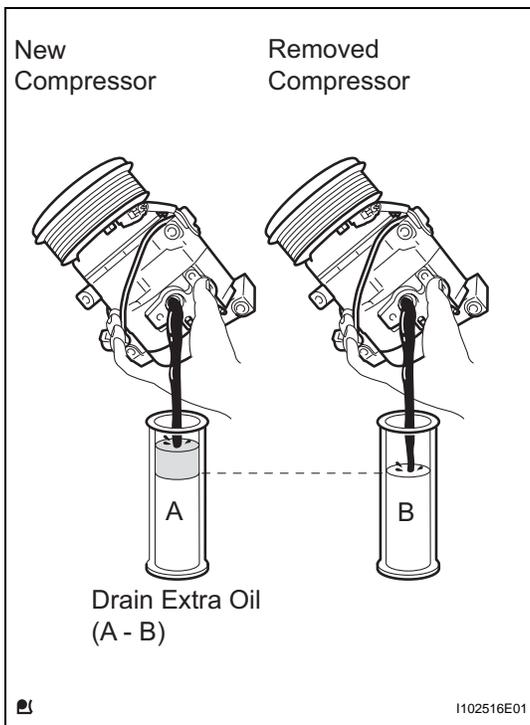
New compressors are filled with sufficient oil for the whole cycle. Therefore, it is necessary to drain residual oil from the condenser and cooling unit.

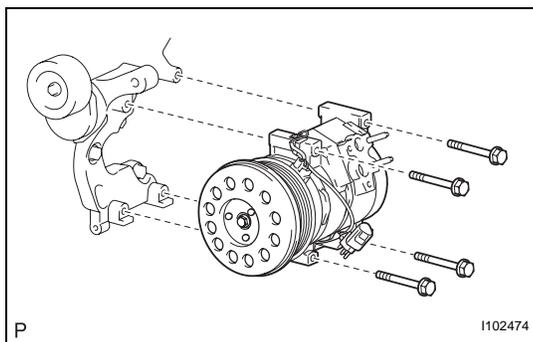
#### Standard:

**(The amount of oil inside a new compressor: 120 (+15) cc (4.1 (+0.51) fl.oz.) - (The amount of oil remaining in the removed compressor) = The amount of oil to be removed when replacing the compressor**

#### NOTICE:

- When checking the compressor oil level, observe the precautions for cooler removal/installation.
- If a new compressor is installed without removing the amount of oil remaining in the pipes of the vehicle, the amount of oil becomes too large. This prevents heat exchange in the refrigerant cycle and causes refrigeration failure.
- If the amount of oil remaining in the removed compressor is too small, check for oil leakage.
- Use ND-OIL8 compressor oil.



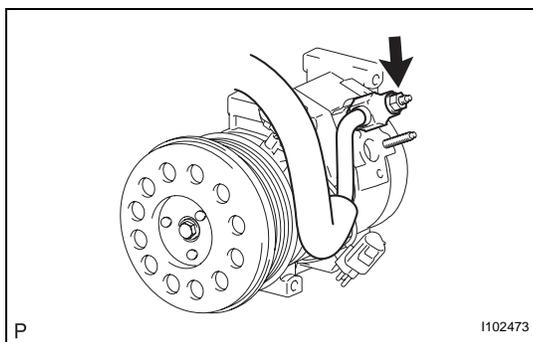


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**2. INSTALL COOLER COMPRESSOR ASSEMBLY**

- (a) Install the compressor with the 4 bolts.  
**Torque: 24.5 N\*m (250 kgf\*cm, 18 ft.\*lbf)**
- (b) Connect the connector.



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**3. INSTALL DISCHARGE HOSE SUB-ASSEMBLY**

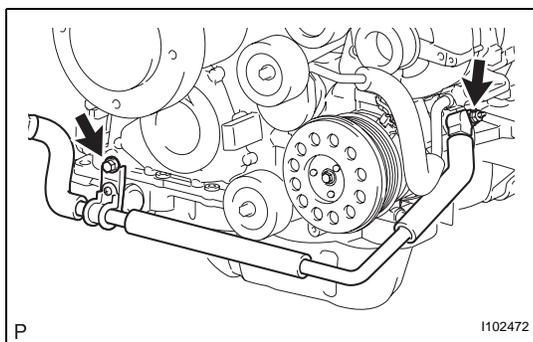
- (a) Remove the attached vinyl tape from the hose.
- (b) Apply sufficient compressor oil (ND-OIL8) to a new O-ring and the fitting surface of the compressor.

**Compressor oil:****ND-OIL8 or the equivalent**

- (c) Install the O-ring onto the discharge hose.
- (d) Install the discharge hose onto the compressor with the nut.

**Torque: 9.8 N\*m (100 kgf\*cm, 87 in.\*lbf)**

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**4. INSTALL SUCTION HOSE SUB-ASSEMBLY**

- (a) Remove the attached vinyl tape from the hose.
- (b) Apply sufficient compressor oil (ND-OIL8) to a new O-ring and the fitting surface of the compressor.

**Compressor oil:****ND-OIL8 or the equivalent**

- (c) Install the O-ring onto the suction hose.
- (d) Install the suction hose onto the compressor with the nut.

**Torque: 9.8 N\*m (100 kgf\*cm, 87 in.\*lbf)**

- (e) Install the suction hose with the bolt.

**Torque: 7.8 N\*m (80 kgf\*cm, 69 in.\*lbf)****5. INSTALL FAN AND GENERATOR V BELT (See page [EM-6](#))****6. INSTALL NO. 1 ENGINE UNDER COVER SUB-ASSEMBLY****7. INSTALL BATTERY TRAY****8. INSTALL BATTERY****9. INSTALL BATTERY HOLD DOWN CLAMP**  
**Torque: 6.0 N\*m (61 kgf\*cm, 53 in.\*lbf)****10. CONNECT CABLE TO NEGATIVE BATTERY TERMINAL****Torque: 3.9 N\*m (40 kgf\*cm, 35 in.\*lbf)****11. CHARGE REFRIGERANT (See page [AC-16](#))****12. WARM UP ENGINE (See page [AC-18](#))****13. CHECK FOR REFRIGERANT LEAKAGE (See page [AC-18](#))**