



# KIT END BELL ASSEMBLY

100324, 100324-1, 100324-2



**Installation and servicing of Danfoss Turbocor® compressors by qualified and product trained personnel only. Follow these instructions and sound refrigeration/electrical/servicing practices relating to installation, commissioning, maintenance and service.**

<p>Consult the appropriate DTC Service Manual on <a href="http://turbocor.danfoss.com">turbocor.danfoss.com</a> for detailed service instructions.</p>	<p><b>Never power compressor without covers in place and secured.</b></p> <p><b>Removing the mains input cover will expose you to a voltage hazard of up to 575V. Ensure the mains input power is off and locked out before removing cover.</b></p> <p><b>Before removing top cover, wait at least 20 minutes after isolating AC power to allow the high voltage capacitors to discharge.</b></p>	<p>Always wear appropriately rated safety equipment when working around equipment and/or components energized with high voltage.</p> <p><b>This equipment contains hazardous voltages that can cause serious injury or death.</b></p>	<p><b>Recover all refrigerant from compressor in accordance with local codes and ensure pressure is fully vented before the removal of refrigerant containing components.</b></p>
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## 1 - Introduction:

END BELL ASSEMBLY Removal and Installation Instructions.

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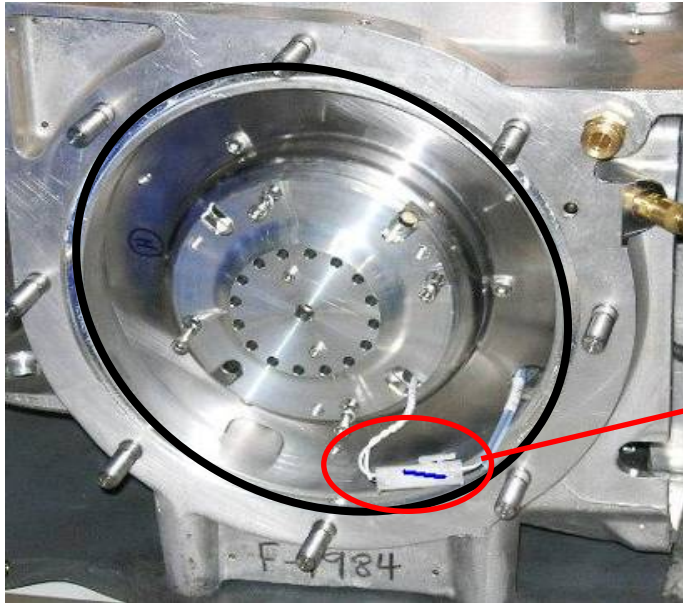
## 2 - Removing Refrigerant from Compressor:

- Recover refrigerant from compressor in accordance with local codes and practices.

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## 3 - Replacement Procedure:

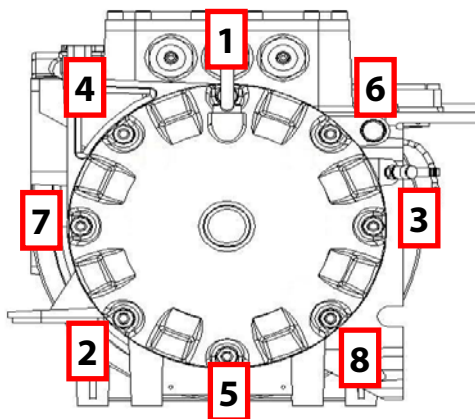
1. Select the compressor for which you want to change the End bell
2. Isolate the compressor by closing the valves in the suction and discharge sides.
3. Discharge the refrigerant from the compressor using appropriate tools.
4. Remove the nuts/socket head screws (depending on your compressor model) which fasten the End bell to the Main Housing.
5. Remove the old O-ring from the main housing and wipe the O-ring groove.
6. Place the new O-ring in to the O-ring groove on the Main housing. Check for the witness mark on the Axial Bearing Connector.



7. Check the seal area (area between red lines) on the End bell for burr, damage or scratches.






8. Place the End bell on the main housing using nuts /hexagonal head screws.
9. Tighten the nuts/hexagonal head screws by hand to have a preliminary adjustment.
10. Using the Torque Wrench, torque the 8 x Screws to 22Nm. according to the following order.



11. Repeat the tightening process twice to have a perfect seal.
12. Recharge the system if necessary, and start the compressor.

4 - Kit Contents

QTY	Part(s) Description	Picture(s)
1	END BELL ASSEMBLY	
1	'O' RING	
1	EYE BOLT M10X17LG	

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