

## Refrigerant Compressor Head and Valve Plate Removal and Installation

### Removal

**NOTE:** Before doing any work on the head and valve plate, open both service valves to release any gas pressure in the compressor. The cylinder head is made of aluminum; be careful when removing it not to damage the sealing surfaces.

1. Remove the screws from the cylinder head. See Fig. 1.

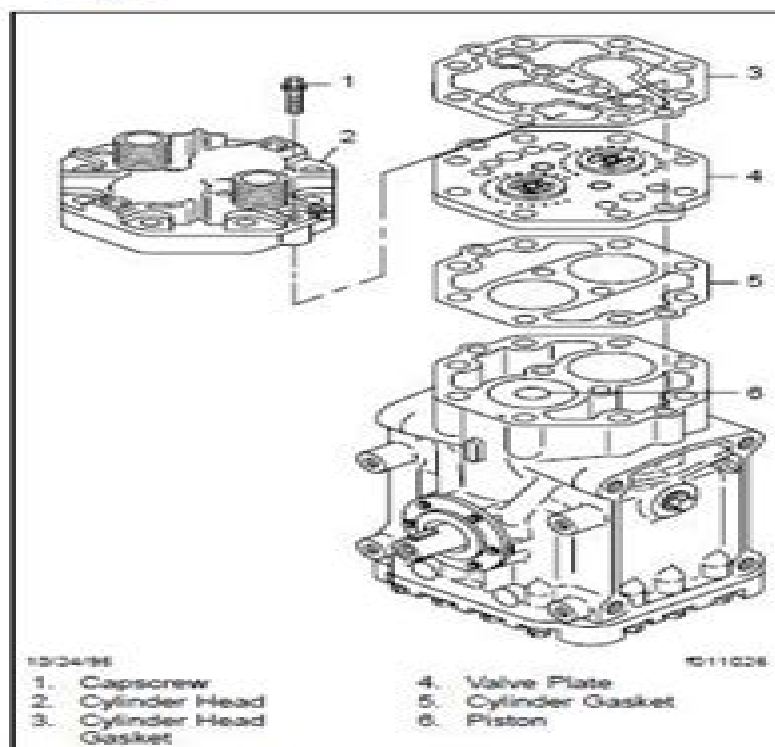


Fig. 1, Head and Valve Plate Removal

2. Remove the valve plate and head from the cylinder by prying or tapping under the ears extend-

ing from the valve plate. If the head and valve plate adhere, hold the head and tap the valve plate ears away from the head with a soft hammer.

### CAUTION

Do not hit or tap the head to separate it from the valve plate. Damage to the head may result.

3. Being careful not to scratch or nick the machined sealing surfaces, remove all gasket material adhering to the head, valve plate, or cylinder.

### Installation

**NOTE:** Valves and valve plates are furnished only as a complete assembly.

1. Apply a thin film of clean mineral oil to the area of the crankcase to be covered by the cylinder gasket. Place the cylinder gasket in position on the cylinder so that the dowel pins in the crankcase pass through the dowel pin holes in the cylinder gasket.
2. Apply a thin film of clean mineral oil to the top and bottom valve plate areas to be covered by gaskets. Place the valve plate in position on the cylinder gasket so that the discharge valve assemblies are facing up and the locating dowel pins go through the dowel pin holes in the valve plate. The discharge valve assemblies are the smaller diameter ones with the retainer over the valve reed.
3. Place the head gasket in position on the valve plate so that the dowel pins go through the dowel pin holes in the gasket.
4. Apply a light film of clean mineral oil to the machined surface of the cylinder head which contacts the head gasket. Place the head on the cylinder head gasket so that the dowel pins go into the dowel pin holes in the head.
5. Insert the head screws and tighten all the screws until the heads make contact.
6. Tighten the head screws 17 to 25 lbf·ft (23 to 34 N·m) in sequence. See Fig. 2.

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