

Table of Contents

Section	Title	Page
1	REPAIR AND OVERHAUL	9
1.1	INTRODUCTION	9
1.2	EVACUATION/DRYING THE REFRIGERATING SYSTEM	9
1.3	EVACUATION, LEAK TESTING AND START-UP OF THE COMPRESSOR/PACKAGE	9
1.3.1	EVACUATION OF REFRIGERANT BEFORE SERVICING	9
1.3.2	LEAK-TIGHTNESS AFTER SERVICING	9
1.3.3	EVACUATION AFTER SERVICING	9
1.3.4	START-UP AFTER SERVICING	9
1.4	GENERAL RECOMMENDATIONS	10
2	DISASSEMBLY	11
2.1	FLYWHEEL REMOVING	11
2.2	DISMANTLING SUCTION GAS FILTER	11
2.3	DISMANTLING THE PRESSURE RELIEF VALVE HOUSING	12
2.4	REMOVING DISCHARGE VALVE ASSEMBLY	12
2.5	REMOVING THE PISTON/CONNECTING ROD ASSEMBLY	13
2.6	REMOVING THE VALVE-LIFTING HOUSING AND THE CYLINDER LINER	14
2.7	DISMANTLING THE ROTARY SHAFT SEAL	15
2.8	REMOVING OIL SUCTION AND OIL DISCHARGE FILTER HOUSING	17
2.9	REMOVING OIL PUMP ASSEMBLY	17
2.10	THRUST BEARING	19
2.10.1	DISMANTLING STANDARD THRUST BEARING	19
2.10.2	HEAVY DUTY THRUST BEARING CONSTRUCTION	20
2.10.2.1	DISMANTLING HEAVY DUTY THRUST BEARING	20
2.11	REMOVING CRANKSHAFT, INTERMEDIATE BEARING AND MAIN BEARINGS	21
3	INSPECTION AND PREASSEMBLY	25
3.1	PRESSURE RELIEF VALVE ASSEMBLY	25
3.1.1	Warning independent pressure relief valves	26
3.2	LUBRICATING OIL PRESSURE REGULATOR	26
3.3	CONTROL OIL PRESSURE REGULATOR	27
3.4	VALVE-LIFTING CONTROL MECHANISM	27
3.5	DISCHARGE VALVE ASSEMBLY	28
3.6	PISTON/CONNECTING ROD	29
3.7	CYLINDER LINER AND VALVE-LIFTING MECHANISM	32
3.8	OIL PUMP AND OIL FILTERS	33
3.9	MAIN BEARINGS	37
3.10	ROTARY SHAFT SEAL	38
3.11	CRANKSHAFT	39
3.12	THRUST BEARINGS	40
3.12.1	STANDARD BRONZE THRUST BEARING, MARK 2	40
3.12.2	HEAVY DUTY THRUST BEARING	40
3.13	CRANKCASE	40

Section	Title	Page
4	REASSEMBLING	43
4.1	CRANKSHAFT, MAIN BEARINGS AND INTERMEDIATE BEARING	43
4.1.1	Bearing cover driving side	43
4.1.2	Assembly procedure of 2 and 4-cylinder compressors	43
4.1.3	ASSEMBLY PROCEDURE 3, 6 AND 8-CYLINDER COMPRESSORS	43
4.1.4	Pump side	44
4.1.5	Standard thrust bearing	44
4.1.6	Oil pump assembly for standard thrust bearing	45
4.1.7	Heavy duty thrust bearing and oil pump	45
4.1.8	CHECKING AXIAL PLAY OF THE CRANKSHAFT	46
4.1.8.1	Checking axial play of crankshaft; Procedure for 2 and 4 cylinder compressors	46
4.1.8.2	Checking axial play of crankshaft; Procedure for 3, 6 and 8 cylinder compressors	46
4.2	OIL SUCTION/DISCHARGE FILTER, LUBRICATING/CONTROL OIL PRESSURE REGULATOR	47
4.3	CYLINDER LINER	48
4.4	VALVE-LIFTING CONTROL MECHANISM	49
4.5	PISTON/CONNECTING ROD ASSEMBLY	49
4.6	DETERMINING THE PISTON CLEARANCE	50
4.7	SUCTION/DISCHARGE VALVE ASSEMBLY	51
4.8	ROTARY (SLIP RING) SHAFT SEAL	52
4.9	SUCTION GAS FILTER	54
4.10	PRESSURE RELIEF VALVE ASSEMBLY(see Section 3.1.1)	54
4.11	OIL FILLING	54
4.12	MOUNTING THE FLYWHEEL	55
4.13	DISCHARGE VALVES, LEAKAGE TEST PROCEDURE	55
5	MISCELLANEOUS	57
5.1	SURVEY OF TORQUES FOR BOLTS AND NUTS GRASSO 10	57
5.2	WEAR LIMITS AND TOLERANCES	58
5.3	REQUIRED SERVICE TOOLS AND MATERIALS	58
5.4	GRASSO SPECIAL TOOLS AND AIDS	59
5.5	FITTING INSTRUCTIONS FOR PIPE COUPLINGS AND DOUBLE LOCKING RING	60
5.6	MASS OF SEPARATE COMPONENTS AND COMPRESSORS	60
5.7	RELIEF VALVE POSITIONS	60