



Installation of Replacement Stators Into Housings

Due to the possibility of shrinkage of the stator core and motor housing during heating and cooling or loss of material during cleaning of the outside of stator and inside of motor housing, these instructions must be followed.

- Determine position of wire bundle from existing stator, and clearly mark the wire bundle location. The new stator bundle must be located in same position.
- Heat and remove old stator from housing. Allow housing to cool, then clean inside housing by sanding and wiping clean.
- Prepare new stator for installation. Make sure exterior of stator is clean and free of contaminants.
- Bring housing back up to temperature.
- For installation apply Loctite 620 retaining compound around the stator circumference in three places (top, middle and bottom) and for large stators (top, between top and middle, between middle and bottom and bottom).
- Locate new stator so wire bundles are in original location (marked in step #1), then carefully lower stator into housing. Be sure stator is fully seated on shoulder in housing, and allow Loctite to cure.

IMPORTANT: RETAINING COMPOUND MUST BE USED ON ALL REPLACEMENT STATORS!