

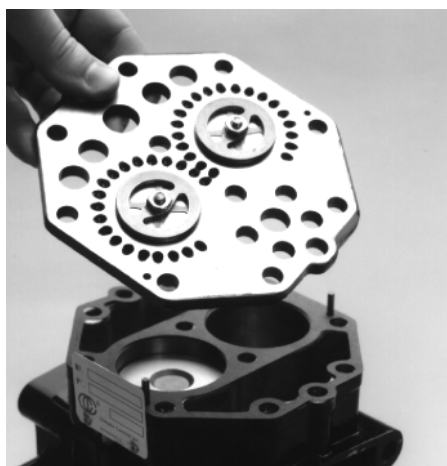


3. All gasket material adhering to the head, valve plate, or crankcase; should be carefully removed in such a manner that the machined sealing surfaces are not scratched or nicked.

#### INSTALLATION

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

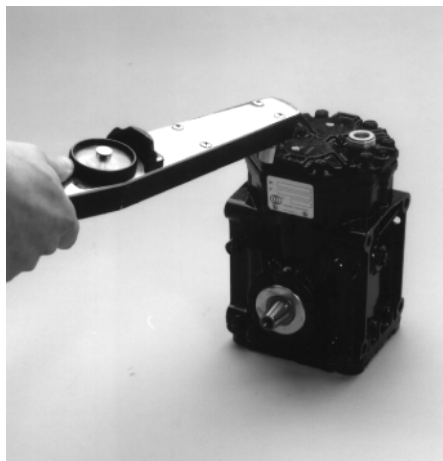
1. Apply a thin film of clean refrigeration oil on the area of the crankcase to be covered by the crankcase gasket. Place the cylinder gasket in position on the cylinder so the dowel pins in the crankcase go through the dowel pin holes in the cylinder gasket.



2. Apply a thin film of clean refrigeration 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 the discharge valve assemblies (i.e. the smaller diameter assemblies with the restrainer over the valve reed) are facing up and the locating dowel pins go through the dowel pin holes in the valve plate.

3. Place the head gasket, with the bead facing up, in position on the valve plate so the dowel pins go through the dowel pin holes in the gasket.

4. Apply a light film of clean refrigeration oil on the machined surface of the cylinder head which matches the head gasket. Place the head on the cylinder head gasket so the dowel pins go into the dowel pin holes in the head.



5. For a flange head, apply a thin film of clean refrigeration oil to the service valve flanges. Place an oiled service valve O-ring or gasket in position on the cylinder head service valve flanges. Place the service valves in position on the proper service valve ports (suction or discharge) and insert the four longer screws through the service valve mounting pads, the head, the valve plate, and into the crankcase. For a Tube 'O' or Rotalock head, insert the longer torx screws on the inside of the service valve ports and the shorter torx screws on the outside. Insert the remaining head screws and run in all the screws until the heads make contact. Tighten the head and service valve screws (using a torque wrench) to 17-25 ft. lbs. (23.0-33.9 N-m) in sequence as shown on torque sequence chart, page 15.

## BASEPLATE SERVICING

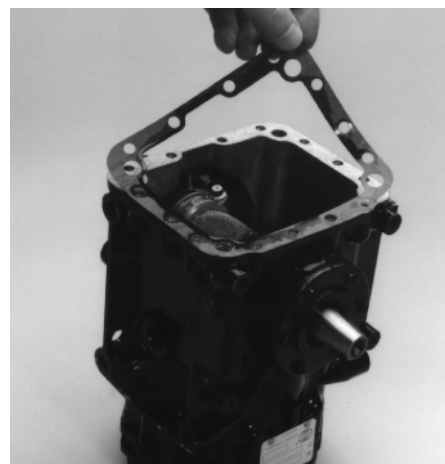
#### REMOVAL



1. Remove the baseplate bolts.
2. Remove baseplate and gasket. If the baseplate is stuck, lightly tap the edges of the baseplate with a soft hammer.
3. Remove any gasket material adhering to the baseplate or crankcase. This should be done in a manner such that the sealing surfaces are not scratched or nicked.

#### INSTALLATION

1. Apply a thin film of refrigeration oil to a new gasket and the sealing surface of the crankcase and baseplate.



2. Properly align the gasket on the crankcase.