INSTRUCTIONS

99TA526090F (for RCD use only)

Instruction Sheet Number: **99TA526090F**

Description: Terminal Plate Package

Author: R.C.D. Date: February 20, 2013

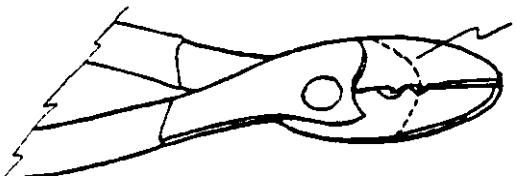
Part Number: 06DA660134

Included In Kit:

1)	Terminal Plate Assembly	06DA407624	(1)
2)	Cover Gasket	06DA504123	(1)
3)	Splice	06DA680035	(2)
4)	Screws	06DA502343	(4)
5)	Warning Label	06DA502503	(1)
6)	Instruction Sheet	99TA526090	(1)

In addition to this kit, you should have the right tool for the job. The secret to making a fast and accurate repair on a 06D compressor terminal plate is to use a modified crimping tool. Start with a tool designed to crimp wire terminals with capacities from 10 through 20 AWG wire size. This tool is modified by grinding down the tip so it will fit around the terminal posts on the terminal plate. (see Figure 1)

Figure 1



WARNING: Before performing any service work on the terminal box, disconnect all power including crankcase heater power and relieve the pressure from the compressor. Follow the safety instructions found on the compressor terminal box cover. Once the pressure in the compressor has been relieved, the terminal plate and gasket are replaced as follows:

(1) Remove the external wires and the terminal box. Then loosen and remove the terminal plate capscrews.

(2) Pull the terminal plate out from the crankcase and mark the wires for later identification and positioning in the replacement terminal plate.

(3) Cut the wires as close to the terminal post as possible to remove the old terminal plate.

(4) Strip the insulation back approximately 3/8 inch from the end of each wire. Twist the ends of the wire together and tin each wire just enough to prevent any loose or stray stands. Use only rosin core solder. Trim the ends of the wires with a file so they will fit into the terminal posts.

(5) The two low voltage wires will not crimp tightly in the terminal post because of their size. Therefore, a butt connector (06DA680035) must be used on each end of the two wires to increase their diameter and insure a tight crimp.

(6) Before attaching the wires to their respective terminal posts, clean the old gasket material from the crankcase and install the new gasket after first lubricating it lightly with refrigerant oil. Do not soak the gasket in oil.

(7) Next, identify and insert the wires in their proper terminal post and cramp each one using the modified crimping tool. Be sure the slot in the crimping tool and fits around the terminal post or an improper crimp will result creating a high resistance connection.

(8) Replace the terminal plate. Be careful not to pinch or crimp any of the motor leads. Tighten the (4) 5/16” hex head screws provided and torque to 16-20 ft. lbs.

(9) Evacuate, charge and leak test the compressor in accordance with standard practices, then check each terminal post for a grounded condition using a volt-ohmmeter. Replace the terminal box, external wiring and the box cover.

The installation of the terminal plate is now complete.