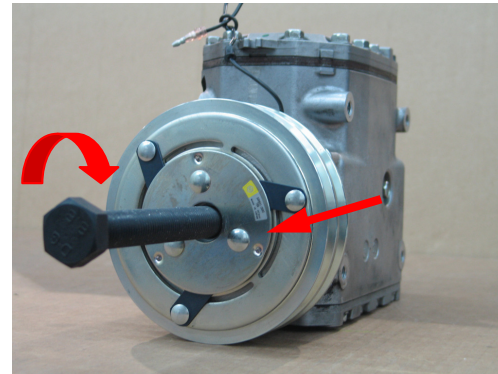


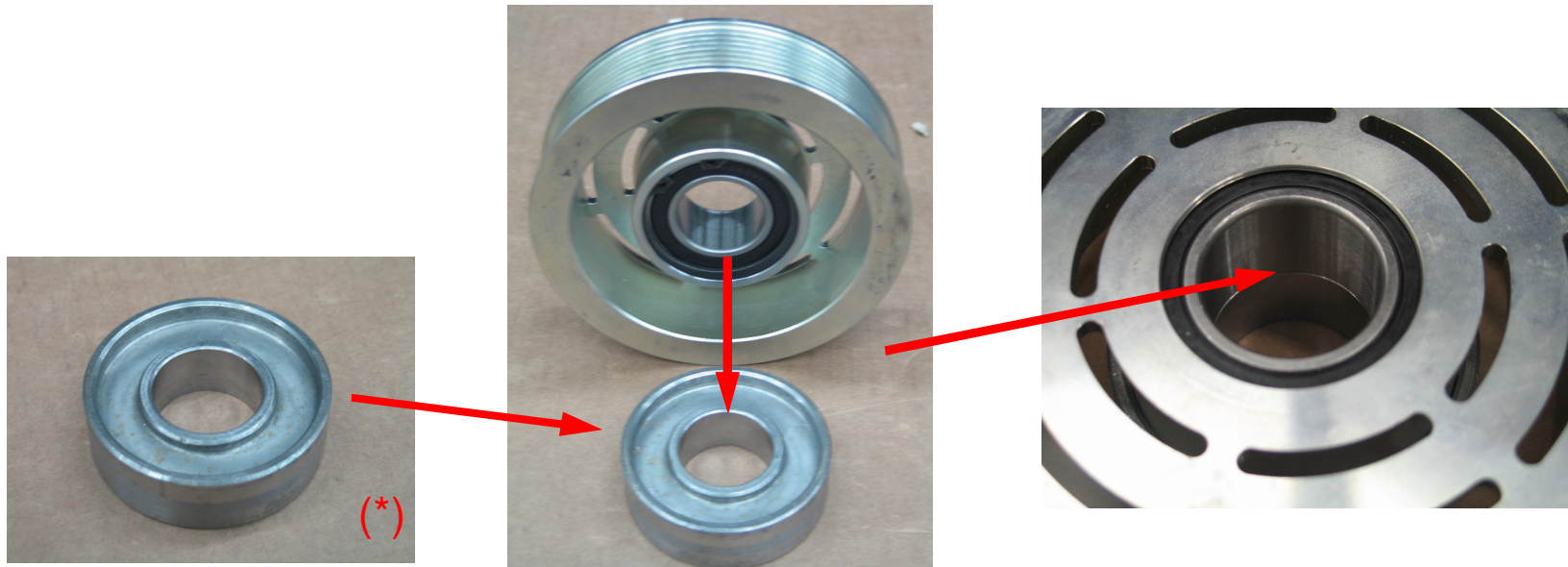
## SB12120016 - TK-315 clutch replacement

- Remove the original clutch assembly from the compressor
  - Remove the center mounting bolt (M8x30)
  - Place a M20 bolt onto the armature hub and tight slightly to free the pulley and armature assembly from the compressor shaft
  - Remove the armature from the pulley



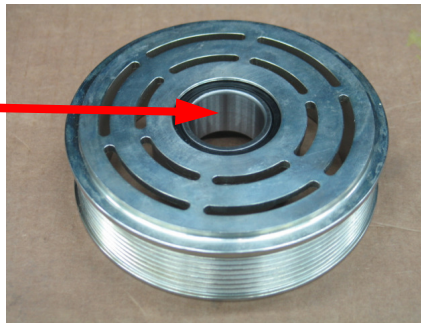
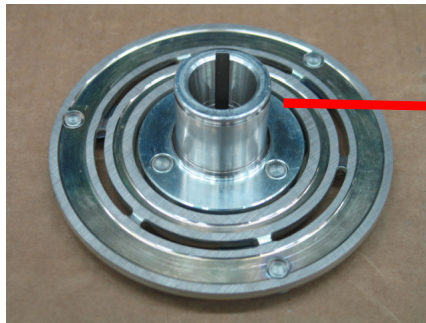
## SB12120016 - TK-315 clutch replacement

- Use a fixture (\*) to ensure stress is only applied to the inner ring of the bearing during the fitting process:



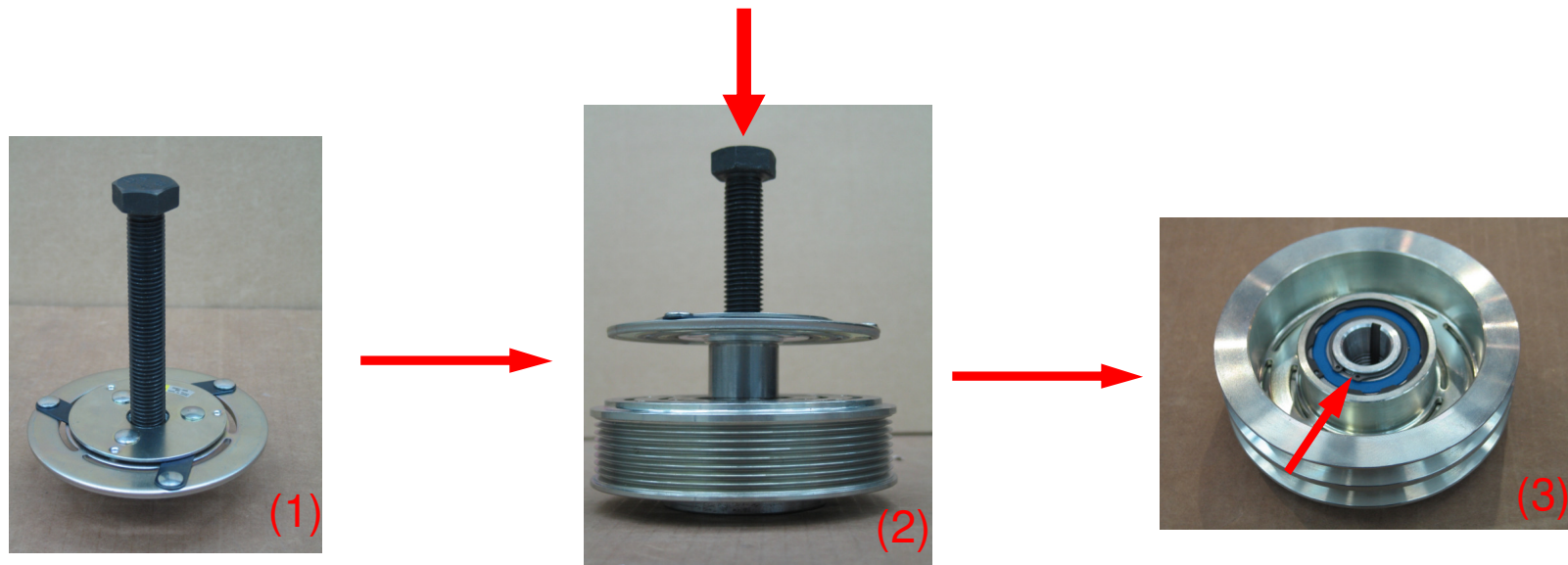
## SB12120016 - TK-315 clutch replacement

- Place the original armature aligned with the new compressor clutch – do not press:



## SB12120016 - TK-315 clutch replacement

- Fit a M20 bolt into the hub of the armature (1), press the armature into the clutch pulley (2) and secure the assembly with the safety ring (3):





# SB12120016 - TK-315 clutch replacement

- Do not apply forces to the pulley that may either spread the forces:

- across the armature



- across the pulley



- or across the ball bearing:



## SB12120016 - TK-315 clutch replacement

- Place the entire assembly into the compressor shaft ensuring the proper alignment with the shaft key
- Mount the shaft mounting bolt (M8x30) and washer to 15 Nm in order to secure the pulley into the shaft

