



Spare Parts Catalogue

AD – Series Axial Retarder

Insulated Earth Return

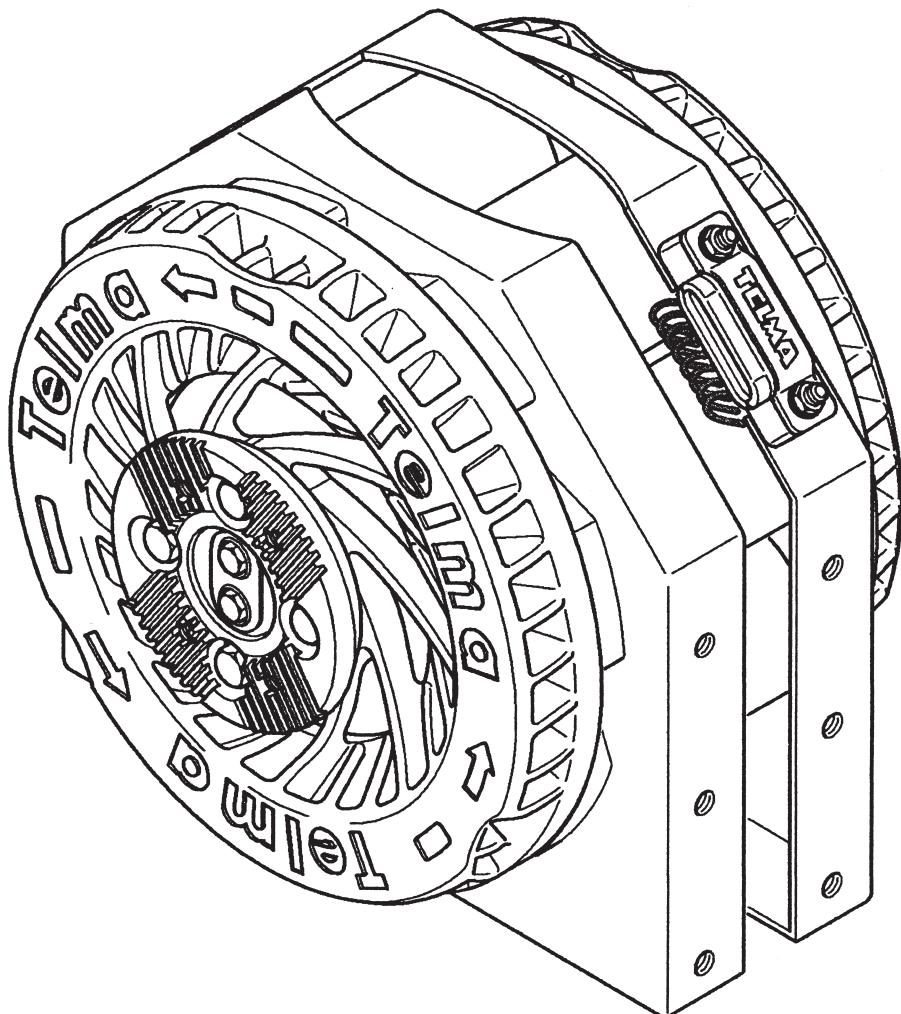


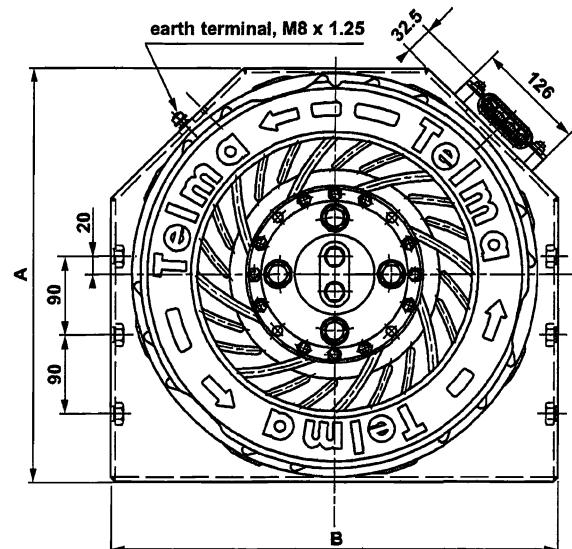
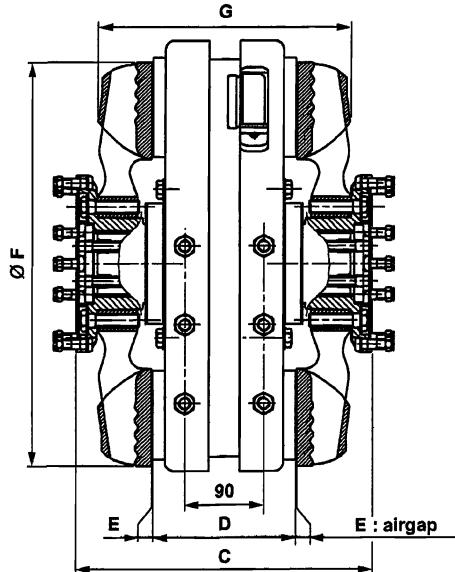
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Technical specifications of the AD series retarders

RETARDER MODEL		AD50-55	AD50-90	AD61-30	AD61-55	AD72-00	AD72-45
RETARDER CODE		BF20/BF30	BB20/BB30	BC20/BC30	BD20/BD30	BE20/BE30	BH20/BH30
MAXIMUM BRAKING TORQUE	Nm lb·ft	540 398	900 664	1300 958	1600 1180	2000 1475	2450 1807
Total mass	Kg lb	124 273	125 276	197 434	197 395	230 507	251 553
Stator mass	Kg lb	85 187	86 190	142 313	142 313	152 335	171 377
Rotors mass (with flanges)	Kg lb	39 86	39 86	55 121	55 121	78 172	80 176
AIR-GAP 0° -0.15mm/-0.006inch	mm inch	1	1	1.4	1.4	1.4	1.4
RESISTANCE PER STAGE ± 5% at 20°C (68 °F)	12 Volts 24 Volts	Ω	0.68 2.7	0.25 1	0.36 1.45	0.22 0.89	0.2 0.8
RESISTANCE PER COIL ± 5% at 20°C (68 °F)		Ω	1.35	0.5	0.73	0.45	0.4
AMPERAGE PER STAGE ± 5% at 20°C (68 °F)	12 Volts 24 Volts	A	18 9	48 24	33 16.5	54 27	60.5 30.2
INSULATION RESISTANCE (Retarder dry)	M Ω	≥1	≥1	≥1	≥1	≥1	≥1

Identification of the retarders by their dimensions



RETARDER

Item

AD50-55	AD50-90	AD61-30	AD61-55	AD72-00	AD72-45
BF20. ...	BB20. ...	BC20. ...	BD20. ...	BE20. ...	BH20. ...
BF30. ...	BB30. ...	BC30. ...	BD30. ...	BE30. ...	BH30. ...

A (mm [in])	363 [14.29]	363 [14.29]	455 [17.91]	455 [17.91]	475 [18.70]	495 [19..49]
B	400 [15.75]	400 [15.75]	496 [19.53]	496 [19.53]	519 [20.43]	519 [20.43]
C	253 [9.96]	253 [9.96]	337 [13.27]	337 [13.27]	337 [13.27]	342 [13.47]
D	163 [6.42]	163 [6.42]	163 [6.42]	163 [6.42]	163 [6.42]	168 [6.61]
E (-0.15 [-0.006])	1 [0.039]	1 [0.039]	1.4 [0.055]	1.4 [0.055]	1.4 [0.055]	1.2 [0.047]
ØF	352 [13.86]	352 [13.86]	425 [16.73]	425 [16.73]	464 [18.27]	489 [19.25]
G	261 [10.28]	261 [10.28]	290 [11.42]	290 [11.42]	287 [11.30]	292 [11.50]

Indexes, designation and dimensions for identification of the coupling flanges

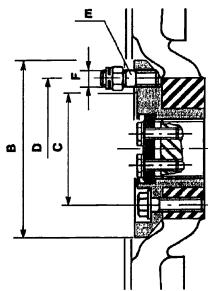


Figure I

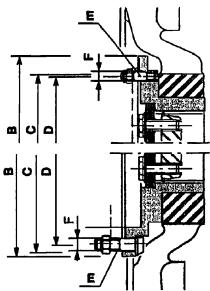


Figure II

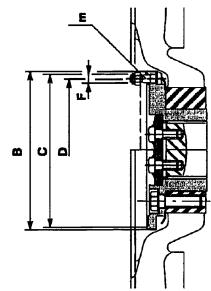


Figure III

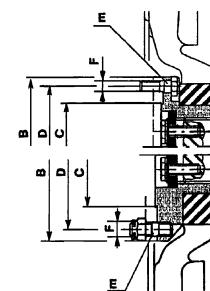


Figure IV

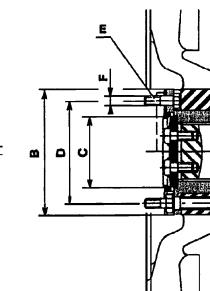


Figure V

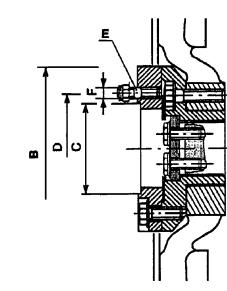


Figure VI

Item	Description	Fig.	B	C	D	E	F
103	SAE 1300, metric fasteners	I	151	60.32	79.37	4	10
104	SAE 1400, metric fasteners	I	151	69.85	95.25	4	12
105	SAE 1500, metric fasteners	I	151	95.25	120.67	4	14
106	SAE 1600, metric fasteners	II	174.6/203.2	168.22	155.52	8	10
107	SAE 1700, metric fasteners	III	203.2	196.85	184.12	8	10
108	SAE 1800, metric fasteners	III	203.2	196.85	184.12	12	11
110*	SAE 1800, metric fasteners	III	203.2	196.85	184.12	12	11
117	DIN Ø 150	IV/V	150	90	130	8	12
120	DIN Ø 180	IV	180	110	155.5	8	14
123	Mercedes-Benz Ø 120	VI	150	82.5	101.6	6	10
124	Mercedes-Benz Ø 130	I	130	82.56	112	8	10
134	DIN Ø 120	IV	130	75	101.5	8	10
139	DIN Ø 180	IV	180	110	155.5	8	16
140	DIN Ø 180	IV	180	110	155.5	10	16
141	DIN Ø 165	IV	165	95	140	8	16
145	SAE 1700 R reinforced	III	203.2	196.85	184.12	12	10
152	SAE 1710	III	203.2	196.85	184.12	8	9.52
154	SAE 1350/1410	I	151	69.85	95.25	4	11.1
155	SAE 1480/1550	I	151	95.25	120.67	4	12.7
157	SAE 1760/1810	III	203.2	196.85	184.12	12	11.1
158	SAE 1550/1610	II	174.6/203.2	168.25	155.52	8	9.52

Dimensions (mm)

- B external diameter of the retarder coupling flange
- C centering diameter
- D drilling diameter (P.C.D.) or distance between fasteners
- E number of securing screws or holes
- F diameter of securing screws or studs

Indexes, designation and dimensions for identification of the coupling flanges

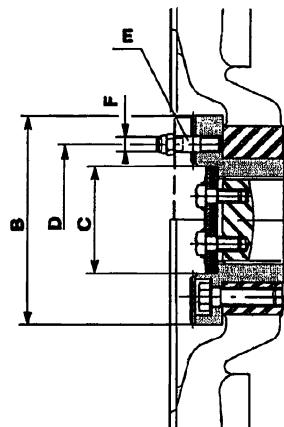


Figure VII

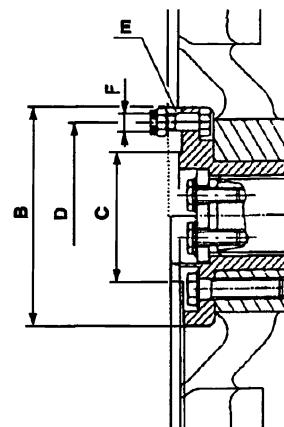


Figure VIII

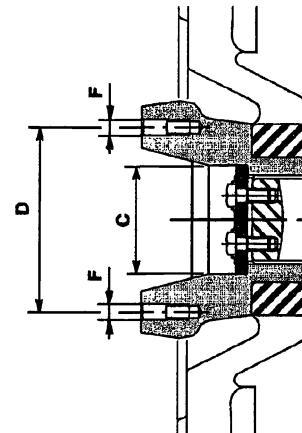


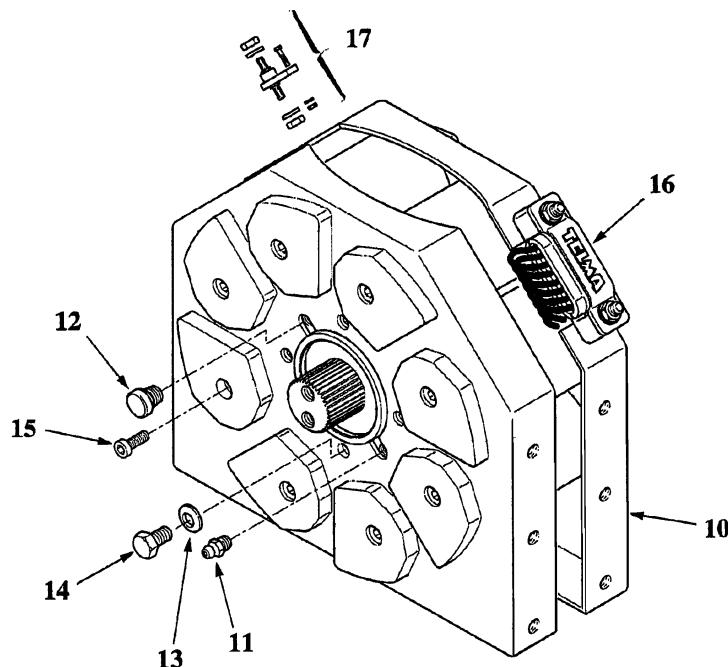
Figure IX

Item	Description	Fig.	B	C	D	E	F
128	Cross-serration Ø 120	VII	150 (AD50-55 to AD50-90) 165 (AD61-30 to AD61-55)		100	4	10
129	Cross-serration Ø 150	VII	150 (AD50-55 to AD50-90) 165 (AD61-30 to AD61-55) 180 (AD72-00)		130	4	12
135	Nissan diesel Ø 165	VIII	165	90	80x116	4	16
136	SCANIA P40/P400	IX			131.9x85	4	12
137	SCANIA P50/P500	IX			125.7x95	4	12
138	Cross-serration Ø 180	VII	180		150	4	14

Dimensions (mm)

- B external diameter of the retarder coupling flange
- C centering diameter
- D drilling diameter (P.C.D.) or distance between fasteners
- E number of securing screws or holes
- F diameter of securing screws or studs

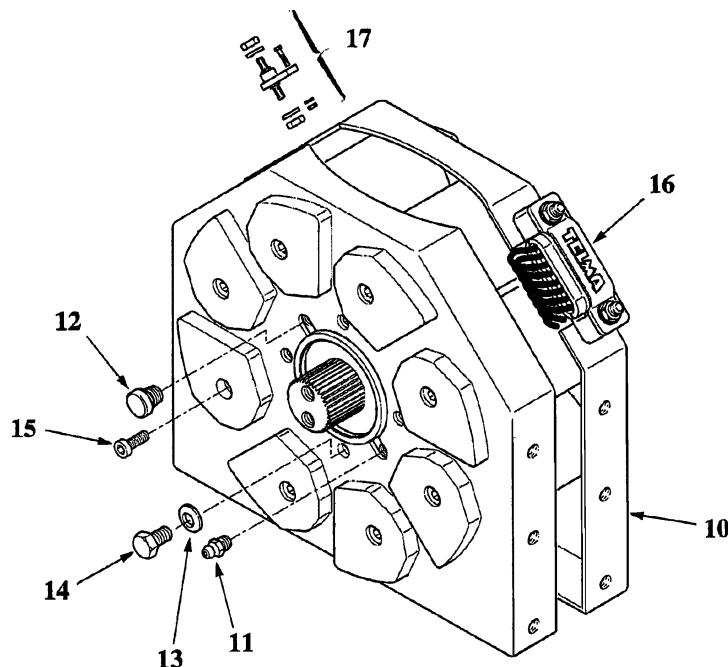
Stator assembly AD50-55 / AD50-90



Item	Description	Qty	RETARDER CODE	
			AD50-55 BF20... ...	AD50-90 BB20... ...
10	Stator assembly 12 Volts 24 Volts	1	VB107778 VB107779	VB107780 VB107781
11	Grease nipple	1	VF500100	VF500100
12	Air escape valve	1	VF500160	VF500160
13	Spring washer for flange securing screw	8	VF200600	VF200600
14	Hub securing screw	8	VF100750	VF100750
15	Pole securing screw	16	VF108280	VF108280
16	Junction block	1	VD408596	VD408596
17	Earth terminal	1	VD408597	VD408597

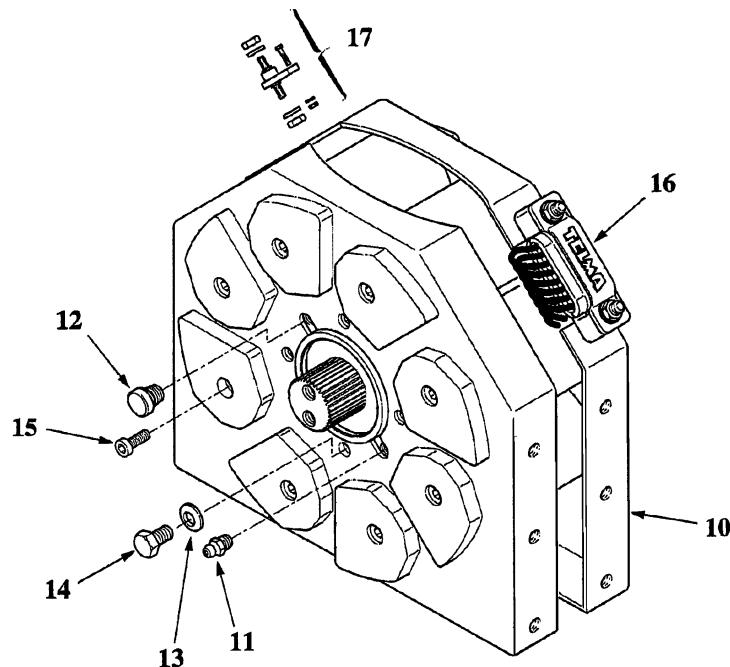
Stator assembly

AD61-30 / AD61-55



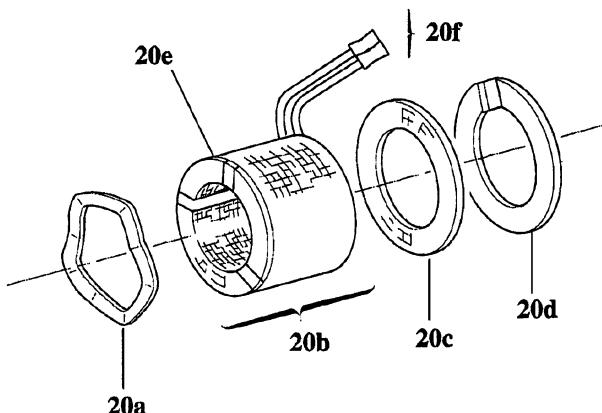
Item	Description	Qty	RETARDER CODE	
			AD61-30 BC20. ...	AD61-55 BD20. ...
10	Stator assembly 12 Volts 24 Volts	1	/	VB107784 VB107785
11	Grease nipple	1	VF500100	VF500100
12	Air escape valve	1	VF500160	VF500160
13	Spring washer for flange securing screw	8	VF200600	VF200600
14	Hub securing screw	8	VF100750	VF100750
15	Pole securing screw	16	VF108280	VF108280
16	Junction block	1	VD408596	VD408596
17	Earth terminal	1	VD408597	VD408597

Stator assembly AD72-00, AD72-45



Item	Description	Qty	RETARDER CODE	
			AD72-00 BC20... /	AD72-45 BH20... /
10	Stator assembly 12 Volts 24 Volts	1	VB107786 VB107787	VB107902 /
11	Grease nipple	1	VF500100	VF500100
12	Air escape valve	1	VF500160	VF500160
13	Spring washer for flange securing screw	8	VF200600	VF200600
14	Hub securing screw	8	VF100750	VF100750
15	Pole securing screw	16	VF108280	VF108280
16	Junction block	1	VD408596	VD408596
17	Earth terminal	1	VD408597	VD408597

Coil assembly

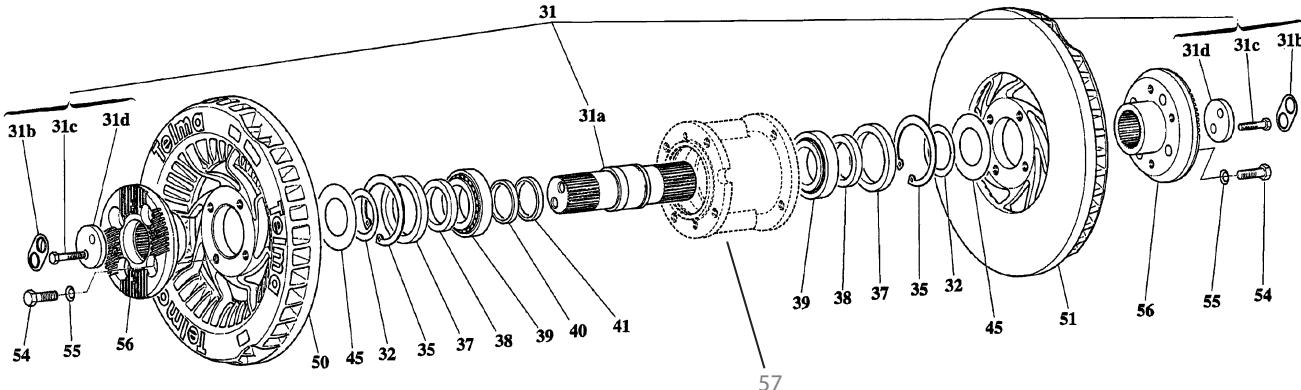


RETARDERS	REFERENCES					
	Coil assembly including items 20a to 20f	Pressure washer item 20a	Impregnated coil item 20b	Coil end insulator item 20c	Protective washer sleeve item 20d	Connections kit of coil item 20f
AD50-55	VD310635	VD503722	supplied under the assembly part number	VD503782	VD503699	VB202036*
AD50-90	VD310636	VD503722		VD503782	VD503699	VB202036 *
AD61-30	VD310637	VD503791		VD503783	VD503790	VB202036 *
AD61-55	VD310638	VD503791		VD503783	VD503790	VB202036 *
AD72-00	VD310639	VB514766		VD503784	VD503730	VB202036 *
AD72-45	VD1000244	VB515162		VD503912	VD503927	VB202036 *

* set of 8 pieces, to be cut to the dimensions of the coils.

Retarder shaft assembly

AD50-55 / AD50-90



Item	Description	Qty	RETARDER AD50-55 AD50-90
▲ 31	Shaft assembly: including	1	Supplied in Item 57
▲ 31a	shaft with counter sunk holes	1	Supplied in Item 57
●▲ 31b	tab washer	2	VB515160
●▲ 31c	shaft end screw	4	VF100380
▲ 31d	plate	2	VB515157
●▲ 32	Set of air-gap adjusting shims	1	VB100150
●▲ 35	Snap ring for bore	2	Supplied in Item 37
●▲ 37	Double lip seal Kit	2	VB107909
●▲ 38	Spacer ring	2	Supplied in Item 37
▲ 39	Tapered roller bearing	2	Supplied in Item 57
▲ 40 ▲ 41	Set of bearing adjusting shims Spacer ring	1	Supplied in Item 57
▲ 45	Dust cover	2	VB515503
50	Clockwise rotor	1	VB107958
51	Anti-clockwise rotor	1	
54	Coupling flange securing screw to rotor	8	VF100700
55	Spring washer for flange securing screw	8	VF200600
56	Coupling flange	2	see pages 13 to 18
▲ 57	Hub Assembly	1	VB107980

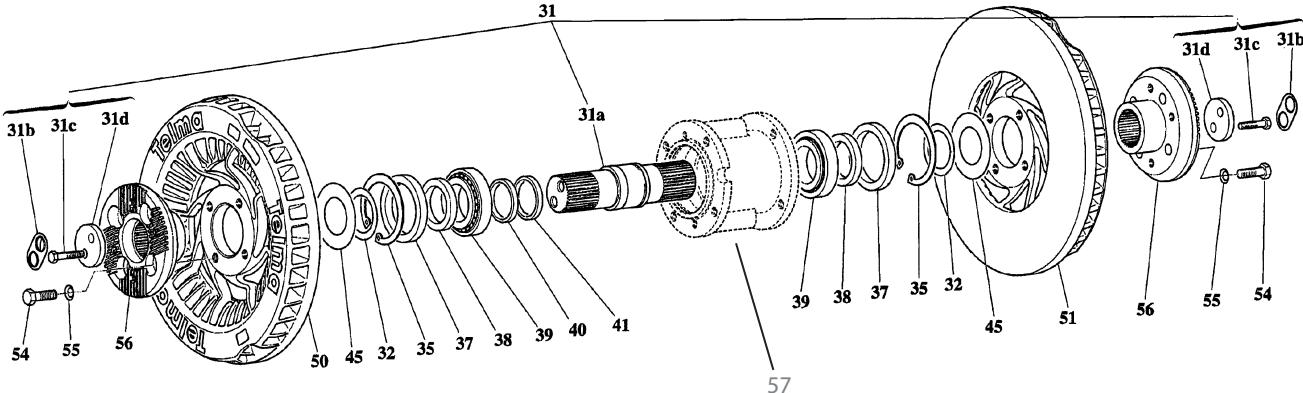
▲ = Included or pre-installed in Item 57 Hub Assembly

● = Included in Item 37 Double lip seal kit

(Item 37 and 57 supplied 1 per retarder)

Retarder shaft assembly

AD61-30 / AD61-55



Item	Description	Qty	RETARDER AD61-30 AD61-55
▲ 31	Shaft assembly: including	1	Supplied in Item 57
▲ 31a	shaft with counter sunk holes	1	Supplied in Item 57
●▲ 31b	tab washer	2	VB515160
●▲ 31c	shaft end screw	4	VF100380
▲ 31d	plate	2	VB515158
●▲ 32	Set of air-gap adjusting shims	1	VB100160
●▲ 35	Snap ring for bore	2	Supplied in Item 37
●▲ 37	Double lip seal Kit	2	VB107907
●▲ 38	Spacer ring	2	Supplied in Item 37
▲ 39	Tapered roller bearing	2	Supplied in Item 57
▲ 40	Set of bearing adjusting shims	1	Supplied in Item 57
▲ 41	Spacer ring	1	Supplied in Item 57
▲ 45	Dust cover	2	VB514990
50	Clockwise rotor	1	VB107953
51	Anti-clockwise rotor	1	
54	Coupling flange securing screw to rotor	8	VF100800
54	Coupling flange securing screw to rotor only for Indexes 134 and 136	8	VF108330
55	Spring washer for flange securing screw	8	VF200820
55	Spring washer for flange securing screw only for Indexes 134	8	VF200810
56	Coupling flange	2	see pages 13 to 18
▲ 57	Hub Assembly	1	VB107979

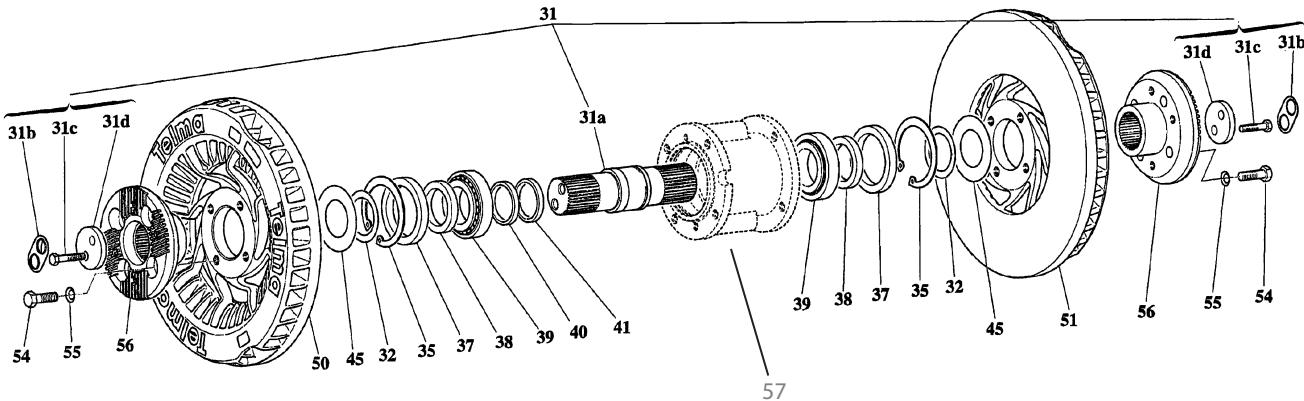
▲ = Included or pre-installed in Item 57 Hub Assembly

● = Included in Item 37 Double lip seal kit

(Item 37 and 57 supplied 1 per retarder)

Retarder shaft assembly

AD72-00 / AD72-45



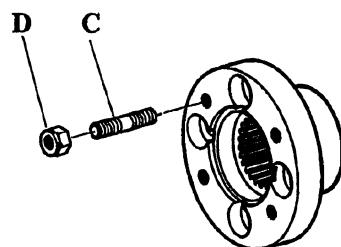
Item	Description	Qty	RETARDER	
			AD72-00	AD72-45
▲ 31	Shaft assembly: including	1	Supplied in Item 57	Supplied in Item 57
▲ 31a	shaft with counter sunk holes	1		Supplied in Item 57
●▲ 31b	tab washer	2	VB515119	VB515119
●▲ 31c	shaft end screw	4	VF100500	VF100500
▲ 31d	plate	2	VB515159	VB515159
●▲ 32	Set of air-gap adjusting shims	1	VB100170	VB100170
●▲ 35	Snap ring for bore	2		Supplied in Item 37
●▲ 37	Double lip seal Kit To Serial # 394333 / From Serial # 394334	1	VB107942 / VB107906	VB107906
●▲ 38	Spacer ring	2		Supplied in Item 37
▲ 39	Tapered roller bearing	2	Supplied in Item 57	Supplied in Item 57
▲ 40 ▲ 41	Set of bearing adjusting shims Spacer ring	1	Supplied in Item 57	Supplied in Item 57
▲ 45	Dust cover	2	VB515542	VB515542
50 51	Clockwise rotor Anti-clockwise rotor	1	VB107954	VB107955
54	Coupling flange securing screw to rotor	8	VF101100	VF101100
54	Coupling flange securing screw to rotor only for Indexes 134 and 136	4	VF108260 VF108320	VF108260 VF108320
55	Spring washer for flange securing screw	8	VF200830	VF200830
56	Coupling flange	2	see pages 13 to 18	see pages 13 to 18
▲ 57	Hub Assembly	1	VB107978	VB107978

▲ = Included or pre-installed in Item 57 Hub Assembly

● = Included in Item 37 Double lip seal kit

(Item 37 and 57 supplied 1 per retarder)

SAE coupling flanges with metric fasteners



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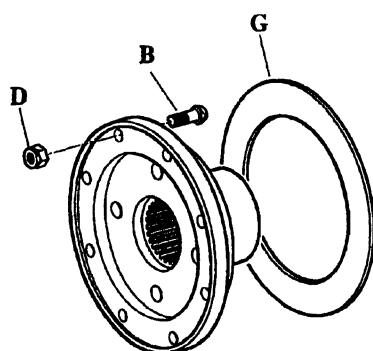
Figure I

INDEX	RETARDER	Fig.	REFERENCES			
			Fastener assembly	Screw (item B)	Stud (item C)	Nut (item D)
104	AD50-55 AD50-90	1	VB107709		VF131300 Qty: 4	VF120160 Qty: 4
105	AD50-90	1	VB107766		VF131420 Qty: 4	VF120170 Qty: 4
	AD61-30 AD61-55	1	VB100980		VF131420 Qty: 4	VF120170 Qty: 4

CAUTION: After degreasing the parts, the studs must be fitted to the coupling flange with LOCTITE 270.

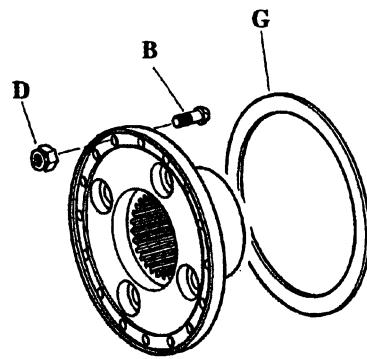
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SAE coupling flanges with metric fasteners



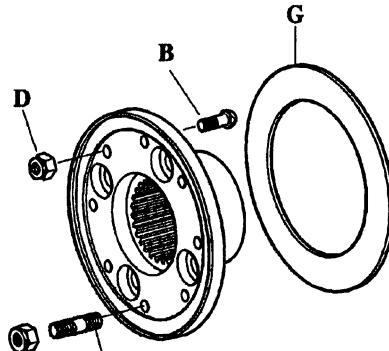
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Figure II



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Figure III



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Figure IV

INDEX	RETARDER	Fig.	REFERENCES			
			Fastener assembly	Screw (item B)	Stud (item C)	Nut (item D)
106	AD50-90	II	VB107767	VF101230 Qty: 8		VF120140 Qty: 8
	AD61-30 AD61-55	IV	VB107190	VF101230 Qty: 8		VF120140 Qty: 8
	AD72-00	IV	VB107173		VF131100 Qty: 8	VF120140 Qty: 8
107	AD61-55	III	VB107191	VF101230 Qty: 8		VF120140 Qty: 8
	AD72-00	III	VB107174	VF101230 Qty: 8		VF120140 Qty: 8
108	AD61-30 AD61-55	III	VB107192	VF119120 Qty: 12		VF120150 Qty: 12
	AD72-00	III	VB107176	VF119120 Qty: 12		VF120150 Qty: 12
110	AD72-00	III	VB107176	VF119120 Qty: 12		VF120150 Qty: 12
145	AD61-30 AD61-55	III	VB107193	VF119230 Qty: 12		VF120140 Qty: 12
	AD72-00	III	VB107175	VF119230 Qty: 12		VF120140 Qty: 12

to be ordered separately

Retaining plate (item G)

VB515031
Qty: 8

VB515031
Qty: 1

VB515031
Qty: 1

VB502830
Qty: 1

VB515031
Qty: 1

VB502830
Qty: 1

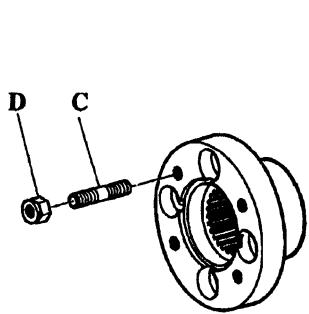
VB502830
Qty: 1

VB515031
Qty: 1

VB502830
Qty: 1

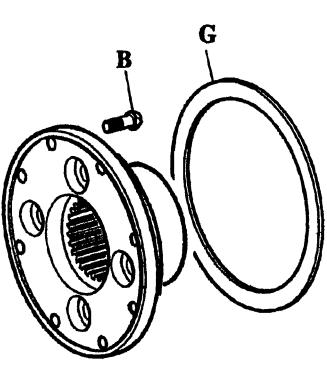
CAUTION: After degreasing the parts, the studs must be fitted to the coupling flange with LOCTITE 270.

SAE coupling flanges with anglo american fasteners

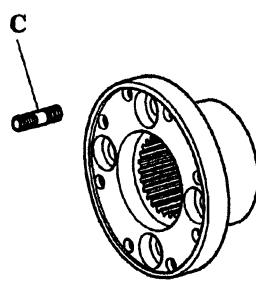


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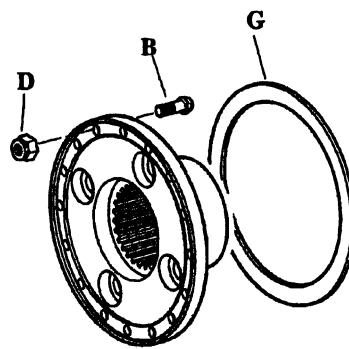
Figure V



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Figure VI



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Figure VII



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Figure VIII

INDEX	RETARDER	Fig.	REFERENCES				to be ordered seperately Retaining plate (item G)
			Fastener assembly*	Screw (item B)	Stud (item C)	Nut (item D)	
152	AD61-30 AD61-55	VIII	VB107194	VF119270 Qty: 8			VB515031 Qty: 1
	AD72-00	VIII	VB107180	VF119270 Qty: 8			VB502830 Qty: 1
154	AD50-55 AD50-90	V	VB107768		VF130120 Qty: 4	VF120370 Qty: 4	
155	AD50-55 AD50-90	V	VB107769		VF130130 Qty: 4	VF120340 Qty: 4	
	AD61-30 AD61-55	V	VB107267		VF130130 Qty: 4	VF120340 Qty: 4	
157	AD61-55	VIII	VB107398	VF104180 Qty: 12		VF120370 Qty: 12	VB515031 Qty: 1
	AD72-00	VIII	VB107182	VF104180 Qty: 12		VF120370 Qty: 12	VB502830 Qty: 1
158	AD50-90	VI	VB107770	VF119270 Qty: 8			VB515031 Qty: 1
	AD61-30 AD61-55	VI	VB107195	VF119270 Qty: 8			
	AD72-00	VII	VB107179		VF130110 Qty: 8		

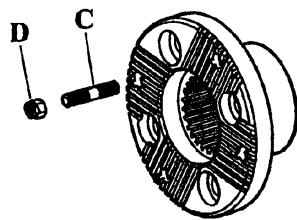
*Fastener Assembly includes the flange and items B, C and D.

NOTE: The "INDEX" refers to last 3 digits of the retarder part number.

CAUTION: After degreasing the parts, the studs must be fitted to the coupling flange with LOCTITE 270.

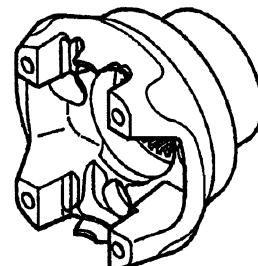
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70° cross-serrated coupling flanges and SCANIA yokes



INDEXES { 128
129
138

Figure IX



INDEXES { 136
137

Figure X

INDEX	RETARDER	Fig.	REFERENCES			
			Fastener assembly*	Screw (item B)	Stud (item C)	Nut (item D)
128	AD50-55 AD50-90	IX	VB107751	/	VF131110 Qty: 4	VF120140 Qty: 4
	AD61-30 AD61-55	IX	VB107206	/	VF131110 Qty: 4	VF120140 Qty: 4
129	AD50-90	IX	VB107771	/	VF131360 Qty: 4	VF120380 Qty: 4
	AD61-30 AD61-55	IX	VB107196	/	VF131360 Qty: 4	VF120380 Qty: 4
	AD72-00	IX	VB107183	/	VF131360 Qty: 4	VF120380 Qty: 4
136	AD61-55	X	VB107630	/	/	/
	AD72-00	X	VB107001	/	/	/
137	AD72-00	X	VB107002	/	/	/
138	AD61-30 AD61-55	IX	VB1074521	/	VF131500 Qty: 4	VF120390 Qty: 4
	AD72-00	IX	VB107185	/	VF131500 Qty: 4	VF120390 Qty: 4

*Fastener Assembly includes the flange and items B, C and D.

NOTE: The "INDEX" refers to last 3 digits of the retarder part number.

INDEX 128, 129, 136, 137, and 138 are not commonly sold in the USA.

CAUTION: After degreasing the parts, the studs must be fitted to the coupling flange with LOCTITE 270.

DIN flat coupling flanges

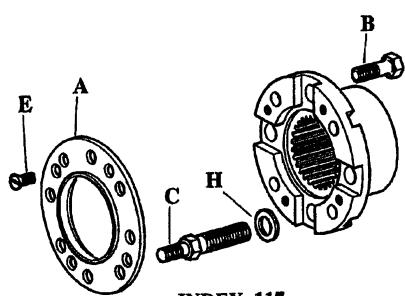
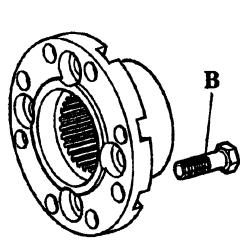
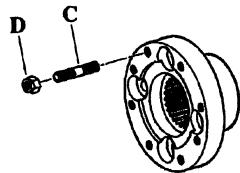


Figure XI



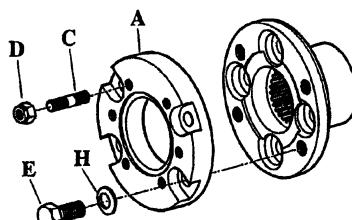
INDEXES {117 120}

Figure XII



INDEXES {117 124}

Figure XIII



INDEX 123

Figure XIV

INDEX	RETARDER	Fig.	REFERENCES						
			Fastener assembly	Adaptor (item A)	Screw (item B)	Stud (item C)	Nut (item D)	Screw (item E)	Washer (item H)
117	AD50-55 AD50-90	XIII	VB107772	/	/	VF131260 Qty: 8	VF131260 Qty: 8	/	/
	AD61-30 AD61-55	XII	VB101100	/	VF100510 Qty: 8	/	/	/	/
	AD72-00	XI	VB100840	VF502910 Qty: 1	VF100510 Qty: 8	VF130520 Qty: 4	/	VF109300 Qty: 4	VF200830 Qty: 4
120	AD61-55	XII	VB101120	/	VF100820 Qty: 8	/	/	/	/
	AD72-00	XII	VB107178	/	VF101430 Qty: 8	/	/	/	/
123	AD50-55 AD50-90	XIV	VB107773	VB503890 Qty: 1	/	VF131150 Qty: 6	VF120140 Qty: 6	VF100850 Qty: 4	VF200810 Qty: 4
124	AD50-55 AD50-90	XIII	VB107774	/	/	VF131180 Qty: 8	VF120140 Qty: 8	/	/
	AD61-30	XIII	VB107326	/	/	VF131180 Qty: 8	VF120140 Qty: 8	/	/

*Fastener Assembly includes the flange and items A through H.

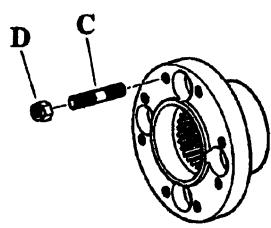
NOTE: The "INDEX" refers to last 3 digits of the retarder part number.

INDEX 117, 120, 123, and 124 are not commonly sold in the USA.

CAUTION: After degreasing the parts, the studs must be fitted to the coupling flange with LOCTITE 270.

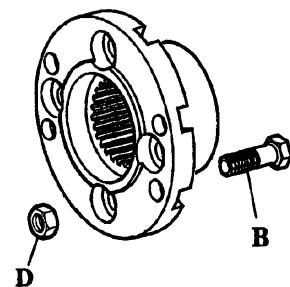
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DIN flat coupling flanges



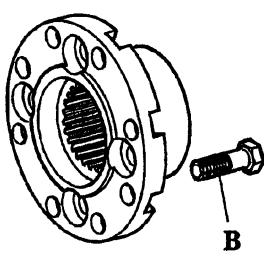
INDEX 134

Figure XV



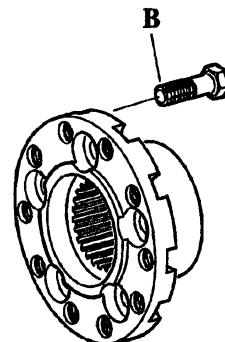
INDEX 135

Figure XVI



**INDEXES { 139
141**

Figure XVII



INDEX 140

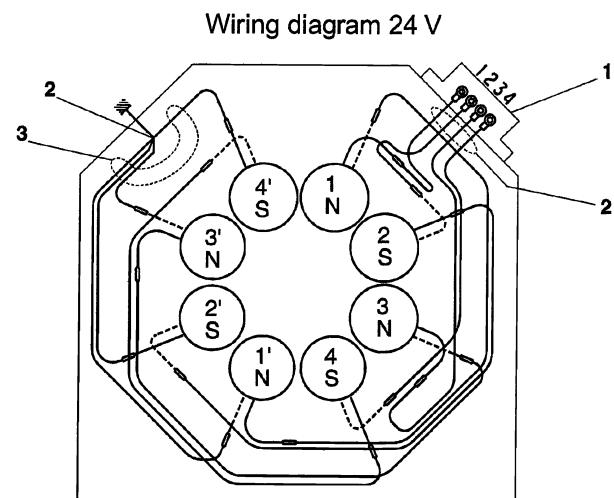
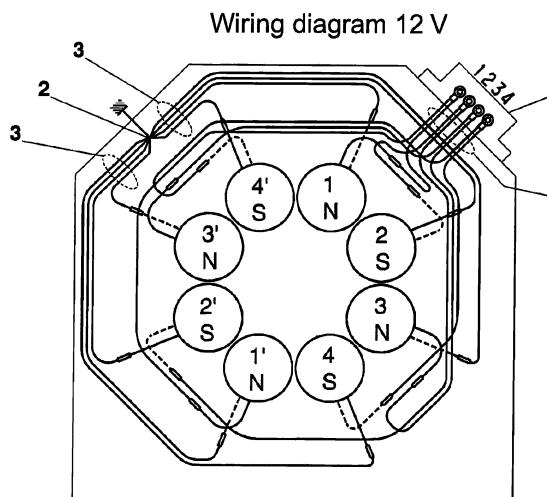
Figure XVIII

INDEX	RETARDER	Fig.	Fastener assembly	Screw (item B)	Stud (item C)	Nut (item D)
134	AD50-55 AD50-90	XV	VB107775	/	VF131180 Qty: 8	VF120140 Qty: 8
	AD61-30 AD61-55	XV	VB103230	/	VF131160 Qty: 8	VF120130 Qty: 8
140	AD72-00	XVIII	VB100900	VF101230 Qty: 10	/	/
141	AD72-00	XVII	VB101130	VF101120 Qty: 8	/	/
	AD72-00	XVII	VB100890	VF101120 Qty: 8	/	/

NOTE: The "INDEX" refers to last 3 digits of the retarder part number.
 INDEX 134, 140 and 141 are not commonly sold in the USA.

CAUTION: After degreasing the parts, the studs must be fitted to the coupling flange with LOCTITE 270.

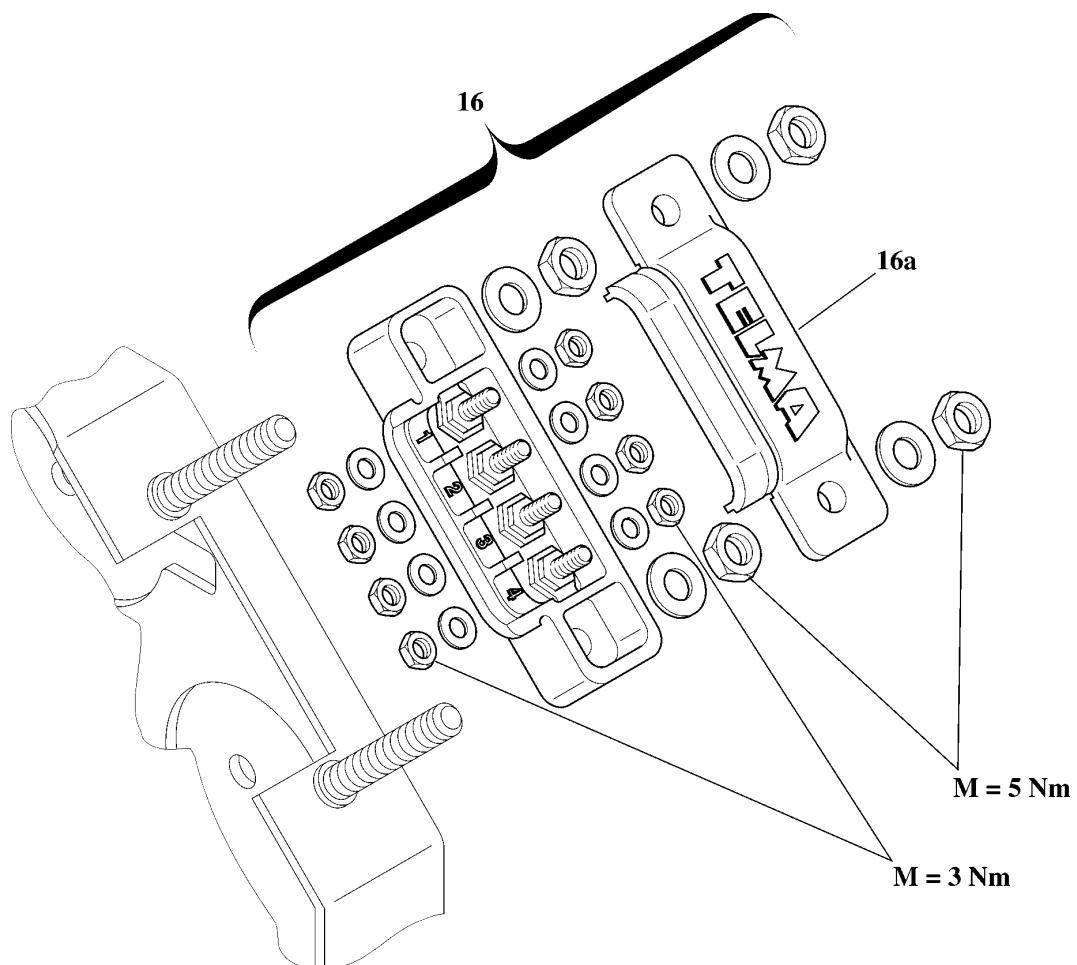
Internal wiring assembly

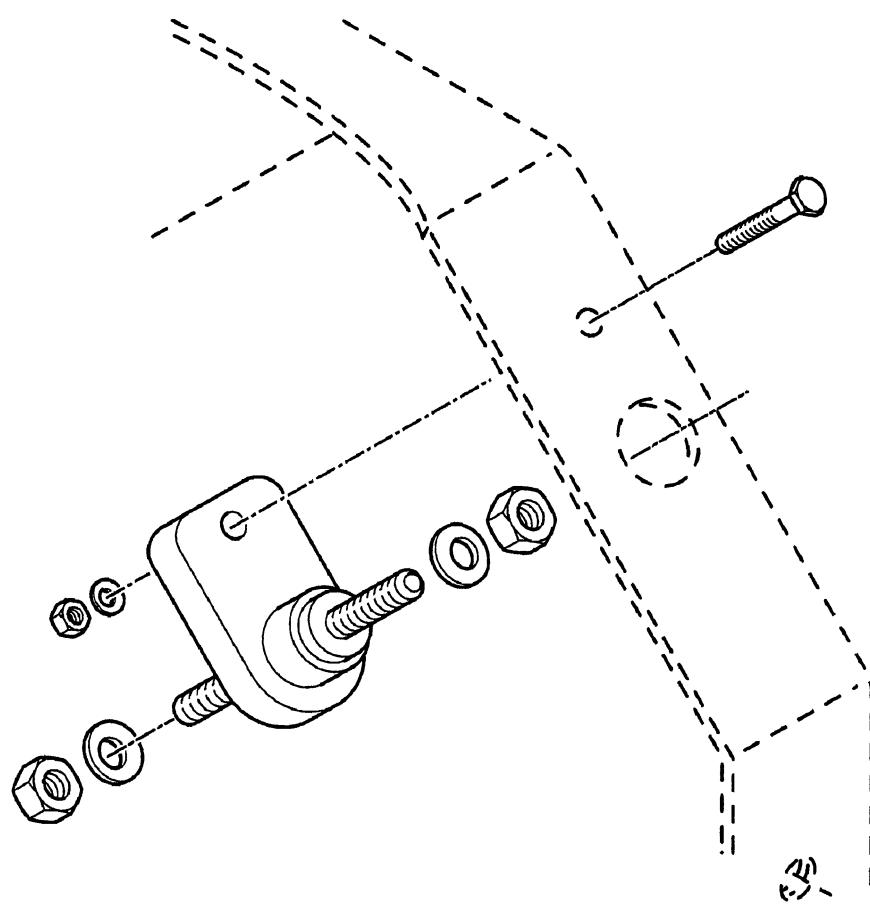


— red sleeve
- - - blue sleeve

Qty	Item	Description	RETARDER			
			AD50-55 AD50-90	AD61-30 AD61-55	AD72-00	AD72-45
1	1	Junction block assembly (see details on page 20)	VD408596	VD408596	VD408596	VD408596
1	2	Earth terminal assembly (see details on page 21)	VD408597	VD408597	VD408597	VD408697
1	3	12 Volts whole wiring assembly	VD408600	VD408602	VD408604	
1	4	24 Volts whole wiring assembly	VD408601	VD408603	VD408605	

Item	Description	Qty	Reference
16	Connecting block assembly with cover	1	VD 408 596
16a	Cover for connecting block	1	VD 503 622

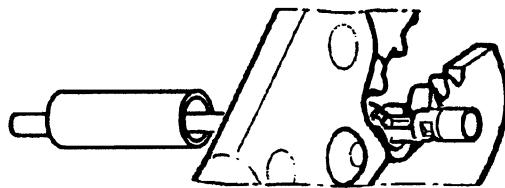
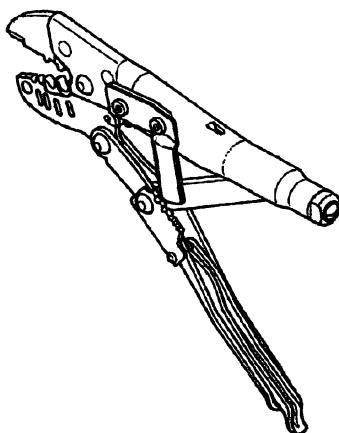




Crimping tool and wiring repair kit

In certain cases, it can be necessary to replace damaged crimp connectors.

Only genuine TELMA parts (see below repair kit VD 408 491) and a suitable crimping tool should be used.

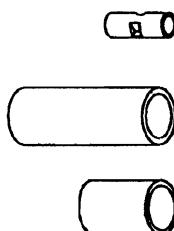


Crimp the terminal using the last notch of the crimping tool.

IMPORTANT:

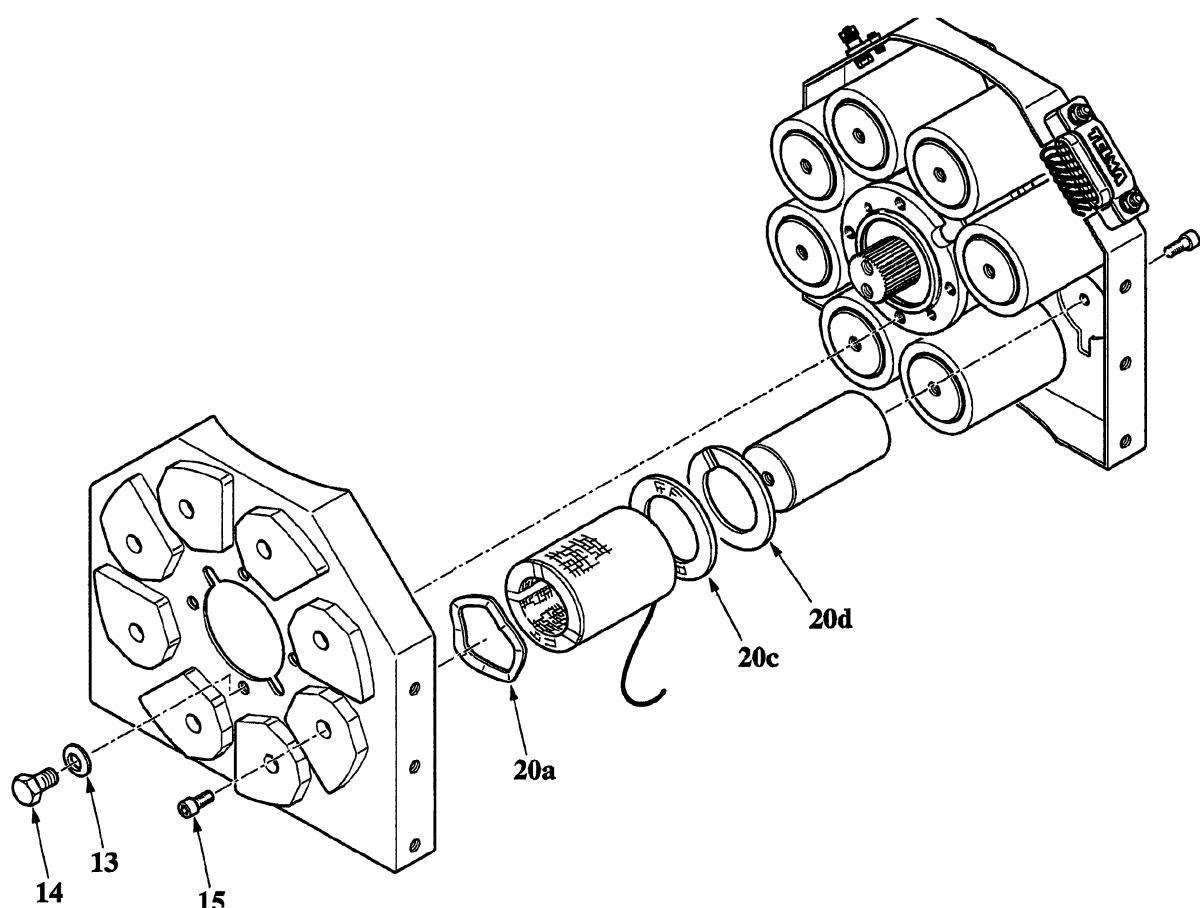
Remove the insulating varnish of the coil wire before crimping the crimp connector.

Set VD 408 491 of connecting parts including:



Description	Qty
crimp connector.....	16
Viton sleeve.....	16
red shrinking sleeve.....	8

Replacement of a coil



Replacement of a coil

1 – REMOVAL OF A DAMAGED COIL

- Remove the screws (item 15) which attach the rear pole shoe plate (without connecting block) (item 18) to the poles and the screws (item 14) with the washers (item 13) which attach the pole shoe plate to the hub. Remove the pole shoe plate.
- After having identified the coil to be replaced, remove both connecting wires from the stator and mark them with red and black sleeves prior to cutting the connecting wires near the crimp connectors.
- Remove the pressure washer from the pole, the defective coil, the insulating washer at the bottom of the coil and the stainless steel protective washer.

2 – CLEANING OF THE STATOR

- Remove all traces of varnish and oxidation if present that may be on the pole and the pole shoe plate

3 – FITTING OF THE NEW COIL

- Unpack the replacement coil assembly
- Place the new stainless steel protective washer (item 20d) on the stator with the notch inside the recess of the housing for the coil wire location.
- Place the new insulating washer (item 20c) on top of the protective washer.
- Put the new coil in place and position so that the wires fit into the notch of the protective washer.
- Check that there is no excessive play between the coil and the pole; otherwise the coil must be cemented using epoxy adhesive.
- Slide a heat shrink sleeve on both wires of the new coil.
- Remove 5mm (1/4 inch) of insulation from the ends of the connecting wires.
- Following the suitable internal wiring diagram and the marks made during the disassembly, install the proper connecting wires into the crimp connectors of the coil and crimp the connector.
- Slide the heat shrink sleeve over the connector and heat with hot air to shrink it.
- Put the internal wiring back in place and secure to the stator with the tabs attached to the stator.
- Put in place the new pressure washer (item 20a) on the coil.
- Place the pole shoe plate back on the coils and verify that all the pressure washers are in proper contact with the coils.
- Re-install the pole securing screws (item 15) as well as the hub securing screws (item 14) with the washers (item 13). Tighten the pole securing screws to 45 Nm (33 lb-ft) and the hub securing screws to 68 Nm (50lb-ft).
- After tightening, check that the coils do not turn; otherwise the pressure washers on the other side must also be replaced.
- Make the electrical checks of the stator.



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