

## ABSTRACT

This document will provide a procedure for the proper replacement of stators into motor 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, be sure to follow these instructions closely.

## PROCEDURE

- 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 (Figure 1).
- Prepare new stator for installation. Make sure exterior of stator is clean and free of contaminants. **DO NOT STAND STATOR ON THE COPPER WINDINGS**
- For installation, apply Loctite 609 retaining compound generously around the stator circumference and inside the motor housing in at least three places (top, middle and bottom) and for large stators (top, between top and middle, between middle and bottom and bottom) (Figure 2).



Figure 1

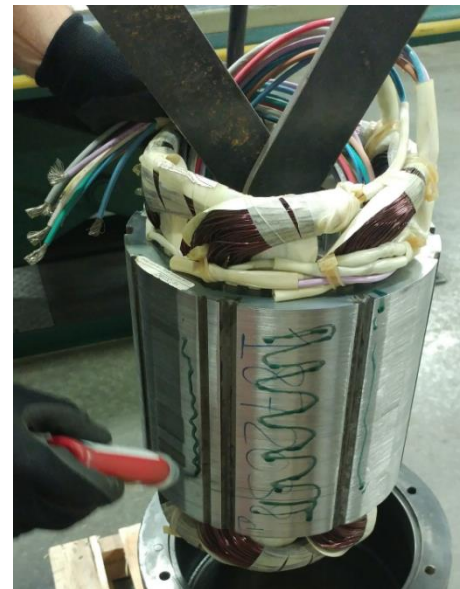


Figure 2

- Position new stator so wire bundles are in original location (marked in step #1). If you are unsure of the original location, on T motors, the wire bundle should be opposite of the cable entry (Figure 3). On P motors and larger, locate the gap in the shoulder at the bottom of the motor housing (Figure 4). Line up the slot in the stator iron with this gap (Figure 5). You will use this gap to pass the oil chamber seal probe wire through.
- Carefully lower stator into housing
- Be sure stator is fully seated on shoulder in housing, and allow locking compound to cure.

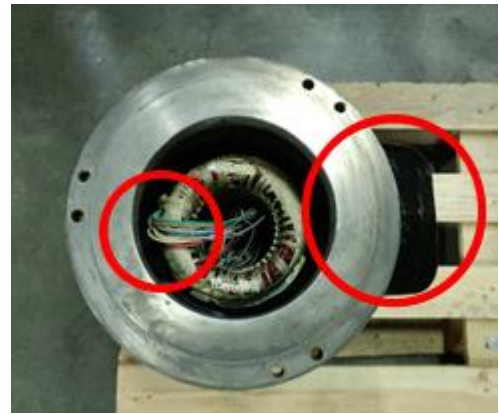


Figure 3

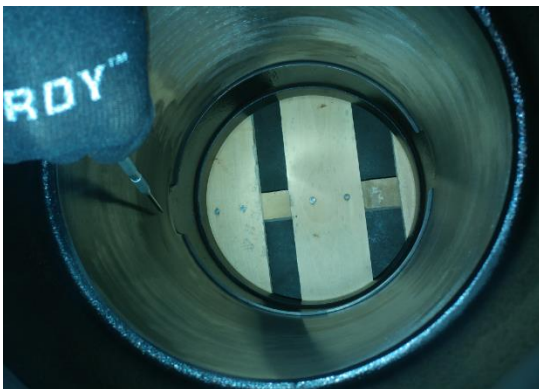


Figure 4

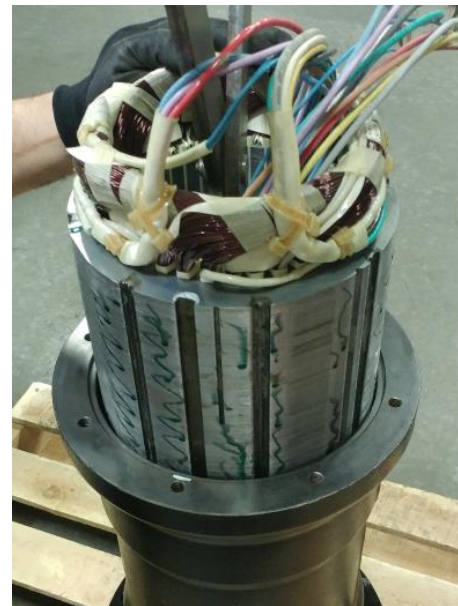


Figure 5

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