



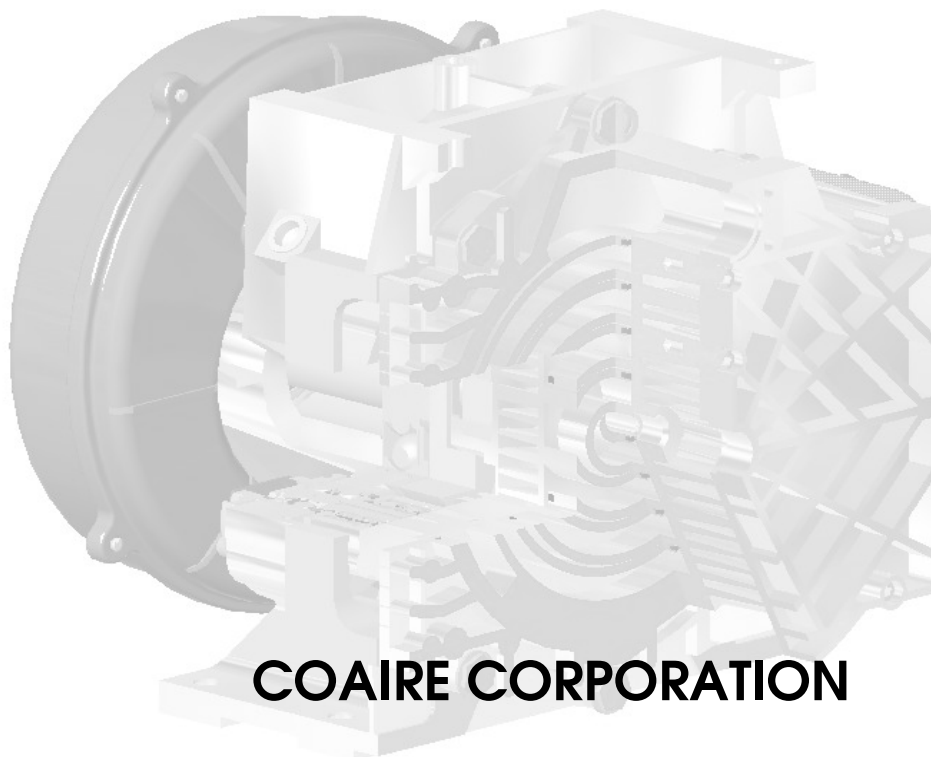
Authorized Distributor Only

OILFREE SCROLL AIREND MAINTENANCE MANUAL AND PARTS LIST

MODEL

BC-KL32L(H)

BC-KL52L(H)



COAIRE CORPORATION

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January, 2013

For proper and safe use of the compressor, please follow all instructions and safety precautions as identified in this manual, along with general safety regulations and practices.

Printed in U.S.A.

SAFETY AND PRECAUTIONS

Before you install the air compressor you should take the time to carefully read all the instructions contained in this manual. Electricity and compressed air have the potential to cause severe personal injury or property damage. Before installing, wiring, starting, operating or making any adjustments, identify the components of the air compressor using this manual as a guide. The operator should use common sense and good working practices while operating and maintaining this unit. Follow all procedures and piping accurately. Understand the starting and stopping sequences. Check the safety devices in accordance with the following procedures contained in this manual. Maintenance should be done by qualified personnel, accurately with proper tools. Follow the maintenance schedule as outlined in the manual to ensure problem free operation after start up.

**SAFETY PRECAUTIONS
BEFORE INSTALLING THE COMPRESSOR OR PERFORMING ANY MAINTENANCE READ THIS
MANUAL CAREFULLY.**

WARNINGS

COMPRESSED AIR AND ELECTRICITY ARE DANGEROUS. BEFORE DOING ANY WORK ON THIS UNIT, BE SURE THE ELECTRICAL SUPPLY HAS BEEN SHUT OFF(LOCKED AND TAGGED) AND THE ENTIRE COMPRESSOR SYSTEM HAS BEEN VENTED OF ALL PRESSURE.

1. Do not remove the cover, loosen or remove any fittings, connections or devices when this unit is operating or in operation. Hot liquid and air that are contained within this unit under pressure can cause severe injury or death.
2. The compressor has high and dangerous voltage in the motor, the starter and control box. All installations must be in accordance with recognized electrical procedure. Before working on the electrical system, ensure that the system's power has been shut off by use of a manual disconnect switch. A circuit breaker or fuse switch must be provided in the electrical supply line to be connected to the compressor. The preparation work for installation of this unit must be done on suitable ground, maintenance clearance and lightning arrestors for all electrical components.
3. Do not operate the compressor at a higher discharge pressure than those specified on the compressor nameplate. If so an overload will occur. This condition will result in electric motor shutdown.
4. Use only safety solvent for cleaning the compressor and auxiliary equipment.
5. Install a manual shut off valve(isolation type) in the discharge line for service work.
6. Whenever pressure is released through the safety valve during operation, it is due to excessive pressure in the system. The cause of excessive pressure should be checked and immediately corrected.
7. Before doing any mechanical work on the compressor,
 - a) Shut down the unit.
 - b) Electrically isolate the compressor by use of the manual disconnect switch in the power line to the unit. Lock and tag the switch so that it cannot be operated.
8. Before starting the compressor, the maintenance instructions should be thoroughly read and understood.
9. After maintenance work is completed, covers must be securely closed.
10. For questions contact your distributor before proceeding.

STATEMENT OF WARRANTY TERMS & CONDITIONS

General Provisions:

- a) Coaire warrants our air compressors and scroll systems (henceforth called “products”) to be free from material defects and workmanship under proper use, operating conditions, installation, and application based on the terms and conditions set forth below. Coaire offers no other warranty, whether expressed or implied, including any warranty of merchantability or fitness for a particular purpose.
- b) Any air compressor, part or material found to be defective will be repaired, replaced or refunded at the sellers option free of charge, provided that Coaire is notified with the stated warranty period.
- c) All claims shall be made in writing using our **warranty claim report** located within each service manual.
- d) All claims must have the **start-up report sheet** included. The start-up report sheet is located within each service manual.
- e) All returns of allegedly defective equipment must have prior written authorization. Said authorization shall be obtained through our service department. Any compressors, parts, or materials must be returned freight prepaid to the manufacturers factory within (30) days of the return authorization date. Any shipment returned to the factory collect will be refused.
- f) If an item is found to be warrantable, the repaired or replacement item will be returned normal ground freight, prepaid. Expedited return freight costs are the responsibility of the requestor.
- g) Any replacement part or material is warranted to the extent of the remaining warranty period

Standard Period of Warranty:

- h) Coaire warrants our system(s) for a period of (15) months from shipment, (12) months from the documented start-up, or 5,000 hours of use, whichever occurs first. During such period, Coaire will be liable for all product or material defects and will assume the costs of repair or replacement so long as the product(s) are located within the continental United States or Canada. In addition, the product(s) must be easily accessible by service personnel for removal.
- i) In addition to item “g” above, Coaire warrants the air compressor air end (compressor only), parts only (no labor) for a period of (27) months from shipment, (24) months from the documented start-up, or 7,500 hours of use, whichever occurs first.
- j) Coaire product(s) located outside of the continental United States or Canada shall include a parts only warranty for a period of (15) months from shipment, (12) months from the documented start-up, or 5,000 hours of use, whichever occurs first.

Exclusions – Coaire shall have no warranty obligation for:

- k) Products not installed in accordance with our written instructions and specifications
- l) Operated in an unsuitable environment, in excess of stated product parameters, modified in any way, or used in an improper manner
- m) That have not been properly maintained per Coaire’s written instructions
- n) Use of corrosive materials or insoluble lubricants
- o) Normal wear and tear items are not included under this warranty
- p) Any OEM (original equipment manufacturer) component that may be used within our products will carry the original manufacturer’s warranty
- q) Product is properly stored prior to installation
- r) Product not installed by a competent, qualified installer
- s) Product which may have been damaged during shipment

Liability Limitation:

- t) Coaire shall not be liable for any damages (incidental, consequential, punitive, et al.) that may arise from the use of our product. Coaire’s liability in all events, is limited to and shall not exceed, the original purchase price.

Suitability of the Product:

- u) Jurisdictions has various codes, Coaire makes no claim as to the suitability for all jurisdictions. It is the buyer’s responsibility to ensure the product, installation, and use comply with local jurisdictions.

Identification plate:

- v) Coaire products have identification plates on the air compressors as well as on the enclosures. These data plates show the primary information for the product. This data should always be referred to when calling the manufacturer or distributor. The removal or alteration of the identification plate(s) shall immediately void all warranty.

Who to contact for warranty claims:

Web: www.coaire.com
Phone: (562) 496-3935
Fax: (562) 463-4928

All freight damage claims should be filed within 15 working days and should be directed to the carrier.

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1. AIREND MAINTENANCE TABLE

Item	Action needed	Run Time(Hours)				Remarks
		500	2,500 Or 6 month	5,000 Or 1 year	10,000 Or 2 years	
Bearing Grease	Re-grease			●*	●	
Tip Seal Kit	Replace			●*	●	
Sirocco Fan	Clean		○	○	○	
Air-end Fin	Clean		○			Every 2500hrs or less
Fan Duct, Cover	Clean			○	○	
Sirocco Fan	Clean			○	○	
Intake Filter	Clean, Replace	○	●			Every 2500hrs or less

Note

- 1) ○ : clean, ● : replace or regrease
- 2) (*) : every 5,000 hours for high pressure pump(140psi)

CAUTION

① Routine maintenance and disassembly maintenance, must be applied when the hourly or time schedule comes due, whichever comes first.

② Regular maintenance, disassembly maintenance standard: is applied when the standard use condition and installation environment are satisfactory and when the surrounding environment or operation condition is severe, the period or time for regular maintenance and disassembly maintenance must be shortened.

③ The regular maintenance and disassembly maintenance are not part of the warranty.

④ Cleaning: When the surrounding environment or operation condition are service (high heat or dirty environment), the cleaning time or periodic maintenance intervals must be shortened. (BC-KL32,52L/H) per 2,500 hours)

2. REGULAR MAINTENANCE

2.1 Preparation

1) Tools

- ① screw driver (+ cross-tip)



- ② 17mm hand socket, extension, ratchet handle



- ③ Holding Spanner
- ④ Low pressure compressed air
- ⑤ Torque wrench, in-lbs

2.2 Disassembly order and method

1) Fan duct

- ① Loosen the 3 upset type M6 bolts and separate the fan duct.



2) Fan cover (external)

- ① Loosen the 5 tapping screw M6 bolts and separate the fan cover.



3) Airend pulley

① Take off the hexagon socket head cap screws with a spanner in the balance weight of pulley rotation direction and remove the pulley/fan assembly.



4) Fan cover (internal)

① Separate the fan cover by loosening the 3 screws.



5) Fixed scroll set

① Separate the fixed scroll by removing six(6) self locking nuts.



2.3 Cleaning

1) Orbiting scroll cooling fin

① Remove dust and dirt attached to the cooling fin using compressed air gun.



② Do not clean the orbiting scroll set with organic solvent (thinner, solvent)

2) Fixed scroll cooling fin

- ① Remove dust and dirt attached to the cooling fin using compressed air gun.



- ② Do not clean the orbiting scroll set with organic solvent (thinner, solvent).

NOTE

Damage may occur to special protective coating.

3) Fan cover & duct

- ① Remove dust and dirt attached to the fan cover and duct using air gun.



4) Sirocco fan

- ① Remove dust and dirt attached to the sirocco fan using air gun.



2.4 Maintenance

NOTE

Conduct maintenance in a clean location to prevent pollution and damage to the scroll maintenance parts. Use only recommended high temperature grease. (Consult your distributor)

1) Injecting grease into orbiting scroll center bearing

- ① Remove the dust cap on the top rib or left of housing.



- ② The crank shaft key must be in 7 o'clock direction when seen from the front.



- ③ Insert the nozzle connected to the grease gun into the housing dust cap hole and connect to the grease nipple attached to the crank.



NOTE

Move the crank shaft from left to right and check the connection of the grease nozzle and nipple. Bearing should rotate smoothly and quietly.

- ④ Press the grease gun button and inject grease.



NOTE

Keep the nipple securely on the grease gun nozzle so that grease does not leak between the grease gun nozzle and nipple. Rotate the crank so the grease is applied evenly within the bearing, do not over grease.

- ⑤ After injecting the grease fit the housing with the dust cap.



2) Injecting grease into pin crank bearing

- ① Use a flat screw driver to remove the 3 bearing grease caps behind the housing.



- ② Apply grease onto the pin crank orbiting scroll shaft bearing. Use a needle grease nozzle, apply grease evenly within the bearings, do not over grease.



③ Stick the grease gun nozzle closely into the pin crank bolt nipple and press the grease gun button about 3 to 4 times to supply grease to the housing bearing.



CAUTION

Watch closely so that grease does not leak between the grease gun and pin crank nipple when injecting the grease.

④ Re-assemble the 3 bearing grease caps into its original position, do not force them, hand pressure is adequate.



3) Tip seal set exchange

① Separate the high pressure and low pressure tip seal from the top seal by using pick in the fixed scroll set.



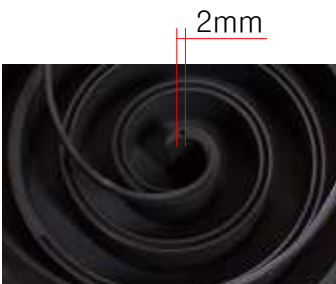
② Using the same method, separate the dust seal and back up tube.



③ Using the same method, separate tip seal from the orbiting scroll set.



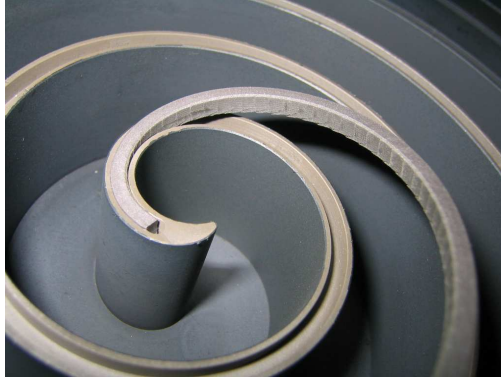
④ Lift about 2mm from the high pressure central tip seal and insert into the high pressure tip seal vertical hem and fix with finger tips.



CAUTION

Shaped slit on the side and the bottom of the tip seal, wrap facing the center of the insertion.

⑤ Direction of Slit Side



CAUTION

Insert tip seal so that lip side (slit side) of tip seal contacts the bottom of seal groove and faces inside of scroll wrap.

If you miss, the performance of the compressor may be impaired and wrap is injured by high temperature.



Remove HP tip seal and LP tip seal from FS set and OS set by using tip of sharp tool.

HP tip seal : Length is short.

LP tip seal : Length is long.

⑥ Insert high pressure tip seal using the same method.

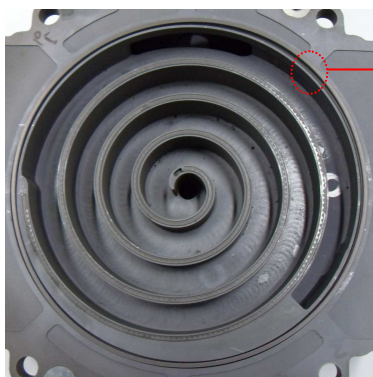
⑦ Insert low pressure tip seal into the end of the high pressure tip seal and press down with finger tip and insert and cut according to tip seal groove with a knife.



⑧ Insert low pressure tip seal using the same method.

⑨ When fixing a backup tube to the fixed scroll set, the joint must face 6 o'clock direction.

⑩ Fit the dust seal on top of the back-up tube.



Dust seal

CAUTION

The top and bottom are not distinguishable when assembling dust seal.

2.5 Assembling

1) Fixed scroll set

- ① Assemble the fixed scroll set according to the housing parallel pin location.



- ② Temporarily assemble 6 self-locking nuts then tighten with cross pattern sequence using a torque wrench.



[TORQUE]

BC-KL32L(H) : 260 lbf.inch(300kgf.cm)

BC-KL52L(H) : 260 lbf.inch(300kgf.cm)

2) Sirocco fan & fan cover, duct

- ① Fit 3 screws onto the fan cover (internal).



- ② Tighten the hexagon socket head cap screws with a spanner in the balance weight of pulley reverse-rotation direction to assemble the pulley sirocco fan assembly.



👁 Torque : 174 lbf.inch(200kgf.cm)

- ③ Close the fan cover (external) with self-tapping screw.



CAUTION

When tightening tapping screw, please be careful so that the screw thread does not get damaged.

3. DISASSEMBLING MAINTENANCE (OVERHAUL)

3.1 Maintenance jig and tool

- ① orbiting scroll center bearing disassembling jig
- ② orbiting scroll set axial direction gap adjusting jig



- ③ Crank shaft set injection press 1TON

④ Torque wrench (1) : 0~87 lbf.inch(0~100kgf.cm), Torque wrench (2) : 0~347 lbf.inch(0~400kgf.cm)



- ⑤ socket wrench : M5, M6, M8, M10



- ⑥ hand socket : 17mm & extension



⑧ Phillips screw driver



3.2 Exchange parts

① orbiting scroll pin crank bearing cover set



② Housing pin crank bearing cover set



③ Pin crank set



④ Crank shaft set



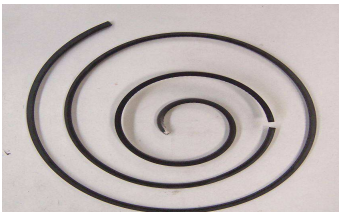
⑤ orbiting scroll center bearing



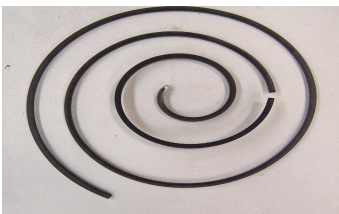
⑥ orbiting scroll center bearing grease seal



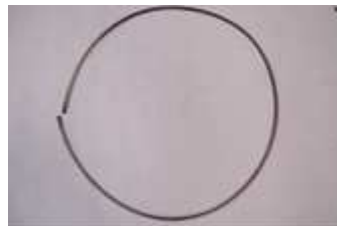
⑦ Fixed scroll tip seal set(HP tip seal : Length is short, LP tip seal: Length is Long)



⑧ Orbiting scroll tip seal set(HP tip seal:Length is short,LP tip seal:Length is Long)



⑨ Dust seal, backup tube



3.3 Disassembling order and method

1) Fan duct

- ① Loosen the 3 type M6 bolts and separate the fan duct.



2) Fan cover (external)

- ① Loosen the 5 self-tapping screws(M6) and separate the fan cover.



3) Airend pulley

- ① Take off the hexagon socket head cap screws with a spanner in the balance weight of pulley rotation direction and separate the airend pulley, as well as the sirocco fan assembly.



4) Fan cover (internal)

- ① Separate the fan cover by loosening the 3 upset bolts.



5) Fixed scroll set

- ① Loosen the 6 self-locking nuts and separate the fixed scroll set.



6) Orbiting scroll set

- ① Remove the 3 bearing covers behind the housing assembly using a M6 socket wrench, and remove the 3 pin crank bolts using a 13mm hand socket by placing the spanner in the pulley balance weight rotating counter-clockwise.



- ② Hold the orbiting scroll set with the hand and remove from the housing assembly.



CAUTION

Do not remove the orbiting scroll rear plate fit M5 hexagon socket head cap screws and orbiting scroll of the orbiting scroll set.

③ Remove the crank bearing assembly cover hexagon socket head cap screws of the orbiting scroll rear plate and remove the pin crank set by pulling.



④ Remove the O-ring using a o-ring pick.

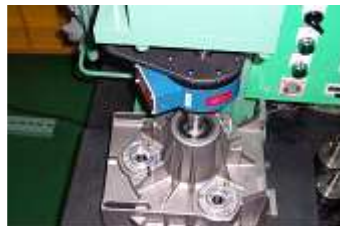


7) Crank shaft set

① Remove the hexagon socket head cap screws of the bearing cover attached to the housing.



② Support the housing set with a jig and remove the crank shaft with a press.



- Directly press the crank shaft set with a press.
- Apply the press load gradually, and when the crank shaft assembly starts to move, work at minimum load.

☞ **Press load : 694 lbf.inch (800kgf.cm)**

8) Ball bearing

- ① Using a jig, remove the ball bearing of housing with a press.



WARNING

Be careful not to damage the housing when using a jig.

3.4 Cleaning

1) Orbiting scroll cooling fin

- ① Remove dust and dirt attached to the cooling fin using compressed air.



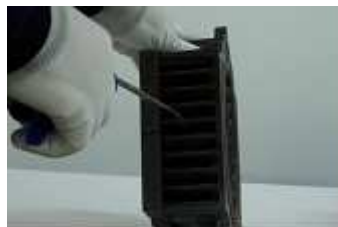
- ② Do not clean the orbiting scroll set with organic solvent (thinner, solvent).

CAUTION

Damage may occur to protective coating on metal components.

2) Fixed scroll cooling fin

- ① Remove dust and dirt attached to the cooling fin using air gun.



- ② Do not clean the orbiting scroll set with organic solvent (thinner, solvent).

3) Fan cover & duct

- ① Remove dust and dirt attached to the fan cover and duct using air gun.



4) Sirocco fan

- ① Remove dust and dirt attached to the sirocco fan using air gun.



5) Housing

- ① Remove dust inside the housing using a air gun. For dirt not removable with an air gun, use a brush or a dry cloth.



CAUTION

**Do not use organic solvent.
Damage may occur to protective coating on metal components.**

3.5 Assembling

1) Ball bearing housing assembling

- ① Check whether the part is the correct part.



② Before installing the bearing, apply some grease to the bearing contact area of the housing.

③ Support the inside of the housing using 3 jigs, and install the ball bearing using a jig, with a press.

CAUTION

Use caution on the installation of ball bearing.



④ Bearing installation load: 1100 lbf(500kgf)

⑤ Remove the bearing from inside of the bearing to the opposite side.



2) Bearing cover assembling

① Screw in the bearing cover with hexagon socket head cap screws using proper torque.



☞ **Tightening torque: 61 lbf.inch(70kgf.cm)**

3) Crank shaft housing assembling

① Support the housing set with a jig and install the crank set with a press.



② Before installing the crank shaft, apply some grease to the bearing contact surface in the housing installation.

☞ **Press injection load: 694 lbf.in(800kgf.cm)**

③ Screw in the bearing cover with hexagon socket head cap screws using proper torque.



☞ **Closing torque: 61 lbf.inch(70kgf.cm)**

4) Orbiting scroll center bearing assembling

① Put the orbiting scroll center bearing on top of the orbiting scroll set and install using jig, with a press.



② Before installing the bearing, apply some grease to the orbiting scroll center bearing contact area.

③ Place the oil seal on top of the orbiting scroll center bearing and install using a jig, with a press.



CAUTION

The oil seal must be on the same side as the top boss of the orbiting scroll set.

5) Pin crank set assembling

① Apply grease from the cartridge onto the 6 O-rings and insert into the O-ring groove of orbiting scroll set.



- ② Apply grease to the rest of the O-rings and insert into the crank set.



- ③ Insert the crank set into the orbiting scroll set and tighten the bearing cover with hexagon socket head cap screws once, then a second time with a torque wrench.



- 👁 1st torque: 17.4 lbf.inch(20kgf.cm)
- 👁 2nd torque: 34.7 lbf.inch(40kgf.cm)

- ④ Turn the pin crank set by hand and check whether it rotates smoothly.



6) Assembling orbiting scroll set in the housing

- ① Position the location of crank shaft balance weight horizontally.



- ② Determine the location of pin crank of orbiting scroll set.

③ Adjust the location so that the eccentric part of the pin crank is at the 6 o'clock position.



④ When assembling orbiting scroll set in the housing, press in evenly top, bottom, right and left.



CAUTION

Do not apply excessive force.

⑤ Place a flat washer on the housing set back orbiting scroll bearing side and assemble crank bolt, then use the spanner to tighten the pin crank bolt with 26 lbf.inch(**30kgf.cm**) with the crank shaft secured and tighten with a torque wrench.



⑥ Tighten the bearing cover with 35 lbf.inch(40kgf.cm) with 3 hexagon socket head cap screws



NOTE

In order to prevent loosening of the bolt, apply loctite 242, 542.

⑦ Check the gap in the assembled fixed scroll on the orbiting scroll wrap floor and housing plane surface.



👁 Gap: 0.2mm

7) Adjusting axial direction gap

① Fix the jig onto the housing plane surface.



👁 Fix 4 parts.

② Turn the 3 dial gauge number adjusting board by hand so the long hand of the dial gauge points at '0'.



③ When the small hand of the dial gauge reads the “0” location, tighten the 3 bearing cover hexagon socket head cap screws behind the housing gradually with evenly distributed force.



④ Adjusting method when the 3 dial gauge scales indicates ① : -16mm, ② : -18mm, ③ : -21mm



①



②



③

Stage 1: Tighten the hexagon socket head cap screws of ③ equally and adjust at -16mm of ①.



Stage 2: Tighten the hexagon socket head cap screws of ⑥ equally and adjust at -16mm of ⑤.



Stage 3: Tighten the hexagon socket head cap screws of ⑤, ⑥ and ⑦ equally and adjust at -0.13mm.



👁 **Adjustment standard: -0.13 ~ -0.14mm**

⑤ After adjusting, rotate the crank shaft once and check the dial gauge scale amplitude is within 0.02mm.



⑥ Assemble the grease cap on the bearing cover.



8) Assembling tip seal set

① Separate the high pressure and low pressure tip seal from the top seal by using pick and in the fixed scroll set.



② Using the same method, separate the dust seal and back up tube.



③ Using the same method, separate tip seal from the orbiting scroll set.

④ Lift about 2mm from the high pressure central tip seal and insert into the high pressure tip seal vertical hem and fix with finger tips.

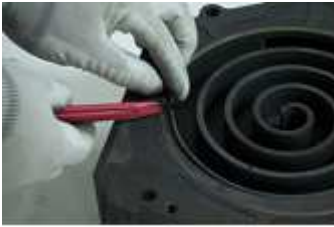


CAUTION

Shaped slit on the side and the bottom of the tip seal, wrap facing the center of the insertion.

⑤ Insert high pressure tip seal using the same method.

⑥ Insert low pressure tip seal into the end of the high pressure tip seal and press down with finger tip and insert and cut according to tip seal groove with a knife.

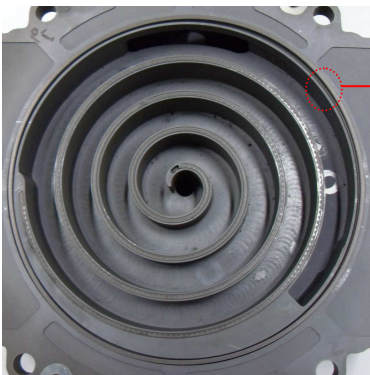


⑦ Insert low pressure tip seal using the same method.

⑧ When fixing a backup tube to the fix scroll set, the joint must face 6 o'clock direction.



⑨ Fit the dust seal on top of the back-up tube.



Dust seal

CAUTION

The top and bottom is not distinguishable when assembling dust seal.

9) Fixed scroll set assembling

- ① Assemble the fixed scroll set according to the housing parallel pin location.



- ② Assemble with 6 self-locking nuts then tighten with regulated torque by using torque wrench using cross pattern sequence.



👁 **Tightening torque:**

BC-KL32L(H) : 260 lbf.inch(300kgf.cm)

BC-KL52L(H) : 260 lbf.inch(300kgf.cm)

10) Sirocco fan & fan cover, duct

- ① Fit 3 bolts onto the fan cover (internal).



- ② Close the hexagon socket head cap screws with a spanner in the balance weight of pulley (reverse-rotation direction) to assemble the Airend pulley with attached sirocco fan.



👁 **torque : 174 lbf.inch(200kgf.cm)**

- ③ Attach the fan cover (external) with self-tapping screw.

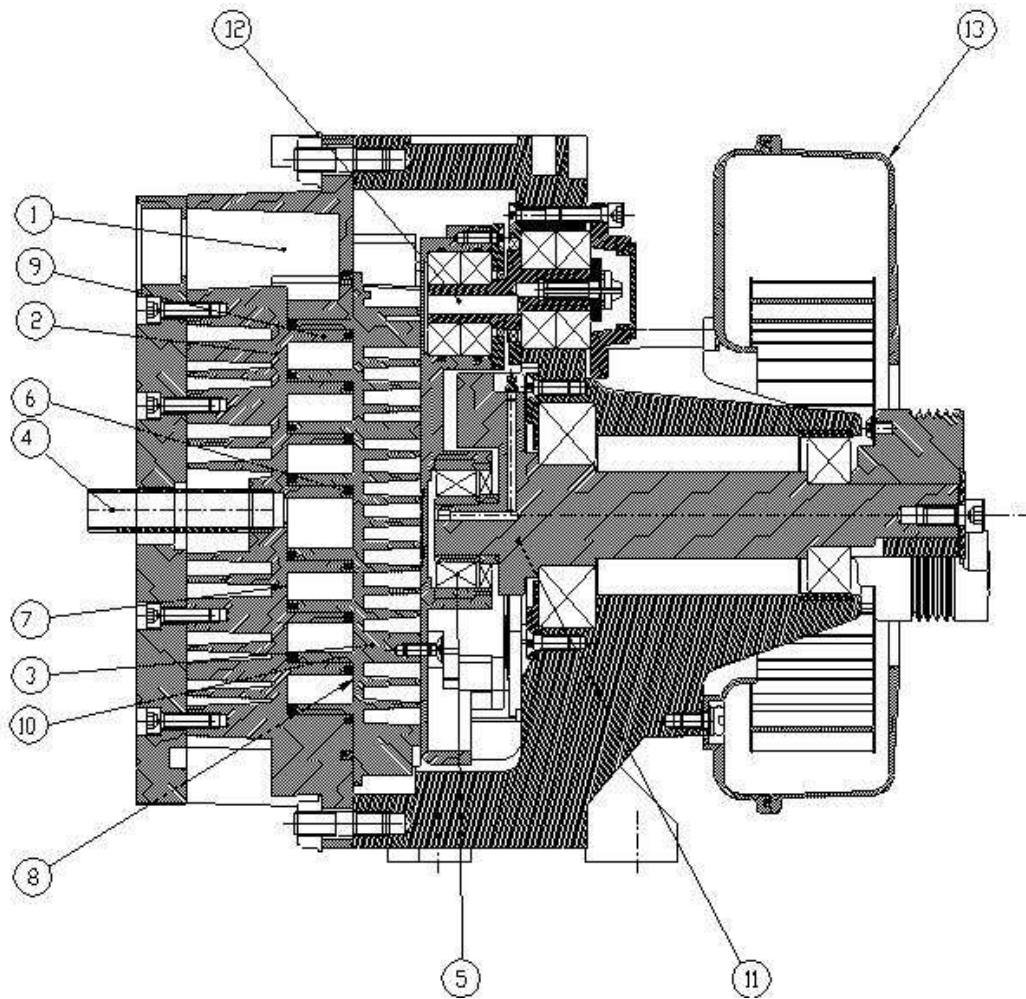


CAUTION

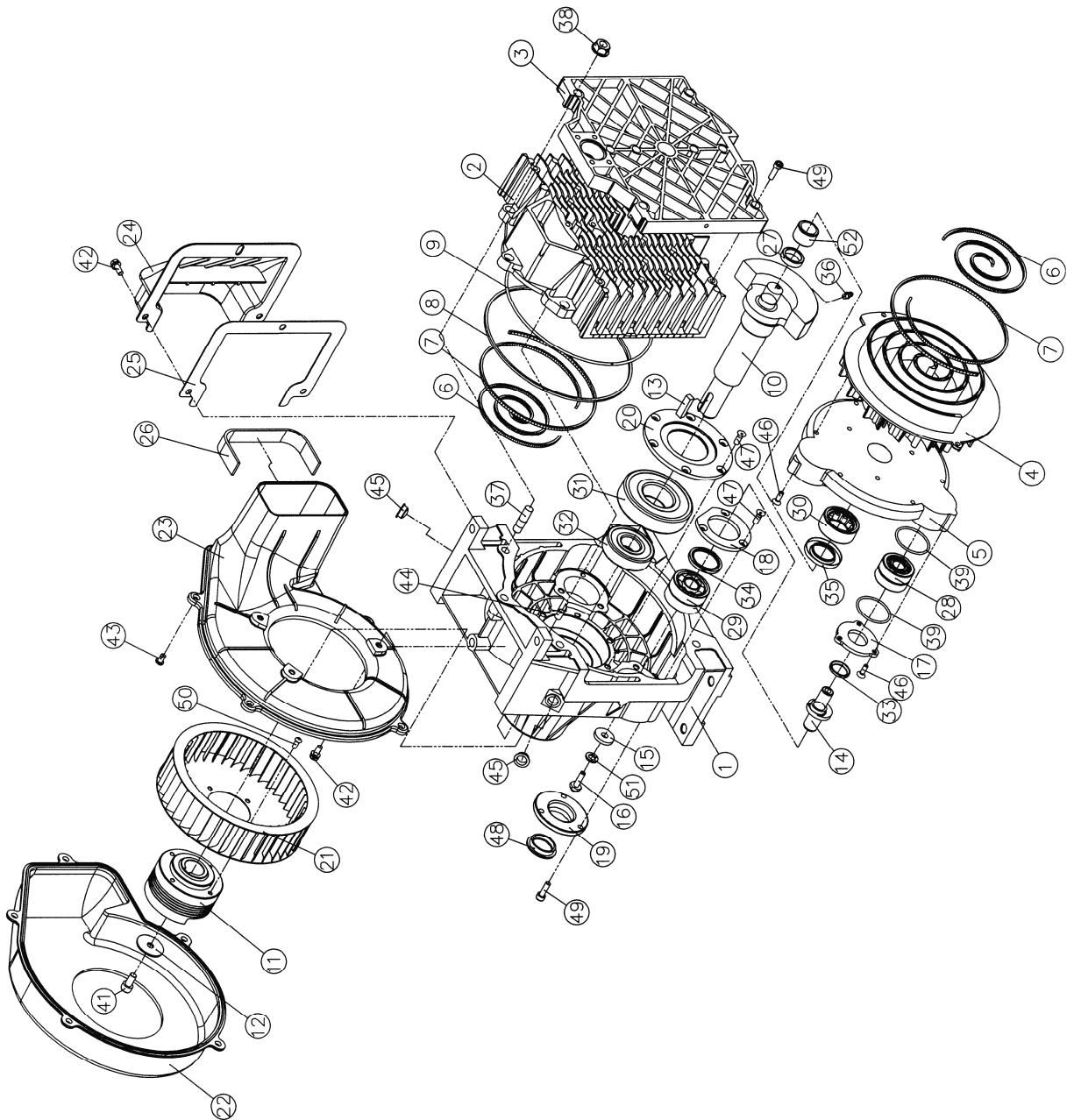
When tightening tapping screw, please be careful so that the screw thread does not get damaged.

4. AIREND SECTIONAL VIEW

- ① : INTAKE PORT
- ② : FIXED SCROLL
- ③ : ORBITING SCROLL
- ④ : DISCHARGE PIPE
- ⑤ : ORBITING SCROLL CENTER BEARING
- ⑥ : TIP SEAL
- ⑦ : FIXED SCROLL DRIVING SURFACE
- ⑧ : ORBITING SCROLL DRIVING SURFACE
- ⑨ : FIXED SCROLL WRAP
- ⑩ : ORBITING SCROLL WRAP
- ⑪ : CRANK SHAFT
- ⑫ : PIN CRANK
- ⑬ : FAN COVER



5. AIREND EXPLODED VIEW



1) Part List

PARTS NO.	PART NAME	QTY.	PARTS NO.	PART NAME	QTY.	PARTS NO.	PART NAME	QTY.
1	HOUSING	1	18	BEARING COVER(2)	3	35	OIL SEAL	1
2	FS(FIXED SCROLL)	1	19	BEARING COVER(3)	3	36	GREASE NIPPLE	1
3	FS REAR PLATE	1	20	BEARING COVER(4)	1	37	STUD BOLT	6
4	OS(ORBITING SCROLL)	1	21	SIROCCO FAN	1	38	WASHER NUT	6
5	OS REAR PLATE	1	22	FAN COVER(1)	1	39	O RING	6
6	HP TIP SEAL	2	23	FAN COVER(2)	1	41	HEX SOCKER HEAD BOLT	1
7	LP TIP SEAL	2	24	FAN DUCT	1	42	UPSET BOLT	6
8	BACKUP TUBE	1	25	DUCT PACKING(1)	1	43	TAPPING SCREW	5
9	DUST SEAL	1	26	DUCT PACKING(2)	1	44	DOWEL PIN	2
10	CRANK SHAFT	1	27	OIL SEAL RACE	1	45	DUST PROOF CAP	2
11	COMP. PULLEY	1	28	ANGULAR BEARING	3	46	SOCKET PLATE HEAD BOLT	18
12	PULLEY WASHER	1	29	ANGULAR BEARING	3	47	SOCKET PLATE HEAD BOLT	15
13	KEY	1	30	OS DRIVING BEARING	1	48	GREASE CAP	3
14	PIN CRANK	3	31	BALL BEARING	1	49	HEX SOCKET HEAD BOLT	17
15	PIN CRANK HOLDER	3	32	BALL BEARING	1	50	BUTTON BOLT	4
16	PIN CRANK HOLDER	3	33	G SEAL	3	51	SPRING WASHER	3
17	BEARING COVER(1)	3	34	G SEAL	3	52	OS DRIVING BEARING INNER RACE	1

6. ASSEMBLING TORQUE TABLE

Item	Part	standard	Torque (kgf.cm)
① Bearing support area	Hexagon socket head cap screws	M5	40
② Bearing support area	Hexagon socket head cap screws	M6	40
③ Bearing support area	Hexagon socket head cap screws	M6	70
④ Bearing support area	Hexagon socket head cap screws	M6	70
⑤ Pin crank	Hexagon socket head cap screws	M8	200
⑥ Airend pulley	Hexagon socket head cap screws	M8	200
⑦ Fixed scroll set	Nut	M10	300
⑧ Sirocco fan	Bolt	M5	60

CAUTION

When tightening bolts and nuts, use a torque wrench.

Warranty Claim Report

Please complete the following claim form, your claim will be confirmed by our sales representative.

To : Coaire Technologies, Corporation
 8740 Pioneer Blvd., Santa Fe Springs, CA 90670
 Tel(562)463-3935.Fax(562)463-4928

Distributor	Company		Date	
	Address		Model	
Customer	Company		Serial No.	
	Address		Run Hours	Hrs.
			Setting Press.	PSIG

OPERATING CONDITIONS

Percent(%) on load	%	Ambient Temperature	·F
No. of days of operation weekly	Days	Discharge temperature	·F
Hours per day	Hours	Compressor area temperature	·F
Machine setting OL/OL or Mod		Environment ¹⁾	

¹⁾ 1 to 10, 1 being clean, 10 very dirty

Incoming			Full load amperage at _____ PSIG			Unload amperage at _____ PSIG		
L1 - L2	L2 - L3	L1 - L3	L1 - L2	L2 - L3	L1 - L3	L1 - L2	L2 - L3	L1 - L3
Volts	Amp.	Amp.	Amp.	Amp.	Amp.	Amp.	Amp.	Amp.

Symptom

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Fault Diagnosis

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Resolution

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Parts required				Labor Cost		
No.	Item Number	Description/MFGR Part Number	Quantity	Labor Time: Hrs x	\$/Hrs= \$	
01				Travel Time: Hrs x	\$/Hrs= \$	
02				Total Amount: \$		
03						
04				Technicians name:		

WRITTEN BY _____ SIGNATURE **X** _____



STARTUP REPORT

Please fill out completely and return to the factory to validate warranty.

CUSTOMER AND MACHINE INFORMATION

CUSTOMER		FACTORY SHIP DATE	/ /
ADDRESS		DATE STARTED UP	/ /
CITY/STATE		MODEL NUMBER	
PHONE		SERIAL NUMBER	
WRITTEN BY		HOURS ON MACHINE	Hrs.

MACHINE INFORMATIONS AND INITIAL STARTUP

Compressor Environment- excellent , good , fair , poor .

Machine Location – indoors outdoors if outdoors, protected from rain? Yes No .

Approx. ambient temperature _____ adequate ventilation? - Yes No .

Did you check for correct rotation? Yes No Nameplate amperage for voltage used _____

Incoming Voltages

L1-L2	L2-L3	L1-L3
Volts	Volts	Volts

Full load amperage at _____ PSIG

L1	L2	L3
Amp.	Amp.	Amp.

Unload amperage at _____ PSIG

L1	L2	L3
Amp.	Amp.	Amp.

Is the machine on a level and stable surface? Yes No .

Did you have to add lubricant oil? – Yes No .

if yes, please indicate amount and exact name and type. (Amount _____ Name _____ Type _____)

Was a flexible connector used to connect piping? – Yes No .

Approx. time spent during startup procedure _____ Hrs.

Did you advice customer on operation and maintenance of machine? Yes No .

Application and installation comments:

Machine Sold By(Company) _____ Sales Person _____

Startup performed by _____ Date _____

THERE IS NO WARRANTY WITHOUT THIS REPORT!

**QUALITY AND RELIABILITY
WITHOUT COMPROMISE**



TECHNOLOGIES CORP.

8740 Pioneer Blvd., Santa Fe Springs, CA 90670

TEL.(562)463-3935 • FAX(562)463-4928

*COAIRE reserves the right to make changes, at any time without notice as
a result of our commitment to continuous improvement.*