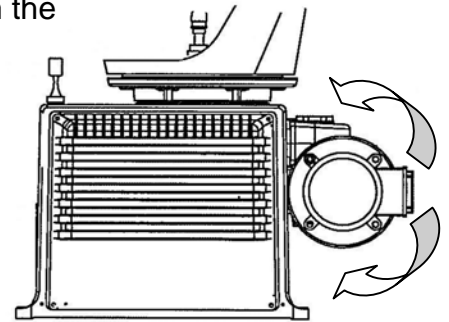


**Product: BridgeMaster E Series Radars**

**Subject: Removal/Replacement of S Band Scanner Motor**

**Instructions for removing the AC Motor from the Gearbox**

1. Leave the Motor/Gearbox Assembly fitted to the turning unit housing this makes removal/dismantling easier.
2. Remove 4 off Bolts, Nuts and Single coil washers from the Motor/Gearbox interface flanges and retain them.
3. Holding the Motor Terminal Box, apply a force to the motor housing, first clockwise and then anti-clockwise. This should loosen the motor from the gearbox flange and break the gasket seal. If the motor refuses to rotate then use a hide mallet or a wooden block and hammer on the side of the terminal box.



**NEVER use a screwdriver between the flanges as this will damage them.**

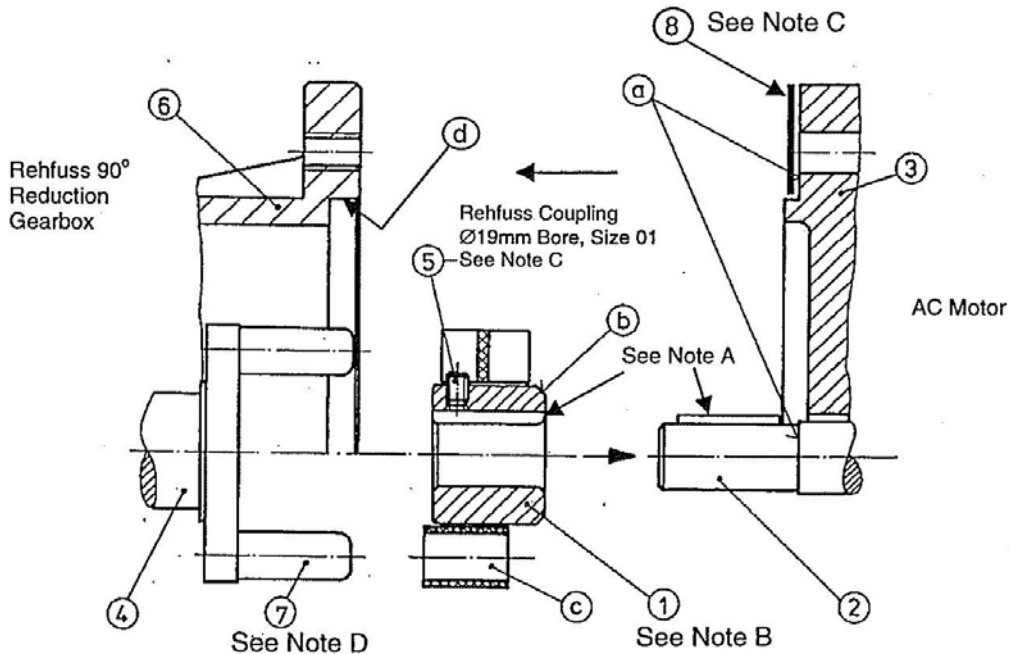
4. Now supporting the motor weight rotate and pull the motor away from the gearbox flange while holding the motor square in both planes. The motor spigot will then come away from the gearbox recess and the shaft coupling (Rehfuss Coupling Dia 19mm Bore, Size 01) will part from the drive pins on the gearbox.
5. Continue pulling the motor until fully parted, supporting the motor weight to avoid damaging the shaft coupling plastic ring.
6. If the Service Engineer suspects that the shaft coupling is damaged in any way then it must be replaced (LMS Part No. MA00011940).
7. The Sealing Gasket ( LMS Part No. MA00008037 for 1 $\phi$  or MA00007815 for 3 $\phi$ ) must always be renewed when removing the motor.
8. Fit new sealing gasket and reassemble with new AC Motor as per instruction A4/65830053-1 (see page 2).
9. Finally after assembly of the motor to the gearbox, apply a smear of denso paste (LMS Part No. 9037446) or similar around the joint line of the flanges.  
Note: Denso paste or similar must **not** be applied direct to the gasket faces.

# LITTON MARINE SYSTEMS UK

## Service Bulletin No.22

### ASSEMBLY INSTRUCTIONS FOR ATTACHING THE MOTOR TO THE IEC ADAPTOR USING THE REHFUSS COUPLING

- A) Before assembly ensure that motor shaft, key, coupling bore and keyway are clean and free from burrs, apply anti-scuffing paste LMS Pt No 6003443 to the shaft to help assembly and prevent seizure of the parts after prolonged usage.
- B) Slide/Light Press the coupling (1) up to the motor shaft (2) until the hub rests against the shaft collar (a) and the flange facing (a) lie on a single plane and that the highly chamfered side (b) faces the motor flange (3). This guarantees the correct distance between the coupling and the coupling shaft (4).
- C) Tighten the radial locking screw (5) in the hub and remove any excess anti-scuffing paste before final assembly. Now fit the sealing gasket (8) LMS Pt No MA00007815 (3 Phase) or MA00008037 (1 Phase) onto the motor flange spigot and align holes.
- D) Apply anti-scuffing paste onto coupling socket pins (7) and gearbox recess (d) only, it must **not** be applied direct to the gasket face area before fitting the motor. Now place the motor onto the IEC adaptor (6). In doing so, ensure that the socket pins have been correctly inserted into the bore holes (c) of the coupling ring.
- E) Screw the motor and the IEC adaptor together. Motor fixing screws to be supplied by LMS. Finally apply a smear of Denso Paste LMS Part No 9037446 (30g tube) around the joint line. Note, Denso Paste must not be applied direct to the gasket surfaces.



91003755 (65830262) } 19:1  
 91003773 (65830263) }  
 91003756 (65830264) } 9.75:1  
 91003774 (65830265) }  
 91003766 (65830266) } 12:1  
 91003772 (65830267) }

91003751 (65830232) }  
 91003752 (65830233) } 3phase  
 91003753 (65830238) }  
 91003754 (65830239) }  
 91003757 (65830230) } 1phase  
 91003759 (65830236) }

Production Approved	Design Approved	Drawn

65830/197		B		
65830/180		A		
Mod No	Suf	Rev	Date	Approved

Litton Marine Systems Limited

WORD DESIGN

Title: ASSEMBLY INSTRUCTIONS FOR REHFUSS COUPLING

Drawing Number:

A4 / 65830053-1

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