

**FIGURE 6-13. REMOVING P7 STATOR ASSEMBLY**

23. Verify that the stator is adequately supported and then carefully remove the capscrews from the stator attachment ring.

**⚠ WARNING** *To prevent personal injury, use adequate lifting devices to support heavy components. Keep hands and feet clear while lifting.*

**⚠ CAUTION** *Improper stator assembly rigging and handling can result in damage to stator and rotor assemblies. Lifting eyes may not be at center-of-gravity position of stator assembly. Therefore, lifting and moving the stator assembly alone, by hoisting at lifting eyes only, presents the hazard of load imbalance; allowing one end to drop and other end to rise. Make sure the stator is adequately hooked/strapped to maintain level control of stator assembly while lifting and moving.*

24. Being careful not to drag the windings on the rotor, move the stator assembly sufficiently away from engine to sling and support the rotor assembly. Do not allow rotor assembly to hang on engine flywheel.

**⚠ CAUTION** *Drive disc damage can be caused by allowing the rotor assembly to hang on flywheel. Use adequate hoist and sling to support the rotor assembly.*

25. Reposition or add hoist and sling support for the main rotor, and remove the forklift. See Figure 6-14, Rotor Lift detail.

**⚠ WARNING** *To prevent personal injury, use adequate lifting devices to support heavy components. Keep hands and feet clear while lifting.*

26. Remove the stator assembly, being careful not to drag the windings on the rotor. Place stator assembly away from the chassis in the horizontal position.

27. Using the hoist and sling to support the rotor, carefully remove the capscrews and flat washers that secure the drive discs to the engine flywheel.

**⚠ WARNING** *To prevent personal injury, use adequate lifting devices to support heavy components. Keep hands and feet clear while lifting.*

28. Remove the rotor assembly and place it on wood blocks in the horizontal position. To avoid possible distortion, do not allow the drive discs and fan to rest on anything.

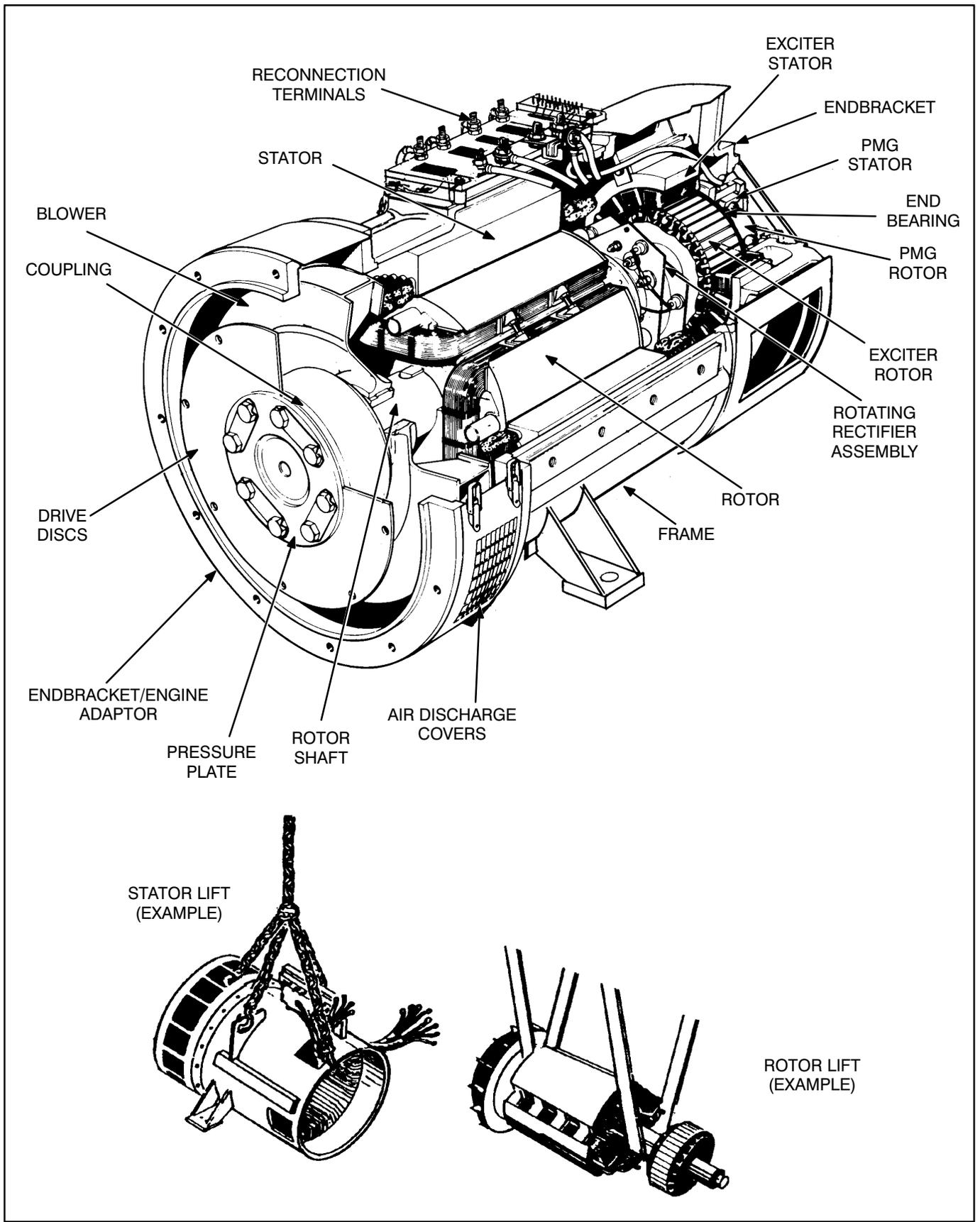


FIGURE 6-14. TYPICAL GENERATOR ASSEMBLY

## Generator Assembly Removal

29. Remove the fasteners from the two generator mounting feet brackets.
30. Attach cables of lifting device to generator lifting points (Figures 6-10 or 6-11).
31. Using an adequate lifting device, lift the generator (at lifting eyes provided, and main stator housing) until the mounting feet brackets are clear of the frame member.
32. If the engine does not have chassis mounts at generator end, block the rear of the engine in place by supporting the flywheel housing. A length of steel channel and wooden blocking is required to support the rear of the engine. Place the channel and blocking under the flywheel housing. Lower the generator until most of the set weight is supported by the blocking (see Figure 6-12).
33. Disconnect the grounding strap from the flywheel housing.
34. Carefully remove the capscrews and flat washers that secure the drive discs to the engine flywheel.
35. Verify that the generator assembly is adequately supported. Carefully remove the capscrews securing the engine adaptor endbracket to the engine flywheel housing.
  - ⚠ WARNING** *To prevent personal injury, use adequate lifting devices to support heavy components. Keep hands and feet clear while lifting.*
  - ⚠ CAUTION** *Improper generator assembly rigging and handling can result in damage to stator and rotor assemblies. Lifting eyes may not be at center-of-gravity position of stator assembly. Therefore, lifting and moving the generator by hoisting at lifting eyes only, presents the hazard of load imbalance; allowing one end to drop and other end to rise. Make sure the generator is adequately hooked/strapped to maintain level control of assembly while lifting and moving.*
36. Remove the generator assembly away from engine. Place generator assembly on floor with a piece of wood beneath the stator housing (toward PMG end) to allow for endbracket removal, if desired.

## GENERATOR REASSEMBLY

Generator reassembly is the reverse of disassembly procedure.

To assemble the stator and rotor at the same time, continue with step 1. To assemble the stator and rotor individually, skip to step 17.

- Using an adequate lifting device, locate the generator assembly into position near the engine flywheel housing. Align the holes of the rotor drive discs with the holes of the engine flywheel. Install the capscrews and flat washers that secure the drive discs to the engine flywheel, hand tighten.

**⚠ WARNING** *To prevent personal injury, use adequate lifting devices to support heavy components. Keep hands and feet clear while lifting.*

**⚠ CAUTION** *Improper generator assembly rigging and handling can result in damage to stator and rotor assemblies. Lifting eyes may not be at center-of-gravity position of stator assembly. Therefore, lifting and moving the generator by hoisting at lifting eyes only, presents the hazard of load imbalance; allowing one end to drop and other end to rise. Make sure the generator is adequately hooked/strapped to maintain level control of assembly while lifting and moving.*

- Align the holes of the engine adaptor endbracket with the holes in the flywheel housing and install the capscrews and lock washers. Refer to Figure 6-13 and Table 6-3 for torque specifications.
- Secure the rotor assembly to the flywheel. Refer to Figure 6-13 and Table 6-3 for torque specifications.
- Lift the generator slightly and remove any blocking from under the flywheel housing. Lower the generator (see Figure 6-12).

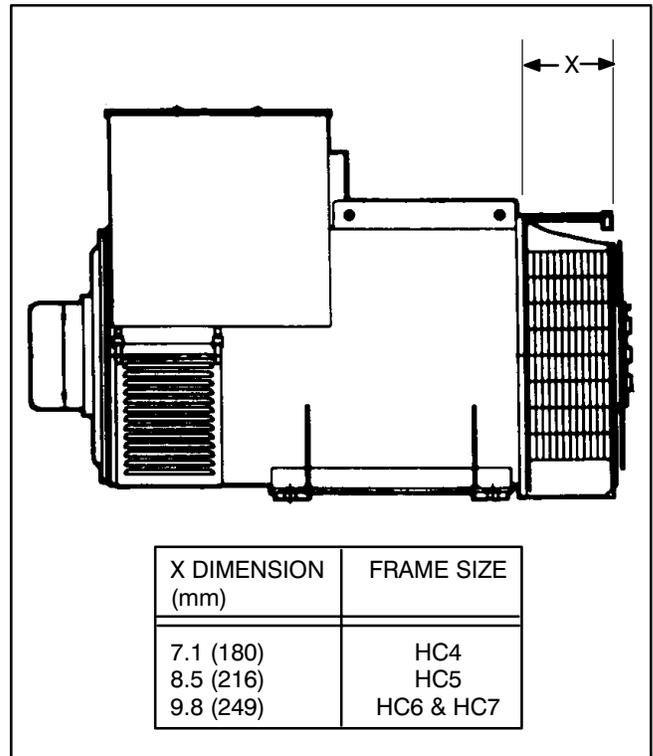


FIGURE 6-15. GENERATOR FRAME SIZE

TABLE 6-3. GENERATOR MOUNTING TORQUE

FRAME SIZE	ROTOR ASSEM. TO FLYWHEEL	FLYWHEEL HSG. ENDBRACKET TO ENGINE ADAPTER
HC4	85 ft-lbs. (115 N•m)	35-38 ft-lbs. (47-52 N•m)
HC5	150-170 ft-lbs. (203-190 N•m)	75-85 ft-lbs. (101-115 N•m)
HC6/7 & P7	150-190 ft-lbs. (203-245 N•m)	95-105 ft-lbs. (129-142 N•m)