CAUTION This symbol is used to indicate presence of hazards that can cause minor property damage.

1. Remove the following anti-drive end parts from the alternator:
   a. Fan guard screws, grommets/grommet inserts, and fan guard.

   Figure 1 - C612 Alternator

2. Remove anti-drive end housing:
   a. Scribe marks across ADE housing and shell to ensure proper position when alternator is reassembled.
   b. Remove ADE locknuts and housing (discard locknuts).
   c. Remove and discard O-ring from bearing bore.

3. Remove and discard anti-drive end bearing from shaft using a bearing puller.

4. Remove and discard spiral ring seal from groove in shaft.

   Figure 2 - C612 Assembly with Old-style Bearing

5. Wind new spiral ring seal in groove on shaft closest to rotor. Lubricate with Klüber Asonic® HQ72-102 or equivalent.

6. Re-install anti-drive end housing:
   a. Install new O-ring in bearing bore of anti-drive end housing. Lubricate with Klüber Asonic® HQ72-102 or equivalent.
   b. Align scribe marks on shell and anti-drive end, then lower ADE housing in position.

   CAUTION There will be a slight resistance as spiral ring seal enters bearing bore. Do not force housing on shaft. Spiral ring seal can be damaged by too much pressure.

   c. Secure anti-drive end housing with new locknuts. Use a suitable adhesive such as Loctite® 222 on studs and nuts. Follow adhesive manufacturer’s instructions. Torque screws to 5.1 Nm/45 lb. in.

7. Support drive end of shaft with ADE housing facing up. Install new double-wide bearing in position by pressing on inner race of bearing, using suitable tool (such as CEN part no. A10-102).

   Figure 3 - C612 Assembly with New-style Bearing

8. Install fan and fan guard:
   a. Install new fan on shaft. Fasten with fan washer and new fan nut. Torque nut to 67.8 Nm/50 lb. ft.
   b. Install fan guard. Fasten with new grommets/grommet inserts and screws. Use a suitable adhesive such as Loctite® 222 on screws. Follow adhesive manufacturer’s instructions. Torque screws to 1.1 Nm/10 lb. in.

1 Loctite is a registered trademark of Loctite Corporation.
2 Asonic is a registered trademark of Klüber Lubrication.