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**SAFETY INSTRUCTIONS**

**Caution!** Refrigerating compressors are pressurised machines and therefore require particularly careful and meticulous handling.

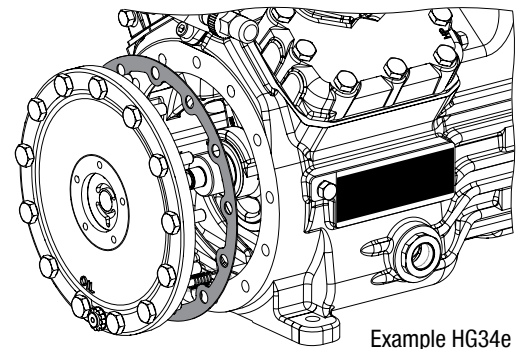
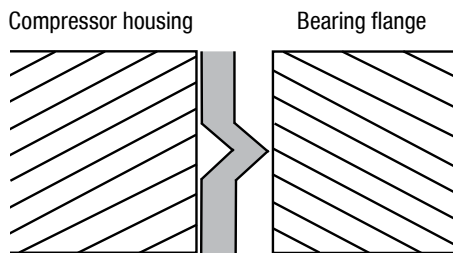
- Only qualified staff are allowed to perform repairs.
- National safety regulations, accident prevention regulations, technical rules and other valid specifications must be observed.
- The compressor may only be operated in refrigerating systems, and only with refrigerants approved by Bock.
- The maximum tolerable operating overpressure may not be exceeded (not even for test purposes).
- Pressure switches are required to safeguard the machine from excess pressures.
- New compressors are provided with an overpressure filling ex works (inert gas, approx. 3 bar nitrogen). Before connecting up the refrigerating system, the pressure in the compressor must be relieved.

- Before starting the compressor, the discharge shut-off valve and suction shut-off valve are to be opened.
- Before starting up, check that all components mounted by the user have been properly mounted and are connected pressure-tight with the compressor (e.g. replaced parts, etc.).
- When starting up, do not start the compressor in a vacuum. Only operate the compressor when the whole system has been filled.
- Surface temperatures of more than 60°C are possible on the pressure side respectively under 0°C on the suction side, depending on the operating conditions.

1. **Release screws, bearing flange**  
11 screws M8 x 25 for HG(HA)12  
13 screws M10 x 35 for HG(HA)22+34

2. **Dismounting bearing flange**  
Remove bearing flange and seal. The oil pump and the plug must be disassembled.

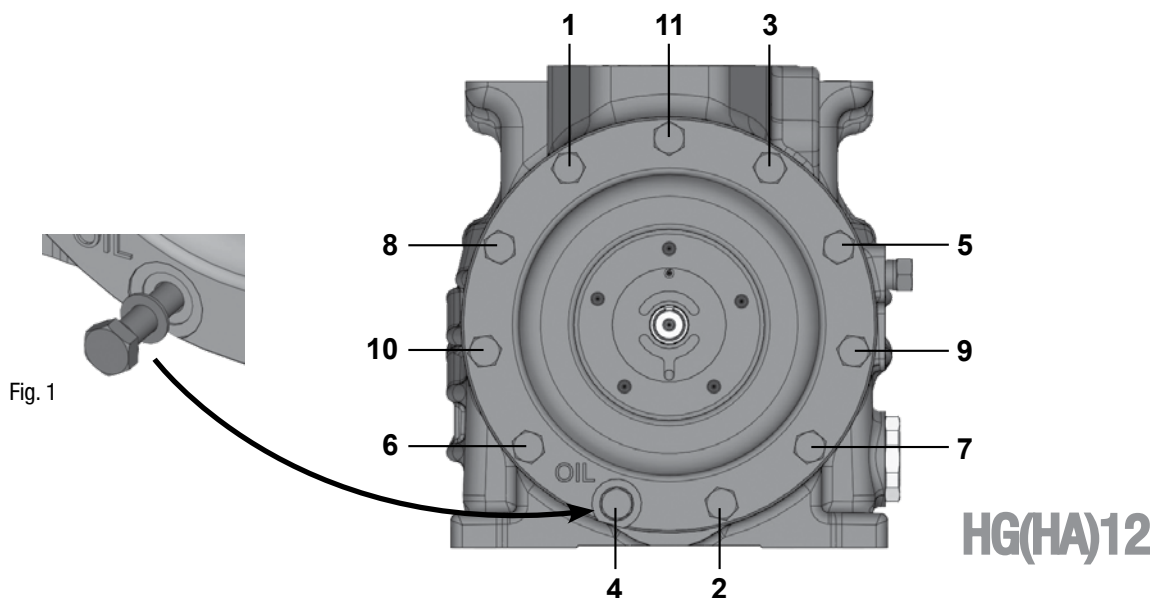
Installation position of the steel seal



Example HG34e

3. **Mounting bearing flange for HG(HA)12**  
11 screws M8 x 25 (Pos. 1 - 11)  
1 copper seal under oil drain screw (Fig. 1)

**Important!** Observe sequence as listed in numbering.  
M8 x 25: 37 Nm

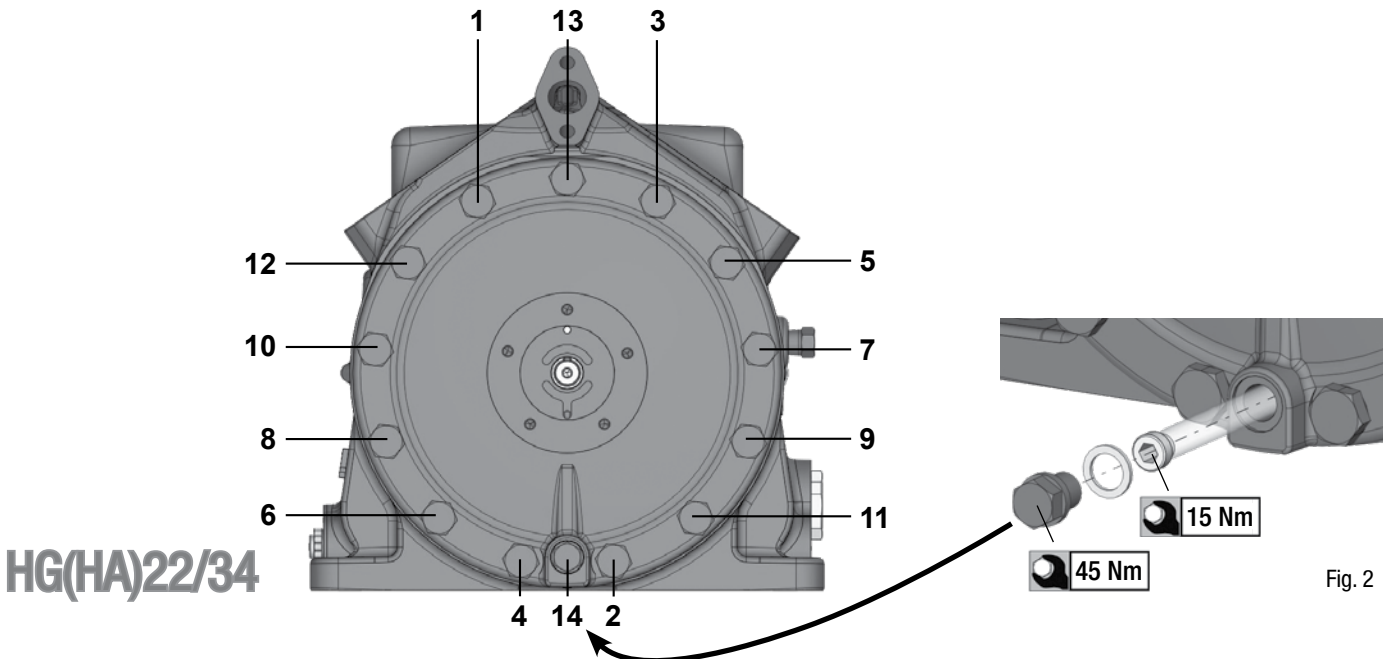


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4. Mounting bearing flange for HG(HA)22+34

- 13 screws M10 x 35 (Pos. 1 - 13)
- 1 locking screw M12 x 1,5, 1 seal ring and 1 oil strainer (fig. 2)

Important! Observe sequence as listed in numbering.  
M10 x 35: 75 Nm



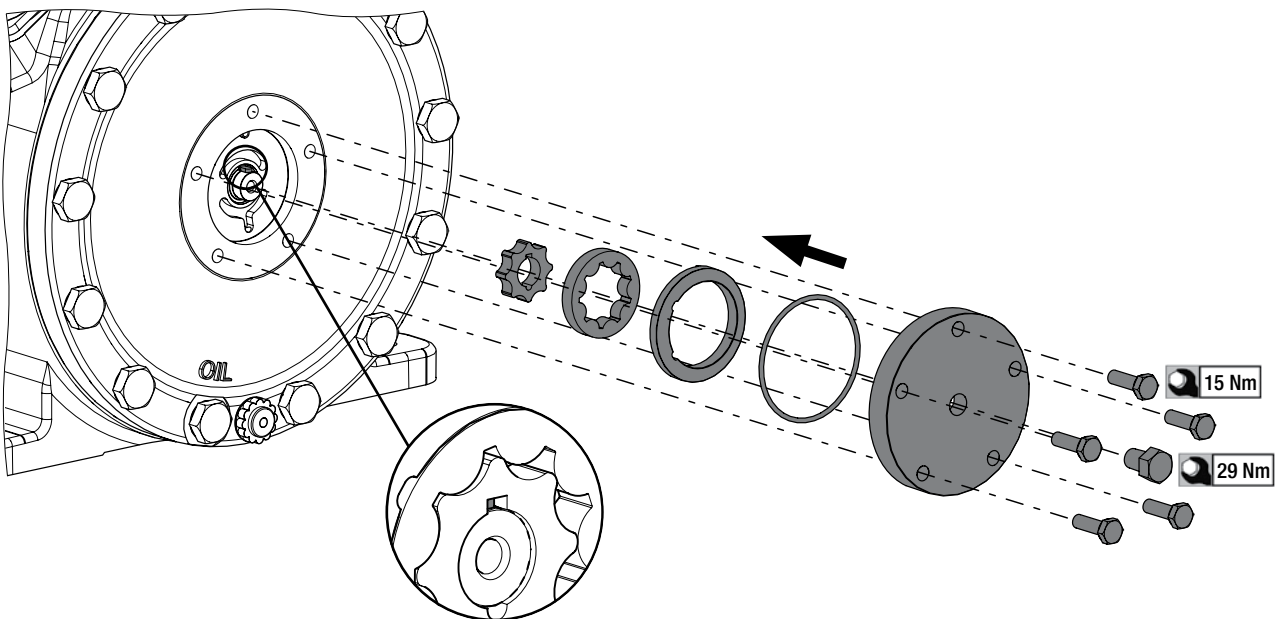
HG(HA)22/34

Fig. 2

5. Mounting oil pump

Pay attention to the correct position of the inner rotor to the feather key on the crankshaft!

Important! Observe the tightening torques.



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