

**DRIVE END FRAME BEARING ASSEMBLY  
REPLACEMENT INSTRUCTIONS FOR 24SI™ ALTERNATORS**

**NOTICE!** It may be necessary to obtain **10520982 Miscellaneous Hardware Kit** to replace parts that may be damaged or lost during disassembly.

**WARNING!!!** ALWAYS USE PROPER EYE PROTECTION WHEN PERFORMING ANY MECHANICAL REPAIRS TO A VEHICLE – INCLUDING, BUT NOT LIMITED TO, ANY INSTALLATION AND OR REPAIRS TO THE DELCO REMY<sup>®</sup> ALTERNATORS. FAILURE TO USE PROPER EYE PROTECTION CAN LEAD TO SERIOUS AND PERMANENT EYE DAMAGE.

Only perform the mechanical functions that you are properly qualified to perform. Mechanical repairs that are beyond your technical capabilities should be handled by a professional installation specialist.

**DANGER!!!** To avoid injury or damage, always disconnect the negative cable at the battery before removing or replacing the alternator. The alternator output terminal is always live (“hot”). If the battery is not disconnected, a tool accidentally touching this terminal and ground can quickly get hot enough to burn skin or damage tools and surrounding parts.

**FOLLOW ENGINE OR VEHICLE MANUFACTURER’S INSTRUCTIONS CAREFULLY WHEN REMOVING AND REINSTALLING THE ALTERNATOR.****REMOVAL INSTRUCTIONS**

1. Remove vehicle leads connected to the alternator, noting their positions for reinstallation of the alternator.
2. Remove the pulley nut, pulley, drive end slinger and external drive end spacer.
3. Remove the four (4) thru-bolts that hold the drive end and slip ring end frames together.
4. Remove the drive end frame assembly, being careful not to disturb the stator assembly.

**NOTICE!** Excessive movement may weaken or break a lead or leads between the stator and rectifier assemblies.

5. Remove the three (3) screw assemblies and bearing retainer plate.
6. Remove and dispose of the old drive end bearing.

**INSTALLATION INSTRUCTIONS**

1. Install new drive end bearing assembly into drive end frame. Push bearing into housing bore until it is seated, **by applying force against the outer race only**, using a press. Do not use excessive force.
2. Reinstall bearing retainer plate. Torque the three (3) screw & lock washer assemblies to **5.0-9.0 N-m (44-80 lb in)**.
3. Reinstall the drive end frame assembly, being careful to line up the non-threaded mounting lugs.
4. Reinstall the four (4) thru-bolts. Using a crossing pattern, torque bolts to **7.8-9.2 N-m (90-120 lb in)**.
5. Install the external drive end spacer, drive end slinger, pulley and pulley nut. Tighten the pulley nut to **80-115 N-m (59-85 lb ft)**.
6. Reinstall alternator according to engine or vehicle manufacturer’s instructions.
7. Reattach the battery (+) terminal lead to alternator battery terminal and torque nut to **9.0-13.0 N-m (80-120 lb in)**.
8. Reconnect the negative (-) cable at the battery.

**NOTICE** - Only licensed Remy Inc. product and component parts should be used, and the use of other parts or modifications not approved by Remy Inc. will void all applicable warranties. The failure to carefully follow these Installation Instructions, set forth above, will void all applicable warranties. Delco Remy<sup>®</sup> is a registered trademark of General Motors Corporation, licensed to Remy Inc., Pendleton, IN 46064.