

Figure 91
Assembly Mounting Sequence

T. Bleach Cup:

Place the bleach cup, spring end down, inside the agitator column. Should the two parts become separated prior to installation in the column, they should be reassembled as follows:

Assemble the bleach cup spring to the bleach cup by inserting the widest coil of the spring in the groove in the lower end of the bleach cup. Figure 91.

U. Bellows—Replacement:

1. Follow Procedure R.
2. Remove the nut, washer, "O" ring and diaphragm mount-

ing support.

3. Disengage the snap ring, Figure 92, that retains the water seal bellows on the tub, using 12071 pliers; remove the bellows.
4. Remove the retainer from the top of the inner bellows:
Note: The inner bellows retainer sometimes sticks in the top of the water seal bellows and comes off with the water seal bellows. The retainer must be removed from the water seal bellows for proper reassembly.
5. Disengage the snap ring that retains the inner bellows on the tub mounting nut. Use 12168 Tool.

Important Reassembly Notes:

Castings that come in contact with the sealing areas of the bellows or tub seal parts must be clean and free of corrosion to avoid leaks after reassembly.

a. Inner Bellows:

1. If the removed bellows is to be reinstalled, stretch the bellows and check between each fold for holes or wear. Check the formation at the top of the bellows for distortion. If the bellows is not perfect, discard it and install a new one, Figure 92.

Note: Manually rotate the tub clockwise and at the same time pull upward until the agitator shaft reaches the top of its stroke to facilitate bellows installation.

2. Inner bellows retainer: Place the retainer on the top of the inner bellows and work the top of the inner bellows up into the flanged bottom of the retainer, Figure 93.

b. Water Seal Bellows:

If the removed bellows is to be reinstalled, stretch the bellows and check between each fold for holes and wear. If the bellows is not in perfect condition, discard it and install a new one, Figure 94.

Note: Manually rotate the tub clockwise and at the same time pull upward until the agitator shaft reaches the top of its stroke to facilitate bellows installation. Install the diaphragm support spacer and tighten the hold down nut to 80" lb. torque. See Figure 95.

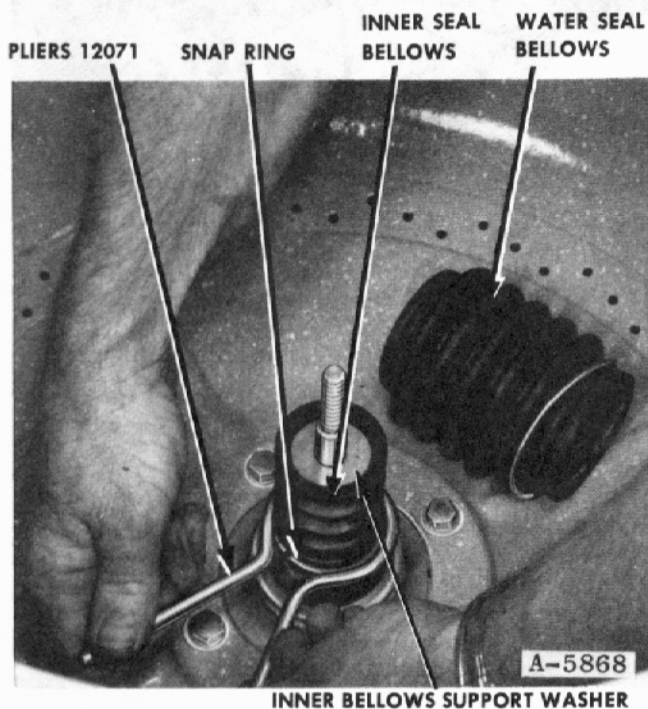


Figure 92
Removing Inner Bellows

Note: Install the same number of 0638863 spacers between the bottom of the diaphragm and diaphragm support spacer as were installed originally and check spacing.

Bellows Installation Suggestion:

When installing a new bellows on any model washer, warm the bellows by immersing under hot water for a few minutes. This will allow the bellows to become pliable and easier to install. Wipe the interior dry before installation.

V. Agitator Mounting Nut—Temporary Installation:

1. Install the agitator assembly on the agitate shaft and tighten the nut to approximately 140 inch pounds on the shaft.
2. Push downward on the top of the assembly until the agitate shaft is at the absolute bottom of its stroke.

**POSITIONING
WATER SEAL
BELLOWS SUPPORT**

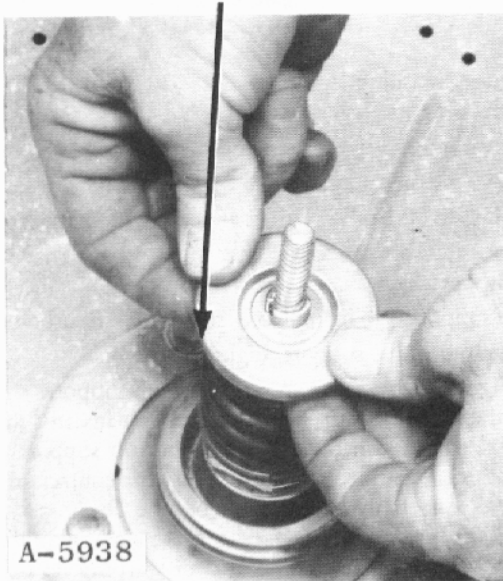
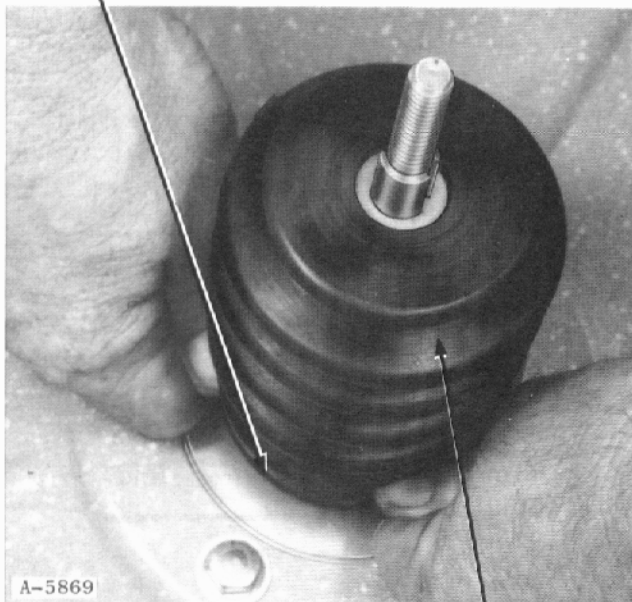


Figure 93
Water Seal Bellows Support

START HERE



WATER SEAL BELLOWS

Figure 94
Installing Outer Bellows

3. Observe the clearance between the bottom edge of the diaphragm and the bottom of the washer tub.
4. **Important**—This clearance between the bottom of the diaphragm and washer tub must not be less than $2\frac{1}{32}$ " or more than $2\frac{3}{32}$ " when measured between the ribs in the bottom of the tub. The diameter of a dime may be used to gauge minimum clearance and a penny can be used to gauge maximum clearance.
5. The clearance can be adjusted by adding or removing 0638863 spacer washers between the bottom of the lower cone and the top of the diaphragm mounting support.

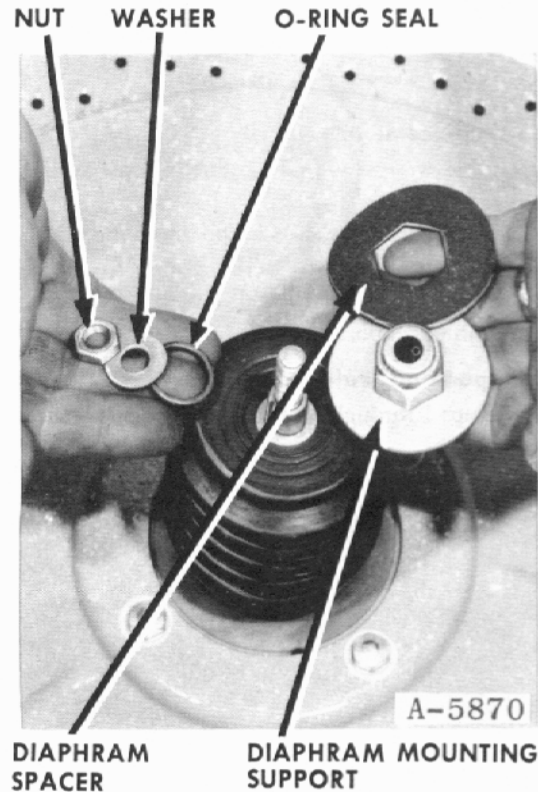
Cleaning Agitate Shaft Threads:

Remove any remaining Loctite or other foreign material from the agitate shaft threads, using a wire brush and a clean dry cloth.

Agitator Mounting Nut—Permanent Installation:

Apply two drops of "Blue" or "242" Loctite to the upper threads of the agitator mounting nut.

Note: Be sure the O-Ring seal is not damaged or twisted. If damaged, replace it with new one. The "O" ring should be lubricated on installation with soap solution to assure proper sealing.



**DIAPHRAM
SPACER**

**DIAPHRAM MOUNTING
SUPPORT**

Figure 95
Diaphragm Mounting Support

Additional notes on Frigidaire 638860 Bellows Replacement:

- ✓ The use of a long (18") 3/8" extension (or two extensions coupled together) on your 3/4" socket makes agitator removal easier. Hold the tub by placing your left foot in it, and this longer extension will allow excellent leverage.
- ✓ If the original, hard-to-find bellows snap ring tool is unavailable, a very large Channellock-style pliers may be (carefully) used to remove and reinstall.
- ✓ Most of the later '1-18's' didn't use the inner, 'oil' bellows seal, but only the larger outer 'water' bellows, so if there's no inner bellows on yours, don't panic, it was probably manufactured that way.
- ✓ Smaller leaks, especially on the later versions of this washer, were often through the main shaft seal. Water leaking through this seal was usually seen running out the plastic trough attached to the mechanism. This little trough was intended to divert these leaks away from the mechanism.
- ✓ I don't recommend using Loctite® on the agitator nut. It will make your life that much more miserable if you have to remove it again, and you'll find the agitator will stay on just fine without it.
- ✓ Do use a bit of silicone-based lubricant on the diaphragm support O-ring. This will prevent its twisting when the agitator nut is tightened. It's a good idea to lightly sand the inside surface of the nut that contacts this O-ring too.
- ✓ Removal of the tub nut isn't necessary to replace the bellows seal(s).