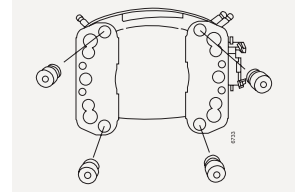


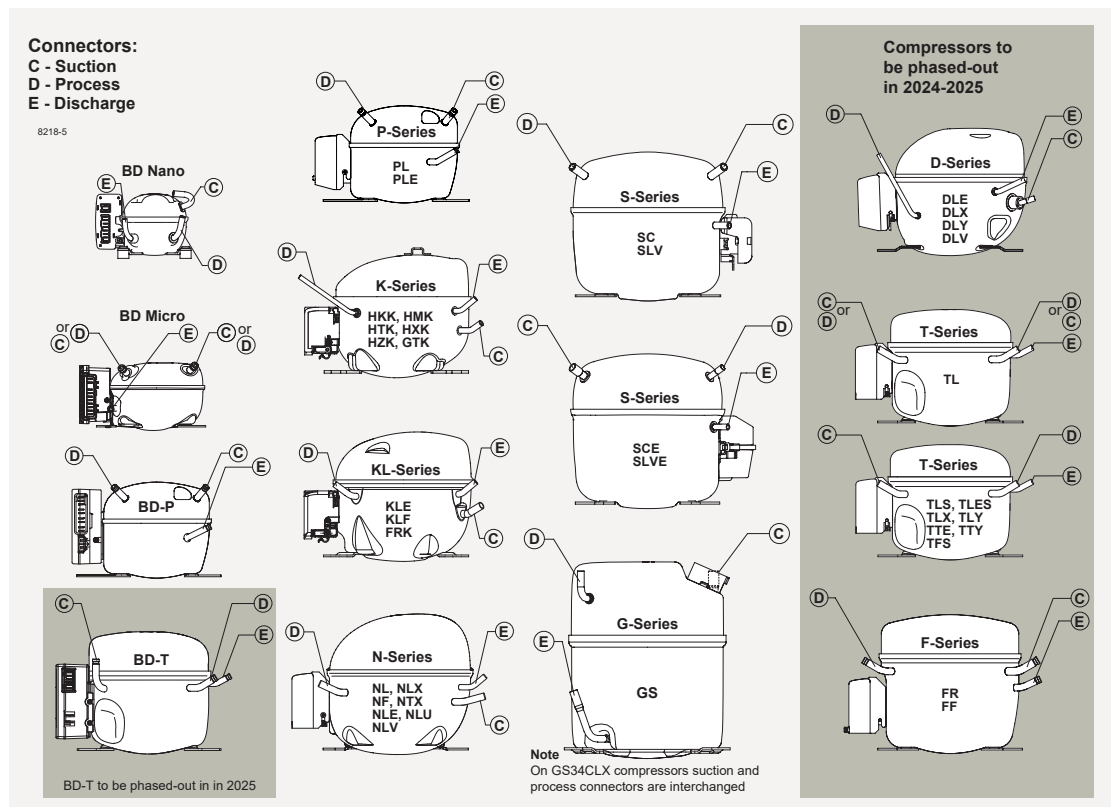
Mounting the Compressor

Brazing problems caused by oil in the connectors can be avoided by placing the compressor on its base plate some time before brazing it into the system. The compressor must never be placed upside down when mounting the rubber grommets in the base plate. Instead place the compressor on its side with the connectors upwards. The system should be closed within 15 minutes to avoid moisture and dirt penetration. Tightening torque for M6 bolt joint mountings should be $5 \text{ Nm} \pm 0,5$ (hand-tight).



Connector Positions

The positions of connectors are found in the sketches below.
C means suction and must always be connected to the suction line.
E means discharge and must be connected to the discharge line.
D means process and is used for processing the system.



Most Secop compressors are manufactured with copper connectors and are sealed with rubber plugs. Other compressors are supplied with aluminum cap sealed connectors, which consist of a thick-walled copper plated steel tube with great corrosion resistance and good braze ability. The aluminum cap sealing ("capsolut") offers a tight sealing. The seal ensures that the compressors have not been opened after leaving Secop's production lines. In addition to that, the seal makes a protecting charge of nitrogen superfluous. The connectors are welded in the compressor housing and thus the weld cannot be destroyed by overheating during brazing operations. The seal is easily removed with an ordinary pair of pliers.

Compressors with an "S" in the model denomination and all NL/DL/SCE types have a direct intake system, which means increased capacity. The suction connectors at these compressors must be connected to the suction line to prevent capacity loss.

220-240 V compressors and most BD compressors are normally supplied with millimetre tubes, while 115 V compressors are supplied with inch tubes. All connectors have a shoulder to provide optimal brazing conditions. Drifting of the connectors for more than 0.3 mm is not allowed.

For the refrigerants R600a and R290, process tubes can be closed with a LOKRING® connection. Brazing is not allowed during servicing systems with flammable refrigerants.

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