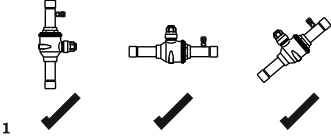
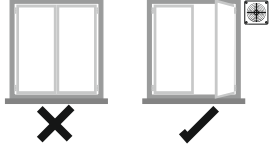
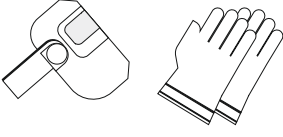
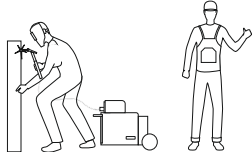
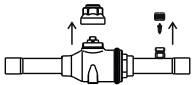
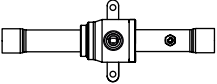
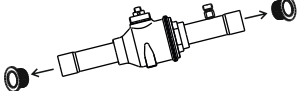
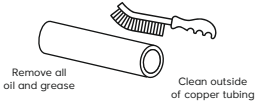
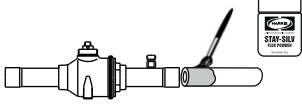
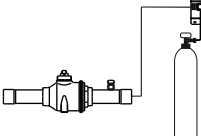
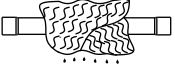
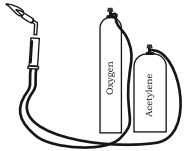
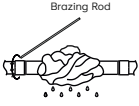
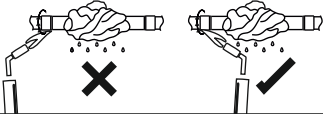
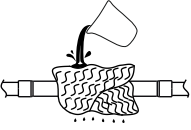
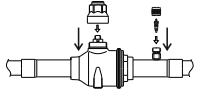
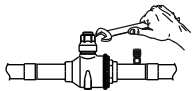


Ball Valve - Bi-Flow Refrigerant On/Off Valve Installation Guideline

Installation Position  1	Do Installation work in normal, clean and safe atmospheric conditions, Please do not do any work in hazardous and unsafe conditions.  2	When working makes sure that the area has enough ventilation or working exhaust.  3										
Use face shield or green goggles as protection for eyes. Use heat resistance gloves.  4	Wear impervious coverall clothing with breathable fabrics.  5	Remove the brass dead cap of operating spindle. Also remove the cap and inner parts of Schrader Valve if present.  6										
Turn the ball valve stem to open position. The pin must be positioned as show.  7	Remove the plastic cap ends just when you are ready to braze.  8	Clean the mating parts with cleaning pad or special wire brush  9										
Apply flux to the male connection after cleaning operation  10	During brazing bleed an insert gas (Dry Nitrogen or CO₂)  11	Wrap a wet cloth over ball valve. It must cover the existing brazed tubes on the body and spindle.  12										
Preferably use oxygen-acetylene brazing equipment and a torch capable to increase temperature to the required value as soon as possible.  13	Use copper or high silver brazing rod as required.  14	<table border="1"> <tr> <th>Ball Valve connection</th> <th>Mating Part</th> <th>Recommended Harris Make Brazing Alloy or Equivalent.</th> </tr> <tr> <td>Copper</td> <td>Copper</td> <td>Most Common used is Harris-O. For higher Vibration joints you may use Harris - Stay-Sliv 2 / Stay-Sliv 15/Dynaflow.</td> </tr> <tr> <td>Copper</td> <td>Steel</td> <td>Stay-Sliv 25</td> </tr> </table> 15 Use Brazing Flux as required	Ball Valve connection	Mating Part	Recommended Harris Make Brazing Alloy or Equivalent.	Copper	Copper	Most Common used is Harris-O. For higher Vibration joints you may use Harris - Stay-Sliv 2 / Stay-Sliv 15/Dynaflow.	Copper	Steel	Stay-Sliv 25	
Ball Valve connection	Mating Part	Recommended Harris Make Brazing Alloy or Equivalent.										
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Copper	Steel	Stay-Sliv 25										
flame direction should be opposite to the valve body. Do not touch the flame of the torch directly to the copper tube. Heat the tube by turning the torch around. Do not focus on one point.  16	After brazing one side, allow it cool. Pour cold water onto the cloth to cool it further. Then apply the above listed steps again for the other side.  17	Do not forget to attach the brass caps and inner parts of Schrader Valve back to their places. Check the Schrader Valve and connections for leaks.  18										
Tighten the cap for sealing, with the torque written on it. Please check if the gasket is properly placed in the cap.  19	Technical Properties <table> <tr> <td>Nominal pressure</td> <td>: 45 bar</td> </tr> <tr> <td>Temperature Range</td> <td>: -40°C to 150°C</td> </tr> <tr> <td>Body Material</td> <td>: Forged brass</td> </tr> <tr> <td>(EN 12420, EN 12165, CW617N):</td> <td></td> </tr> <tr> <td>Tube Material</td> <td>: Copper (EN 12735-1)</td> </tr> </table>		Nominal pressure	: 45 bar	Temperature Range	: -40°C to 150°C	Body Material	: Forged brass	(EN 12420, EN 12165, CW617N):		Tube Material	: Copper (EN 12735-1)
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