1. Determine the piping sizes of each part from Table-3, 4, and 5.

4. The 2-branch joint is equipped with a stopper.

5. Braze the pipes under nitrogen purge.

6. Be careful that foreign materials like dust do not enter into the piping when connecting pipes.

6. Apply insulation material to all refrigerant pipes inside the pipe, and connect the pipe.

For liquid line

For gas line

Pipe cover (field) Insulation material (field supply)

Pipe cover (field) Insulation material (field supply)

- Install the pipe cover (field) along the liquid pipe (field).
- Install the joint section of pipe cover (field) with insulated sealing tape (field supply). (Refer to Fig. 4.)
- Apply the same procedures to the gas pipe (field) also.

Note 1. Apply insulation to all refrigerant piping (field supply). When using a commercially available insulating material, make sure to use the heat resistant insulation material (resistant 200°C minimum).

Note 2. The insulation cover shrinks slightly, so wrap the pipe cover (field) and the field-installed insulation material securely with tape by overlapping the tape as shown in Fig. 3.