



# THERMACORE LINE SETS - INSTALLATION INSTRUCTIONS

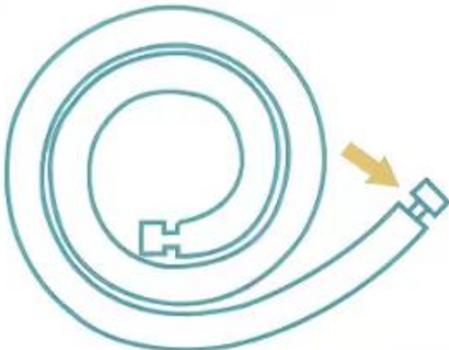
## INSTALLATION BEST PRACTICES

- 1. Keep the tubing clean and dry** — Before connection, ensure the interior is free of dust, oil, and moisture. Cap both ends when stored or routed through construction areas.
- 2. Use the correct refrigerant and oil** — Never mix different refrigerants or oils. Contamination can lead to system malfunction.
- 3. Purge with nitrogen when brazing** — Always purge the line with dry nitrogen gas during brazing to prevent oxidation and carbon buildup inside the tube.
- 4. Protect nearby components** — Shield valves, O-rings, and service ports from excessive heat during brazing.
- 5. Support and secure the line set** — Use proper hangers or clamps to prevent sagging or vibration. Avoid contact with walls or sharp edges.
- 6. Insulate properly** — Ensure full insulation coverage on suction lines. Seal around wall penetrations to prevent air leakage and condensation.
- 7. Follow manufacturer length limits** — Adhere to the specified maximum line length, vertical lift, and equivalent piping restrictions for system efficiency.
- 8. Perform leak and vacuum testing** — After installation, pressure-test with nitrogen and evacuate the system to the required vacuum level before charging refrigerant.
- 9. Commission the system** — Verify system pressures, temperatures, and operation. Record subcooling and superheat values where applicable.
- 10. Educate the end user** — Explain routine inspection and maintenance requirements, especially for insulation integrity and condensation control.

## SAFETY NOTICE

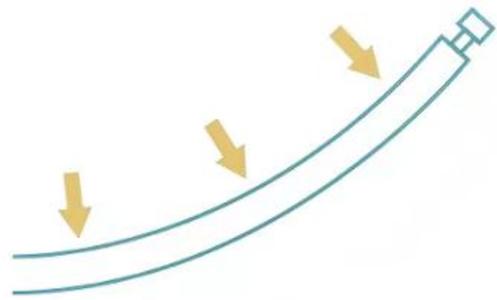
- Always wear protective gloves and eye protection when handling copper tubing.
- Do not install or modify line sets while the system is pressurized or energized.
- Dispose of any damaged tubing responsibly and in accordance with local regulations.

# COPPER LINE SET HANDLING & INSTALLATION INSTRUCTIONS



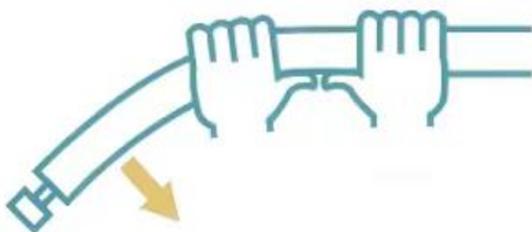
## Uncoiling the Tube

Pull from the outer layer to avoid twisting or flattening.



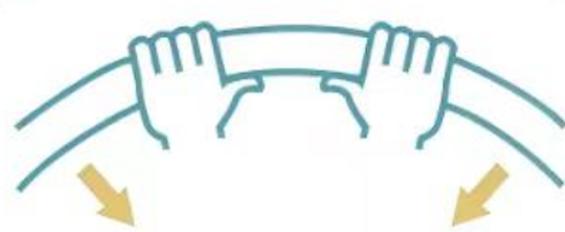
## Uncoiling Evenly

Uncoil gently and evenly — do not use excessive force.



## Correct Bending Direction

Bend toward the inner curve of the tube.



## Apply Even Force

Keep hands close and bend slowly with uniform pressure.



## Avoid Repeated Bending

Do not bend the same section more than once.



## Minimum Bend Radius

Do not bend tighter than 2.5 inches (60 mm).