

THERMACORE LINE SETS - INSTALLATION INSTRUCTIONS

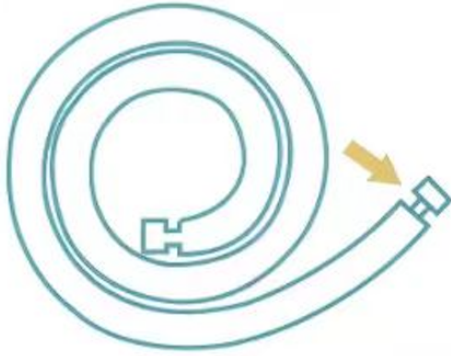
INSTALLATION BEST PRACTICES

- 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

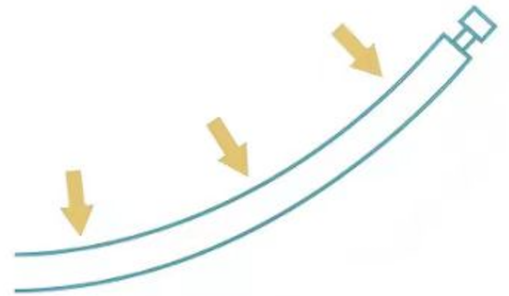
- Always wear protective gloves and eye protection when handling copper tubing.
- Do not install or modify line sets while the system is pressurized or energized.
- Dispose of any damaged tubing responsibly and in accordance with local regulations.

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).