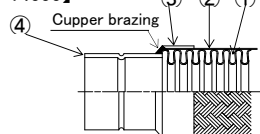


INSTALLATION PROCEDURE

1. Check before working

【Z-14000】



【Z-10000ZU】

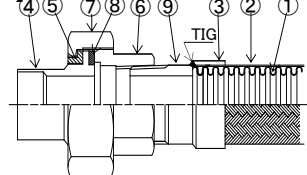
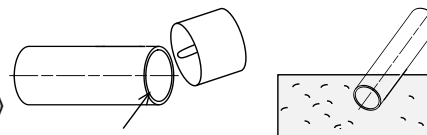


Table1 Parts list

Mark	Part name	Material
1	Bellows	SUS304
2	Braid	SUS304
3	Braid cover	SUS304
4	Union screw	SUS304
5	Insulator	Bakelite
6	Copper socket	C3601BD
7	Union nut	SUS304
8	Gasket	Rubber
9	Male screw	SUS304

- Check product size and length
- No damage and harm

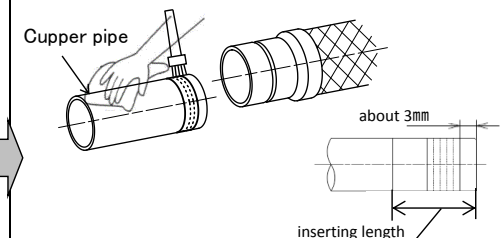
2. Chamfering pipe edge and cleaning



Chamfer the edge by tool

Copper pipe edge shall be treated round shape and edge chamfering by tool.
The contacting surface, pipe outer surface and inner surface of flexible joint end, shall be cleaned up by non-woven fabric or sand paper in order to get rid of oxide layer and dust. Finally wipe out by waste cloth.

3. Application flux 【Tap water, Hot water】

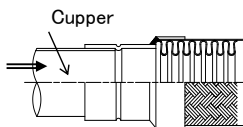


Evenly apply the flux on copper pipe end with keeping off 3mm from the edge in order not to entry the flux pipe inside.

Note : In case of air conditioning piping, it is not necessary to apply the flux.

4. Inserting pipe

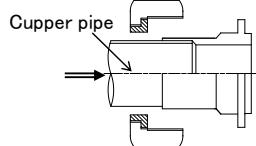
【Z-14000】



【In case of tap water and hot water piping】
Insert copper pipe into flexible joint end as soon as applying flux on surface, and rotate the joint for spreading flux.

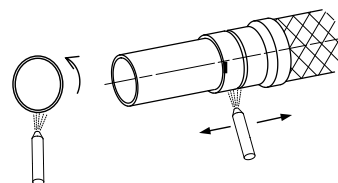
Note : It is strictly necessary to insert the pipe into the end of stopper rib.

【Z-10000ZU】



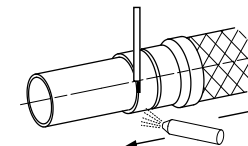
【In case of air conditioning piping】
Insert copper pipe into connector end of joint.

5. Pre-heating 【For air conditioning】



Pre-heat up the joint end and pipe around 600~650°C for making satisfactory brazing.

6. Soldering and brazing



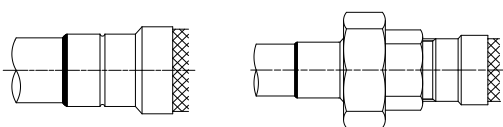
【In case of tap water and hot water piping】
Heat up the joint end and pipe around 280~300°C, and solder with keeping temperature.
【In case of air conditioning piping】
More heat up the joint and pipe end around 700~800°C and set filler metal for brazing with keeping temperature.

Note: Don't cool or move before brazing filler metal get hard.

Accomplishment

【Z-14000】

【Z-10000ZU】



6. Inspection & check



After finishing post handling, it is necessary to inspect and check visually.
Acceptance criteria : The followings are not accepted.

- No fillet
- Discontinuous fillet
- Pinhole
- Remaininf flux and oxide layer

7. Post handling

After brazing filler metal get completely hard, wipe the surface of connecting part by wet waste cloth so that the remaininf flux and oxide layer are gotten rid of.

Note: It is prohibited that the connecting part are rapidly cooled down by wet waste cloth before brazing filler metal getting hard.