

INSTRUCTIONS

DANFOSS SOLDER SLEEVE ADAPTER SETS

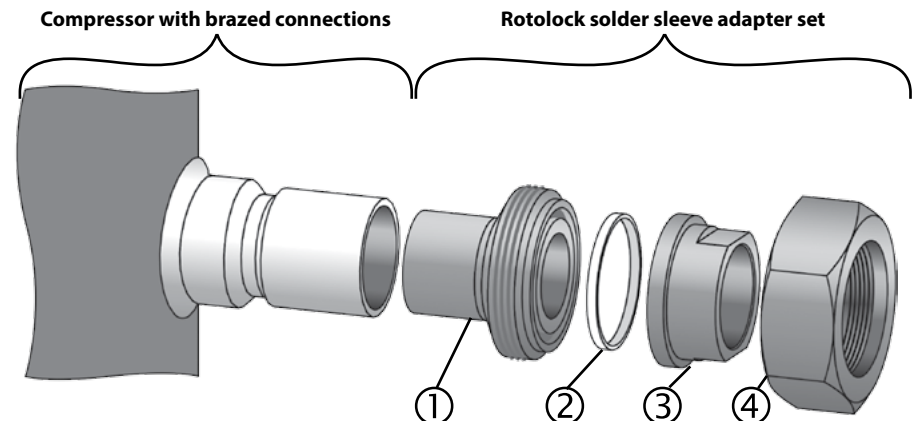
Introduction

Scroll compressors delivered with brazed connections can be changed into rotolock or flange connections by using Danfoss solder sleeves adapter sets. This procedure describes how to assemble solder sleeve adapter sets into the system.

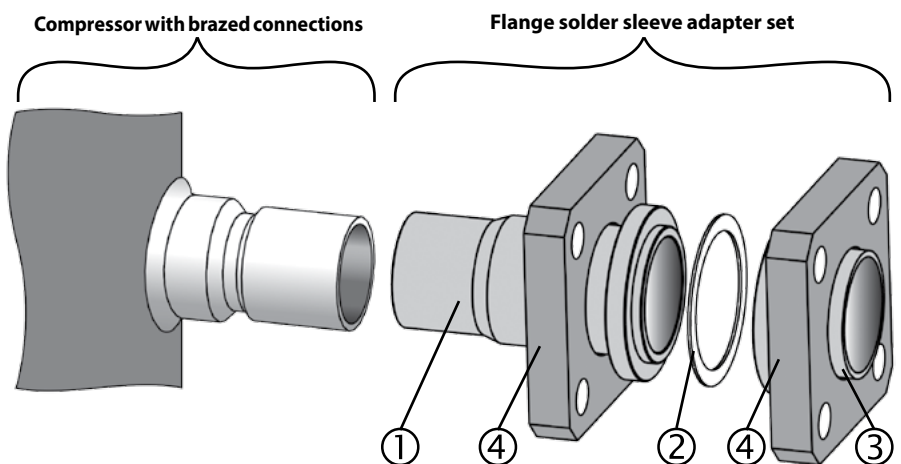
Solder sleeve adapter set composition

Solder sleeves adapter sets contains parts for brazed suction and discharge connexions to be changed into rotolock or flange (depending on the size).

- ①: Rotalock adapter
- ②: Gasket
- ③: Solder sleeve
- ④: Rotalock nut



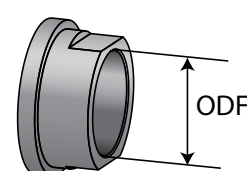
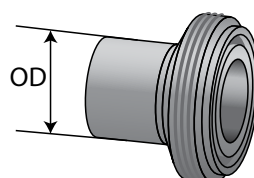
- ①: Flange adapter
- ②: Gasket
- ③: Solder sleeve
- ④: Flange



Solder sleeve adapter set selection

| Code n° | Description | Application | Packaging | Pack size |
|----------|--|--|-------------|-----------|
| 7765005 | Solder sleeve adapter set (1"3/4 Rotalock, 1"1/8 ODF), (1"1/4 Rotalock, 3/4" ODF) | SM084.090.100 & SZ084.090.100 | Multipack | 6 |
| 120Z0125 | Solder sleeve adapter set (1"3/4 Rotalock, 1"1/8 ODF), (1"1/4 Rotalock, 7/8" ODF) | SH090 & WSH090, PSH019, VSH088 & VZH088.117 | Multipack | 8 |
| 7765006* | Solder sleeve adapter set (1"3/4 Rotalock, 1"3/8 ODF), (1"1/4 Rotalock, 7/8" ODF) | SM110.112.120.124.147.148.161 & SZ110.120.148.161 & SH105.120.140.161.184 & WSH105.120.140.161.184, PSH023.026.030.034.039, VSH117 | Multipack | 8 |
| 120Z0405 | Solder sleeve adapter set (1"3/4 Rotalock, 1"3/8 ODF), (1"1/4 Rotalock, 7/8" ODF) | SM/SY/SZ160.175.185.240.300 & SH180.240.300.295.380 & PSH038.051.064.077 & VSH170 & VZH170 | Multipack | 6 |
| 7765028 | Solder sleeve adapter set, (2"1/4 Rotalock, 1"5/8 ODF), (1"3/4 Rotalock, 7/8" ODF) | SM/SY/SZ160.175.185.240.300 & SH180.240.300.295.380 & PSH038.051.064.077 & VSH170 & VZH170 | Multipack | 6 |
| 120Z0317 | Solder sleeve adapter set, (Flange, 2"1/8 ODF), (1"3/4 Rotalock, 1"3/8" ODF) | SY/Z380 | Single pack | 1 |
| 120Z0504 | Solder sleeve adapter set, (2"1/8 Rotalock, 1"5/8 ODF), (1-3/4" Rotalock, 1"3/8 ODF) | SH485 | Single pack | 1 |
| 120Z0126 | Solder sleeve adapter set (1"1/4 Rotalock, 3/4" ODF), (1" Rotalock, 1/2" ODF) | HRM032-042, HRP034-042, HRH029-038 & HHP015-019-021-026 & MLZ015-019-021-026 | Multipack | 6 |
| 120Z0127 | Solder sleeve adapter set (1"1/4 Rotalock, 7/8" ODF), (1" Rotalock, 1/2" ODF) | HRM045-060, HRP045-060, HLM068-075, HLP068-075, HRH040-056, HLH061-068, HLJ072-083, HHP030-038-045, MLZ030-038-042-045 | Multipack | 6 |
| 120Z0128 | Solder sleeve adapter set (1"1/4 Rotalock, 7/8" ODF), (1"1/4 Rotalock, 3/4" ODF) | HLM078-81, HLP078-081 & MLZ048 | Multipack | 6 |
| 120Z0129 | Solder sleeve adapter set (1"3/4 Rotalock, 1"1/8 ODF), (1"1/4 Rotalock, 7/8" ODF) | HCM094-120, HCP094-120, HCJ090-120 & MLZ058-066-076 | Multipack | 6 |

* : Diameter restriction



Instructions

Installation instructions

1. Make sure that no electrical wiring is connected to the compressor.
2. The compressor fitting plugs shall be removed just before brazing the compressor. When brazing the compressor fittings, do not overheat the compressor shell which could damage certain internal components. Use of a heat shield and/or heat-absorbent compound is highly recommended.
3. Place the rotolock adapter (part N° 1) on the suction or discharge port on the compressor.
4. Braze (part N°1) with an adequate silver content brazing material (5% or more) and anti-oxidant flux.
5. Insert the rotolock nut (part N° 4) onto the refrigerant circuit piping.
6. Braze the solder sleeve (part N°3) onto the refrigerant circuit piping with an adequate silver content brazing material (5% or more) and anti-oxidant flux.
7. Place the gasket (part N° 2) on the rotolock adapter (part N°1).
8. Tighten the rotolock nut (part N° 4) holding the sleeve (part N° 3) with an opened spanner to prevent piping distortion and gasket (part N°2) deterioration.

Apply the following torque:

| Rotolock connections | Tightening torque | |
|----------------------|-------------------|--------|
| | N.m | lbf.ft |
| 1" rotolock | 80 | 59 |
| 1 1/4" rotolock | 90 | 66 |
| 1 3/4" rotolock | 110 | 81 |
| 2 1/4" rotolock | 130 | 96 |