

Read through this
 installation Manual
 before installing

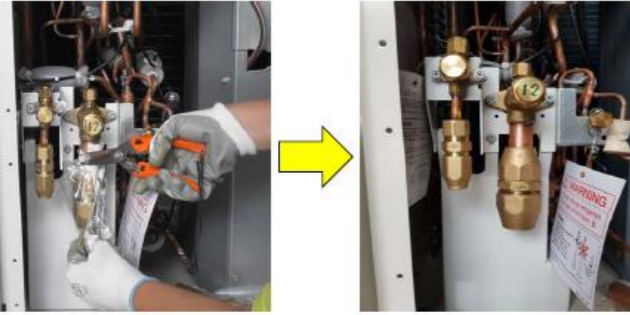


The case which may cause dangerous situation such as injury or minor injury, at the same time, it may cause properly damage when mis-operated.

- In case of insufficient nut tightening, it may cause pipes to come off.
- Excessive tightening is prohibited.
- Tighten the nut completely using the same level of torque as the level which is sufficient to overcome the pawls.
- Before using the tools, be sure you understand how to use them correctly.

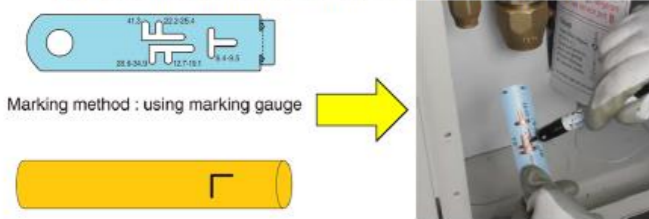
1 Removal of plastic covers:

- Cut the cable ties of both DGT joints and remove the plastic covers.

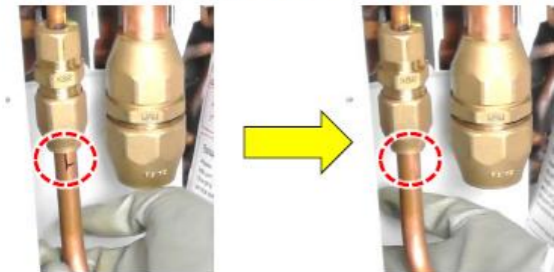


2 Installation of Discharge pipe:

- 1) Mark the 'L' standard insertion line with DGT marking gauge at proper position, according to the pipe size.



- 2) Insert the pipe into the DGT joint and push it in until the 'L' standard line cannot be seen.



- 3) Tighten the nut by hand and complete the tightening using 2 spanners. Ensure that the GREEN indicator on the DGT joint is hidden.



3 Installation of Suction pipe:

- 1) Take out the elbow pipe from the accessories bag.



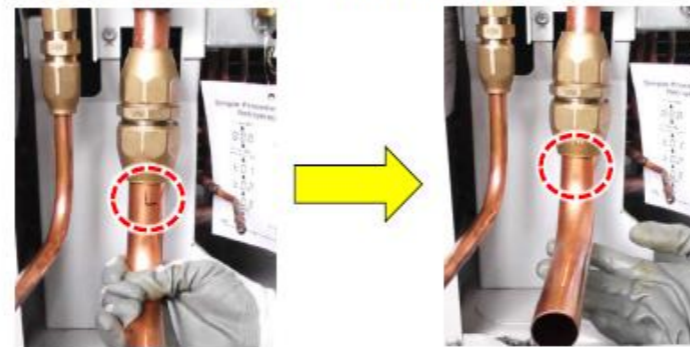
- 2) Mark the 'L' standard insertion line with DGT marking gauge, at the proper position, according to the pipe size.



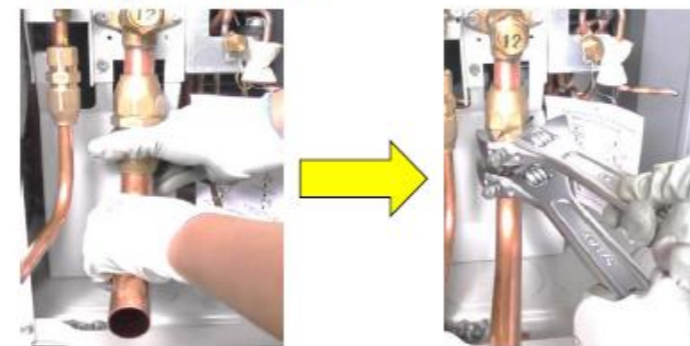
Marking method : using marking gauge



- 3) Insert the pipe into the DGT joint and push it in until the 'L' standard line cannot be seen.



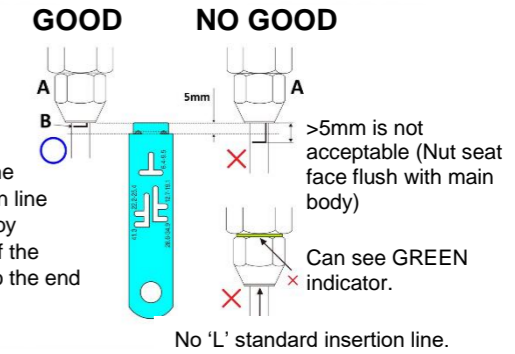
- 4) Tighten the nut by hand and complete the tightening using 2 spanners. Ensure that the GREEN indicator on the DGT joint is hidden.



4 Checking the completion:

- A: GREEN indicator on the DGT joint should be hidden
- B: Check if the 'L' standard insertion line is visible and within 5mm from end face of the nut.

The position of the standard insertion line can be checked by putting the end of the marking gauge to the end of the nut.

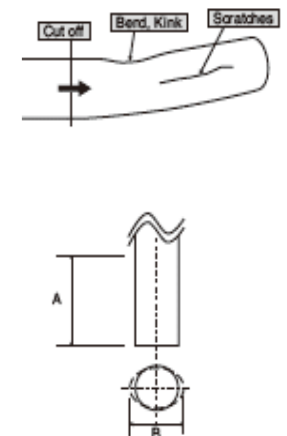


Check the pipe appearance.

- 1) If there are scratches, bends, kinks or ovals of thermal aging of the insert part, cut them off.
- 2) If there are foreign objects, burrs inside of pipe, remove them.
- 3) To remove things attached to the surface of the copper pipe, polish the surface of the pipe until shiny with an abrasive cloth of grade #400 or higher in the cylindrical direction.
- 4) For the piping minimum insertion allowance dimension and the maximum long axis side dimension for piping which has been slightly flattened, be sure to follow the dimensions in table 2.

Table 2: Minimum insertion allowance and maximum long axis side dimension for piping.

Model	Size (OD)	A. Piping minimum insertion allowance (mm)	B. Maximum long axis side dimension (mm)
BDGTA06	Ø6.35	21.6	6.40
BDGTA09	Ø9.52	21.6	9.65
BDGTA12	Ø12.7	37.4	12.85
BDGTA15	Ø15.88	37.4	15.95
BDGTA19	Ø19.05	37.4	19.15
BDGTA22	Ø22.22	41.4	22.25
BDGTA28	Ø28.58	45.2	28.65
BDGTA34	Ø34.92	44.5	34.95
BDGTA41	Ø41.28	46.3	41.35
BDGTA1209	Ø12.7- Ø9.52	Ø9.52	21.6
		Ø12.7	37.4
BDGTA1512	Ø15.88- Ø12.7	Ø12.7	37.4
		Ø15.88	37.4
		Ø19.05	37.4
BDGTA2219	Ø22.22- Ø19.05	Ø22.22	41.4
		Ø19.05	37.4
BDGTA2825	Ø28.58- Ø25.4	Ø25.4	41.4
		Ø28.58	45.2

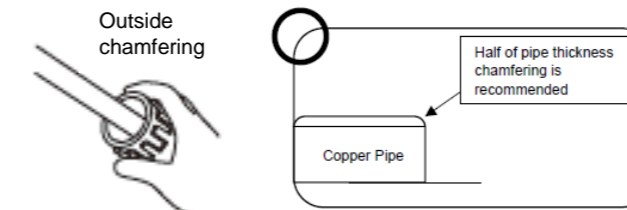


The acceptance limit of the pipe bend and ovality is that pipe can be inserted to the GAS TIGHT JOINT without force.

WARNING Never scratch pipe sections horizontally, as they may cause refrigerant leakage.

Chamfering of pipe before inserting to DGT.

- 1) Outside chamfering / Chamfer about 0.5 C
- 2) Inside chamfering / Deburr the inner part



CAUTION If no chamfering of the outside of the pipe is performed. The O-ring would be damaged and cause leakage. Carry out chamfering with the pipe pointing downward, in order to prevent foreign objects from entering the