

1. Make sure the pump oil does not flow oppositely into the system while the pump is not working.
2. Use a vacuum pump which can evacuate to -14.6 psi.

6-1 Selection of piping material

1. Foreign materials inside pipes (including oils for fabrication) must be 0.14g/100ft. or less.
2. Use the following material specification for refrigerant piping:
 - construction material: Phosphoric acid decoxidized seamless copper for refrigerant.

6-2 Protection of piping

- + Protect the piping to prevent moisture and dusts from coming into the piping.
- + Especially, pay attention when passing the piping through a hole or connecting the end of piping to the outdoor.

Location	Working period	Protection method
Outdoor	1 month or more	Pinch pipes
Indoor	Less than 1 month Regardless of period	Pinch or tape pipes

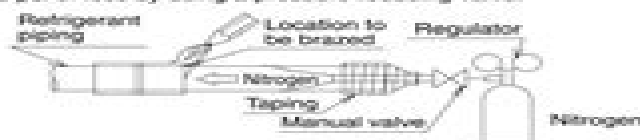
6-3 Piping connection

- For handling of stop valves, refer to "Stop valve operation method" in "5-7 Additional refrigerant charge".
- Only use the flare nuts attached to the stop valves. Using different flare nuts may cause the refrigerant to leak.
- Be sure to perform a nitrogen blow when brazing.

(Brazing without performing nitrogen replacement or releasing nitrogen into the piping will create large quantities of oxidized film inside the pipes, adversely affecting valves and compressor in the refrigerating system and preventing normal operation.)

- Use of oxygen could cause an explosion resulting in severe injury or death. Only use nitrogen gas.
- Refrigerant gas may produce toxic gas if it comes in contact with fire such as from a fan heater, stove or cooking device. Exposure to this gas could cause severe injury or death.

- + When brazing with blowing nitrogen, set the nitrogen pressure to 2-3 psi or less by using a pressure reducing valve.

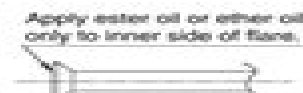


- Do not use anti-oxidants when brazing.
Residue can clog pipes and break the unit.
- Do not let any refrigerant other than the specified refrigerant enter the refrigerant system.
- Do not let any gas such as air enter the refrigerant system.

(Precautions when connecting the piping)

- See the following table for flare nut dimensions.
- When connecting the flare nuts, apply refrigerant oil to the inside and outside of the flares and turn them three or four times at first. (Use ester oil or ether oil.)
- See the following table for tightening torque. (Applying too much torque may cause the flares to crack.)
- After connecting all the piping perform a gas leak check by using nitrogen.

Pipe size	Tightening torque (N·m)	Flange dimension A (in.)	Flange shape (in.)
ø3/8"	26.7±2.6	0.504 - 0.520	
ø5/8"	50.6±5.0	0.760 - 0.776	



- If you are obliged to install the unit without a torque wrench, you may follow the installation method mentioned below.
After the work is finished, make sure to check that there is no gas leak.
- When you keep on tightening the flare nut with a spanner, there is a point where the tightening torque suddenly increases.
From that position, further tighten the flare nut the angle shown below.

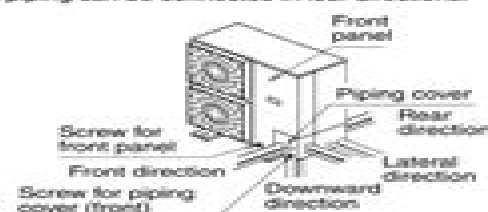
Pipe size	Tightening angle (Guideline)	Recommended arm length of tool (in.)
ø 3/8"	60° - 90°	Approx. 7 7/8
ø 5/8"	30° - 60°	Approx. 11 13/16

Disposal requirements

Dismantling of the unit, treatment of the refrigerant, oil and eventual other parts should be comply the relevant local and national regulations.

6-4 Refrigerant piping work procedure

- The field piping can be connected in four directions



- When connecting the piping downward, remove the knockout hole by making four holes in the middle on the each side of the knockout hole with a drill.



Then cut out the corner of the bottom frame along the slits (in two positions) by using a hacksaw.

- After removing the parts, it is recommended to apply repair paint on the edges, to prevent rusting.

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Table of Contents Installation Manual Daikin Rzq

1. Understanding the eBook Installation Manual Daikin Rzq
 - The Rise of Digital Reading Installation Manual Daikin Rzq
 - Advantages of eBooks Over Traditional Books
2. Identifying Installation Manual Daikin Rzq
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Installation Manual Daikin Rzq
 - User-Friendly Interface
4. Exploring eBook Recommendations from Installation Manual Daikin Rzq
 - Personalized Recommendations

- Installation Manual Daikin RZq User Reviews and Ratings
- Installation Manual Daikin RZq and Bestseller Lists
- 5. Accessing Installation Manual Daikin RZq Free and Paid eBooks
 - Installation Manual Daikin RZq Public Domain eBooks
 - Installation Manual Daikin RZq eBook Subscription Services
 - Installation Manual Daikin RZq Budget-Friendly Options
- 6. Navigating Installation Manual Daikin RZq eBook Formats
 - ePub, PDF, MOBI, and More
 - Installation Manual Daikin RZq Compatibility with Devices
 - Installation Manual Daikin RZq Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Installation Manual Daikin RZq
 - Highlighting and Note-Taking Installation Manual Daikin RZq
 - Interactive Elements Installation Manual Daikin RZq
- 8. Staying Engaged with Installation Manual Daikin RZq
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Installation Manual Daikin RZq
- 9. Balancing eBooks and Physical Books Installation Manual Daikin RZq
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Installation Manual Daikin RZq
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Installation Manual Daikin RZq
 - Setting Reading Goals Installation Manual Daikin RZq
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Installation Manual Daikin RZq
 - Fact-Checking eBook Content of Installation Manual Daikin RZq

- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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