

# 11 Flaring

- Cut pipe with a sharp tube cutter
- Deburr & clean out shavings
- Flare with quality tool
- Set depth properly for good flange
- Make sure nut pulls easily over flange not scraping threads. Too big and it will leak.
- Place a thin film of correct refrigerant oil on male bevel.
- Hand tighten keeping line straight.
- Tighten correctly using a torque wrench according to the, "Tightening torque" chart.

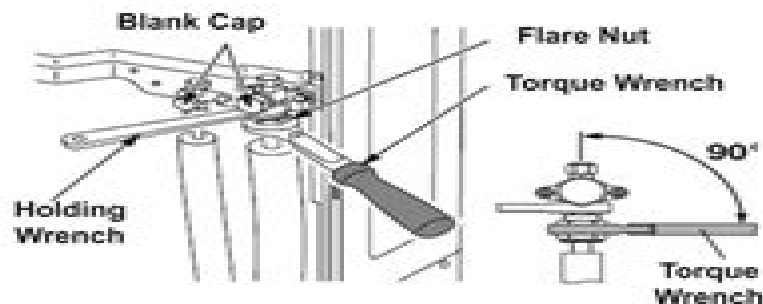


Pipe outside diameter in.(mm)	Dimension A in. (mm)	Dimension B in. (mm)
	Flare tool for R410A, clutch type	
1/4 (6.35)	0 to 0.0197 (0 to 0.5)	23/64 (9.1)
3/8 (9.52)		33/64 (13.2)
1/2 (12.7)		21/32 (16.6)
5/8 (15.88)		25/32 (19.7)

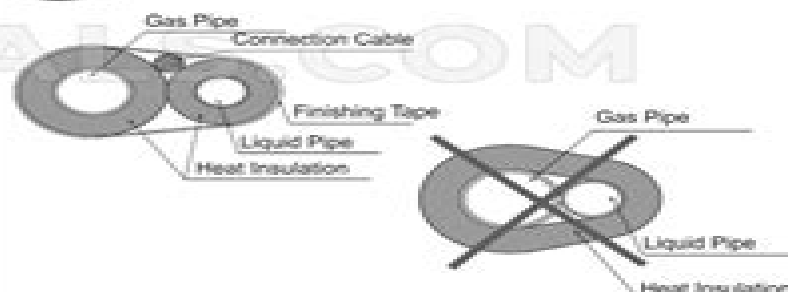
# 12 Pipe Size Torque

**Flare nut (lbf)  
Tightening torque**  
1/4 - 16 to 18  
3/8 - 32 to 42  
1/2 - 49 to 61  
5/8 - 63 to 75

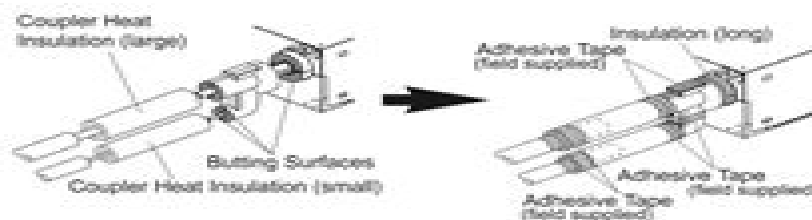
**Flare nut (N-m)  
Tightening torque**  
6.35 - 142 to 159  
9.52 - 283 to 372  
12.70 - 434 to 540  
15.88 - 558 to 664



# 13 Insulation



**All refrigerant pipes and connections  
MUST BE INSULATED SEPARATELY**



# Fujitsu Aou48rlxfz Installation Manual

**M Tight**



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## **Table of Contents Fujitsu Aou48rlxfz Installation Manual**

1. Understanding the eBook Fujitsu Aou48rlxfz Installation Manual
  - The Rise of Digital Reading Fujitsu Aou48rlxfz Installation Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Fujitsu Aou48rlxfz Installation Manual
  - 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 Fujitsu Aou48rlxfz Installation Manual
  - User-Friendly Interface
4. Exploring eBook Recommendations from Fujitsu Aou48rlxfz Installation Manual
  - Personalized Recommendations
  - Fujitsu Aou48rlxfz Installation Manual User Reviews and Ratings
  - Fujitsu Aou48rlxfz Installation Manual and Bestseller Lists
5. Accessing Fujitsu Aou48rlxfz Installation Manual Free and Paid eBooks
  - Fujitsu Aou48rlxfz Installation Manual Public Domain eBooks

- Fujitsu Aou48rlxfz Installation Manual eBook Subscription Services
- Fujitsu Aou48rlxfz Installation Manual Budget-Friendly Options
- 6. Navigating Fujitsu Aou48rlxfz Installation Manual eBook Formats
  - ePub, PDF, MOBI, and More
  - Fujitsu Aou48rlxfz Installation Manual Compatibility with Devices
  - Fujitsu Aou48rlxfz Installation Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Fujitsu Aou48rlxfz Installation Manual
  - Highlighting and Note-Taking Fujitsu Aou48rlxfz Installation Manual
  - Interactive Elements Fujitsu Aou48rlxfz Installation Manual
- 8. Staying Engaged with Fujitsu Aou48rlxfz Installation Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Fujitsu Aou48rlxfz Installation Manual
- 9. Balancing eBooks and Physical Books Fujitsu Aou48rlxfz Installation Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Fujitsu Aou48rlxfz Installation Manual
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Fujitsu Aou48rlxfz Installation Manual
  - Setting Reading Goals Fujitsu Aou48rlxfz Installation Manual
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Fujitsu Aou48rlxfz Installation Manual
  - Fact-Checking eBook Content of Fujitsu Aou48rlxfz Installation Manual
  - 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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