

# 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)

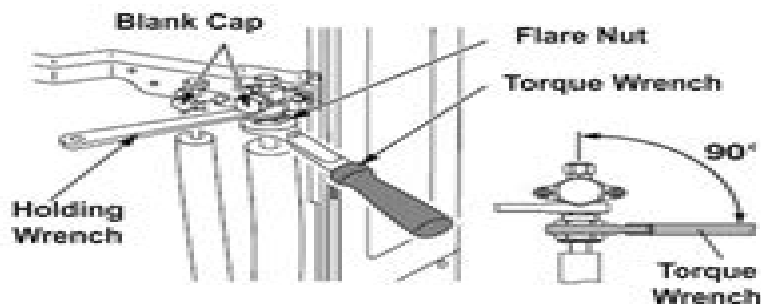
# 12 Pipe Size Torque

**Flare nut (lbf)  
Tightening torque**

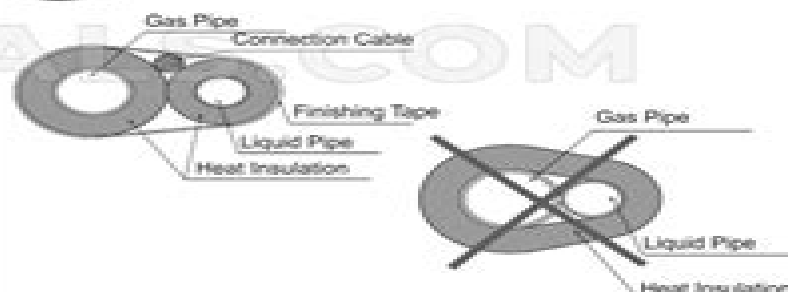
1/4 - 16 to 18  
3/8 - 32 to 42  
1/2 - 49 to 61  
5/8 - 63 to 75

**Flare nut (N-m)  
Tightening torque**

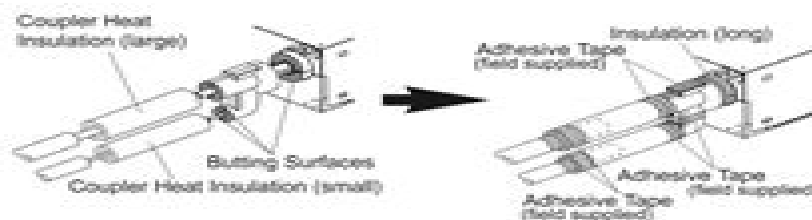
6.35 - 142 to 159  
9.52 - 283 to 372  
12.70 - 434 to 540  
15.88 - 558 to 664



# 13 Insulation



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



# Fujitsu Aou48rlxfz Installation Manual

**S Ashworth**



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