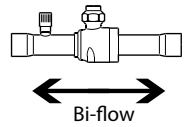


Instruction GBC Ball Valve Brazing Instructions



009R9508

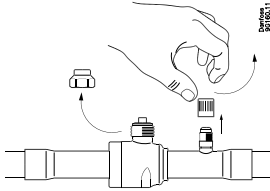
009R9508



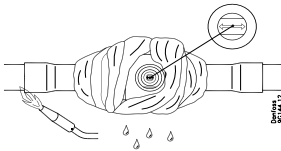
Temperature range:
-40°C → 150°C
(-40°F → 300°F)

PS/MWP = 45 bar (650 psig)

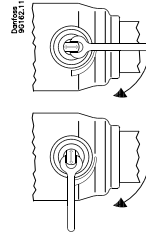
Applicable to all common non-flammable refrigerants, excluding R717 and to non-corrosive gases/liquids dependent on sealing material compatibility. The design pressure shall not be less than the value outlined in Section 9.2 of ANSI/ASHRAE 15 for the refrigerant used in the system.



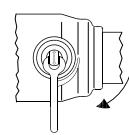
Remove cap and access cap (if present)



Fully soaked
OPEN position

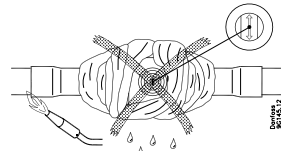


Open

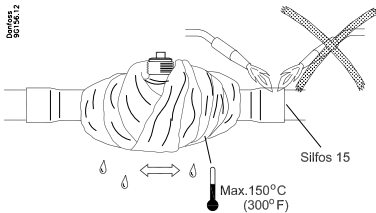


Closed

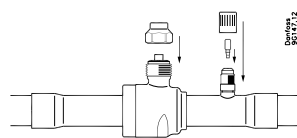
Change stem direction to open position



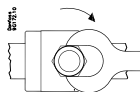
CLOSED position



Max. 150°C
(300°F)



Install Schraeder valve and cap (if present)



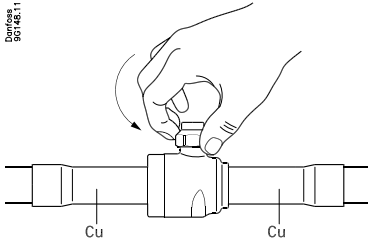
Tighten

Tighten the cap with approx. torque

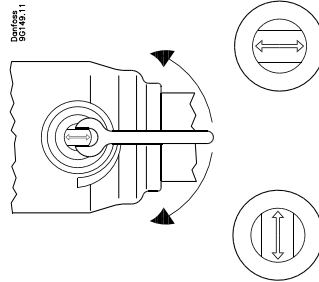
Valve size	6 ~ 22s	25 ~ 35s	42 ~ 79s
Torque	15 Nm	20 Nm	32 Nm

1. Brazing should be operated by qualified skilled technician.
2. The most important is to prevent overheating valve body when brazing, otherwise **the heat may damage the O-ring and cause leak**. The process should be finished within 1 min. or a few seconds.
3. Never keep the flame towards the valve body.
4. We recommend Apply N₂ in the tube when brazing
5. De-pressurize the system before operation. (May result in bodily injury).
6. After finishing brazing, cover another soaked cloth to the joint to cool it down.
7. Final leakage check.

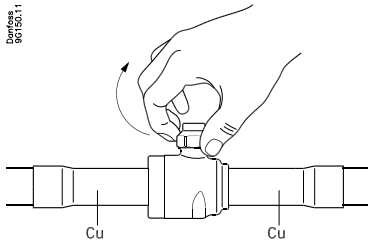
Open / close valves



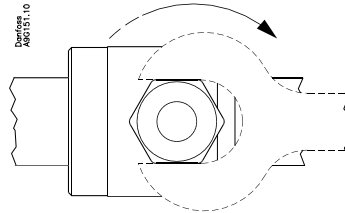
Remove cap



Change stem direction

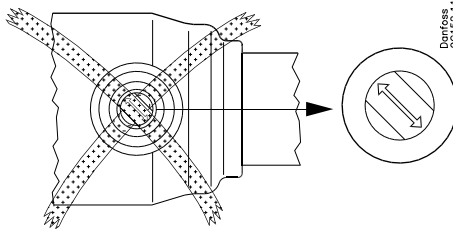


Hand tighten cap



Tighten

Tighten the cap with a torque which should be increased time to time to ensure a good seal.



**Ball valve must always be in either
FULLY OPEN or
FULLY CLOSED position**

Open/Close stem with the Max. torque

Valve size	6 ~ 16s	18 ~ 22s	25 ~ 28s	32 ~ 35s	38 ~ 54s	67 ~ 79sRP	67 ~ 79s
Max. Torque	7 Nm	7 Nm	17 Nm	20 Nm	34 Nm	34 Nm	60 Nm

