

United Technologies

REINFORCEMENT SHELLS for 30XW discharge line

June 2019

Warning: Do not perform any of the servicing instructions provided in this instruction unless you are a trained and qualified technician. Observe all precautions in the instructions, equipment tags, labels and observe all other safety precautions that may apply. Failure to follow this warning could result in property damage, personal injury or death.

REINFORCEMENT SHELLS

Prepare the material

Prepare the surfaces

Shell gluing

Shell assembly and screwing

Check the material & assemble glue gun

Proceed with the circuit one by one

This material list is given for 1 circuit: 2 entire shells are needed around the discharge T

00PSG003364400-
Abrasive paper

Glue tube
Mixer

4 ½ shells
12 screws
12 nuts
2 pliers

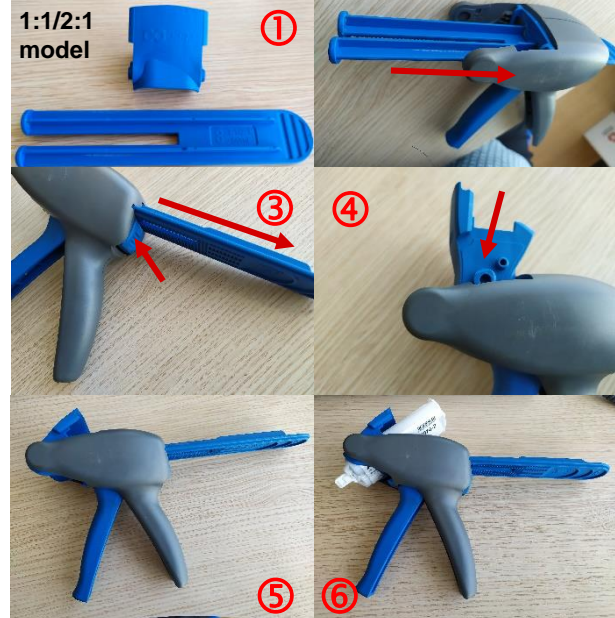


00PSG003364500-
Glue gun



Glue gun assembly

1:1/2:1
model



You will also need:

- Degreasing cleaner
- Abrasive brush (optional - instead of abrasive paper if you have)

REINFORCEMENT SHELLS

Prepare the material
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Shell gluing
Shell assembly and screwing

Prepare the piping and shell surfaces

Stop the circuit starting this operation. The procedure can be applied either on hot or cold line

- Take care of the line hot temperature when operating

Erase brazing overlap with rotative brush or abrasive paper to get flat rounded surface



Erase all the painting on the steel pipe until the shoulder



Apply a half shell on the piping to make sure here is no roughness left



Degrease :

- the copper and steel pipe
- the internal of the shells



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Shell gluing

Put a mark on the shell to highlight the steel pipe edge, it will ease the positioning afterwards

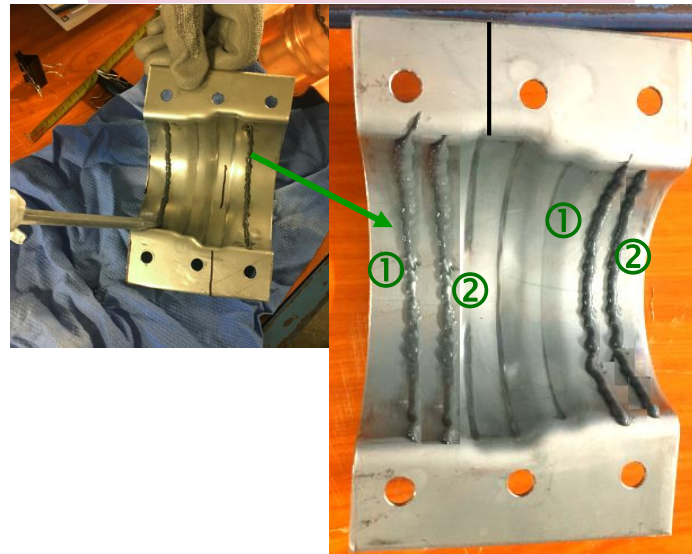


The brazing fillet should be located within the shell groove.

Remove the adhesive cap (rotate), replace with the adhesive mixer



Apply 2 lines of glue on each sides of the half shells



REINFORCEMENT SHELLS

Prepare the material
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Shell assembly and screwing

Position 1 half shell on the discharge line matching the marks



Position the 2nd half shell and use the pliers to get them tight



Position all the screws and tighten them in a crossing way



Screw until the nuts are hardly tightened as well as the edges of the shell



Now you can clean the excess of glue and start the circuit, the glue takes 30 minutes to harden with 60°C discharge temperature (or 8h with stopped unit at 23°C)

Repeat the operation for the second side of the discharge T