



# How To Process Tubing - Sanyo ECO R410A Installation Instructions Manual

Eco-i system air conditioner



1

2

3

Table Of Contents

4

5

6

7

8

9

10

11

12

13

14

15

16

17

18  
19  
20  
21  
22  
23  
24  
25  
26  
27  
28  
29  
30  
31  
32  
33  
34  
35  
36  
37  
38  
39  
40  
41  
42  
43  
44  
45  
46  
47  
48

--

•

[Table of Contents](#)

- 

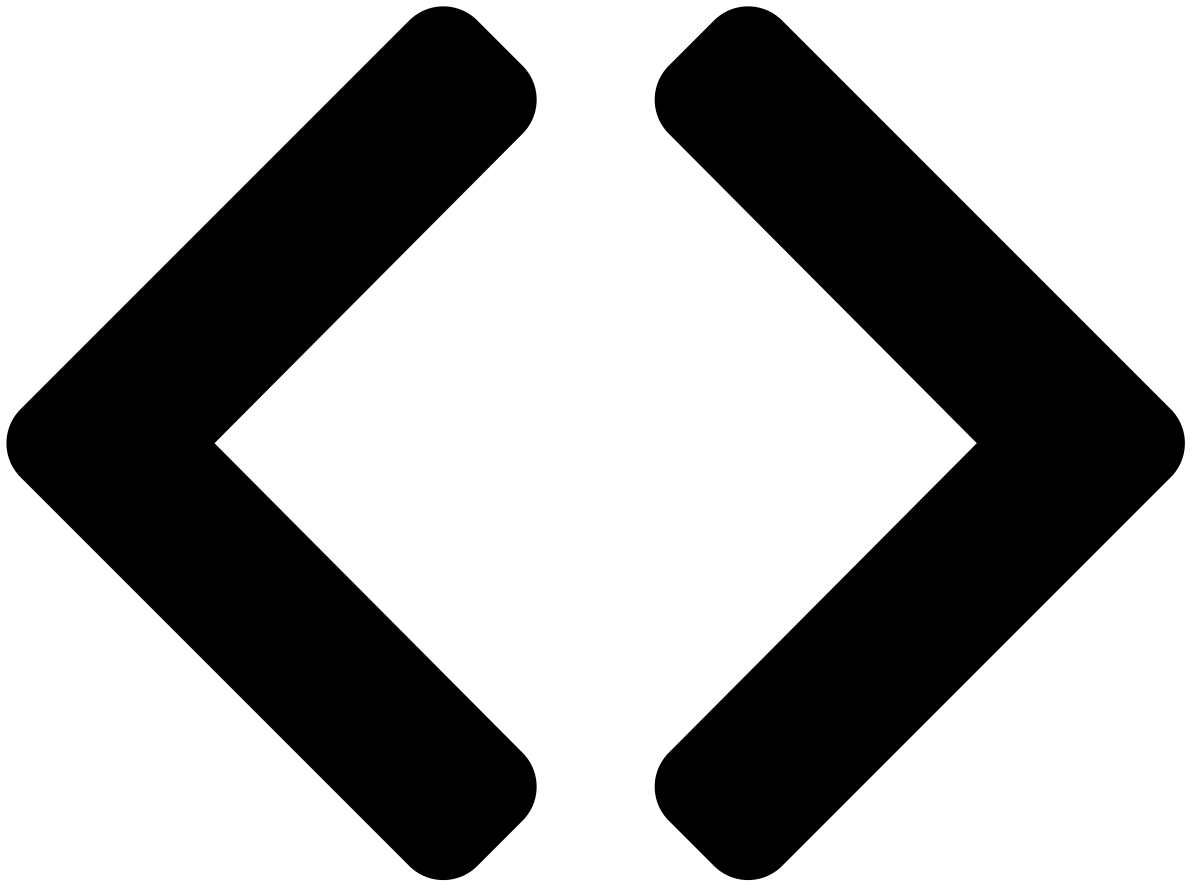
Troubleshooting

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## Bookmarks







Enlarged version

## 5. HOW TO PROCESS TUBING

The liquid tubing side is connected by a flare nut, and the gas tubing side is connected by brazing.

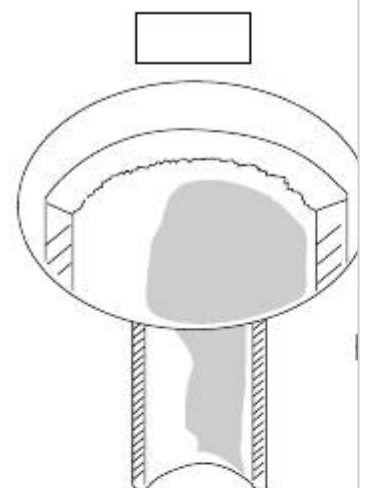
### 5-1. Connecting the Refrigerant Tubing

#### Use of the Flaring Method

Many of conventional split system air conditioners employ the flaring method to connect refrigerant tubes which run between indoor and outdoor units. In this method, the copper tubes are flared at each end and connected with flare nuts.

#### Flaring Procedure with a Flare Tool

(1) Cut the copper tube to the required length with a tube cutter. It is recommended to cut approx. 1 - 2 ft.



longer than the tubing length you estimate.

(2) Remove burrs at the end of the copper tube with a tube reamer or file. This process is important and should be done carefully to make a good flare.

(Fig. 5-1)

When reaming, hold the tube end downward and be sure that no copper scraps fall into the tube. (Fig. 5-2)

(3) Remove the flare nut from the unit and be sure to mount it on the copper tube.

(4) Make a flare at the end of copper tube with a flare tool. (Fig. 5-3)

A good flare should have the following characteristics:

- inside surface is glossy and smooth
- edge is smooth
- tapered sides are of uniform length

Before

Flare tool

**39**

### Deburring

After

### Fig. 5-1

Copper

tubing

Reamer

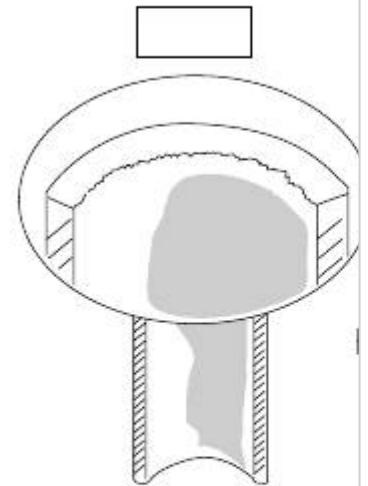
### Fig. 5-2

Flare nut

### Fig. 5-3

Copper

tubing



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[Table of Contents](#)

[Previous Page](#)  
[Next Page](#)

1  
...  
36  
37  
38  
39  
40  
41  
42  
43

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[Indoor Unit](#)

[Installing the Drain Piping](#)

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