

# INSTRUCTIONS

## DANFOSS SOLDER SLEEVE ADAPTER SETS

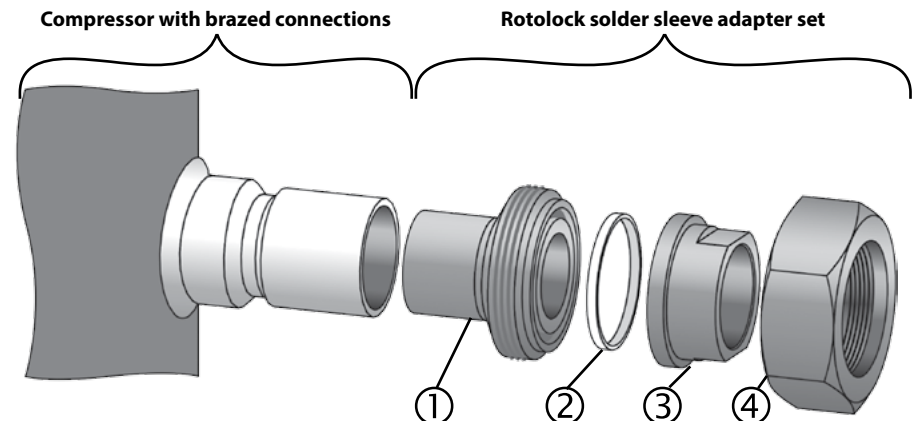
### Introduction

Scroll compressors delivered with brazed connections can be changed into rotolock or flange connections by using Danfoss solder sleeves adapter sets. This procedure describes how to assemble solder sleeve adapter sets into the system.

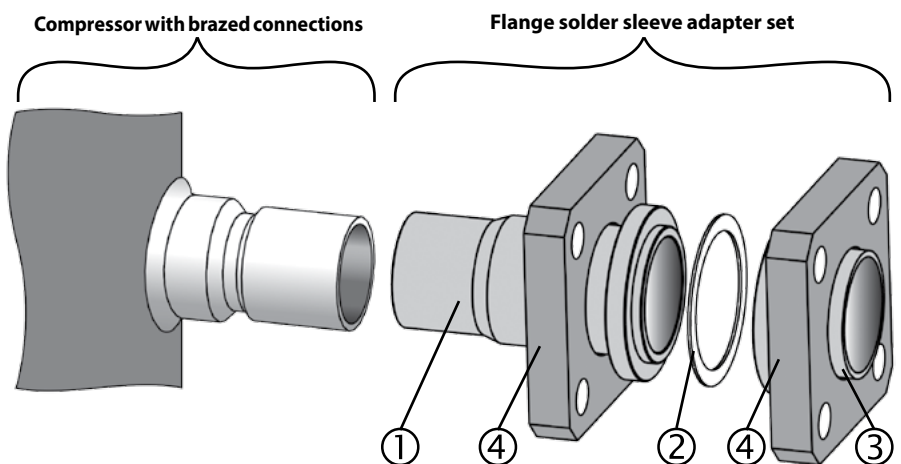
### Solder sleeve adapter set composition

Solder sleeves adapter sets contains parts for brazed suction and discharge connexions to be changed into rotolock or flange (depending on the size).

- ①: Rotalock adapter
- ②: Gasket
- ③: Solder sleeve
- ④: Rotalock nut



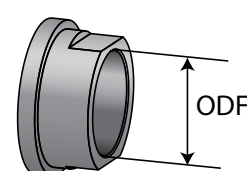
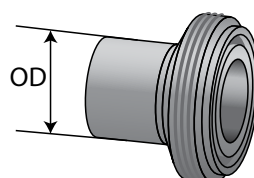
- ①: Flange adapter
- ②: Gasket
- ③: Solder sleeve
- ④: Flange



### Solder sleeve adapter set selection

Code n°	Description	Application	Packaging	Pack size
7765005	Solder sleeve adapter set (1"3/4 Rotalock, 1"1/8 ODF), (1"1/4 Rotalock, 3/4" ODF)	SM084.090.100 & SZ084.090.100	Multipack	6
120Z0125	Solder sleeve adapter set (1"3/4 Rotalock, 1"1/8 ODF), (1"1/4 Rotalock, 7/8" ODF)	SH090 & WSH090, PSH019, VSH088 & VZH088.117	Multipack	8
7765006*	Solder sleeve adapter set (1"3/4 Rotalock, 1"3/8 ODF), (1"1/4 Rotalock, 7/8" ODF)	SM110.112.120.124.147.148.161 & SZ110.120.148.161 & SH105.120.140.161.184 & WSH105.120.140.161.184, PSH023.026.030.034.039, VSH117	Multipack	8
120Z0405	Solder sleeve adapter set (1"3/4 Rotalock, 1"3/8 ODF), (1"1/4 Rotalock, 7/8" ODF)	SM/SY/SZ160.175.185.240.300 & SH180.240.300.295.380 & PSH038.051.064.077 & VSH170 & VZH170	Multipack	6
7765028	Solder sleeve adapter set, (2"1/4 Rotalock, 1"5/8 ODF), (1"3/4 Rotalock, 7/8" ODF)	SM/SY/SZ160.175.185.240.300 & SH180.240.300.295.380 & PSH038.051.064.077 & VSH170 & VZH170	Multipack	6
120Z0317	Solder sleeve adapter set, (Flange, 2"1/8 ODF), (1"3/4 Rotalock, 1"3/8" ODF)	SY/Z380	Single pack	1
120Z0504	Solder sleeve adapter set, (2"1/8 Rotalock, 1"5/8 ODF), (1-3/4" Rotalock, 1"3/8 ODF)	SH485	Single pack	1
120Z0126	Solder sleeve adapter set (1"1/4 Rotalock, 3/4" ODF), (1" Rotalock, 1/2" ODF)	HRM032-042, HRP034-042, HRH029-038 & HHP015-019-021-026 & MLZ015-019-021-026	Multipack	6
120Z0127	Solder sleeve adapter set (1"1/4 Rotalock, 7/8" ODF), (1" Rotalock, 1/2" ODF)	HRM045-060, HRP045-060, HLM068-075, HLP068-075, HRH040-056, HLH061-068, HLJ072-083, HHP030-038-045, MLZ030-038-042-045	Multipack	6
120Z0128	Solder sleeve adapter set (1"1/4 Rotalock, 7/8" ODF), (1"1/4 Rotalock, 3/4" ODF)	HLM078-81, HLP078-081 & MLZ048	Multipack	6
120Z0129	Solder sleeve adapter set (1"3/4 Rotalock, 1"1/8 ODF), (1"1/4 Rotalock, 7/8" ODF)	HCM094-120, HCP094-120, HCJ090-120 & MLZ058-066-076	Multipack	6

\* : Diameter restriction



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## Instructions

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### Installation instructions

1. Make sure that no electrical wiring is connected to the compressor.
2. The compressor fitting plugs shall be removed just before brazing the compressor. When brazing the compressor fittings, do not overheat the compressor shell which could damage certain internal components. Use of a heat shield and/or heat-absorbent compound is highly recommended.
3. Place the rotolock adapter (part N° 1) on the suction or discharge port on the compressor.
4. Braze (part N°1) with an adequate silver content brazing material (5% or more) and anti-oxidant flux.
5. Insert the rotolock nut (part N° 4) onto the refrigerant circuit piping.
6. Braze the solder sleeve (part N°3) onto the refrigerant circuit piping with an adequate silver content brazing material (5% or more) and anti-oxidant flux.
7. Place the gasket (part N° 2) on the rotolock adapter (part N°1).
8. Tighten the rotolock nut (part N° 4) holding the sleeve (part N° 3) with an opened spanner to prevent piping distortion and gasket (part N°2) deterioration.

Apply the following torque:

Rotolock connections	Tightening torque	
	N.m	lbf.ft
1" rotolock	80	59
1 1/4" rotolock	90	66
1 3/4" rotolock	110	81
2 1/4" rotolock	130	96