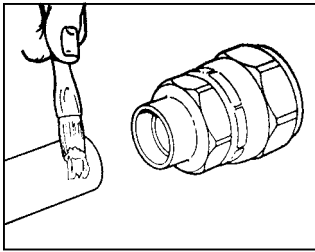
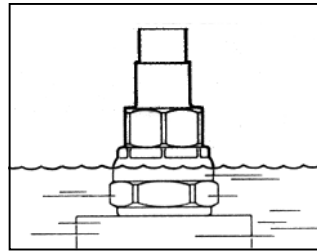


Factory Brazing Instructions



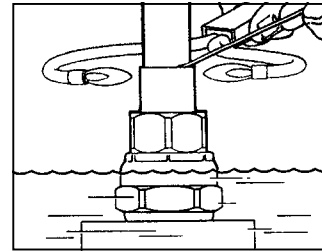
Step 1 Sparingly apply paste flux to the copper tube.

Note: Liquid flux or excessive flux can run inside the coupling and cause corrosion.

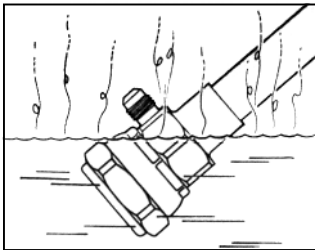


Step 2 Immerse the coupling (diaphragm end) into a flowing cool water bath.

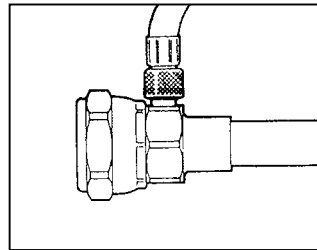
- 5780 and 57781 female halves: Water level should be halfway up the nut and the nut hex fully immersed.
- 5782 and 5783 male halves: Water level should fully cover the threads.



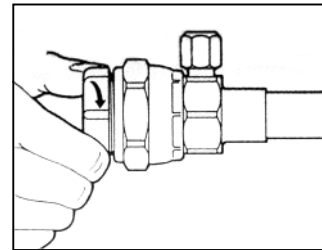
Step 3 Use a double tip torch to promote even heating and reduce braze time.



Step 4 After the alloy solidifies, quench the tubing and coupling to reduce the temperature below 400°F. Make sure the water does not enter the open charge port in the 5781 or 5783 half.



Step 5 The couplings can be subjected to unit test pressures up to 300 psig. If pressures in excess of 300 psig are used, the protector caps and plugs should be installed



Step 6 Protector caps and plugs should be installed finger tight. Overtightening can damage the diaphragm. The diaphragm and O-ring can be lubricated with refrigerant oil prior to installing the protector caps or plugs as added assurance of proper lubrication when connected at unit installation.

Male-Half Installation Procedure

Male half (5782) should be mounted with the hex on the inside of the unit held in place with the appropriate mounting flange. Sheet metal opening, screw hole diameter, and mounting bolt circle dimensions are included in the chart below.

Coupling Part Number	Coupling Hex Size	Recommended Sheet Metal Opening	Flange Part Number	Mounting Bolt Circle	Screw Hole Diameter
5782-Size-6	3/4"	0.656	5700-22-6	1.44	0.201
5782-Size-6	3/4"	0.656	5700-22-6	1.44	0.153
5782-Size-8	15/16"	0.969	FD67-1008-10	1.69	0.153
5782-Size-10	1-1/16"	1.094	FD67-1110-10	1.69	0.201
5782-Size-10	1-1/16"	1.094	FD67-1008-12	1.69	0.153
5782-Size-11	1-1/8"	1.156	150-22-8	1.69	0.201
5782-Size-11	1-1/8"	1.156	5700-22-10	1.69	0.153
5782-Size-12	1-7/16"	1.469	FD57-1110-12	2.12	0.201
5782-Size-12	1-7/16"	1.469	FD57-1111-12	2.12	0.153

All dimensions in inches.