

TURBOTEC PRODUCTS, INC.

TITLE: Technical Bulletin for Brazing Connections to Plastic-Jacketed Coils with Lokring® Fittings	DOCUMENT #: MFEP002	REV.: B	REV. DATE: 05/09/06	PAGE: 1 of 3
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PURPOSE

To describe the leak prevention method used during the brazing of connections to coils that have the following components (see Figure 1):

- Plastic jacket (coil outer tube).
- Lokring® fittings.

SCOPE

This document applies to plastic-jacketed Turbotec coils with Lokring® fittings.

RECOMMENDED PROCEDURE

1. Prepare for brazing by wetting several cloths with cold water.
2. In the heat zone (areas that will be exposed to heat during the brazing process), wrap the cold, wet cloths around the plastic jacket and Lokring® fitting (see Figure 2).
3. Braze connection (see Figure 3).
4. Cool the brazed connection with a cold, wet cloth to prevent any heat from the brazed connection traveling up the plumbing to the Lokring® fitting.
5. Remove cold, wet cloth wrapped around Lokring® fitting.
6. Wrap cold, wet cloth around second Lokring® fitting.
7. Braze connection.
8. Cool the brazed connection with a cold, wet cloth to prevent any heat from the brazed connection traveling up the plumbing to the Lokring® fitting.
9. Unwrap coil.

TECHNICAL INFORMATION

1. The Lokring® fitting/joint must always be kept at a temperature lower than 302° F.
2. Temperature testing should be performed to verify that the Lokring® fitting/joint is not being exposed to temperatures higher than 302° F during the brazing process.
3. A heat sink must be used on both the Lokring® fitting/joint and on the plastic jacket during the brazing process to protect both components.

CUSTOMER AGREEMENT

We have read and understand the above statements concerning the proper practices for brazing plastic-jacketed coils with Lokring® fittings:

Company Name

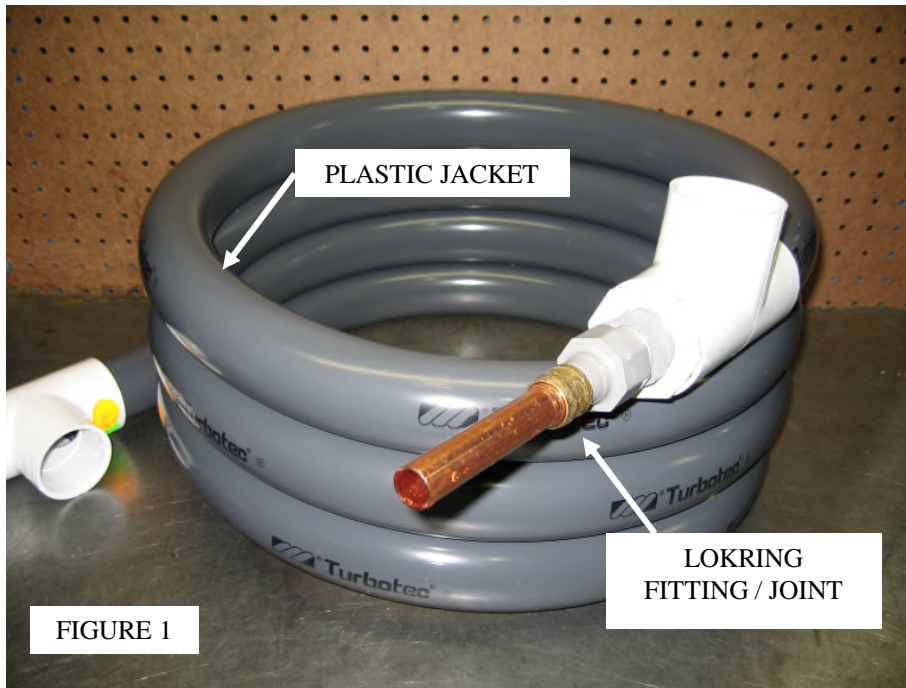
Company Representative

Date

AUTHOR: T. MATTSON	AUTHORIZING MANAGER(S): T. MIMITZ	EFFECTIVE DATE: 08/27/2004
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