Instructions

KIT NUMBER: 100312-1	**DESCRIPTION:** KIT- HERMETIC FEEDTHRU-HIGH POWER(TG310)
DOCUMENT NUMBER: 700783-1	**Rev:** A

Parts list

Qty	P/N	Description	Picture
3	400026	FEEDTHRU, HIGH POWER ASSEMBLY (HFO-1234ZE)	
6	901534	BOLT M10x16 STEEL GRADE A HEXAGON HEAD Z/P	
6	900116	WASHER, M10 SPRING DACROMET 500LC, DIN 127B	
1	902361	O'RING-PARKER#2-254-TOWER TOP PLATE-EPDM 740-75-1W/2LG	
3	901868	O'RING, PARKER#2-121-EPDM 740-75-1W/2LG	

Refrigerant Recovery

Refer to Industry/ASHRAE Standards when performing service on the refrigeration system.

⚠ CAUTION

Always wear proper safety equipment when handling refrigerants

Feed thru removal

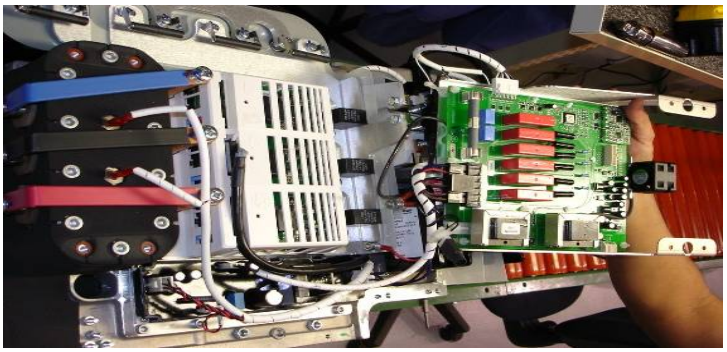
1. Release the four screws of the Main Input Cover and remove the Mains input cover from the compressor.
2. Release the nine screws of the top cover and remove the top cover from compressor.
3. Check the assembly order of the bolt(s), washer(s), lock-washer(s) and nut(s) before disassembly.
4. Remove the cable tie from the ground cable using cutters. Remove the ground connector using a 13mm wrench.

5.

6. Remove the four screws holding the Soft Start on the compressor using a Philips screwdriver.

7.

8. Flip the Soft-Start over to have access to the connector clips. Remove the three clip connectors from the Soft-Start.



9. Remove the cables and keep them with Soft-Start in an electrostatic bag or box.
10. Use pliers to disconnect the two connectors from thermistor sensor's feed thru
11. Remove the three M10 bolts and three M8 screws to release the three buss assembly connections between the IGBT assembly and the high power feed thru.
12. Release the 10 bolts which secure top cover plate in to the Main housing.
13. Lift the cover plate and gently unplug the trimester connectors.
14. Carefully remove the plate and inspect the area between cover plate and Main housing.
15. Remove the M10 bolt and ring terminal connections from feed thru in order to be able to release feed thru assembly.
16. Remove the high power feed thru using a 36 mm wrench

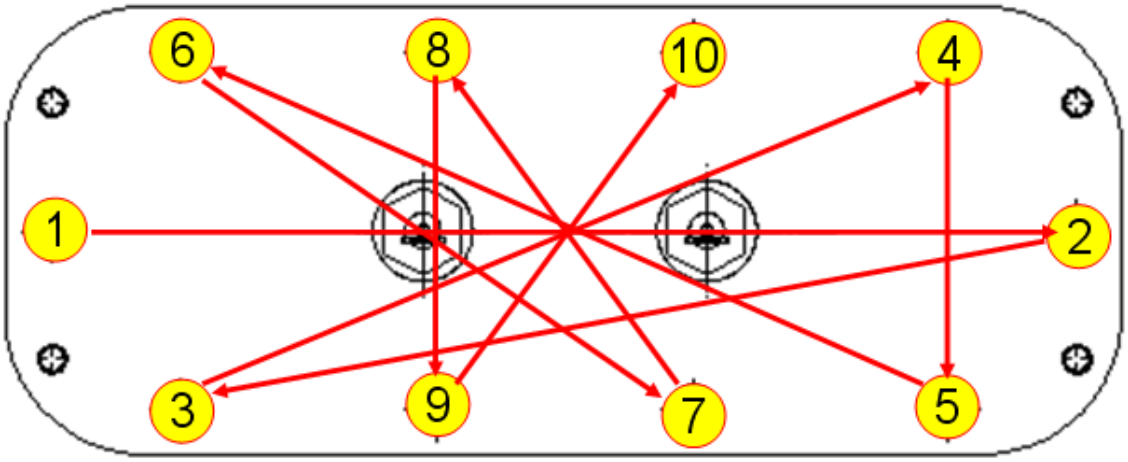
17. Inspect the fitting area for any residue or debris and clean the threads if needed

Installation:

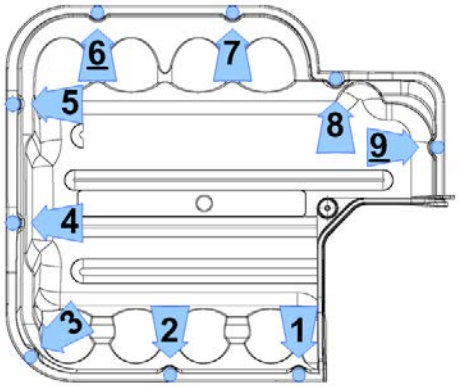
Note:

It is far more desirable to take care in installation identifying and inspecting O-rings than to repeatedly overhaul components with faulty seals.

1. Remove the old o-ring from housing assembly
2. Ensure that the area used for installations is clean and free from all contamination.
3. Apply O-lube and mount three O-rings (901868) on the feed-thru (400026).
4. Place the new High power feed thru and tight it by hand first.
5. Using a torque wrench tighten it to (10 Nm / 7.38 lb ft)
6. Place the ring terminal and secure it using the M10 X 20 bolt from inside.
7. Tighten the bolt to (14 Nm/ 10.32 lb ft) using a torque wrench.
8. Hold the feed thru using a 36mm wrench while applying torque to the M10 screws to prevent loosening or over torque the feed thru assembly.
9. Remove the O-ring (902361) that is to be installed from its package and inspect it for defects such as blemishes, abrasions, cuts, or punctures.
10. The slight stretching of the O-ring when it is rolled inside out will help to reveal some defects not otherwise visible. A further check of each O-ring should be made by stretching it between the fingers, but care must be taken not to exceed the elastic limits of the rubber.
11. Pre shaped O-rings which are coated by white powder should be cleaned up using O-lube and a soft rag
12. After inspection and prior to installation, lubricate the O- ring, and all the surfaces that it must slide over with a light coat of the "LUBRICATION-SUPER "O" LUBE- 900578"
13. Inspect the O-ring groove and clean it using a soft cloth then blow air to remove any particle may cause leak.
14. Assembly must be made with care so that the O-ring is properly placed in the groove and not damaged as the housing is closed.
15. Avoid rolling or twisting the O-ring when manoeuvring it into place.
16. Keep the position of the O-ring mold line constant.
17. Care must be taken while plugging the thermistor sensor's connectors that the top plate or pliers must not damage the mounted O-ring on the housing
18. Tighten the screws in diagonal order according to the following figure.
19. Secure the top plate assembly with 10 screws using a torque wrench and Allen key setting them in to 13 Nm/9.6 lb ft following the sequence shown in the next figure



20. Follow the torque sequence and torque twice.
21. Perform a leak test to ensure that the parts are assembled and sealed perfectly.
22. Reverse the removal procedure and start the compressor.
23. Fasten according to the following sequence. Follow the sequence twice. The first time, fasten screws to half way down to allow adjustments.



24. Place the Main input cover. Set the side of main input first and then the side of the top cover.
25. Fasten the Main input cover with a screwdriver with torx bit**.** Fasten according to the sequence. Follow the sequence twice. The first time; only fasten the screws half way down to allow adjustments. Fasten # 4 only once.