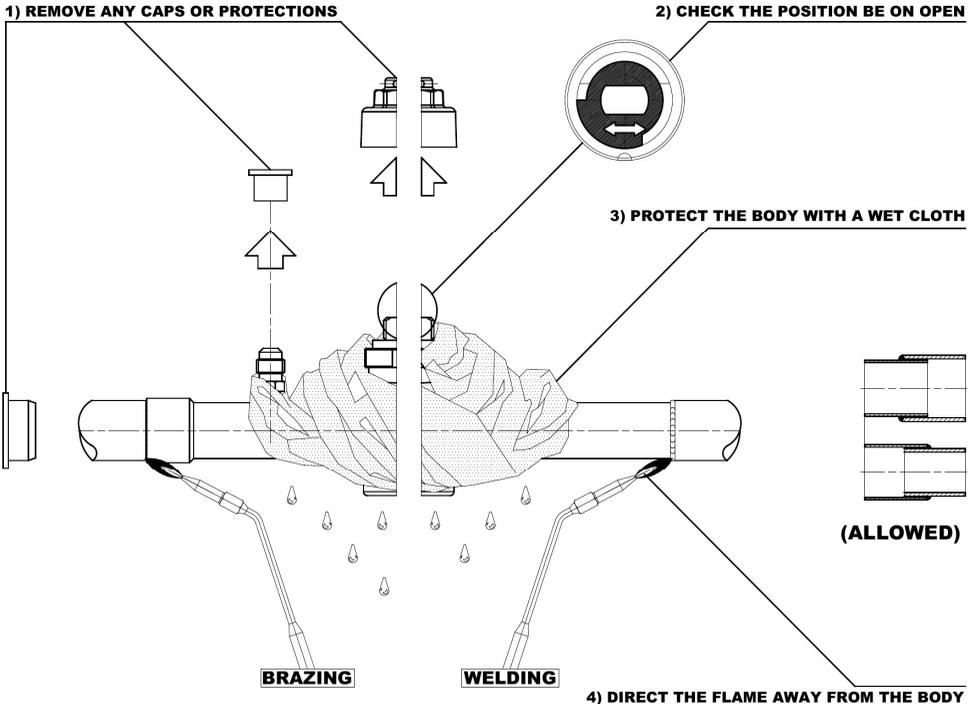
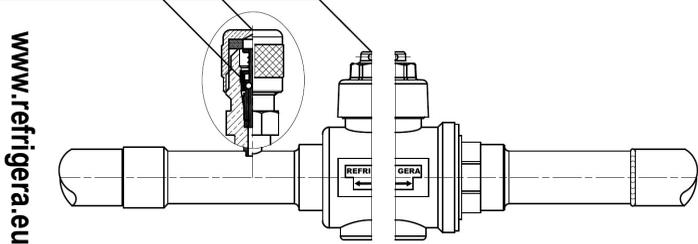


# Ball Valve 2-Way Brazing / Welding Instructions

Suitable for most Group1 / Group2 Refrigerants, according to 2014/68/EU P.E.Directive  
 Brazing / Welding should be operated by qualified personnel  
 Prevent to overheat the valve body when Brazing / Welding (MAX 150°C x 1 MIN)  
 Apply Nitrogen inside the valve during Brazing / Welding  
 De-Pressurize the System before starting operation  
 Braze with at least 5% silver alloy



**5) IF REQUIRED, MOUNT CAPS AND SCHRADER MECHANISM PROVIDED IN THE PACKAGE BOX**



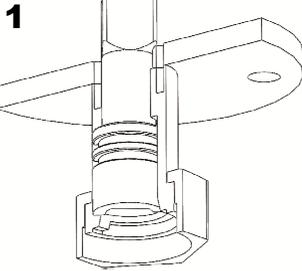
www.refrigera.eu



Valve Size	6-22mm	28-35mm	42-108mm
Tighten Cap with approx. Torque	15Nm	20Nm	32Nm
Schrader mechanism Max Torque	0,25Nm		

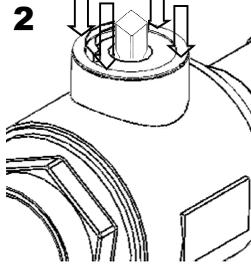
**CAUTION: PRODUCT NOT SUITABLE TO BE USED WITH R717—AMMONIA**  
 A13014-f\_R0-13/03/20

# Kit Mounting in Actuators-Fit Valve



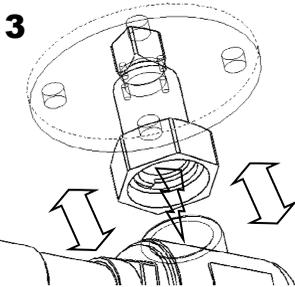
**1** Assembly Kit is supplied pre-assembled with the connection on the valve's stem already inserted

Il Kit di Assemblaggio viene fornito pre-montato, cioè con lo stelo di collegamento al perno della valvola a sfera già inserito



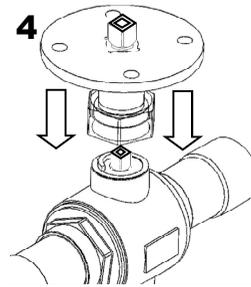
**2** Before start mounting the Kit, put the PTFE gasket enclosed in the box on the upper side of the valve, carefully-centering it with the stem

Prima di montare il Kit assicurarsi di posizionare la guarnizione in PTFE fornita nella confezione sotto il cappello della valvola, controllandone bene la centratura



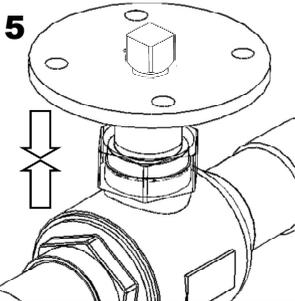
**3** Draw up your Kit to the valve. Start inserting the Kit to the valve's stem, aligning parallel faces

Avvicinare il Kit alla sede del cappello e, facendo riferimento alle facce parallele del perno, iniziare ad inserirlo nel Kit



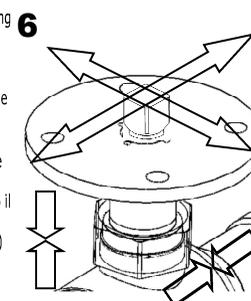
**4** Continue drawing up your Kit to the valve, centering the stem and disregarding the position of the nut

Continuare ad avvicinare il Kit al piano, facendo riferimento, per la centratura, al perno senza agire sul dado filettato



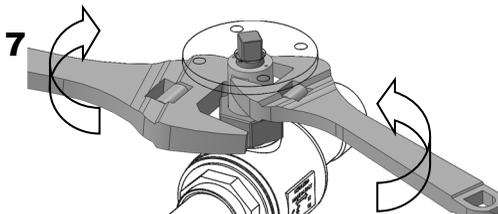
**5** Join the two sides without applying force. Then turn Kit counter-clockwise until it will fit into the valve (you'll hear the characteristic "click" and you'll no more able to rotate kit around the valve)

Accoppiare senza forzare le estremità. Ruotare delicatamente in senso antiorario fino ad incastrare il kit alla valvola (dopo il "click" e non sarà più possibile ruotare il Kit rispetto alla valvola)



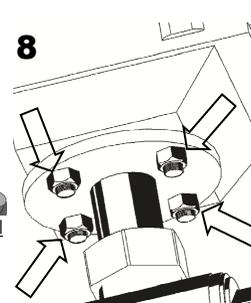
**6** Check the perfect alignment of the holes and for the stability of the contact

Accertarsi del perfetto allineamento dei fori e della stabilità del kit



**7** Secure the nut with a torque of at least 40 Nm, without forcing the internal parts by leveraging the faces of the counter-screwing on the extension

Fissare il dado con una coppia di almeno 40Nm. Per non forzare le parti interne, far leva sulle facce di contro-avvitamento ricavate sul cilindro



**8** Assemble kit with the electric actuator by well-tightening all the bolts

Accoppiare l'attuatore ed avvitare saldamente tutti i dadi di fissaggio

**CAUTION: DO NOT ROTATE MANOEUVRING ROD BEFORE ASSEMBLING THE ACTUATOR**

**IMPORTANTE: NON RUOTARE LO STELO PRIMA DELL'ACCOPIAMENTO CON L'ATTUATORE**

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