Danfoss Solenoid Valve

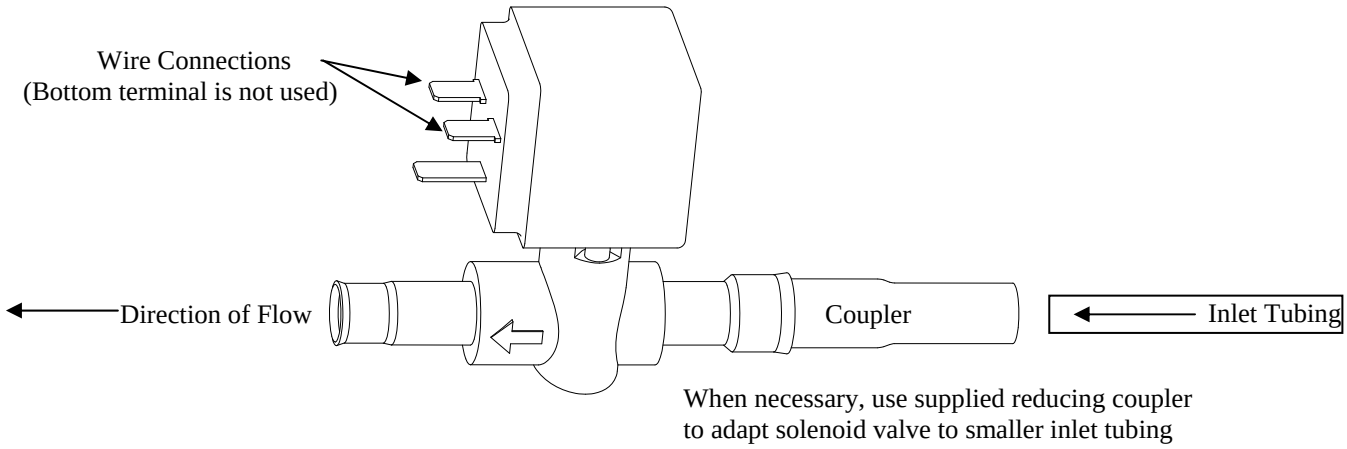
Installation Instructions
(Brazing Procedures)

Overview of Valve Replacement

- Danfoss stainless steel solenoid valves require a slightly different brazing technique than brass-bodied valves.
  Copper clad stainless steel does not require as much flame contact as copper tubing.
  Heat will need to be applied to the copper tubing first and then the valve socket.
- 15% to 55% silver solder is recommended.
- Flux is not needed.

Brazing Procedure

1. Install reducing coupling on solenoid valve inlet when necessary.



2. Apply heat to copper tubing first and move flame toward valve socket.
   A. Heat copper tubing for approximately 10 to 15 seconds and then direct the heat to the valve socket.
   B. Heat the valve socket for 2 to 5 seconds and apply silver solder to joint.
3. Install new liquid line drier.
4. Pressure test system with 150-psig nitrogen.
5. Verify system operation; refer to service manual for complete specifications.

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