## SERVICE COMMUNICATOR

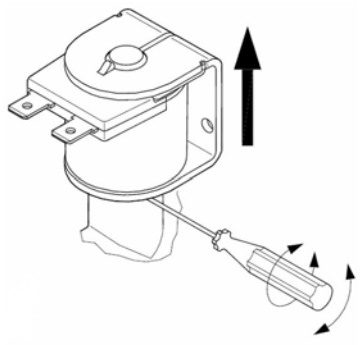
# Subject: Danfoss Solenoid Valve Brazing Procedures

Several models of current production ice machines use a Danfoss solenoid valve. The following procedures must be followed before and during installation of a Danfoss solenoid valve.

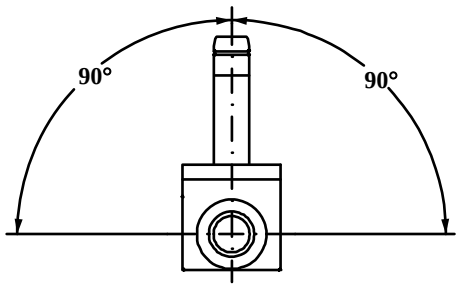
### Overview of Valve Replacement

- 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. Apply heat to the copper tubing and then to the solenoid socket.
- 15% silver solder is recommended, although silver bearing solder in the 5% to 55% range can be used.
- Flux is not needed.

1. Remove coil and verify direction of flow.



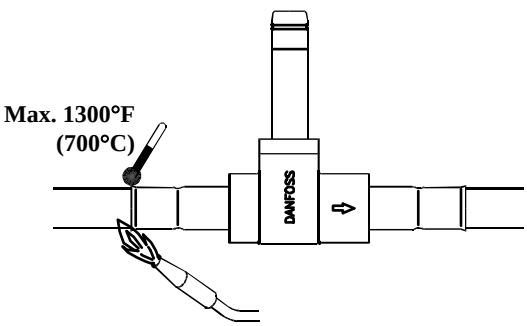
2. Fit valve in place and align stem at 12:00.

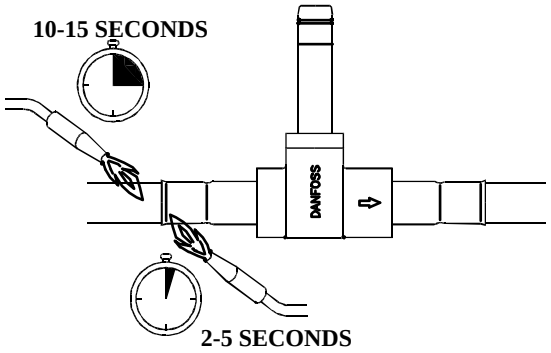



3. **Do not disassemble valve**.

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4. Apply heat to copper tubing first and move flame toward valve socket.
    A. Heat copper tubing for approximately 10 to 15 seconds and direct the heat to the solenoid socket
    B. Heat the solenoid socket for 2 to 5 seconds and apply silver solder to joint.
    C. Do not attempt to fill solenoid flange with solder. Solder will draw into socket.




5. Install new liquid line drier.
6. Leak check joints by pressurizing system with 150-psig nitrogen.
7. Evacuate and recharge system to nameplate charge.
8. Reinstall coil by pushing down and twisting 1/4 turn and attach wiring.
9. Refer to service manual for complete specifications then verify system operation.

