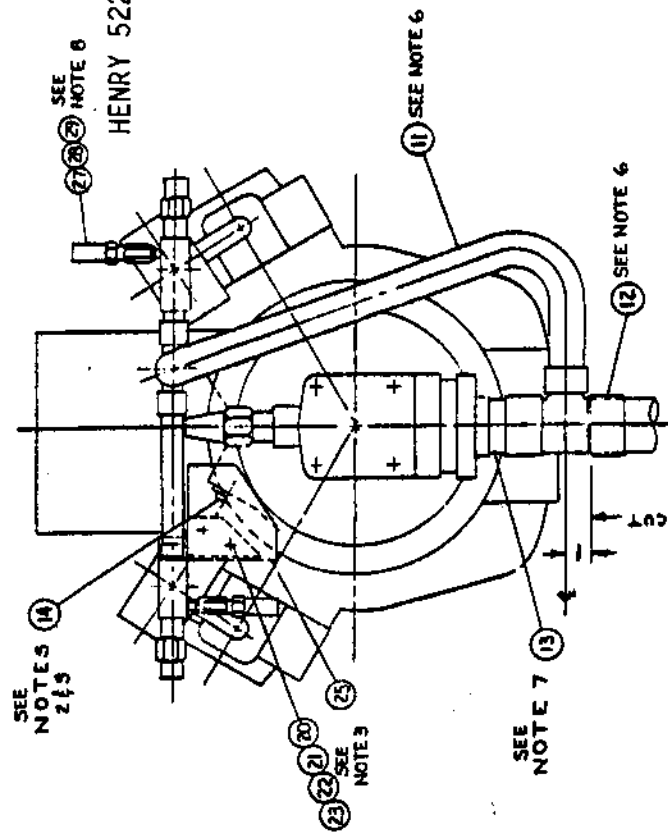
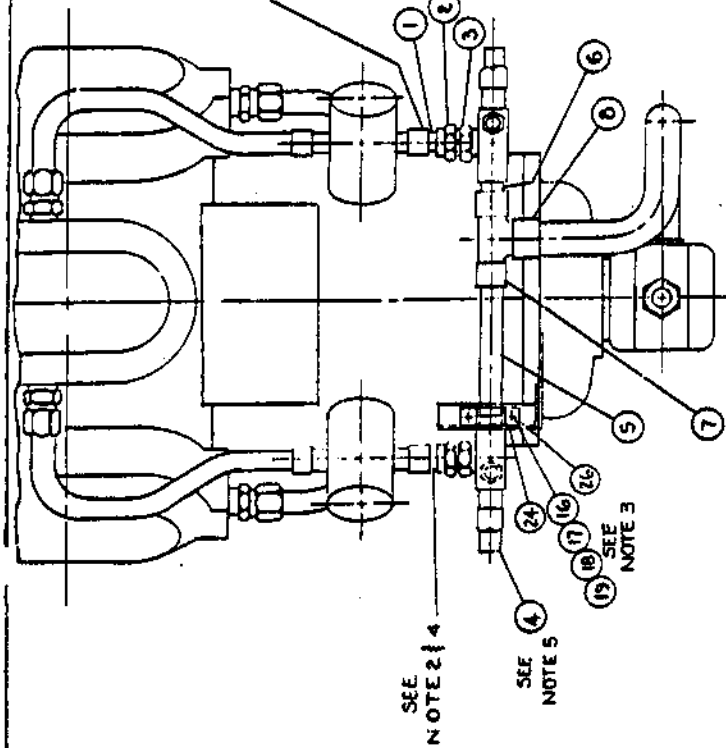




ITEM	PART NO.	DESCRIPTION
1	062-71530	TUBE, CU, ST 7/8 X .0410 X 13/8
2	023-07727A	SPUD, ROTALOCK
3	028-04836	GASKET, TEFLON 10.0 X 7/8 I.D.
4	022-01659B	VALVE, ROTALOCK
5	062-70045	TUBE, CU, L.A. 1/8 X .0410 X 2 1/2
6	063-54691	TUBE, CU, L.A. 7/8 X .0410 X 1 3/4
7	023-05677	BUSHING 1/8 X 7/8
8	023-00271	TEE, SLO, 1/8 X 1/8 X 1/8
9		
10		
11	065-24870A	CONN., UNLOADING
12	023-10247	TEE, SLO, 2 1/8 X 2 1/8 X 1 3/8
13	066-87141	TUBE, CU, HT, 2 1/8 X .080 X 3 1/2
14	063-04208	PLUG, PIPE 3/4 NPT, E SQ. 50C, CSK.
15	035-04514	INSTRUCTIONS
16	021-02459	SCREW, MCH, RD, REC, 1/4 X 24 UNC X 1/2
17	021-05164	WASHER, PLAIN
18	021-08292	LOCKWASHER
19	021-08282	NUT, HEX, 10-24 UNC
20	021-08381	SCREW, CAP HEX, 1/4 X 20 X 3/4
21	021-05165	WASHER, PLAIN
22	021-08276	LOCKWASHER
23	021-00451	NUT, HEX, 1/4 X 20 UNC
24	065-24892B	BRACKET
25	065-24893A	SUPPORT
26	065-24895A	CLAMP
27	022-04375	VALVE, RELIEF
28	023-12134	ADAPTER, FEM, 1/4 FLA X 1/4 NPT
29	028-06259	GASKET, FLA, 1/4 O.D. TUBE

NOTES:

- PERFORM ALL BRAZING WITH NITROGEN IN LINES TO AVOID CONTAMINATION OF SYSTEM BY OXIDATION OF COPPER.
- REMOVE 7/8 O.D. TUBES THAT CONNECT UNLOADING VALVES TO MONITOR AT MOTOR END BY UNBRAZING FROM UNLOADING VALVES AND REMOVE CONNECTORS FROM MONITORING. USE WET RAG TO KEEP HEAT FROM DAMAGING VALVES. PLUG HOLES IN MONITORING WITH ITEM 14, OR PLUGS, GRADE APP. (NOT PROVIDED).
- ASSEMBLE TUBES, ITEM 14, AND OR SCREWS, ITEM 16, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, INTO UNLOADING VALVES AFTER FLUXING. BRAZE BOTH CONNECTIONS AT THE SAME TIME USING WET RAG AS ABOVE.
- POT ROTALOCK VALVES IN PLACE. HAND TIGHT, WITHOUT USING GASKETS. OPEN VALVES TO PREVENT HEAT DAMAGE TO SEAT. WRAP VALVES WITH WET RAG AND BRAZE HEADER ASSEMBLY INTERCONNECTING TUBING AND FITTINGS UP TO AND INCLUDING ITEM 8. USE CARE TO INSURE THAT BUSHING IS PROPERLY BRAZED. AFTER HEADER ASSEMBLY, COOL, DISASSEMBLE ROTALOCK VALVES AND INSTALL GASKETS, ITEM 3. CLEAN CHECK EACH UNLOADING VALVE AFTER RE-INSTALLATION OF HEADER ASSEMBLY.
- ESTABLISH C OF TEE, ITEM 12, BY PRE-ASSEMBLING WITHOUT BRAZING ITEMS 11 & 12. AND CUT SECTION LINE AT DIMENSION SHOWN.
- UNBRAZE STUD FROM VALVE AND DISCARD. INSTALL ITEM 13 INTO VALVE AND COMPLETE BRAZING OF ENTIRE ASSY.
- ATTACH ADAPTER ITEM 28 TO ROTALOCK VALVE WITH ITEM 29. ATTACH VALVE ITEM 27 TO ITEM 28 WITH TEFLON TAPE.

HENRY 5221 450 PSIG