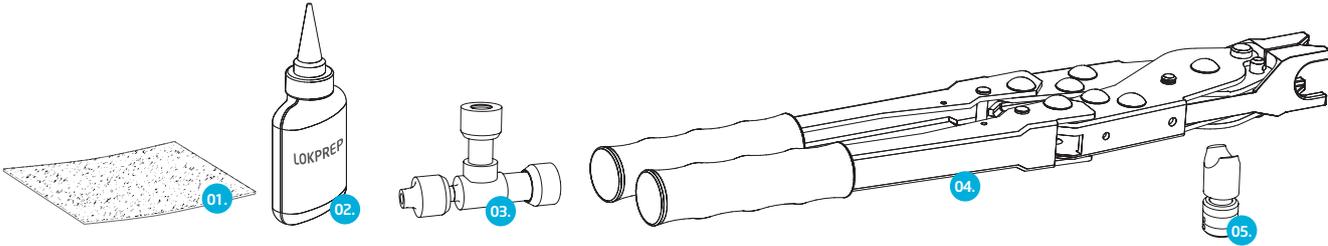


ASSEMBLY INSTRUCTIONS

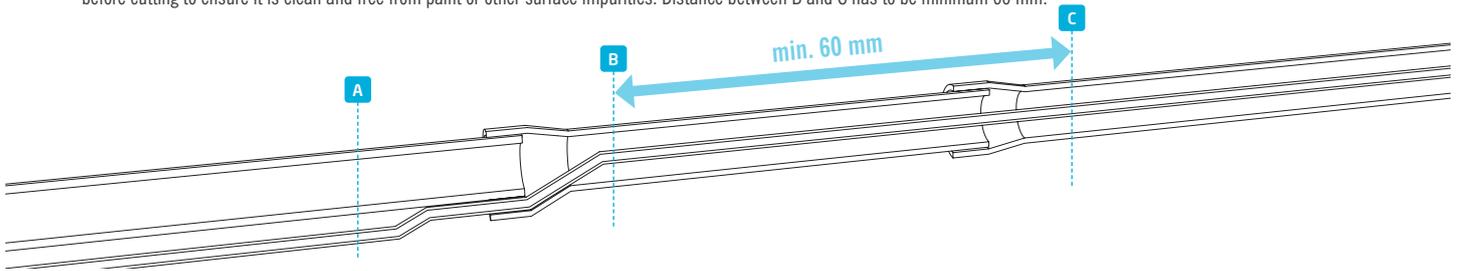
Assembly of a LOKRING NTR connection type 00
(Repair of roll-bond condenser suction lines)

VULKAN
LOKRING

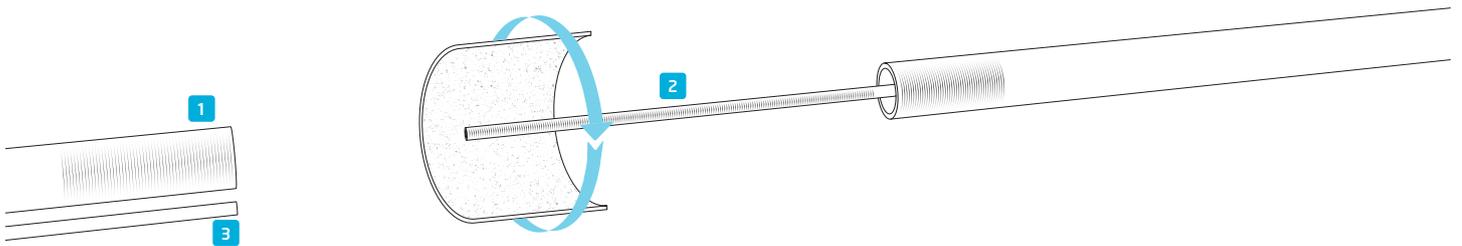


01. Emery cloth 02. LOKPREP 65G 03. LOKRING NTR connector 04. Hand assembly tool 05. Assembly fitting

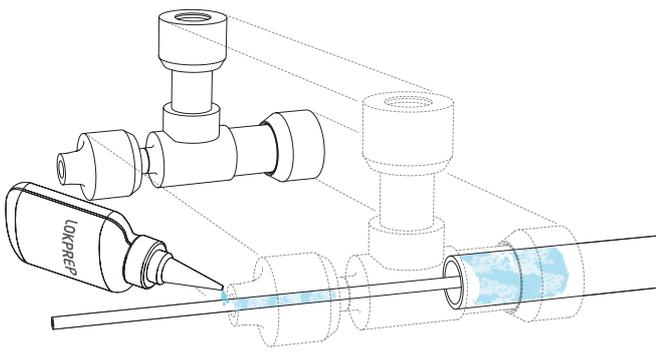
1 Cut the suction line at the positions marked A, B and C.
A: Cut Cu suction line and capillary tube. **B:** Cut Cu suction line and capillary tube. **C:** Cut Al suction line only. Clean Al suction line in a rotational motion using emery cloth (01) before cutting to ensure it is clean and free from paint or other surface impurities. Distance between B and C has to be minimum 60 mm.



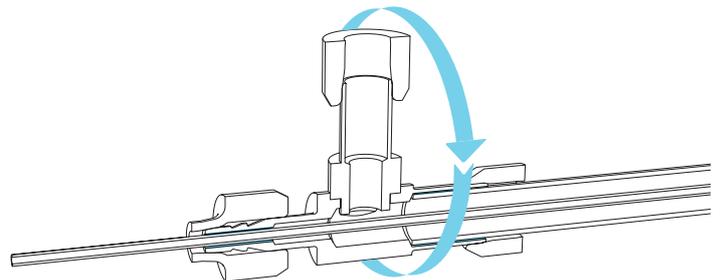
2 As a result, you get tubes 1, 2 and 3. Clean all tube ends in a rotational motion to ensure that they are clean and free from paint or other surface impurities. Clean the complete length of the capillary tube of tube 2.



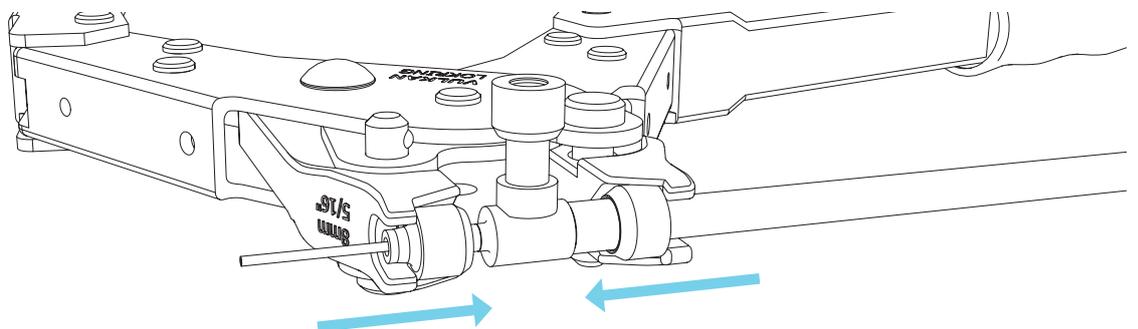
3 Apply LOKPREP 65G (02) onto the complete length of the insertion depths of the capillary tube and the Al suction line of tube 2.



4 Push the LOKRING NTR connector (03) onto tube 2 and rotate the LOKRING NTR connector (03) through 360° to distribute the LOKPREP 65G (02) evenly. Respect the curing time of the LOKPREP 65G (02).

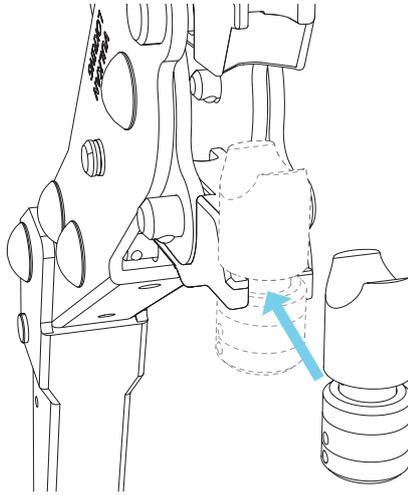


5 Position the jaws of the hand assembly tool (04) squarely onto the rings of the LOKRING NTR connector (03). In a controlled manner use the hand assembly tool (04) to press the rings onto the connector ensuring that the insertion depth of the tubes does not change throughout this process. Once both rings are flush to the centre stop of the connector the joint is complete, remove the hand assembly tool (04) from the LOKRING NTR connector (03).



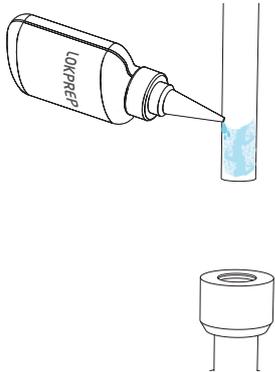
6

Insert the assembly fitting (05) into one jaw of the hand assembly tool (04).



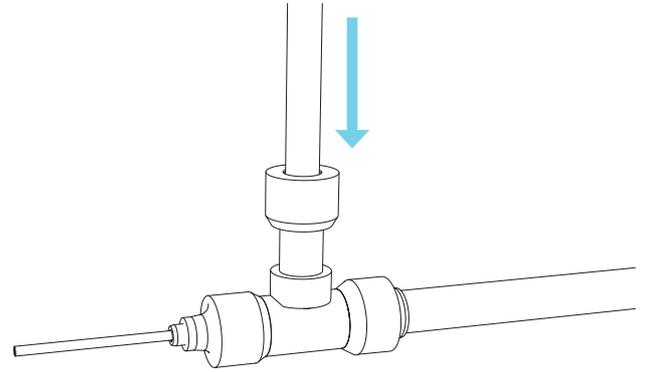
7

Apply LOKPREP 65G (02) onto the tube end of tube 1 (Cu suction line). Respect the curing time of the LOKPREP 65G (02).



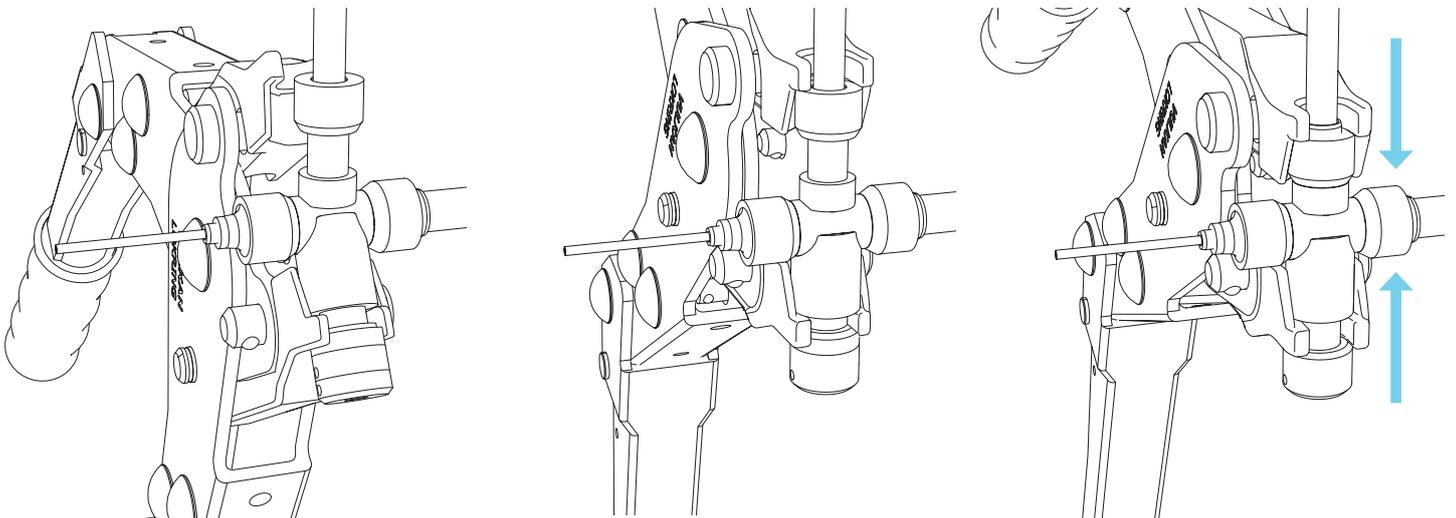
8

Insert tube 1 (Cu suction line) into the LOKRING NTR connector (03) until the tube reaches the inner stop.



9

Position the hand assembly tool (04) in a way which ensures that the assembly fitting (05) is flush to the body of the LOKRING NTR connector (03) and the assembly jaw is squarely onto the ring of the LOKRING NTR connector (03). In a controlled manner use the hand assembly tool (04) to press the ring onto the connector ensuring that the tube remains seated against the centre stop of the LOKRING NTR connector (03) throughout this process. Once the ring is flush to the centre stop of the connector the joint is complete, carefully remove the hand assembly tool (04) from the LOKRING NTR connector (03).



10

Connect tube 3 (capillary tube) according to the assembly instructions for LOKRING® tube connection assembly version 00 on www.vulkan.com.

