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REFERENCE:

REV. NO.	DESCRIPTION	DATE	BY

PROJECT:
HEALTH CARE

TITLE:
HVAC INSTALLATION
INSTRUCTION

PROJ. NO.	PROJ. ENGR.	SCALE @ 24X36: N/A
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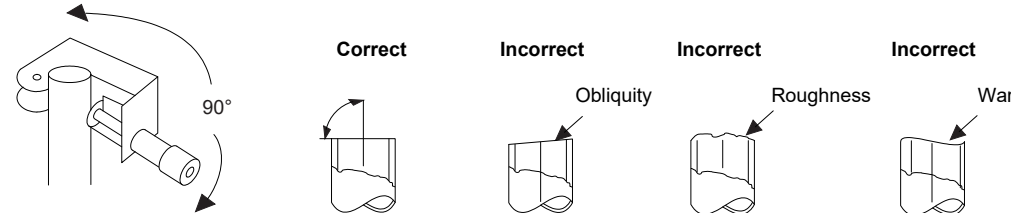
DATE :
August 28, 2026

DRAWING NO. M - 0 6	REV.
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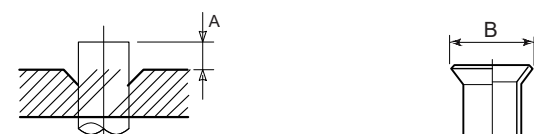
Pipe connection method

Flaring

1. Cut the pipe with a pipe cutter.



2. Remove the burr inside the pipe.
When removing the burr, be careful that the chips do not fall into the pipe.
3. Remove the flare nuts attached to the outdoor / indoor unit, then insert them into each of the pipes.
4. Flare the pipes.
See the following table for the projection margin (A) and flaring size (B).



Pipe	Outside diameter	Thickness	A		B	Flare Nut		
			Rigid (clutch type) R410A tool	Imperial (wing nut type) R410A tool		Width across flat	Tighten torque	
in	1/4"	0.03"	0 to 0.02"	0.04" to 0.06"	0.39"	0.67"	10.3 to 13.3	14 to 18
mm	6.35	0.8	0 to 0.5	1.0 to 1.5	9.9	17	24.3 to 31.0	33 to 42
in	3/8"	0.03"	0 to 0.02"	0.04" to 0.06"	0.52"	0.87"	13.2	22
mm	9.52	0.8	0 to 0.5	1.0 to 1.5	13.2	22	36.1 to 45.0	49 to 61
in	1/2"	0.03"	0 to 0.02"	0.04" to 0.06"	0.65"	1.02"	16.6	26
mm	12.7	0.8	0 to 0.5	1.0 to 1.5	16.6	26	46.5 to 56.8	63 to 77
in	5/8"	0.04"	0 to 0.02"	0.04" to 0.06"	0.78"	1.14"	19.7	29
mm	15.88	1.0	0 to 0.5	1.0 to 1.5	19.7	29	73.8 to 88.5	100 to 120
in	3/4"	0.05"	0 to 0.02"	0.04" to 0.06"	0.94"	1.42"		
mm	19.05	1.2	0 to 0.5	1.0 to 1.5	24.0	36		

Selection of pipe materials and size

Selection of pipe material

Material: Phosphorus deoxidation seam-less pipe

Capacity code of indoor and outdoor units

- For the indoor unit, the capacity code is decided at each capacity rank.
- The outdoor unit's capacity codes are decided at each capacity rank.
- The maximum No. of the connectable indoor unit and the total value of the indoor unit's capacity codes are also decided.

Minimum wall thickness for R410A application

Soft	Half Hard or Hard	OD (inch)	OD (mm)	Minimum wall thickness (mm)
OK	OK	1/4"	6.35	0.80
OK	OK	3/8"	9.52	0.80
OK	OK	1/2"	12.70	0.80
OK	OK	5/8"	15.88	1.00
NG * (1)	OK	3/4"	19.05	1.00

* (1) If the pipe size is Ø3/4" (19.05), use a suitable material.

Table 1

Indoor unit capacity type	Capacity code Equivalent to capacity	Indoor unit capacity type	Capacity code Equivalent to capacity
007 type	7.5	036 type	36
009 type	9.5	042 type	42
012 type	12	048 type	48
015 type	15.4	—	—
018 type	18	—	—
021 type	21	—	—
024 type	24	—	—
027 type	27	—	—
030 type	30	—	—

Table 2

Outdoor unit capacity type	Capacity code Equivalent to capacity	No. of connectable indoor units	Total capacity code of connectable indoor units	
036 type	36	2 to 6	Min. * (2)	Max.
048 type	48	2 to 8	24	64
060 type	60	2 to 9	30	



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