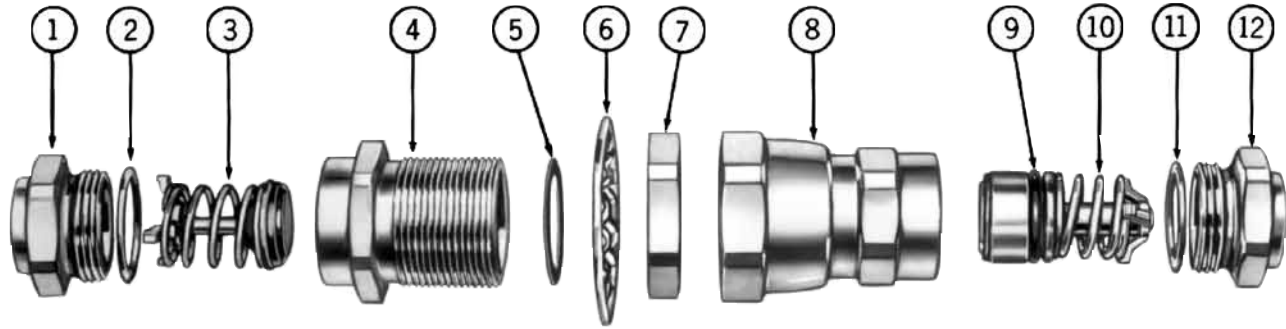


5400 Series Low Air Inclusion Refrigerant

Assembly Instructions/Component Part Numbers



Typical Male Coupling Half (S2)

Assembly Instructions

Steps:

1. After tubing or hose has been connected to adapters ① and ⑫, install O-Rings ② and ⑪* on adapters. Be sure O-Rings are not twisted.
2. Oil O-Rings ② and ⑪ liberally with system fluid to prevent them from scuffing and tearing when coupling body is threaded on adapter.
3. S2 Half—Lubricate poppet face with system fluid. Insert poppet valve assembly ③ into body ④. Tighten body ④ on adapter ①. After body and adapter make metal-to-metal contact, tighten by rotating body ④ 1/8" with respect to adapter ① or torque per table value.

S5 Half—Oil O-Ring ⑨* liberally with system fluid. Insert valve and sleeve assembly 10 into body ⑤. Tighten body ⑤ on adapter ⑫. After body and adapter make metal-to-metal contact, tighten by rotating body ⑤ 1/8" with respect to adapter ⑫ or torque per table value.

4. Coupling Connection—Lubricate gasket seal ⑥ on 5400-S2 half with system fluid. Thread union nut ⑧ on 5400-S2 half. Tighten union nut to torque values shown in table. Be sure S2 and S5 bodies do not rotate during connection.

Typical Female Coupling Half (S5)

Bulkhead Mounting—S2 Half

Install lock washer ⑥ on S2 half. Insert S2 half through bulkhead, and tighten jam nut ⑦ so that lock washer teeth are fully compressed.

NOTE: Lock washer 6 must be between hex of S2 half and bulkhead.

Maximum Bulkhead Thickness

Body Size	Lock Washer Installed	Lock Washer Not Used
1/4	.206	.256
1/2	.136	.203
3/4	.232	.292
1	.101	.161

Torque Values

Recommended torque values in ft. lbs., are listed below.

Dash Size	Adapter to Body		
	Braze Type or Aluminum	Non-braze Type Steel or Brass	S2 Half to S5 Half
-4	6-8	12-15	10-12
-8	15-20	35-45	35-37
-12	35-40	45-55	45-47
-16	50-60	55-65	65-67

*IMPORTANT: Generous lubrication is required for all gaskets and O-Rings. Use refrigeration oil only when used in refrigerant system.

Component Part Numbers

Item Number	Dash Size → O.D. Tube Size →	-4 1/4"-3/8"	-8 1/4"-5/8"	-12 5/8"-7/8"	-16 7/8"-13/8"	Line Ref.
Typical Male Half						1
1	Tubing Adapter	202208-* -4	202208-* -8	202208-* -12	202208-* -16	2
2	O-Ring	22546-12	22546-17	22546-23	22546-28	3
3	Poppet Valve Assembly	5400-S20-4	5400-S20-8	5400-S20-12	5400-S20-16	4
4	Body	5400-17-4	5400-17-8	5400-17-12	5400-17-16	5
5	Gasket Seal	22008-4	22008-8	22008-12	22008-16	6
6	Lock Washer	5400-54-4S	5400-54-8S	5400-54-12S	5400-54-16S	7
7	Jam Nut	5400-53-4S	5400-53-8S	5400-53-12S	5400-53-16S	8
Typical Female Half						9
8	Union Nut and Body Assembly	5400-S16-4	5400-S16-8	5400-S16-12	5400-S16-16	10
9	O-Ring	22546-10	22546-112	22546-116	22546-214	11
10	Valve and Sleeve Assembly	5400-S19-4	5400-S19-8	5400-S19-12	5400-S19-16	12
11	O-Ring	22546-12	22546-17	22546-23	22546-28	13
12	Tubing Adapter	202208-* -4	202208-* -8	202208-* -12	202208-* -16	14

*Specify O.D. Tubing size of adapter required in 16th of an inch. Example: -4 coupling with 3/8" O.D. tubing is 6/16 or -6. Part number is then 202208-6-4.

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