



TRANE®

General Service Bulletin

Re-torquing of flat gaskets before start-up

Order Number: CTV-SVB17C-EN

DATE: October 2005

Introduction

The purpose of this bulletin is to remind all service technicians of the importance of checking the flat gasket bolt torque's before charging and starting the chiller.

NOTICE: Warnings and Cautions appear at appropriate sections throughout this literature. Read these carefully.

⚠ WARNING: Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION: Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.

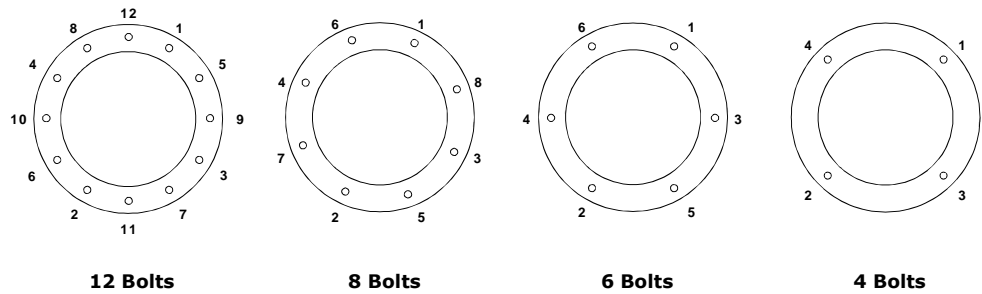
CAUTION: Indicates a situation that may result in equipment or property-damage only accidents.

Discussion

During the installation of any of the below listed La Crosse-built chillers, all economizer flange bolts should be re-torqued to current factory specifications as follows.

Torque all bolts using a calibrated, good quality torque wrench. All bolts shall be tightened in three stages and in a star pattern as shown in Figure 1.

Figure 1.



Stage 1 - Cordless Drill - Driver to 5 ft-lbs.
 Stage 2 - Hand torque wrench to 15 ft-lbs.
 Stage 3 - Hand torque wrench to final torque as per Table 1.

Table 1.

Flange Family Size	Torque in Ft-lbs.
4 inch	33 ± 3
5 inch	25 ± 3
6 inch	25 ± 3
8 inch	33 ± 3
10 inch	25 ± 3
All other sizes	33 ± 3

Note: Factory uses a cordless drill-driver tool to provide initial tightening of bolts. Other means can be used for this stage. Second stage and final torque values should be accomplished with torque wrench for best results.

This service should be performed once the holding charge has been removed from the unit. Once the unit is charged and or running the re-torquing procedure discussed in this bulletin may not prevent the leak from occurring.

The following flanged economizer joints are included in this bulletin:

- Compressor inter-stage (1 connection-2 stage, 2 connections-3 stage)
- Evaporator connection (orifice)
- Condenser connection (orifice)/Condenser connection sump (032 & 050 shells)

Units Affected

- CVHE
- CVHF
- CVHG
- CDHF
- CDHG

Future work being done on flat gasket leaks

There will be additional design and process changes that will be completed within the next several months. This work will supplement the refrigerant leak issues at these joints.

Labor Authorization

There will be no authorized labor given.

Questions

For general questions contact the CTV Technical Service department in La Crosse at 608-787-3943 or e-mail at TechService@trane.com.



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Stocking Location	Electronic Only

Trane has a policy of continuous product data and product improvement and reserves the right to change design and specifications without notice. Only qualified technicians should perform the installation and servicing of equipment referred to in this bulletin.