Installer's Guide

Aluminum Coil Repair Kits

KIT01146 & KIT08157

ALL phases of this installation must comply with NATIONAL, STATE AND LOCAL CODES.

IMPORTANT—This Document is **customer property** and is to remain with this unit. Please return to service information pack upon completion of work.

IMPORTANT:
These kits are to be used for repair of aluminum coils only. Use on copper coils can cause leaks even though properly installed per this procedure.

A. GENERAL

Kits available:
KIT01146 For coils - 3/8" tube size
KIT08157 For coils - 5/16" tube size

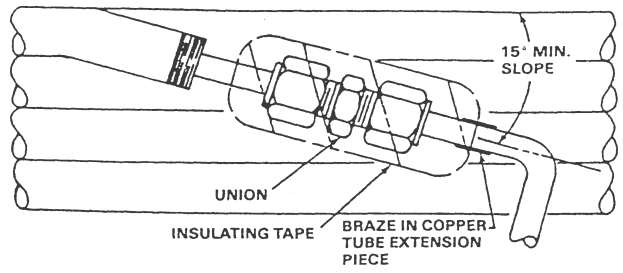
1. Isolate location of leak using, using proper service procedures. If leak is very small it may be necessary to remove cover, fan assembly and all side panels to make a thorough search.
2. After leak has been located recover all refrigerant from the low side first and then the high side in accordance with service procedure 34-1005-02 (SP 928). Leave both valves open during the repair procedure.

B. REPAIRING

FOR LEAK AT TRANSITION JOINT:

1. Cut tubing using a tubing cutter on coil side near the weld and remove transition joint. Unbraze copper end of transition joint.
2. Determine proper length of copper tubing necessaryfor hook-up to replace old transition joint. Using swedged copper tube furnished in kit, cut and braze copper tube extension to copper line before final assembly of coupling. After cleaning aluminum tube (see tube preparation), assemble coupling between aluminum tube and short piece of copper tube. (See Assembly).
3. Slope coupling with copper end down (See Figure 1).

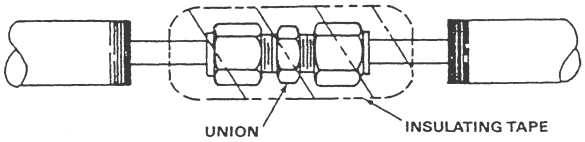
1 **TO REPLACE TRANSITION JOINT**



FOR LEAK IN ALUMINUM COIL:

1. Remove louver to expose coil. (If not previously removed to locate leak).
2. Cut hot melt adhesive at turn which has leak. This adhesive is applied to diagonally opposite corners of the coil.
3. Separate coil to provide working room.
4. Cut tubing at leak using tubing cutter and proceed with tube preparation (See Figure 2).

2 **TO REPAIR LEAKS IN COIL**



TUBE PREPARATION:

1. Strip off the fin stock to expose 1 - 1-1/2 inches of the aluminum tube.
2. Remove the residue of the adhesive from the external surface of the tube using a fine grade of emery cloth.

NOTE:
A rough grade of emery cloth may cause leaks.

⚠ CAUTION

The tube must be circular in the joining region. Leaks will result if tube is not circular.

3. Cut the tube perpendicular to the axis of the tube with a tubing cutter and remove any burrs.

ASSEMBLY:

1. Insert the tube into the body of the fitting. The tube **must** bottom against the shoulder inside the fitting to insure a leak free joint. It is only necessary to loosen the nut to perform this operation — the fitting need not be disassembled.
2. Tighten the nut snugly by hand and then with a wrench tighten an additional 1-1/4 turns. Use a back-up wrench on the fitting body when tightening so as not to twist the tube.

C. CHECKOUT:

1. After repairs have been made add a small charge of refrigerant to the system and recheck for leaks.
2. If no leaks are noticed, evacuate system per service procedure (SP930).
3. Recharge system and check performance.

NOTE:
Charging and performance charts are attached to the unit. However, they may also be referred to in the Service Facts Manual.

D. CORROSION PROTECTION:

1. Wrap the coupling and tubing one inch each side of coupling with insulation provided. Make sure there is a water tight seal around tubing and coupling. (See Figure 1 and Figure 2).

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18-HF06D1-2A-EN 16 Feb 2024
Supersedes 18-HF06D1-2 (Aug 2002)