Section 3

Orifice Assembly for Manifold Applications

The use of the orifice in the compressor suction is not important when all compressors in the manifold set are CSHA, i.e., the downstream compressors can be a mix of CSHA compressors with or without orifices.

Do not substitute using field fittings or tubing when connecting suction piping. Existing suction pipe must be reused or replaced with new Trane or American Standard parts. This original suction tubing and fittings assure that oil is returned to the first compressor in a manifold set.

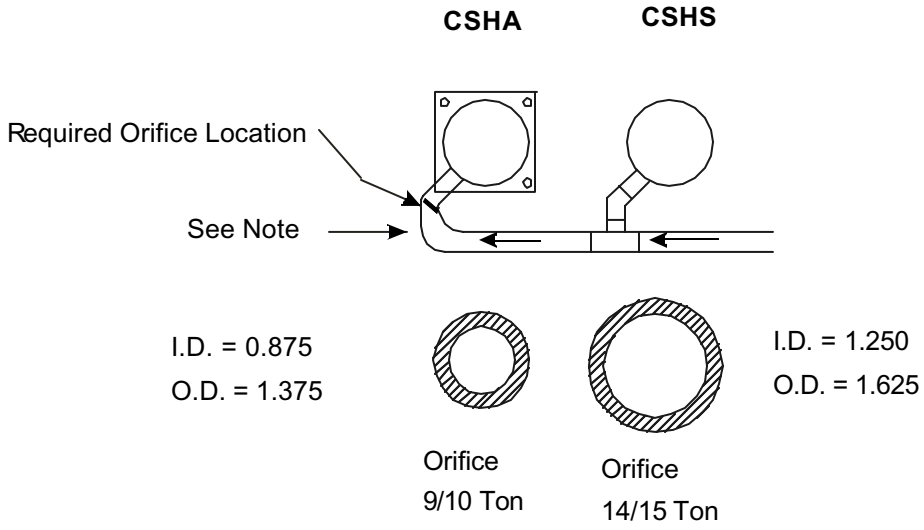
Place the washer shaped orifice into the compressor suction pipe stub on any CSHA compressor mounted in a downstream position. Insert the suction line into the pipe stub so it securely butts up against the face of the orifice. Braze the suction line into place.

Note: If the CSHA compressor is installed in the first upstream position, the orifice is NOT required.

Figure 13 illustrates the location of upstream and downstream compressors in a two, three and four manifold installation.

⚠ CAUTION
Failure to install the orifice may result in compressor failure.

Figure 12 — Placement of an Orifice into a CSHA when in the DOWNSTREAM position of a CSHS



Note: Use the appropriate orifice for the replacement CSHA compressors size. Discard extra orifices.

Section 3

Continued

Figure 13—Upstream and Downstream Compressors