

Copeland Stream semi-hermetic compressors

4MF-13 to 4MK-35
6MM-30 to 6MK-50



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About these guidelines

The purpose of these guidelines is to provide guidance in the application of Copeland Stream 4M* & 6M* semi-hermetic compressors in users' systems. They are intended to answer the questions raised while designing, assembling and operating a system with these products.

Besides the support they provide, the instructions listed herein are also critical for the proper and safe functioning of the compressors. The performance and reliability of the product may be impacted if the product is not used according to these guidelines or is misused.

These application guidelines cover stationary applications only. For mobile applications, please contact the Application Engineering department at Copeland as other considerations may apply.

1 Safety instructions

Copeland semi-hermetic compressors are manufactured according to the latest relevant European safety standards. Particular emphasis has been placed on the user's safety.

Copeland Stream 4M* and 6M* compressors are intended for installation in systems in accordance with the following directives and regulations:

Machinery Directive MD 2006/42/EC	Supply of Machinery (Safety) Regulations 2008
Low Voltage Directive LVD 2014/35/EU	Electrical Equipment (Safety) Regulations 2016

They can be used in the EU only if they have been installed in systems according to instructions and conform to the corresponding provisions of legislation. Conformity to local legislation and regulations must also be observed. For relevant standards please refer to the Manufacturer's Declaration, available at www.copeland.com/en-gb.

NOTE: Only dedicated compressors are allowed to be used with flammable refrigerants. Copeland marks all compressors that are qualified for flammable refrigerants with a sticker indicating the usage of such refrigerants. Systems using flammable refrigerants must be executed correctly while observing safety rules, as specified in corresponding safety standards such as, but not limited to EN 378. They must comply with any and all applicable legislation and regulations. Ensuring compliance remains the user's responsibility.

The Material Safety Datasheet (MSDS) for each individual refrigerant shall be considered – please check the document provided by the gas supplier.

These instructions shall be retained throughout the lifetime of the compressor.

You are strongly advised to follow these safety instructions.

1.1 Icon explanation

 WARNING This icon indicates instructions to avoid personal injury and material damage.	 Fire hazard This icon indicates a risk of flammable atmosphere.
 High voltage This icon indicates operations with a danger of electric shock.	 CAUTION This icon indicates instructions to avoid property damage and possible personal injury.
 Danger of burning or frostbite This icon indicates operations with a danger of burning or frostbite.	 IMPORTANT This icon indicates instructions to avoid malfunction of the compressor.
 Explosion hazard This icon indicates operations with a danger of explosion.	NOTE This word indicates a recommendation for easier operation.
 Danger of explosive atmosphere This icon indicates a risk of explosive atmosphere.	

1.2 Safety statements

- Refrigerant compressors must be employed only for their intended use. The system has to be labelled according to the applicable standards and legislation.
- Only qualified and authorized RACHP (refrigeration, air conditioning and heat pump) personnel are permitted to install, commission and maintain this equipment.
- Electrical connections must be made by qualified electrical personnel.
- All valid standards for connecting electrical and refrigeration equipment must be observed.
- The national legislation and regulations regarding personnel protection must be observed.

Additional requirements and statements for A2L-refrigerant compressors/systems:

- Only competent personnel (as specified in EN 13313) qualified for flammable refrigerant handling are permitted to commission, initiate and maintain the compressor/refrigeration systems using flammable refrigerant; non-trained personnel, including the user, are not allowed to do so and must call on an expert.
- The maximum refrigerant charge is specified in standards such as, but not limited to EN 378, EN 60335-2-40 and EN 60335-2-89. The system designer shall implement all safety measures defined by the applicable standards and the maximum refrigerant charge shall not be exceeded.
- If a flammable atmosphere is detected, immediately take all necessary precautions to mitigate the risk as determined in the risk assessment.



Use personal safety equipment. Safety goggles, gloves, protective clothing, safety boots and hard hats should be worn where necessary.

1.3 General instructions



WARNING

Pressurized system! Serious personal injuries and/or system breakdown!

Accidental system start before complete set-up must be avoided. Never leave the system unattended without locking it out electrically when it is on vacuum and has no refrigerant charge, when it has a holding charge of nitrogen, or when the compressor service valves are closed.



WARNING

System breakdown! Personal injuries! Only approved refrigerants and refrigeration oils must be used.



WARNING

High shell temperature! Burning! Do not touch the compressor and piping until they have cooled down. Ensure that other materials in the area of the compressor do not come into contact with it. Lock and mark accessible sections.



CAUTION

Overheating! Bearing damage! Do not operate compressor without refrigerant charge or without it being connected to the system.



CAUTION

Contact with refrigerant oil! Material damage! Polyolester (POE) lubricant must be handled carefully and the proper protective equipment (gloves, eye protection, etc.) must be used at all times. Refrigerant oil must not come into contact with any surface or material that it might damage, including without limitation, certain polymers, eg, PVC/CPVC and polycarbonate.



IMPORTANT

Transit damage! Compressor malfunction! Use original packaging. Avoid collisions and tilting.

2 Product description

2.1 Compressor range

These application guidelines cover Copeland Stream semi-hermetic compressors. The semi-hermetic reciprocating compressor family consists of different ranges. The Stream series of 4M* and 6M* models ranges from 62 to 153 m³/h displacement.

Compressor	Nominal capacity (hp)	Displacement (m³/h)	Net weight (kg)	Foot print (mm)	Cooling capacity (kW)				
					R448A R449A	R513A	R454C*	R455A*	R454A*
4MF-13	13	62	177	381 x 305	28.0	20.8	27.1	27.7	30.7
4MA-22	22		178		31.8	20.9	28.1	29.3	32.2
4ML-15	15	71	180		36.1	24.1	31.3	34.0	37.2
4MH-25	25		187		36.2	23.8	31.4	34.3	37.6
4MM-20	17	78	182		39.4	26.5	34.5	37.5	41.2
4MI-30	27		188		41.0	26.7	34.9	38.4	41.5
4MT-22	22	88	183		44.5	29.6	37.3	40.6	45.1
4MJ-33	30		190		45.1	29.0	39.6	43.0	46.8
4MU-25	25	99	186		49.4	32.9	43.4	47.6	51.4
4MK-35	32		202		50.7	32.4	44.1	48.2	52.3
6MM-30	27	120	215		59.0	39.9	53.0	58.1	62.9
6MI-40	35		219		61.9	38.5	53.0	56.5	63.1
6MT-35	32	135	221		65.3	44.7	59.1	64.1	70.0
6MJ-45	40		223		69.1	44.9	58.7	64.3	70.4
6MU-40	40	153	225		76.3	49.1	64.4	71.6	77.4
6MK-50	50		230		76.4	48.3	65.1	72.3	77.8

* = A2L refrigerants

Conditions: Evaporating -10 °C, condensing 45 °C, suction gas temperature 20 °C, subcooling 0 K

Table 1: 4M* & 6M* compressor range and performance for use with A1 & A2L refrigerants

Stream semi-hermetic compressors are suitable for a wide range of applications in the form of either single compressors, refrigeration units or as multi-compressor equipment.

NOTE: The compressor is only one component which must be combined with many others to build a functional and efficient refrigeration system. Therefore, the information in this manual relates to Copeland Stream semi-hermetic compressors with standard equipment and accessories only.

2.2 Nomenclature

The model designation contains the following technical information about Stream compressors:

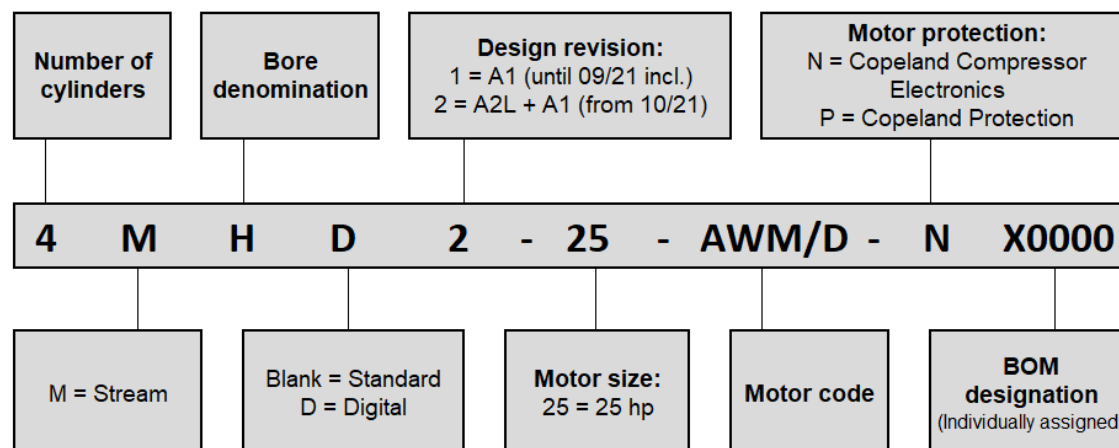


Figure 1: Nomenclature

The Stream compressors have been upgraded internally to support operation with A2L refrigerants. The modified compressors are identified by revision number "2" in the nomenclature. Only the compressors marked with revision number "2" are approved for operation with A2L refrigerants, or alternatively with A1 refrigerants. The compressor models with revision number "1" are qualified for operation with A1 refrigerants only.

The qualification and suitability for A2L operation and the changeover to revision number "2" in the compressor nomenclature are of application from serial number 21J7611M (October 1st, 2021) onwards.

2.3 Nameplate information

All important information for identification of the compressor is printed on the nameplate located below the compressor oil pump. The type of refrigerant used should be stamped on the nameplate by the installer.

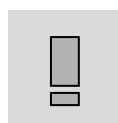


Figure 2: Stream compressor nameplate and nameplate location

The year and month of production are shown on the nameplate as part of the serial number (Jan = A, Feb = B, ... Dec = L). Example: the serial number **23C01811M** indicates a compressor manufactured in March 2023.

2.4 Application range

2.4.1 Qualified refrigerants and oils



IMPORTANT

Some refrigerant blends (for example R454C, R455A and R454A) have a significant temperature glide. It is essential that this glide be carefully considered when adjusting pressure and superheat controls.

NOTE: R454A, R454C and R455A are classified as A2L (mildly flammable) refrigerants.

NOTE: For systems using A1 refrigerants (R448A, R449A, R407A, R407F, R404A, R407C, R513A, R450A, R134a or R22) the flammable refrigerant sticker is not of application and can be removed from the compressor.

Compressors	Stream 4M* & 6M*		
Qualified refrigerants	R454C, R455A & R454A	R448A, R449A, R407A, R407F, R404A, R407C, R513A, R450A & R134a	R22
Qualified oils (factory charged)	RL32 3MAF	RL32 3MAF	Suniso 3 GS
Servicing oils	RL32 3MAF	RL32 3MAF Mobil EAL Arctic 22 CC	Shell 22-12, Suniso 3 GS Fuchs Reniso KM 32 Capella WF 32

Table 2: Qualified refrigerants and oils for recharging and topping up

Oil recharge values can be taken from Copeland Select software available at www.copeland.com/en-gb/tools-resources.

To recharge:

- When the compressor is completely empty of oil, the amount of oil to be "recharged" is typically 0.12 litre less than the original oil charge (oil will already be present in the system).

To top up:

- During commissioning, planned maintenance or servicing, add oil so that the compressor oil level is between min $\frac{1}{4}$ and max $\frac{3}{4}$ of the sight glass.

2.4.2 Application limits



CAUTION

Inadequate lubrication! Compressor breakdown! The superheat at the compressor suction inlet must always be sufficient to ensure that no refrigerant droplets enter the compressor. For a typical evaporator-expansion valve configuration a minimum stable superheat of at least 5 K is required.

For application envelopes and technical data, please see Copeland Select software available at www.copeland.com/en-gb/tools-resources.

2.4.3 PED category and maximum allowable pressure PS

The Pressure Equipment Directive PED 2014/68/EU does not apply to Stream 4M* and 6M* semi-hermetic compressors.

The pressure PS is the maximum allowable pressure at the low- and high-pressure sides of the compressor. The maximum pressure value PS for the individual compressor type is printed on the compressor nameplate. Safety is established in compliance with the relevant standards applicable to the given product. Also refer to **section 3.2.4 "Maximum allowable pressures"**.

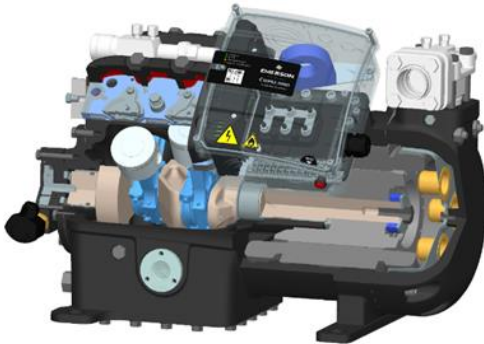
Compressor	PS High pressure side	PS Low pressure side
4M* & 6M*	32.5 bar(g)	22.5 bar(g)

Table 3: Maximum allowable pressures

2.5 Design features

2.5.1 Compressor construction

All Stream 4M* and 6M* compressors are fitted with dedicated valve plates. This is a unique Copeland valve plate design which is comparable to Discus valve plates. To maintain the high capacity of these compressors in case of exchange, make sure to always select the correct valve-plate-to-body gasket.



Each cylinder head has 2 plugged 1/8" - 27 NPTF tapped holes for connecting high-pressure switches.

The high-pressure switches must be calibrated and tested before putting the compressor into service. They must stop the compressor if the allowable pressure is exceeded.

The complete cylinder head area above the valve plate is under discharge pressure.

Figure 3: Stream compressor design

2.5.2 Compressor cooling

Compressor motors must always be cooled, and cylinder head cooling may also be needed at certain operating conditions.

All Stream compressors are suction-gas cooled. The motor is cooled by the incoming refrigerant, which enters the compressor and is then passed over the motor area. An additional fan may be required depending upon the operating conditions – see Select software at www.copeland.com/en-gb/tools-resources.

NOTE: The operation of the additional cylinder head fan can be controlled by the Copeland Compressor Electronics module (dedicated extension module C to be ordered).

2.5.3 Liquid injection / Demand Cooling



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The solenoid valve of the liquid injection is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed properly. Never operate the solenoid coil when not positioned on the solenoid valve. Secure the installation with a screw.

In general, there are two ways to provide additional liquid cooling in the 4M* and 6M* compressors:

- **Liquid injection functionality with the Copeland Compressor Electronics module:** In this case, the Copeland Compressor Electronics system is equipped with an additional extension module C. This control function is used in combination with an additional liquid injection valve kit, installed on the compressor housing.
- **Liquid injection functionality with the traditional Demand Cooling concept:** With this solution, an additional discharge temperature sensor, a separate Demand Cooling driver and a liquid injection valve kit work together.

Liquid injection may be required for low-temperature applications in order to keep the compressor within safe discharge temperature limits.

For low-temperature applications with R448A and R449A in certain areas of the operation envelope, liquid injection might be required on the following compressors:

4MF-13	4ML-15	4MM-20	4MT-22	4MU-25
6MM-30	6MT-35	6MU-40		

NOTE: For corresponding application envelopes, please see Copeland Select software, available at www.copeland.com/en-gb/tools-resources.

2.5.4 Unloaded start



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The solenoid valve of the unloaded start is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed properly. Never operate the solenoid coil when not positioned on the solenoid valve. Secure the installation with a screw.

Unloaded start is mainly required for compressors connected for part-winding start (for example with motor version AWM) or star-delta start (motor version EWM).

4M* and 6M* compressors can be equipped with an internal unloaded start system, to be ordered as an option. The compressor prepared for unloaded start is supplied with a special cylinder head. The control valve and coil are positioned on the top of the cylinder head. An additional check valve must be installed in the discharge piping. Recommended inbuild position for the check valve is approximately 50-100 cm to the compressor discharge connection.

Usually, the unloaded start is activated once for about 5-10 seconds shortly before compressor start and then kept closed during operation. The unloaded start solenoid valve opens a suction channel in the valve plate and the pressure in the discharge line equalizes to the suction side.

A. Standard operation

B. Unloaded start operation

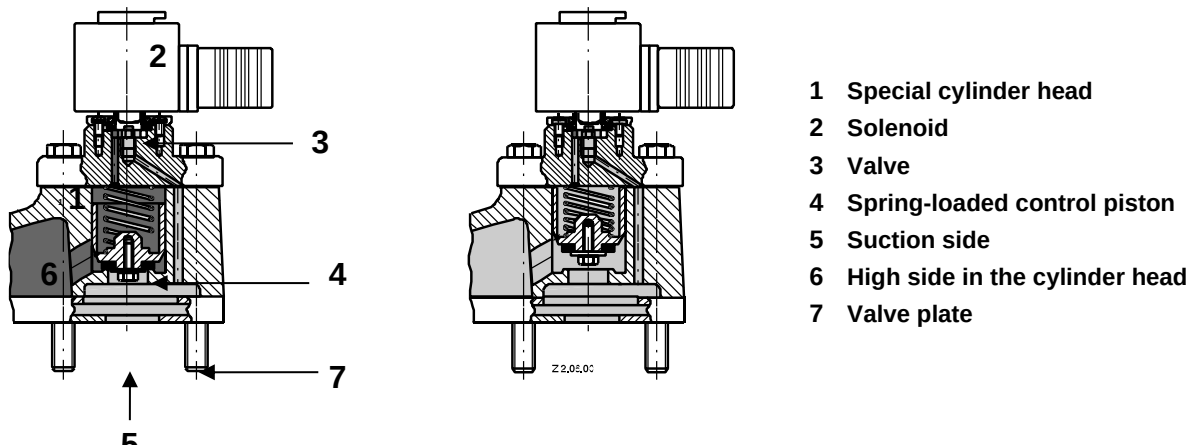


Figure 4: Unloaded start components & operation

Assembly

Installation of the modified cylinder head and valve plate for unloaded start is only possible at certain positions on the compressor. Therefore all 4M* and 6M* compressor models have fixed cylinder head positions for unloaded start.

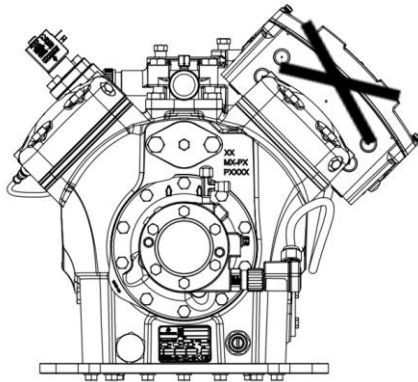


Figure 5: Unloaded start position 4M*

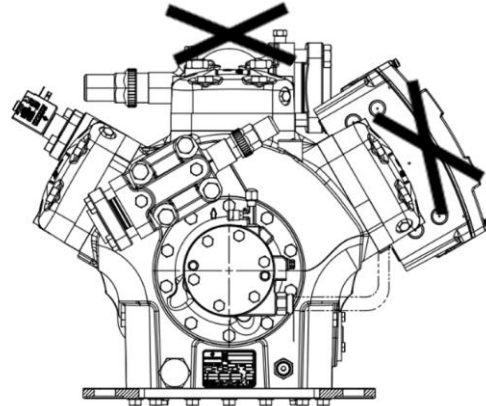


Figure 6: Unloaded start positions 6M*

NOTE: The operation of the unloaded start can also be controlled by the Copeland Compressor Electronics module (dedicated extension module D to be ordered).

2.5.5 Capacity control



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The solenoid valve of the capacity control is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed properly. Never operate the solenoid coil when not positioned on the solenoid valve. Secure the installation with a screw.

A mechanical capacity control is available for 4M* and 6M* compressors. The system used is blocked suction. The suction port of the valve plate will be closed by a control piston. When a compressor is ordered with capacity control, it is equipped with one (4M* models) or one/two (6M* models) special cylinder heads. The capacity control valves with coils are positioned on the top of the cylinder head. Not all cylinder bank positions are possible for the capacity control cylinder head.

Capacity control must be fitted in the following positions:

- 4M* 50 % Terminal box side
- 6M* 1st step 33 % Upper cylinder head
- 6M* 2nd step 66 % Terminal box side

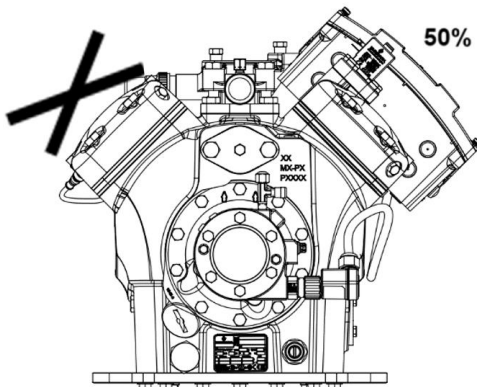


Figure 7: Capacity control position 4M*

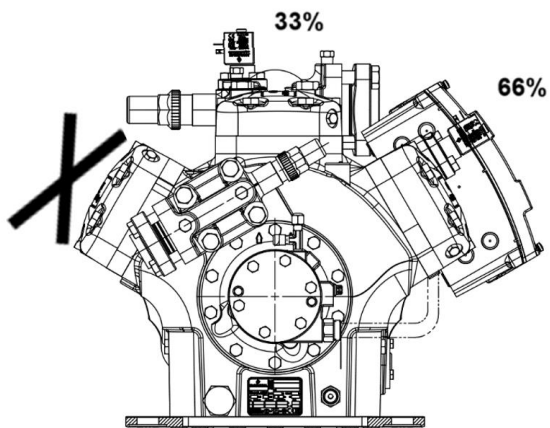


Figure 8: Capacity control position 6M*

2.5.6 Digital capacity control

4M* and 6M* compressors can be fitted with digital capacity control. For this purpose, the compressors must be factory-equipped with specially prepared cylinder heads that enable stepless capacity control with pulse width modulation. When equipped with the cylinder heads for digital capacity control, the compressors get an additional code letter "D" in the nomenclature, ie, 4M*D or 6M*D.

Applied to one bank on a 4M*D compressor it provides 50 to 100 % capacity modulation. When combined with a blocked suction bank on a 6M*D compressor, it provides 33 to 100 % capacity modulation.

Digital capacity control is achieved by using a proven internal unloading method, based on blocking gas to the valve plate suction area. Capacity control can be achieved by varying the percentage of duty cycle when the compressor is loaded and unloaded. The unloader piston mechanism that controls the flow of suction gas into the cylinders is driven by a special solenoid valve for high cycling rates.

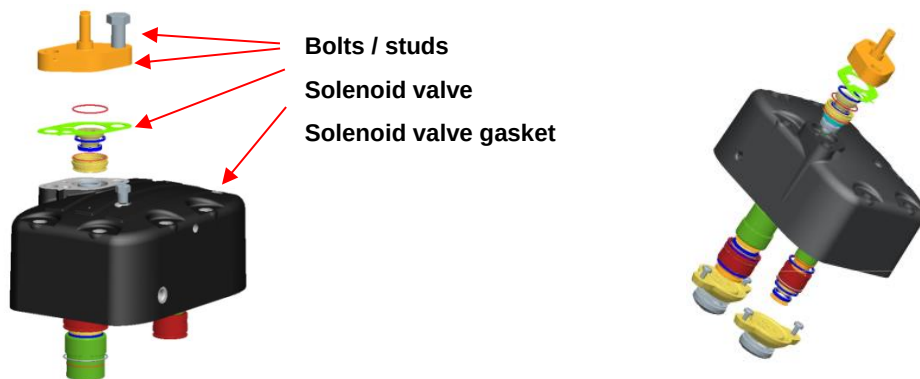


Figure 9: Digital modulation parts

NOTE: Stream compressors with Copeland Compressor Electronics can be fitted with an extension module D for unloaded start and digital regulation.

2.5.7 Oil pump

All Stream compressors are equipped with an external oil pump. The oil pump will always work in the correct direction of rotation, regardless of the rotation direction of the compressor.

Compressors delivered with Copeland Compressor Electronics (-N) or formerly with CoreSense Diagnostics (-D) include the oil pump and the electronic switch for the integrated oil pressure safety functionality.

Compressors with Copeland Protection (-P) are designed to accommodate fittings for an OPS2, FD-113ZU or Sentronic oil safety system or a standard oil pressure switch (OPS2 oil sensor included in the oil pump).

2.5.8 Oil pressure

Normal oil pressure is between 1 and 4.2 bar higher than crankcase pressure. Net oil pressure can be read by connecting two pressure gauges to the compressor and comparing the readings. One gauge should be connected to the oil pump. The second gauge should be connected to the crankcase (oil service plug or any other crankcase connection plug).

NOTE: The pressure measured on the suction service valve, where the refrigerant enters the compressor housing, does not correspond to the crankcase pressure and should not be used as a reference for the indication of oil differential pressure.

2.5.9 Oil circulation

Oil returns with the suction gases through a suction strainer and separates in the motor chamber reaching the crankcase by way of oil return relief valve in the partition between motor housing and crankcase. This relief valve closes on compressor start-up due to the pressure difference arising between motor side and crankcase, thus slowing down pressure decrease in the crankcase over a certain period of time. It reduces the foaming of the oil/refrigerant mixture that would occur if the pressure decreased rapidly.

The valve does not reopen until the pressure has been equalized by means of a crankcase ventilating valve. This second valve connects the crankcase and suction side cylinder head. It reduces the pressure difference by means of a very small bore in the plate of the valve so slowly that oil foams less and only limited oil/refrigerant foam is transferred to the oil pump.

Four-cylinder compressors have one crankcase ventilating valve on the left cylinder bank whereas six-cylinder compressors have two ventilating valves on the left and right cylinder banks.

2.5.10 Oil level

All 4M* and 6M* compressors are delivered with sufficient oil for normal operation – see individual oil quantities in Select. The optimum oil level should be checked by operating the compressor until the system is stable. The oil level should be min $\frac{1}{4}$ and max $\frac{3}{4}$ of the sight glass. However, a higher oil level may be accepted if an oil regulator is used as it will help to reduce excessive oil circulation.

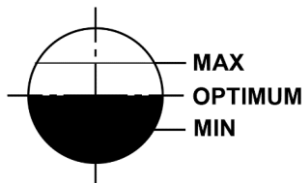


Figure 10: Oil level on 4M* and 6M* compressors

2.5.11 System oil return



CAUTION

Inadequate lubrication! Bearing and moving parts destruction! Ensure adequate oil return from the system into the compressor at any time. No liquid refrigerant return to the compressor. Liquid refrigerant dilutes the oil, could wash the oil off the bearings and moving parts and could lead to overheating and compressor failure.

The system piping must be carefully designed to ensure sufficient refrigerant gas velocity, so that oil returns to the compressor at all times and conditions. Individual piping diameter calculation depends on the refrigerant properties, pressure level, mass flow, and density.

Once a new system design is set and assembled, a functional test is required. The functional test includes a qualification for the general system oil return. Systems with multiple compressors (two, three, or more) require additional oil balancing qualification between the parallel compressors.

System engineers should review the system design and operation to identify the critical conditions and to check oil return and oil balancing. Typically, the following situations should be considered:

- **In single compressor systems:** to check oil return, testing conditions shall be at minimum mass flow and minimum density of suction gas in continuous and frequent start/stop cycling.
- **In multiple compressor systems:** to check oil return and oil balancing in the tandem or rack, testing conditions shall be at the corner points of the system application envelope in continuous and frequent start/stop cycling.
- The system shall also be tested with regards to liquid refrigerant floodback and superheat level of the refrigerant gas at compressor suction.

These checks should be carried out for standard operation, but also for special conditions such as compressor frequent start/stop, compressor start after long off time with migration, defrost, low load, load changes, fans or pumps cycling at low load and more.

2.6 Dimensions of Stream compressors

2.6.1 4M* models

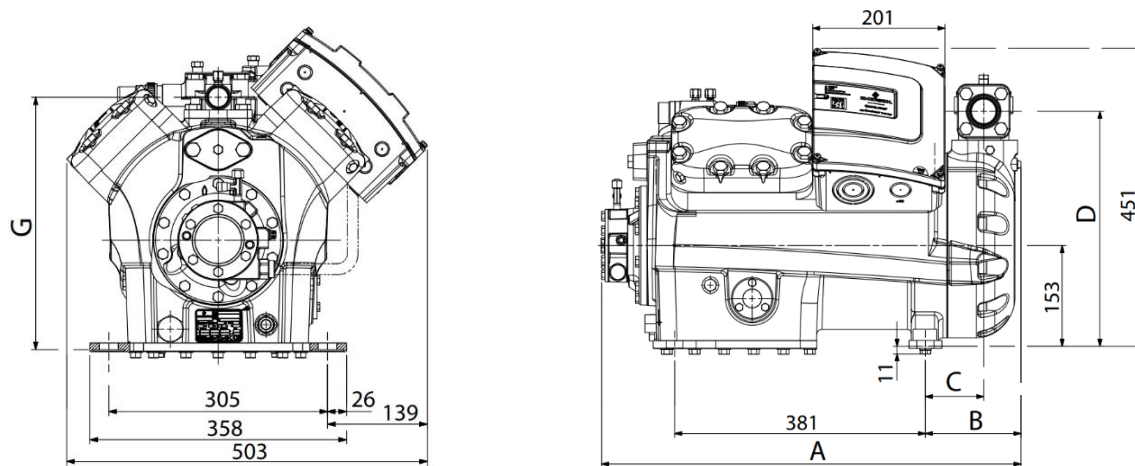


Figure 11: 4M* compressors dimensions

Compressor	A (mm)	B (mm)	C (mm)	D (mm)	G (mm)
4MF-13 4MA-22 4ML-15	637	145	88.5	355.9	354.6
4MH-25 4MM-20 4MI-30	662	170	99.4	376.2	354.8
4MT-22 4MJ-33 4MU-25	662	170	99.4	376.2	354.8
4MK-35	692	200	131.4	380	354.8

Table 4: 4M* compressors dimensions

2.6.2 6M* models

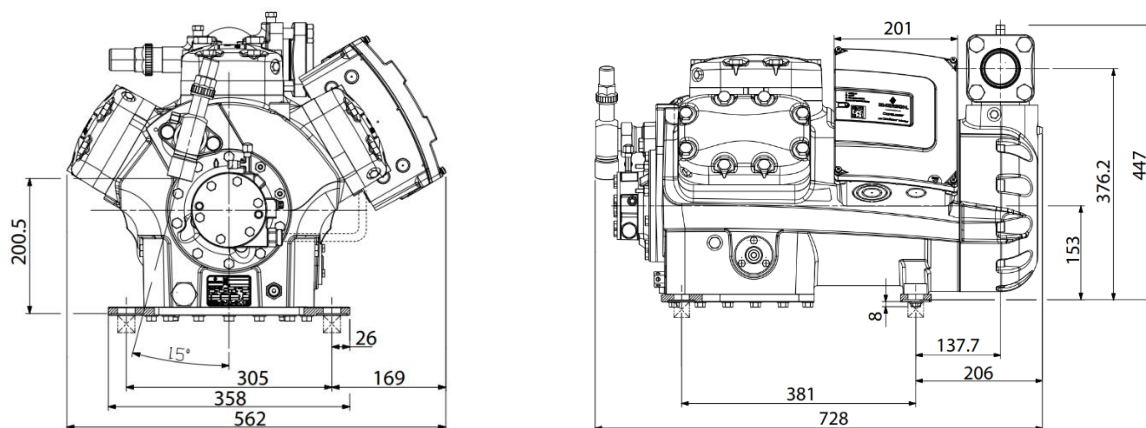


Figure 12: 6MM* and 6MI* compressors dimensions

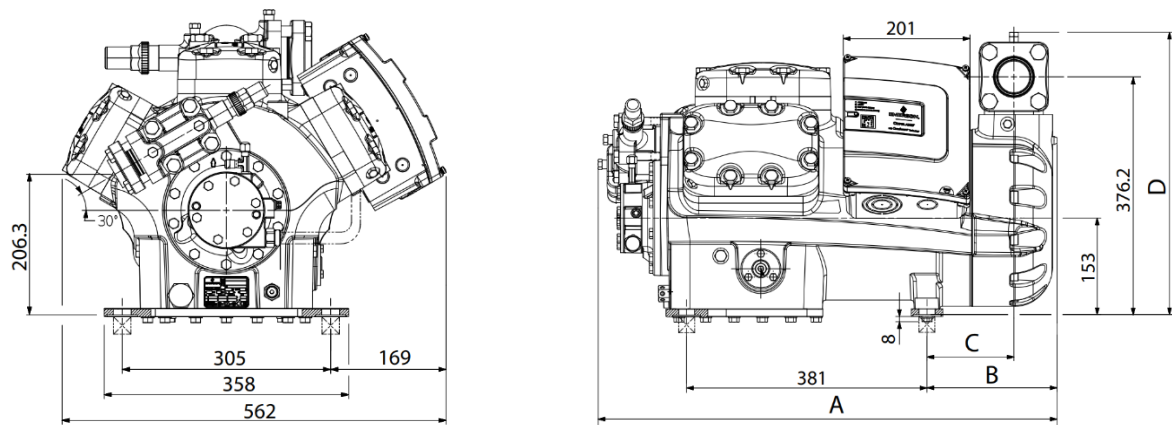


Figure 13: 6MT*, 6MJ*, 6MU* and 6MK* compressors dimensions

Compressor	A (mm)	B (mm)	C (mm)	D (mm)
6MT-35 6MJ-45	729	206	137.8	446
6MU-40	759	238	169.8	445
6MK-50	776	255	186.7	445

Table 5: 6MT*, 6MJ*, 6MU* and 6MK* compressors dimensions

3 Installation



WARNING

High pressure! Injury to skin and eyes possible! Be careful when opening connections on a pressurized item.

3.1 Compressor handling

3.1.1 Delivery

Please check whether the delivery is correct and complete. Any deficiency should be reported immediately in writing. Standard delivery:

- Suction and discharge shut-off valves (service compressor 4M*S and 6M*S have blind flanges instead of shut-off valves)
- Oil charge, oil sight glass
- Mounting kit
- Copeland Compressor Electronics module
- Holding charge up to 2.5 bar(g) (dry air)

Compressors are delivered on pallets. Cooling fans are delivered in separate boxes. Accessories may be mounted or delivered loose. Solenoid valves are never mounted.

3.1.2 Transport and storage



WARNING

Risk of collapse! Personal injuries! Move compressors only with appropriate handling equipment according to weight. Keep in the upright position. Respect stacking loads according to **Figure 14**. Check the tilting stability and if needed take action to ensure the stability of the stacked loads. Keep the packaging dry at all times.



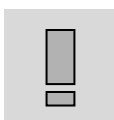
Respect the maximum number of identical packages which may be stacked on one another, where "n" is the limiting number:

- **Transport: n = 1**
- **Storage: n = 1**

Figure 14: Maximum stacking loads for transport and storage

NOTE: The compressor is pre-charged with dry air to avoid any moisture contamination.

3.1.3 Positioning and securing



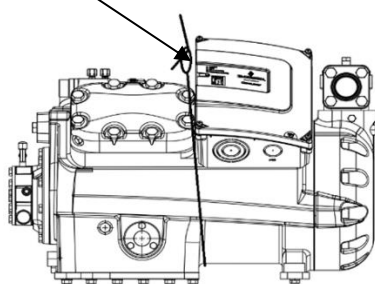
IMPORTANT

Handling damage! Compressor malfunction! Only use the lifting eyes whenever the compressor requires positioning. Using discharge or suction connections for lifting may cause damage or leaks.

If possible, the compressor should be kept horizontal during handling.

For safety reasons two lifting eyes should be fitted before moving a compressor (½" - 13 UNC). Otherwise refer to drawings in **Figure 15** to see how to apply other lifting methods.

4M*
max. 220 kg



6M*
max. 260 kg

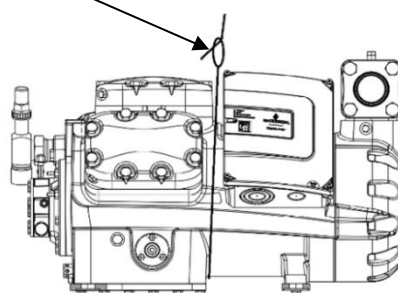


Figure 15: Compressor lifting methods

In order to avoid refrigerant leaks or other damage the compressors should not be lifted by the service valves or other accessories.

3.1.4 Installation location

Ensure the compressors are installed on a solid level base.

For multiple-compressor parallel configurations, the compressors must be positioned completely vertically on a totally horizontal surface or rail.

3.1.5 Mounting parts

To minimize vibration and start/stop impulses, flexible mounting should be used. For this purpose, one specific set of spring mounting parts is delivered with each Stream 4M* or 6M* compressor model.

Due to differences in weight (cylinder / motor side) different springs have to be used on each side. Springs have different colours for easier identification: violet on motor side and orange on cylinder side.

Transport clamps can be used for transportation purposes and must be removed for operation.

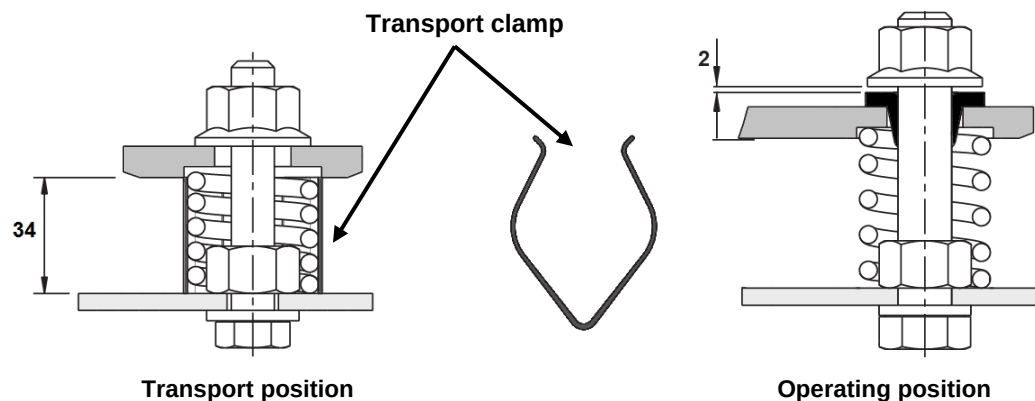


Figure 16: Position of vibration dampers during transport and operation

When Stream compressors are applied in parallel applications, for example in racks, harder rubber mounting parts are alternatives to the standard spring mounting parts.

A compressor may be rigidly mounted, ie, without springs. In this case more shock and vibration loading will be transmitted to the frame.

Unevenness in the mounting surface will have to be compensated by the rack and/or the compressor bottom plate/feet. Excessive unevenness can result in too high mechanical stress to the system and could damage the compressor or rack. Therefore, the flatness of the mounting location is essential. In addition, both vibration/shock and mechanical stress to the compressor can be avoided by using rubber mounting parts.

If the installation requires a very high level of vibration absorption, additional vibration absorbers – available on the market – can be fitted between the rails and the foundation.

3.2 Pressure safety controls

3.2.1 High-pressure protection

Applicable regulations and standards, for example EN 378-2, shall be followed to apply appropriate control and ensure that the pressure never exceeds the maximum limit.

High-pressure protection is required to stop the compressor operating outside the allowable pressure limits. The high-pressure control must be installed correctly, which means that no service valve is allowed between the compressor and the pressure protection.

The high-pressure cut-out setting shall be determined according to the applicable standard, the type of system, the refrigerant and the maximum allowable pressure PS.

The high-pressure cut-out should have a manual reset feature for the highest level of system protection.

3.2.2 Low-pressure protection



CAUTION

Operation outside the application envelope! Compressor breakdown! A low-pressure protection shall be fitted in the suction line in order to stop the compressor when it operates outside the envelope limits. Do not bridge or by-pass the low-pressure limiter.



CAUTION

Low suction pressure operation! Compressor damage! Do not operate compressor with a restricted suction or with the low-pressure limiter bridged. Do not operate compressor at pressures that are not allowed by the operating envelope. Allowing the suction pressure to drop below the envelope limit for more than a few seconds may overheat the pistons and cause damage to parts.

Applicable regulations and standards shall be followed to apply appropriate control and ensure that the pressure is always above the required minimum limit.

The low-pressure control must be installed correctly into the suction line, which means that no service valve is allowed between the compressor and the pressure protection.

The minimum cut-out setting shall be determined according to the refrigerant and the allowed operation envelope – see Select software at www.copeland.com/en-gb/tools-resources.

The low-pressure cut-out should have a manual reset feature for the highest level of system protection.

3.2.3 Protection of A2L-refrigerant systems operating below atmospheric pressure



WARNING

Operation below atmospheric pressure! Fire hazard! During operation below atmospheric pressure, a flammable mixture can form inside the system. Ensure system tightness to prevent any ingress of air.



CAUTION

Operation outside the application envelope! Compressor breakdown! A low-pressure protection shall be fitted in the suction line to stop the compressor when it operates outside the envelope limits.



CAUTION

Low suction pressure operation! Compressor damage! Do not operate compressor with a restricted suction or with the low-pressure limiter bridged. Do not operate compressor at pressures that are not allowed by the operating envelope. Allowing the suction pressure to drop below the envelope limit for more than a few seconds may overheat the pistons and cause damage to parts.

Special requirements for safety and tightness apply to 4M* and 6M* compressor systems that are to be operated below atmospheric pressure. The following precautions must be observed:

- Check all the critical points on the system and piping connections; tightness has to be ensured also at very low pressure.
- Limit the minimum absolute working pressure to 0.5 bar; it is recommended to install a mechanical low-pressure cut-out for quick response.
- The installation of mechanical high-pressure and low-pressure cut-outs is mandatory. For systems provided with a service shut-off valve on the discharge side of the compressor, only mechanical pressure cut-outs shall be used. Electronic pressure limiters, which could cause delayed sensor response, are not allowed.
- The high- and low-pressure cut-outs must be installed correctly on the discharge and suction lines, which means that no service valve is allowed between the compressor and the pressure protection (refer to EN 378 or ISO 5149).
- A discharge temperature control is mandatory to stop the compressor when the maximum discharge temperature is exceeded.
- Additional warning notices shall be affixed to any system equipped with shut-off valves. The warnings must contain instructions to open the shut-off valves completely after each repair or maintenance work. The compressors may only be energized when the safety measures (high- and low-pressure cut-outs and discharge temperature cut-out) have been checked and verified to be operational.

NOTE: All of the above points must be fulfilled. If any of them cannot be met, the compressor must not be operated below atmospheric pressure.

3.2.4 Maximum allowable pressures

The maximum allowable pressures according to EN 12693 are shown on the compressor nameplate. They are obligatory and must not be exceeded.

- High-pressure side (HP): 28.0 bar(g) (up to S/N 14K46143M)
32.5 bar(g) (from S/N 14K46144M onwards)
- Low-pressure side (LP): 22.5 bar

NOTE: The compressor operating range may be restricted for various reasons. Check the application range limitations in Select software at www.copeland.com/en-gb/tools-resources.

3.3 Brazing procedure



WARNING

Air/flammable refrigerant mixture! Creation of a potentially flammable atmosphere! Fire hazard! Remove all refrigerant before opening the system. When working on a refrigerant-filled system, make sure to follow the safety and working instructions given in **Chapter 6 "Maintenance & repair"**.



WARNING

High temperature! Burning! Proceed with caution when brazing system components. Do not touch the compressor until it has cooled down. Ensure that other materials in the area of the compressor do not come into contact with it.



CAUTION

Blockage! Compressor breakdown! Maintain a flow of oxygen-free nitrogen through the system at very low-pressure during brazing. Nitrogen displaces the air and prevents the formation of copper oxides in the system. If allowed to form, the copper oxide material can later be swept through the system and block screens such as those protecting capillary tubes, thermal expansion valves, and accumulator oil return orifices.

Contamination or moisture! Bearing failure! Do not remove the connection plugs until the compressor is set into the unit. This minimises any entry of contaminants and moisture.

Refer to **Figure 17** and procedure below for the brazing of the suction and discharge lines:

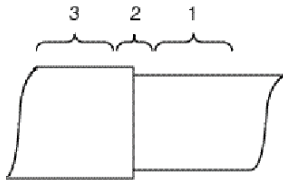


Figure 17: Brazing areas

- Flushing oxygen-free nitrogen through the piping during the brazing process is recommended for applications with A1 refrigerants and mandatory for applications with flammable A2L refrigerants.
- The copper-coated steel tubes on Stream compressors can be brazed in approximately the same manner as any copper tube.
- Recommended brazing material: any Silfos material is recommended, preferably with a minimum of 5 % silver. However, 0 % silver is acceptable. For brazing connections where dissimilar

or ferric metals are joined a silver alloy rod with a minimum silver content of 30 % shall be used being either flux-coated or with a separate flux.

- Be sure tube fitting inner and outer surfaces are clean prior to assembly.
- Using a double-tipped torch, apply heat in area 1.
- As the tube approaches brazing temperature, move the torch flame to area 2.
- Heat area 2 until braze temperature is attained, moving the torch up and down and rotating around the tube as necessary to heat the tube evenly. Add braze material to the joint while moving the torch around the joint to flow braze material around the circumference.
- After the braze material flows around the joint, move the torch to heat area 3. This will draw the braze material down into the joint. The time spent heating area 3 should be minimal.
- As with any brazed joint, overheating may be detrimental to the final result.

3.4 Filter screens



CAUTION

Screen blocking! Compressor breakdown! Use screens with at least 0.6 mm openings.

The use of screens finer than 30 x 30 meshes (0.6 mm openings) anywhere in the system should be avoided with these compressors. Field experience has shown that finer mesh screens used to protect thermal expansion valves, capillary tubes or accumulators can become temporarily or permanently plugged with normal system debris and block the flow of either oil or refrigerant to the compressor. Such blockage can result in compressor failure.

3.5 Insulation material

Insulation material is commonly used in a system to insulate the suction line, suction accumulator, expansion valve bulb or discharge line thermostat. When choosing the insulation material for A2L applications, particular attention shall be paid to its non-electrostatic properties, as it could be a potential ignition source.

4 Electrical connection

4.1 General recommendations

The compressor terminal box has a wiring diagram on the inside of its cover. Before connecting the compressor, ensure the supply voltage, the phases and the frequency match the nameplate data.

The knockouts on the terminal box have to be removed before the electrical glands can be installed. First make sure that the terminal box is closed with its cover. Copeland recommends to use a subland twist drill to avoid any damage to the box while removing the knockouts.



Figure 18: Knockouts on terminal box

For safety reasons, Copeland recommends that the electrical installation be executed in compliance with standard EN 60204-1 and/or other standards and regulations of application when dealing with A2L mildly flammable refrigerants such as R454C, R455A and R454A.

When installing 4M* or 6M* compressors in A2L systems, the following measures must be taken:

- To ensure the wires are properly terminated, the correct terminal and clamping tool for the selected wire size must be used.
- The ground wiring must conform to local regulations and codes of practice (only the provided parts must be used).
- The grounding screw must be torqued to 4.5 to 5.7 Nm.
- A cable strain-relief device must be added.
- Cable and wires must be protected against sharp edges.

4.2 Electrical installation



WARNING

Conductor cables! Electrical shock hazard! Shut off power supply before undertaking any task on electrical equipment.



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The electrical connection of the compressor is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed properly according to installation instructions. Ensure correct mechanical and electrical installation.

Follow the installation and torque instructions below.

System capacitors may remain charged for several minutes after shutdown. Before starting to work on the electrical installation make sure sparking is not possible. Continuously check if the ambient atmosphere is non-flammable when working on the electrical installation.



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! Electrical connections of compressor accessories, eg, crankcase heater, solenoid valves, Copeland Compressor Electronics modules, etc. are not ignition sources during normal operation in A2L-refrigerant systems but could become one if not installed properly according to installation instructions. All cable ends must be fixed properly in the terminal blocks. Ensure permanent and safe connection of all cable connections.

NOTE: For the correct installation of the electrical fasteners on the terminal plate connections, a tightening torque of 8.5 to 9.6 Nm is required on the nuts.

NOTE: It is recommended to install a residual current device (RCD) in any electrical system associated with Stream 4M* and 6M* compressors and A2L flammable refrigerants such as R454C, R455A and R454A. The purpose of the RCD is to detect current leaks to the ground in case of electrical issues, for example with the terminal connection pins or electrical accessories.



Figure 19: Residual current device (RCD)

All compressors can be started Direct-On-Line.

The position of bridges required for Direct-On-Line start (depending on type of motor and/or mains voltage) is shown in **Section 4.2.3 "Jumpers position"**.

4.2.1 Part-winding motors (YY/Y) – Code A

A part-winding motor contains two separate windings (2/3 + 1/3) which are internally connected in star and operated in parallel. The voltage cannot be adapted by changing the electrical connections as the motor is only suitable for one voltage.

The first part-winding, ie, the 2/3 winding on terminals 1-2-3, can be used for part-winding start by removing the bridges. After a time delay of 1 ± 0.1 seconds the second part-winding, ie, the 1/3 winding on terminals 7-8-9, must be brought on line.

4.2.2 Star / Delta motors (Y/Δ) – Code E

This motor is interchangeable for star (Y) or delta (Δ) operation by means of bridges. It is suitable for two voltages, eg, 230 V in delta, 400 V in star connection. If the supply voltage and the nominal voltage of the motor in Δ-connection are identical, the star connection motor can also be used for starting (remove the bridges!).

4.2.3 Jumpers position

Part-winding motors can be connected direct-on-line or part-winding start:

Part-winding motor: Y-Y Code A	Direct-on-line start Y-Y	Part-winding start First start step 1-2-3 Y-Y

Star / Delta motors can be connected direct-on-line or Star/Delta start:

Star/Delta motor: Y-Δ Code E	Direct-on-line start Δ	Direct-on-line start Y	Star/Delta start Y-Δ

4.3 Terminal box



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! Particular attention must be paid in A2L-refrigerant systems as any work on the energized terminals in the compressor terminal box could create an ignition. Do not touch the energized terminals with a tool or cable when the compressor is energized. Compressors operating with flammable refrigerants shall use only the qualified terminal box supplied with the compressor.

The terminal box is IP54 for all Stream 4M* and 6M* compressor models.

Cable glands have an influence on the protection class of the terminal box. The use of appropriate cable glands is strongly recommended in order to maintain the IP protection class.

4.4 Electrical protection

Independently from the internal motor protection, fuses must be installed before the compressor. The selection of fuses has to be made according to VDE 0635, DIN 57635, IEC 269-1 or EN 60-269-1.

4.5 Compressor protection

All Stream 4M* and 6M* compressor models are factory-fitted with a compressor protection. The standard scope of delivery contains the Copeland Compressor Electronics extended and advanced compressor protection system.

Alternatively the compressors can be ordered with Copeland Protection (formerly CoreSense Protection), a less advanced protection system.

Protection		Examples of designation	Comments
Copeland Compressor Electronics	"N"	4MK2-35-AWM/D-N-X0000	From S/N 21E59371 (May 2021) onwards
Copeland Protection	"P"	4MK2-35-AWM/D-P-X0000	Optional version
Next Generation CoreSense	"N"	4MK1-35X-AWM/D-N	From S/N 19L55XXX (Dec 2019) to S/N 21E59371M (May 2021)
CoreSense Diagnostics	"D"	4MK1-35X-AWM/D-D	From S/N 10A52XXX (Jan 2010) to S/N 20L30XX (Dec 2020)

Table 6: Overview of compressor protection systems on 4M* and 6M* compressors

4.5.1 Copeland Compressor Electronics



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The electrical switch of the Copeland Compressor Electronics module is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed properly according to installation instructions.

Copeland Compressor Electronics (formerly Next Generation CoreSense) is standard in all Stream 4M* and 6M* compressors. With active protection, advanced algorithms and features like fault history and LED indicators, Copeland Compressor Electronics enables technicians to diagnose the past and recent state of the system, allowing for quicker, more accurate diagnostics and less downtime.



Figure 20: Copeland Compressor Electronics module



Figure 21: Module location in terminal box

The Copeland Compressor Electronics module has a compact design with a base board and optional plug-in modules with advanced functionalities. The base board with current, discharge temperature and oil sensor, provides advanced diagnostics and protection against faults such as high discharge temperature, locked rotor, single/missing phase, voltage imbalance, low voltage etc. An external overload protection is not necessary. The module is capable of communication via Modbus and Bluetooth (optional) protocol. The optional plug-in modules on the base board will bring additional functionalities.

4.5.1.1 Copeland Compressor Electronics – Specifications

The Copeland Compressor Electronics module is located and prewired in the terminal box. All required parameters are flashed during the production of the compressor.

The power supply for the control module can be 115 or 230 VAC.

Operating ambient temperature	-30 to 70 °C
Storage temperature	-30 to 80 °C
Voltage requirements	115-230 VAC - 50/60 Hz
Protection class	IP00

Table 7: Copeland Compressor Electronics specifications

4.5.1.2 Copeland Compressor Electronics – Features

Copeland Compressor Electronics is a modular system. This modular design gives the customers the flexibility to choose individual protection and/or control levels. It is possible to extend the compressor protection from just basic functions to a high tier protection to enlarge the lifetime of the compressor.



Figure 22: Inside view of the Copeland Compressor Electronics module, with the modular boards

Basic features	
Motor overheat protection	High discharge temperature protection
Insufficient oil pressure protection	Oil level protection (in combination with Copeland Flow Controls TraxOil)
Current protection	Phase failure protection
Voltage imbalance protection	Undervoltage and overvoltage protection
Power consumption measurement	Part-winding protection
Crankcase heater control	Welded contactor protection
Switching frequency overstepping protection	Connection with computer, Android or iOS device
LEDs on the terminal box cover	Reset button for manual reset

Table 8: List of basic features

4.5.1.3 Copeland Compressor Electronics – Extension modules

On demand, the Copeland Compressor Electronics basis module can be equipped with extension modules, for additional features and functions:

- Extension module C: Liquid injection and head fan control
- Extension module D: Digital modulation and unloaded start
- Extension module E: Modbus connectivity

NOTE: More information about Copeland Compressor Electronics and available functions and protections can be found in the following Technical Information:

- TI_Stream_NGCS_01 "Copeland Compressor Electronics for Copeland Stream compressors".
- TI_Stream_NGCS_02 "Modbus communication".
- TI_Stream_NGCS_03 "Modbus extension module – Quick installation guide".
- TI_Stream_NGCS_04 "Copeland Compressor Electronics for Copeland Stream compressors – Quick installation guide".
- TI_Stream_NGCS_05 "Next Generation CoreSense for Copeland Stream Compressors – Guide for the Replacement of CoreSense Diagnostics".
- TI_Stream_NGCS_06 "Copeland Compressor Electronics – Liquid injection extension module C – Quick installation guide".
- TI_Stream_NGCS_07 "Copeland Compressor Electronics – Digital modulation extension module D – Quick installation guide".

4.5.1.4 Copeland Compressor Electronics – Basic modules connections

The Copeland Compressor Electronics module is originally delivered with the basic modules preconnected.

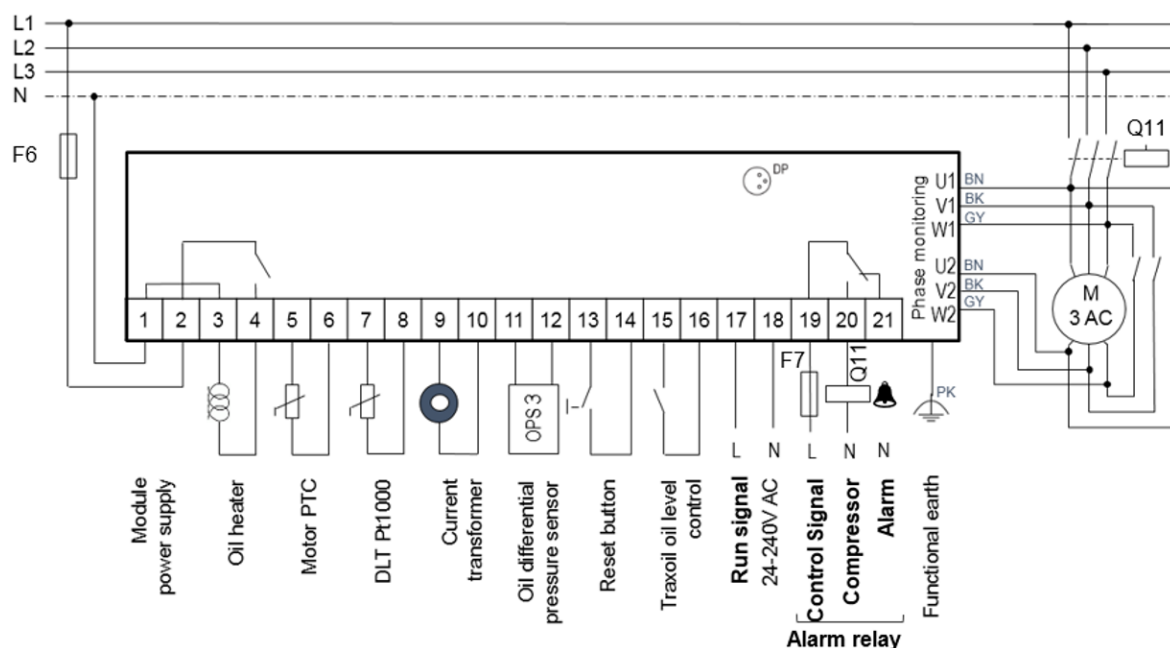


Figure 23: Basic module connections

4.5.1.5 Copeland Compressor Electronics – Electrical connections & wiring diagrams

Legend of the wiring diagrams

B1..... Discharge gas sensor	DGT Discharge gas temperature monitoring
B2..... Oil level watch (TraxOil)	OW..... Digital oil level watch
B3..... Oil differential pressure switch (OPS)	OPS Oil differential pressure protection
B11..... High-pressure switch	AR Alarm relay
B12..... Low-pressure switch	DS Run/control signal
CTR2..... DP Gateway	
E1..... Heater	CH..... Control oil heater
F1/F2/F3. Compressor fuses	PTC..... Motor thermic protection
F4/F5..... Fan fuses	PM..... Phase monitoring
F6 Module and heater fuse	PS Power supply
F7 Control circuit fuse	
H1..... Diagnosis LED	K11..... Time relay for part winding (if used)
M2 Fan motor	
Q11 Compressor contactor	Q14 Compressor contactor 2 nd part winding (if used)
Q12 Compressor contactor Y (if Y/Δ start)	Q15 Fan contactor
Q13 Compressor contactor Δ (if Y/Δ start)	
SB1 Reset button	
Y21..... Solenoid valve capacity control 1	Y22..... Solenoid valve capacity control 2
T1 Current sensor	CM Current monitoring

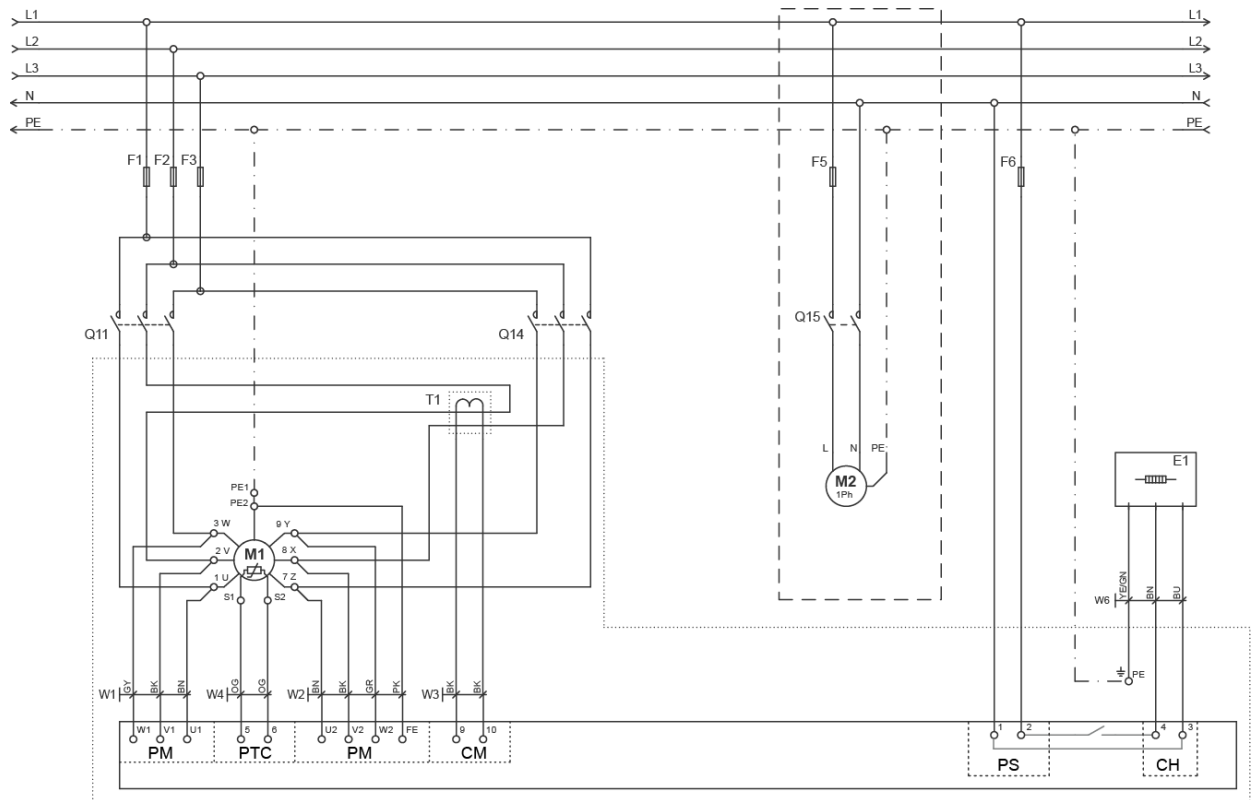


Figure 24: Wiring diagram – Part-winding motors (AW...) for part-winding start

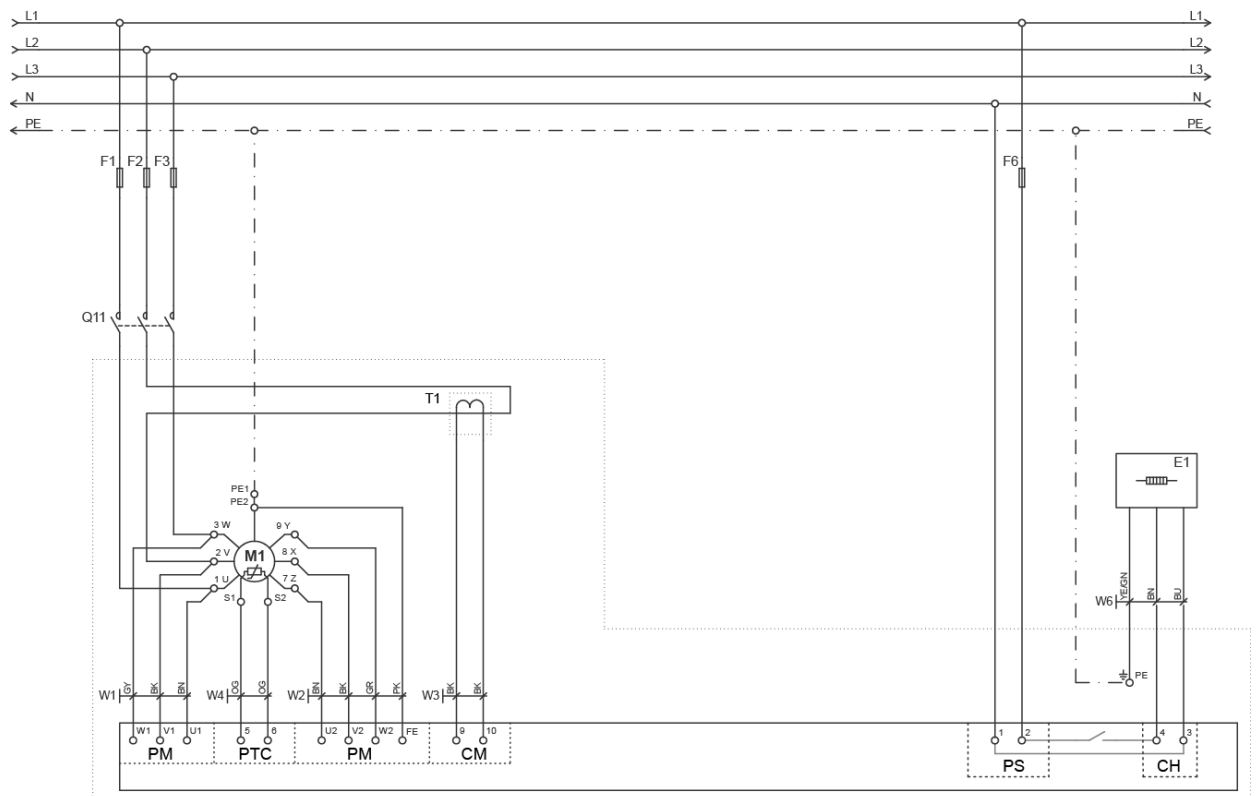


Figure 25: Wiring diagram – Part-winding motors (AW...) for direct-on-line start

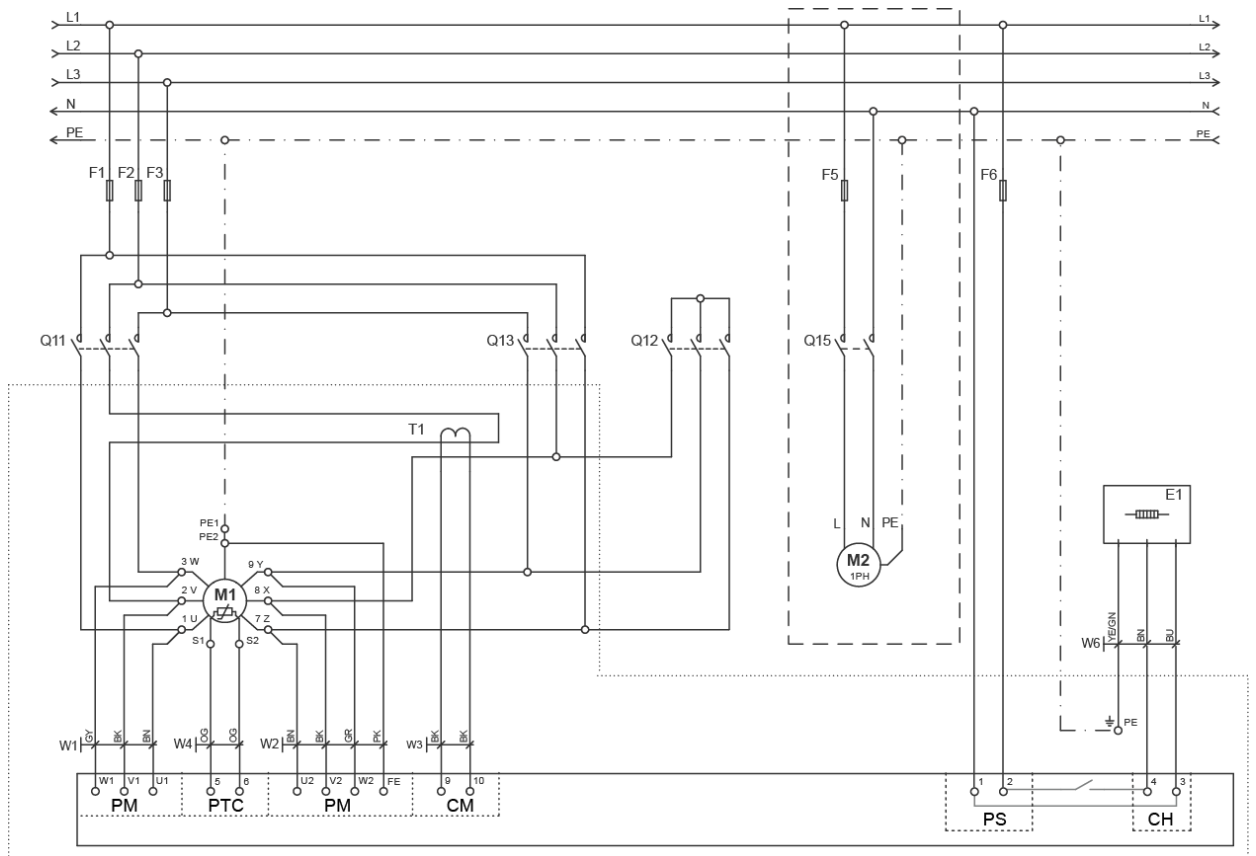


Figure 26: Wiring diagram – Star/Delta motors (EW...)

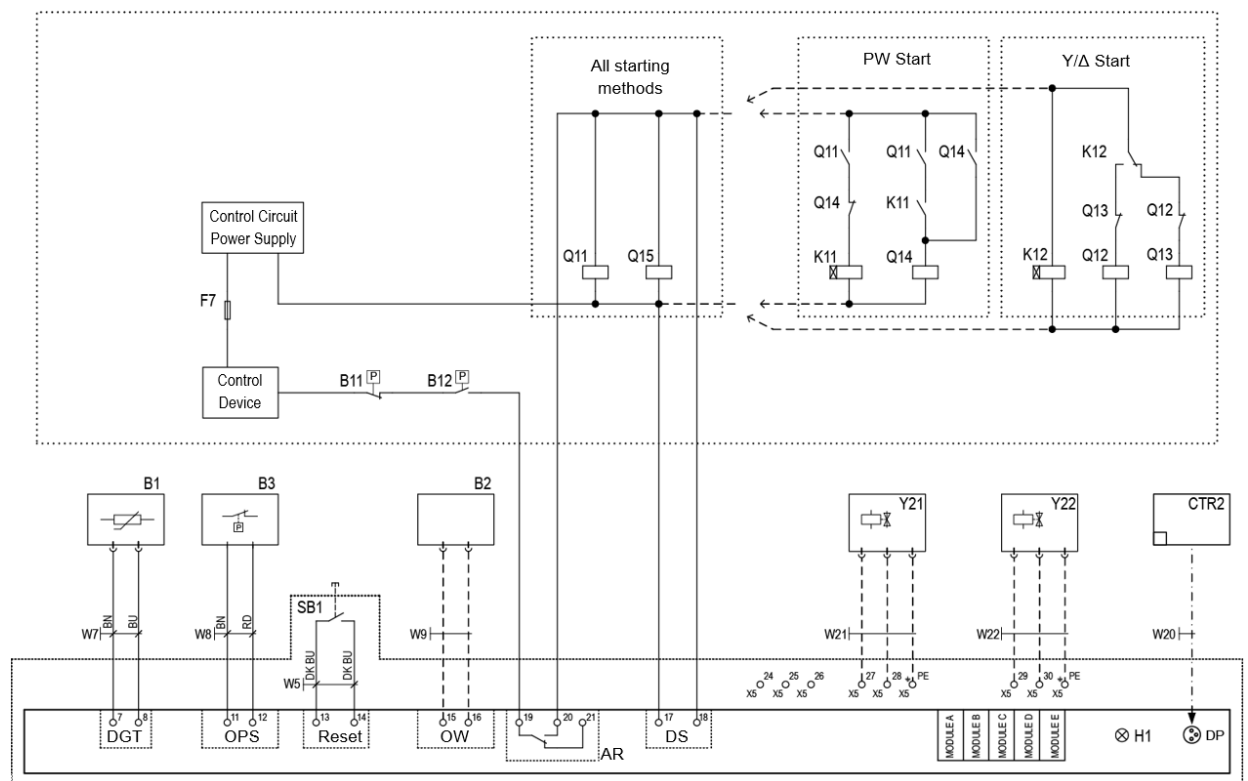


Figure 27: Wiring diagram – Part-winding and Star/Delta motors (AW... & EW...)

4.5.2 Copeland Protection

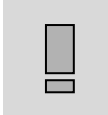


WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The Copeland Protection module is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed and connected properly.

As an alternative to the standard Copeland Compressor Electronics, Stream compressors can also be delivered with Copeland Protection, a more basic compressor protection system. This compressor variation is available as an option in compressor production and must be ordered accordingly. The compressors equipped with a Copeland Protection device will have a "-P" at the end of the description.

4.5.2.1 Copeland Protection – Specifications



IMPORTANT

Different sources for power supply and contact 11-14! Module malfunction!

Use the same potential for the power supply (L) and the switch contact of the control loop (11-14).

In compressors with Copeland Protection, the temperature-dependent resistance of the thermistor (PTC-resistance) is used to sense the winding temperature. Two chains of three thermistors, each connected in series, are embedded in the motor windings in such a manner that the temperature of the thermistors can follow with little inertia.

The Copeland Protection module switches a control relay depending on the thermistor resistance. It is installed in the terminal box to which the thermistors are connected.

Caution: The maximum test voltage for thermistors is 3 V.

The total resistance of the thermistor chains on a cold compressor should be $\leq 1800 \Omega$.

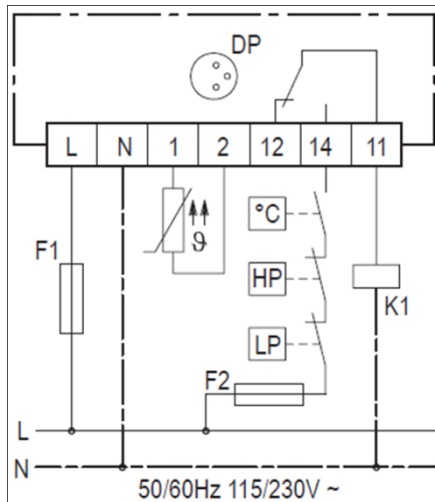
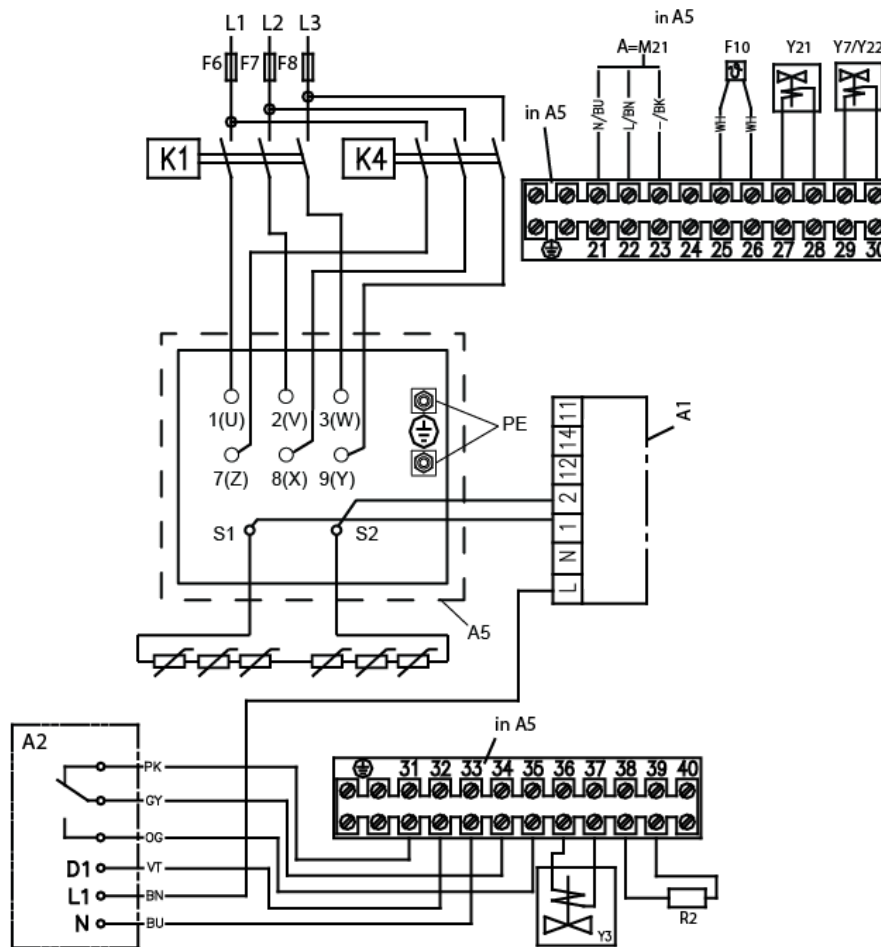


Figure 28: Control circuit wiring diagram

Protection class of the module: IP20.

4.5.2.2 Copeland Protection – Wiring diagrams

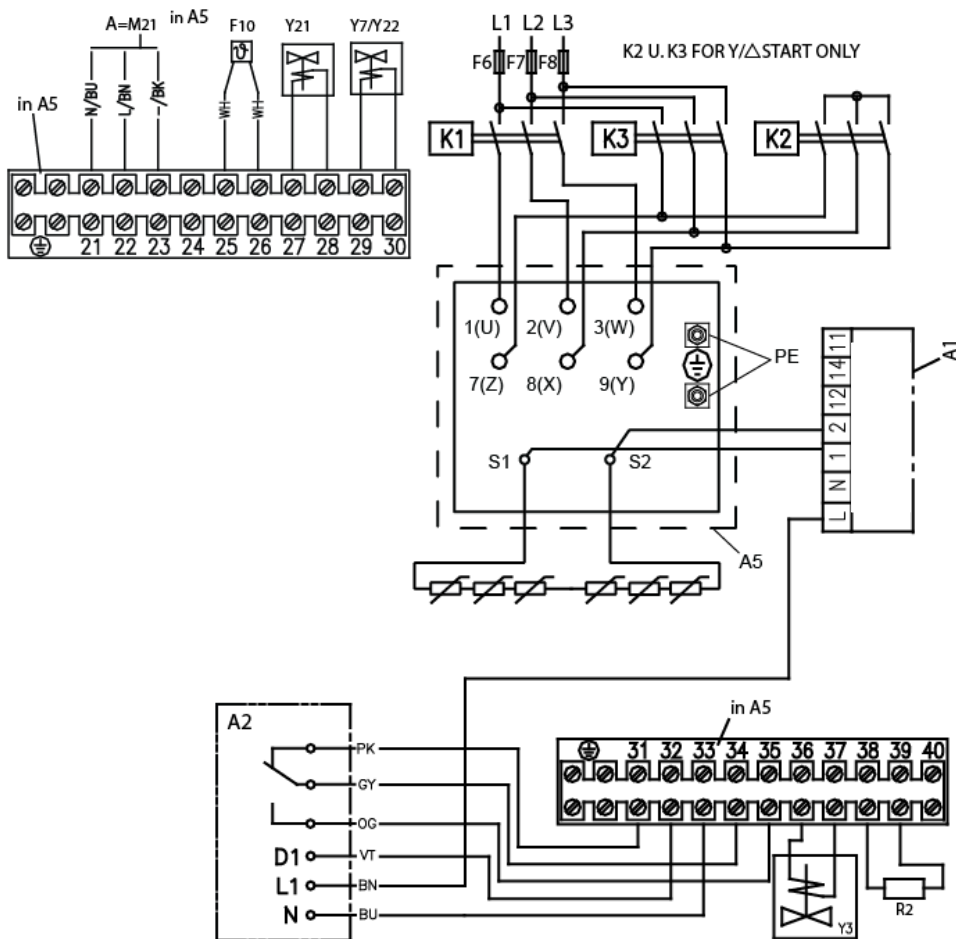
Part-winding motors can be connected direct-on-line or part-winding start.



Legend

A1..... Copeland Protection module	K1..... Contactor M1
A2..... OPS2 Oil pressure switch	K4..... Contactor M1 for second part winding
A5..... Compressor terminal box	M21..... Fan motor / condenser
F6..... Fuse for control circuit	R2 Crankcase heater
F7..... Fuse for control circuit	Y21..... Solenoid valve capacity control 1
F8..... Fuse for control circuit	Y22..... Solenoid valve capacity control 2
F10..... Thermal protection switch M21	Y3..... Solenoid valve unloaded start

Figure 29: Wiring diagram – Part-winding motors (AW...)



Legend

A1..... Copeland Protection module	K1 Contactor M1
A2..... OPS2 Oil pressure switch	K2 Contactor M1 Y-connection
A5..... Compressor terminal box	K3 Contactor M1 Δ-connection
F6 Fuse for control circuit	M21..... Fan motor / condenser
F7 Fuse for control circuit	R2 Crankcase heater
F8 Fuse for control circuit	Y21/22 ... Solenoid valves capacity control
F10 Thermal protection switch M21	Y3 Solenoid valve unloaded start

Figure 30: Wiring diagram – Star/Delta motors (EW...)

4.5.2.3 Oil differential pressure control

The oil pressure switch breaks the control circuit when the pressure difference between the oil pump outlet and the crankcase is too low. The switch must be properly adjusted and tamper-proof. If the oil differential pressure drops below the minimum acceptable value the compressor will be stopped after a 120-second delay. After having solved the problem the control has to be reset manually.

NOTE: Proper oil pressure safety control with an approved switch is a condition of warranty!

The following oil pressure switches can be delivered as accessories:

- Electronic oil pressure switch OPS2
- Mechanical oil pressure switch Copeland Flow Controls FD-113ZU, applicable only with A1 refrigerants

Electronic oil pressure differential switch OPS2



WARNING

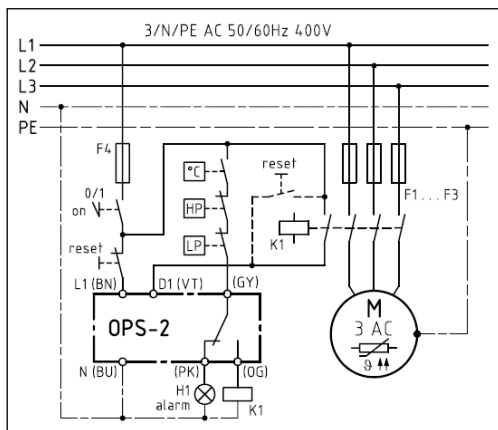
Ignition source in a potentially flammable atmosphere! Fire hazard! The electronic oil pressure switch is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed and connected properly.

The specifications for the OPS2 oil pressure switch are as follows:

- Differential pressure: 0.95 ± 0.15 bar
- Time delay: 120 ± 15 sec

Where there is a 5-wire cable connection between the electrical control panel and the compressor terminal box to the OPS module, the same wires can be applied to the OPS2 which will give the functions of an OPS1 module.

To obtain use of all of the features of the OPS2 a 7-wire cable should be used between the electrical control cabinet and the compressor terminal box. The wiring diagram in **Figure 31** below relates to an option using a 7-wire cable.



Wiring:

- Brown (BN) = Power supply input
- Violet (VIO) = Running signal from the compressor
- Grey (GR) = Input changeover contact from the daisy chain
- Orange (OG) = Output changeover contact linked to the compressor contactor
- Pink (PK) = Output changeover contact linked to the alarm
- Blue (BU) = Power supply output

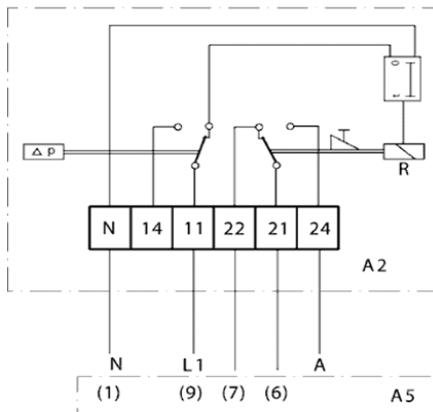
Figure 31: Wiring diagram OPS2

NOTE: Where a 5- or 7-wire cable is stated a 4- or 6-wire cable is required. In some countries only a 5- or 7-wire cable is available. See more wiring diagrams and more information about OPS2 in Technical Information TI Semi_Oil_Pressure_02 "Copeland semi-hermetic compressors – Oil pressure differential switch OPS2" available at www.copeland.com/en-gb.

Electro-mechanical oil pressure switch – Copeland Flow Controls FD-113ZU

The oil differential pressure switch FD-113ZU from Copeland Flow Controls is released for A1 refrigerants only. Application with A2L refrigerants is not possible. The specifications for the FD-113ZU electro-mechanical oil pressure switch are as follows:

- Cut-out pressure: 0.63 ± 0.14 bar
- Cut-in pressure: 0.9 ± 0.1 bar
- Time delay: 120 ± 15 sec



Legend:

- 11..... Voltage connection
- 21..... Control voltage connection
- 22..... Control circuit
- 24..... Alarm connection
- A2..... Oil pressure switch
- A5..... Compressor terminal box
- R..... Relay
- N..... Neutral connection
- t Time delay

Figure 32: Wiring diagram FD-113ZU

Protection class: IP30.

4.5.3 CoreSense Diagnostics (until December 2019)



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The electrical switch of the CoreSense Diagnostics module is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed properly according to the installation instructions.

CoreSense Diagnostics was the standard protection system for Stream 4M* and 6M* compressors until December 2019 included. Stream compressors with "-D" at the end of the description are equipped with a CoreSense Diagnostics device.

CoreSense Diagnostics combines oil and motor protection, including the oil differential pressure protection and the observation of the internal thermistor chain. It provides advanced protection against faults such as high discharge temperature, locked rotor, single/missing phase, voltage imbalance and low voltage. An external overload protection is not necessary. The module is capable of communication via Modbus protocol.



Figure 33: Stream compressor with CoreSense Diagnostics

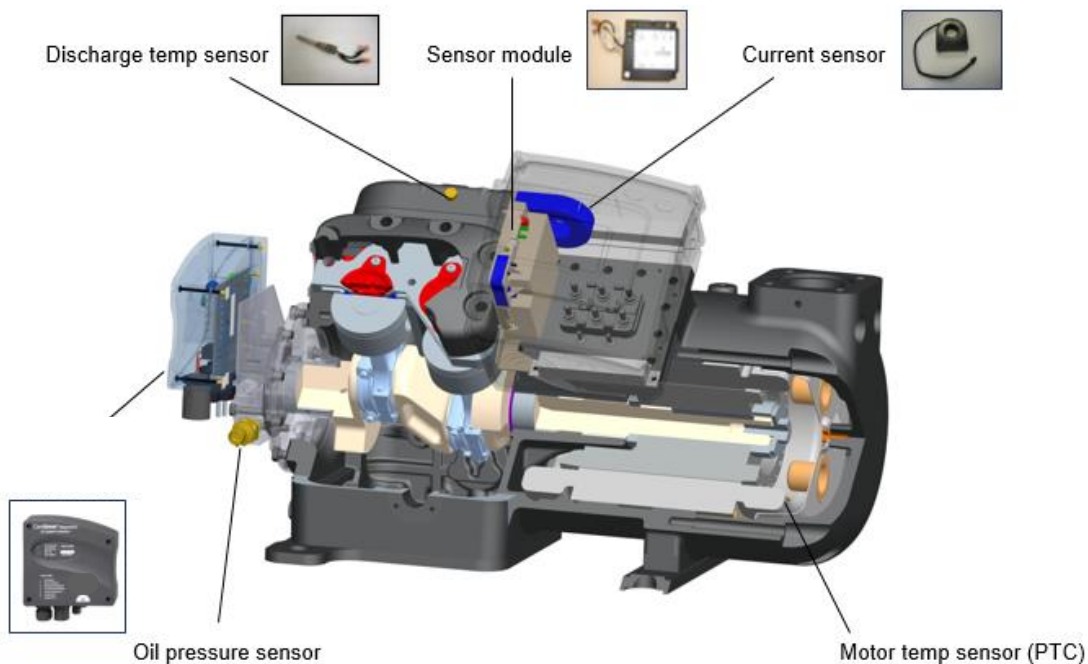


Figure 34: CoreSense Diagnostics module and sensor module

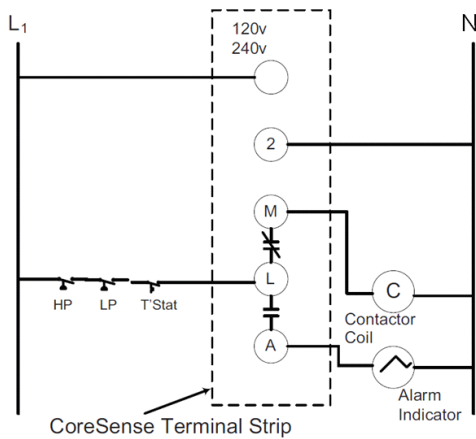
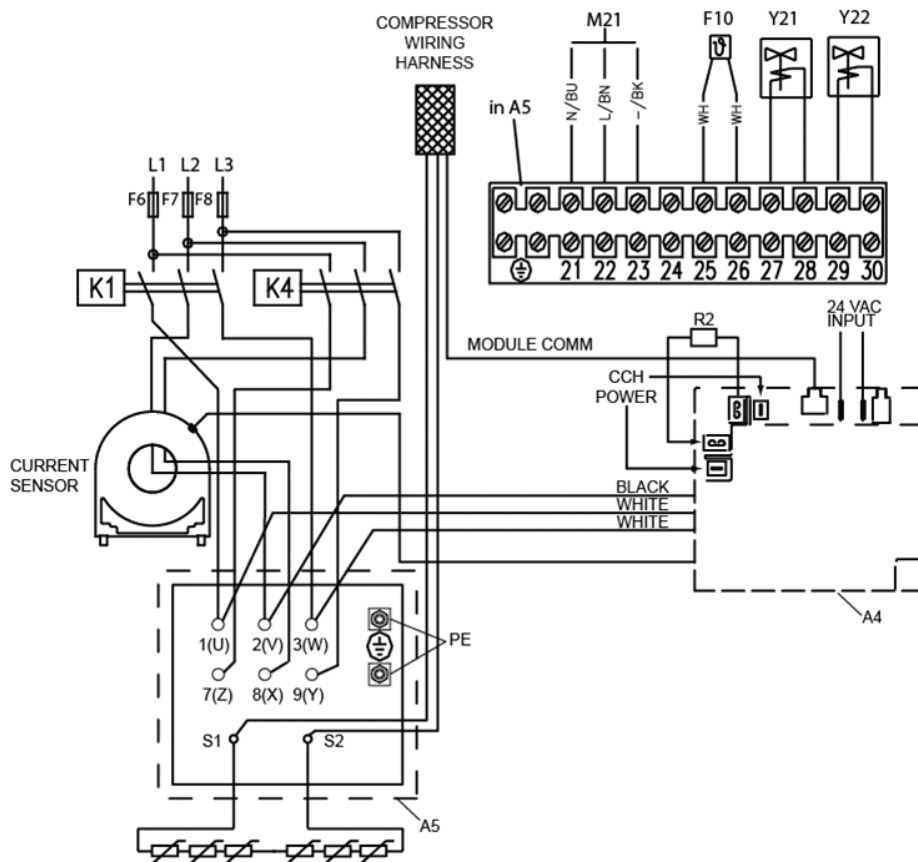


Figure 35: CoreSense Diagnostics module wiring diagram

4.5.3.1 CoreSense Diagnostics – Wiring diagrams



Legend

A4..... Sensor module	K1 Contactor M1
A5..... Compressor terminal box	K4 Contactor M1 for 2 nd part winding
CCH Crankcase heater	M21..... Fan motor / condenser
F6 Fuse for control circuit	R2 Crankcase heater
F7 Fuse for control circuit	Y21 Solenoid valve capacity control 1
F8 Fuse for control circuit	Y22 Solenoid valve capacity control 2
F10 Thermal protection switch M21	

Figure 36: Wiring diagram – Part-winding motors (AW...)

NOTE: The sensor module inside the terminal box requires a separate 24 VAC power supply.

4.6 Crankcase heaters



WARNING

Ignition source in a potentially flammable atmosphere due to hot surface temperature! Fire hazard! The crankcase heater is not an ignition source during normal operation in an A2L-refrigerant system but could become one if not installed properly according to installation instructions.

Ensure correct mechanical installation of the crankcase heater into the sleeve and compressor housing. Use heat transfer paste for adequate heat transfer.



CAUTION

Overheating and burnout! Compressor damage! Never apply power to the crankcase heater in free air, before the crankcase heater is installed on the compressor or when it is not in complete contact with the compressor shell.



IMPORTANT

Oil dilution! Bearing malfunction! Turn the crankcase heater on 12 hours before starting the compressor.

A crankcase heater is used to prevent refrigerant from migrating into the compressor crankcase during standstill periods.

Crankcase heaters for 4M* and 6M* compressors are available in 120 V, 230 V and 480 V.

The operation of 120 V and 230 V crankcase heaters is controlled by the Copeland Compressor Electronics module; this is not possible with 480 V heaters.

The crankcase heater is screwed into a sleeve – see **Figure 38**. The recommended torque for fixing the heater into the sleeve is 57-68 Nm.

Ensure correct mechanical installation of the crankcase heater into the sleeve and compressor housing. Use heat transfer paste for adequate heat transfer.

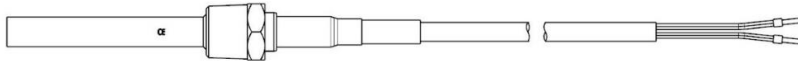


Figure 38: 100-Watt crankcase heater element

The crankcase heater must remain energized during compressor off cycles. The initial start-up in the field is a very critical period for any compressor because all load-bearing surfaces are new and require a short break-in period to carry high loads under adverse conditions.

The crankcase heater must be turned on a minimum of 12 hours prior to starting the compressor. This will prevent oil dilution and bearing stress on initial start-up.

5 Start-up & operation



WARNING

Diesel effect! Compressor destruction! The mixture of air and oil at high temperature can lead to an explosion. Avoid operating with air.



WARNING

Air/flammable refrigerant mixture! Creation of a flammable atmosphere!

Make sure the atmosphere is non-flammable before starting the system. Ensure that the system contains only refrigerant.

5.1 Compressor tightness test



WARNING

High pressure! Personal injuries! Consider personal safety requirements and refer to test pressures prior to test.



IMPORTANT

System contamination! Bearing malfunction! Use only dry inert gases (for example nitrogen) for leak testing. DO NOT USE other industrial gases.

The compressor has been tested for tightness in the Copeland factory. All compressors get a factory holding charge of dry air (about 1 to 2.5 bar, relative pressure). The presence of an intact holding charge serves as a proof of quality against penetrating moisture.

The highest demands are placed on the leak-proof design of the installation and on the leak testing methods – please refer to EN 378.

The whole installation including the compressor shall be tested for tightness before the system is charged with refrigerant. Procedure and acceptance criteria shall conform with the applicable standard, eg, EN 378.

When removing plugs from the compressor in order to connect a pressure gauge or to fill in oil, the plugs may pop out under pressure and oil can spurt.

Any later modification to compressor connections (plugs, screws, etc.) can have an impact on the compressor tightness. Always leak-pressure test the compressor after opening or modifying the connections.

Never add refrigerant to the test gas (as leak indicator).

5.2 System evacuation

Before commissioning, remove the holding charge then evacuate with a vacuum pump. For A2L systems, the vacuum pump and all tools have to be approved for A2L refrigerant/air mixture. The installation should be evacuated down to an absolute pressure of 3 mbar. Proper evacuation reduces residual moisture to 50 ppm. During the initial procedure, suction and discharge shut-off valves on the compressor remain closed. The installation of adequately sized access valves at the furthest point from the compressor in the suction and liquid lines is advisable. The pressure must be measured using a vacuum pressure gauge on the access valves and not on the vacuum pump; this serves to avoid incorrect measurements resulting from the pressure gradient along the connecting lines to the pump.

5.3 Preliminary checks – Pre-starting



WARNING

Air/A2L refrigerant mixture in a potentially flammable or explosive atmosphere! Fire and explosion hazard! Whenever starting up a system charged with A2L refrigerant, eg, after filling, repair, or maintenance, make sure not to start and operate accidentally in a flammable or explosive atmosphere.

Discuss details of the installation with the installer. If possible, obtain drawings, wiring diagrams, etc. It is ideal to use a checklist but always check the following:

- no explosive atmosphere or flammable gas in the ambient, especially for systems with A2L refrigerants;
- suitable ventilation according to room volume and refrigerant charge, especially for systems with A2L refrigerants;
- visual check of the electrics, wiring, fuses etc;
- cable glands in good condition, all electrical connections well connected and terminal box closed to ensure corresponding IP protection;
- visual check of the plant for leaks, loose component parts such as TXV bulbs or solenoid valve coil, loose wires in electrical installation, etc;

- functional test of HP & LP switches and any pressure-actuated valves;
- check setting and operation of all safety features and protection devices;
- all valves in the correct running position;
- pressure and compound gauges fitted;
- correctly charged with refrigerant;
- compressor electrical auxiliary switch location and position.

5.4 Charging procedure



WARNING

Air/A2L refrigerant mixture in a potentially flammable or explosive atmosphere! Fire and explosion hazard! Only use filling equipment designed and approved for use and operation with A2L refrigerants. Make sure all connections are tight to avoid leakage. Make sure to fill with pure A2L refrigerant.



CAUTION

Low suction pressure operation! Compressor Damage! Do not operate compressor with a restricted suction or with the low-pressure cut-out bridged. Do not operate compressor at pressures that are not allowed by the operating envelope.

Prior to charging or re-charging, the refrigerant system must be leak- and pressure-tested with appropriate purging gas.

Ensure that the refrigerant system is grounded prior to charging with refrigerant, especially for systems with A2L refrigerants.

The system shall be liquid-charged through the liquid-receiver shut-off valve or through a valve in the liquid line. The use of a filter-dryer in the charging line is highly recommended. Systems shall be liquid-charged on both the high and low sides simultaneously to ensure a positive refrigerant pressure is present in the compressor before it runs. The majority of the charge shall be placed in the high side of the system to prevent bearing washout during first-time start on the assembly line.

Extreme care shall be taken not to overfill the system with refrigerant.

NOTE: For all systems with A2L refrigerants, the system manufacturer/installer must respect the charge limitations according to valid standards, such as EN 378.

5.5 Initial start-up



CAUTION

Oil dilution! Bearing malfunction! It is important to ensure that new compressors are not subjected to liquid abuse. Turn the crankcase heater on 12 hours before starting the compressor.



CAUTION

High discharge pressure operation! Compressor damage! Do not use compressor to test opening setpoint of high-pressure cut-out. Bearings are susceptible to damage before they have had several hours of normal running in.

Liquid and high-pressure loads could be detrimental to new bearings. It is therefore important to ensure that new compressors are not subjected to liquid abuse and high-pressure run tests. It is not good practice to use the compressor to test the high-pressure switch function on the production line. The switch function can be tested with nitrogen prior to installation and the wiring can be checked by disconnecting the high-pressure switch during the run test.

The compressor must be equipped with the correct accessories, according to Copeland documentation and considering the application intended. Make sure this requirement is met before start-up.

Bolt torque settings are listed in **Appendix 2**.

With the exception of rubber-coated metallic gaskets (Wolverine) all gaskets should be oiled before fitting. O-rings should also be oiled.

NOTE: A compressor should never be operated beyond its approved application range! Check the corresponding data sheet. To avoid motor damage, NEVER start the compressor or carry out high-potential testing when the compressor is under vacuum.

5.6 Minimum run time

Copeland recommends a maximum of 10 starts per hour. The most critical consideration is the minimum run time required to return oil to the compressor after start-up. The minimum on time becomes the time required for oil lost during compressor start-up to return to the compressor sump. Cycling the compressor for a shorter period than this, for instance to maintain very tight temperature control, will result in progressive loss of oil and damage to the compressor.

5.7 Recommended inverter range

Stream compressors are released for inverter applications. However, the operation of 4M* and 6M* compressors with A2L refrigerants, eg, R454C, R455A or R454A and variable frequency has not been officially qualified at this time.

Over a frequency range the compressor system combination can have frequency bands with higher vibration. The degree of vibration and frequency bands are highly dependent on the system. To help reduce these vibration levels rubber mounting can be used on all inverter-driven compressors.

Active oil management should be used for all inverter-driven compressors.

6 Maintenance & repair



WARNING

Conductor cables! Electrical shock hazard! Follow the lockout/tag out procedure and the national regulations before undertaking any maintenance or service work on the system.

Use compressor with grounded system only. Screwed electrical connections must be used in all applications. Refer to original equipment wiring diagrams. Electrical connections must be made by qualified electrical personnel.



WARNING

Explosive flame! Fire hazard! Oil/refrigerant mixtures are highly flammable. Remove all refrigerant before opening the system. Avoid working with an unshielded flame in a refrigerant-charged system.



WARNING

Ignition source in a potentially flammable or explosive atmosphere! Fire and explosion hazard! When opening an A2L-refrigerant system, the atmosphere could be explosive. All electrical components that are a source of ignition must always be switched off during service and maintenance. Ensure that the surface temperatures of the components never exceed the limits set by the applicable safety standard, eg, EN 378-2.

Air/flammable refrigerant mixture! Fire and explosion hazard! Remove all the refrigerant before opening the system. Make sure to remove refrigerant completely from all components such as heat exchangers, refrigerant accumulators, etc. Flush the system and the components with inert gas before undertaking any work and before brazing.



WARNING

Open flame in a potentially flammable or explosive atmosphere! Fire and explosion hazard! The area shall be checked with an appropriate refrigerant detector prior to and during work on an A2L-refrigerant system, to ensure the technician is aware of a potentially toxic or flammable atmosphere. Ensure that the leak detection equipment being used is suitable for use with all applicable refrigerants.

Personnel performing work on a refrigeration system that involves exposing the pipework shall avoid using any ignition source in a way that could lead to a fire or explosion hazard. All sources of ignition shall be kept sufficiently far from the site of installation, repair, removal or disposal during the entire time when refrigerant could be released into the surrounding space.

Open flames and smoking are strictly forbidden at all times.

During service make sure that:

- the area is well ventilated;
- the materials and equipment used are suitable for use under flammable conditions;
- only non-sparking tools are used;
- antistatic gloves and clothes are used;
- build-up of electrostatic charges is avoided;
- no unshielded or naked flame is used.

If parts of the refrigeration system are charged with flammable refrigerant, make sure that all the valves are tightly closed and that the open pipes after the valves are free of refrigerant and oil.



WARNING

Air/flammable refrigerant mixture! Fire and explosion hazard! After opening the compressor for service or repair, ensure accurate closing and hermetic sealing of the opened parts. Check the sealing surface for any contamination and use new and proper gasket material. Use the correct tightening torques for screws and apply Loctite material wherever necessary. Always ensure adequate evacuation process and system leak check before re-filling with refrigerant.

A risk analysis to evaluate all possible risks shall be carried out by the service technician before any repair work on an A2L system.

The compressor shall be tested for tightness before it is charged with refrigerant. For proper tightness test, see applicable standards, eg, EN 378. All joints shall be tested with detection equipment with a capability of 5 g/year of refrigerant or better.

6.1 Qualification of workers

Personnel working on the maintenance, repair and decommissioning of an A2L-refrigerant system shall be adequately trained. Any work procedure affecting safety shall only be executed by qualified and trained personnel in compliance with national or other equivalent certification systems.

Examples of such work procedures are breaking into the refrigerating circuit, opening sealed components, opening ventilated enclosures, etc...

6.2 Preparation and work procedure

For all A2L-refrigerant systems, a work procedure shall be provided in the preparation stage. All personnel working at the site, whether maintenance or other, shall be instructed on the nature of the work being carried out.

If any work is to be conducted on the refrigeration systems or any associated parts, appropriate fire extinguishing equipment shall be provided. Dry powder or CO₂ fire extinguishers are considered appropriate. Confirm that appropriate fire extinguishing equipment is available near the work area.

Prior to starting to work on systems containing flammable refrigerants, safety checks are necessary to ensure that the risk of ignition is minimized.

Work shall be undertaken under a controlled procedure so as to minimize the risk of a flammable gas or vapour being present while the work is being performed.

Avoid working on systems filled with flammable refrigerant in a confined space.

6.3 Unbrazing system components



WARNING

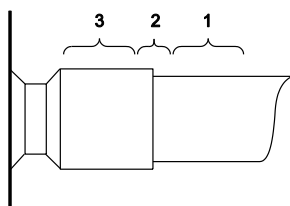
Explosive flame! Fire hazard! Oil/refrigerant mixtures are highly flammable. Remove all refrigerant before opening the system. Avoid working with an unshielded flame in a refrigerant-charged system.

Before opening up a system it is important to remove all refrigerant from both the high and low sides of the system. If a brazing torch is applied to the low side while the low side shell and suction line contain pressure, the pressurized refrigerant and oil mixture could ignite when it escapes and contacts the brazing flame. To prevent this occurrence, it is important to check both the high and low sides with manifold gauges before unbrazing. Instructions should be provided in appropriate product literature and assembly (line repair) areas. If compressor removal is required, the compressor should be cut out of system rather than unbrazed.

6.4 Disassembling system components

Follow the steps described hereunder when disassembling system components:

1. For A1-refrigerant systems (R448A, R449A, R407A, R407F, R404A, R407C, R513A, R450A and R134a), recover refrigerant and evacuate system using a recovery unit and vacuum pump. All the refrigerant shall be recovered to avoid significant release.
2. For A2L-refrigerant systems (R454C, R455A and R454A), recover refrigerant and evacuate system using an A2L-dedicated recovery unit and vacuum pump. Ensure that the outlet of the vacuum pump is not close to any potential ignition source and that ventilation is available.
3. Flush system with inert gas (dry nitrogen). Compressed air or oxygen shall not be used for purging refrigerant systems.
4. For A2L-refrigerant systems, the procedure of evacuation and flushing with oxygen-free nitrogen may need to be repeated until no refrigerant is present in the system. When the final oxygen-free nitrogen charge is used, the system shall be vented down to atmospheric pressure to enable work to take place.
5. Disassemble components with a cutting tool.
6. Drain, recover and dispose of compressor oil as appropriate.



To disconnect:

- Using a pipe cutting tool, cut off the suction and discharge lines in such a manner that the new compressor can easily be re-connected into the system.
- Heat joint areas 2 and 3 slowly and uniformly until the braze material softens and the tube end can be pulled out from the fitting.

Figure 39: Tube connecting areas

To reconnect:

- Recommended brazing material: Silfos with minimum 5 % silver or silver braze used on other compressors.
- Due to the different thermal properties of steel and copper, brazing procedures may have to be changed from those commonly used.

6.5 Exchanging the refrigerant



WARNING

Air/A2L mixture in a potentially flammable or explosive atmosphere! Fire and explosion hazard! For applications with A2L refrigerants, air/A2L mixture in the refrigeration system must be avoided in any case. Make sure that the system is filled with pure A2L refrigerant. In the event that the refrigerant needs replacing, the charge should be recovered using A2L-qualified refrigerant recovery unit and recycling bottles.



CAUTION

Low suction pressure operation! Compressor damage! Do not operate compressor with a restricted suction or with the low-pressure limiter bridged. Do not operate compressor at pressures that are not allowed by the operating envelope. Allowing the suction pressure to drop below the envelope limit for more than a few seconds may overheat the pistons and cause damage to parts.

Qualified refrigerants and oils are given in **Section 2.4.1**.

It is not necessary to replace the refrigerant unless contamination, for example due to an error such as topping up the system with a non-condensable gas or incorrect refrigerant, is suspected. To verify correct refrigerant composition, a sample can be taken for chemical analysis. A check can be made during shutdown by comparing the refrigerant temperature and pressure using precision measurements at a location in the system where liquid and vapour phases are present and when the temperatures have stabilised.

6.6 Replacing a compressor



CAUTION

Inadequate lubrication! Bearing destruction! For systems with refrigerant accumulator, exchange the accumulator after replacing a compressor with a burned-out motor. The accumulator oil return orifice or screen may be plugged with debris or may become plugged. This will result in starvation of oil to the new compressor and a second failure.

Remove the refrigerant and oil completely from the replaced compressor.

6.6.1 Compressor replacement

When replacing an A2L-refrigerant compressor, the oil has to be drained out of the compressor and the compressor should be flushed with dry nitrogen. DO NOT close the stubs with plugs.

In case of motor burnout, most of the contaminated oil will be removed with the compressor. The rest of the oil is cleaned through the use of suction and liquid line filter-dryers. A 100 % activated alumina filter-dryer is recommended for the suction line. It must be removed after 72 hours.

It is highly recommended that the suction accumulator be replaced if the system contains one. This is because the accumulator oil-return orifice or screen may be plugged with debris or may become plugged shortly after a compressor failure. This will result in starvation of oil to the replacement compressor and a second failure.

When a single compressor or a compressor in a parallel configuration is exchanged in the field, it is possible that a large portion of the oil remains in the system. While this may not affect the reliability of the replacement compressor, the extra oil will add to rotor drag and increase power usage.

6.6.2 Compressor return procedure

For A1-refrigerant systems, if a compressor has to be returned to the manufacturer for analysis, the refrigerant must be thoroughly removed before shipment. The compressor can be shipped with the oil filling inside and with closed suction and discharge valves. In addition, the warning sticker with the flammable symbol should be removed so that the compressors are not misdeclared on receipt at the factory.

For A2L-refrigerant systems, both the refrigerant and the oil must be thoroughly removed before shipment. All compressor connections must remain open and warning stickers for flammable refrigerant must be placed on the shipping box. The recommendations and procedure below shall be followed:

- During the entire working procedure continuously check if the ambient atmosphere is flammable. If a flammable atmosphere is detected, immediately cut off the power supply and ventilate the working space.
- Resume working after the atmosphere is no longer dangerous.
- Recover the refrigerant from the system using a suitable recovery unit. During this action, the compressor crankcase heater could be energized – immediately de-energize in case a flammable or explosive atmosphere is detected.
- Recover to 3 mbar absolute pressure or lower. For best results and to recover also the refrigerant dissolved in the oil, run the recovery unit two or three times as necessary.
- Flush the whole system with oxygen-free dry nitrogen.
- Disassemble the compressor by removing the discharge and suction valves or using a cutting tool. Drain and recover compressor oil properly. Purge the compressor with dry nitrogen again for a few minutes.
- The compressor should be returned free of oil and with connections open – do not close connections with plugs.
- Collect and secure the oil properly. Provide information about the quantity of oil drained from the compressor and its colour. Ideally, send a good picture.
- Dispose of the oil according to local rules and regulations.
- Use a proper cardboard box package when preparing the compressor for shipment. Place warning

icons  on each side and on the top of the box. Mention the following message on the box: **"Warning! Flammable A2L-refrigerant compressor for analysis"**.

- The compressor must be kept in the upright position – mark the box accordingly.
- If more than one compressor must be returned, each compressor has to be packed individually.

NOTE: Check with the transport company that all the requirements applying to such shipments are complied with.

6.7 Lubrication and oil removal



WARNING

Air/A2L flammable refrigerant mixture! Flammable and explosive atmosphere! Fire and explosion hazard! When removing oil from an A2L-refrigerant system, use suitable recovery unit and recycling bottles also for oil disposal as A2L refrigerant may still be solved in the oil.



CAUTION

Chemical reaction! Compressor destruction! Do not mix up ester oils with mineral oil and/or alkyl benzene.

The compressor is supplied with an initial oil charge. The standard oil charge for use with Stream 4M* & 6M* compressors is a polyolester (POE) lubricant Emkarate RL 32 3MAF. See nameplate for original oil charge shown in litres. A field recharge is from 0.05 to 0.1 litre less. Oil recharge values can be taken from Select software at www.copeland.com/en-gb/tools-resources.

One disadvantage of POE is that it is far more hygroscopic than mineral oil – see **Figure 40**. Only brief exposure to ambient air is needed for POE to absorb sufficient moisture to make it unacceptable for use in a refrigeration system. Since POE holds moisture more readily than mineral oil it is more difficult to remove it through the use of vacuum.

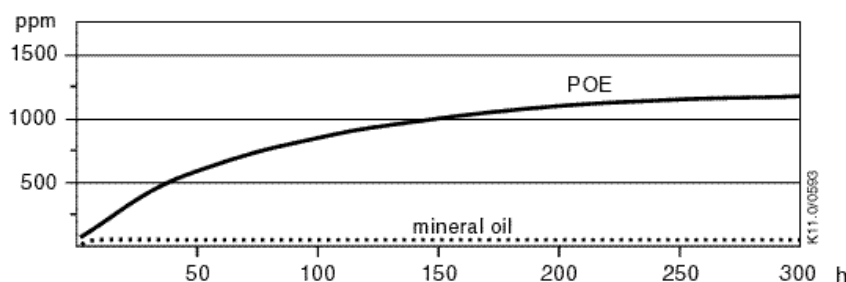


Figure 40: Absorption of moisture in ester oil in comparison to mineral oil in ppm by weight at 25 °C and 50 % relative humidity (h= hours)

Copeland compressors contain oil with low moisture content, which however may rise during the system assembling process. Therefore, it is recommended to install a properly sized filter-dryer in all POE systems to maintain the moisture level in the oil to less than 50 ppm. If POE oil is charged into a system, it is recommended that its moisture content be no higher than 50 ppm.

If the moisture content of the oil in a refrigeration system reaches unacceptably high levels, corrosion and copper plating may occur. The system should be evacuated down to 3 mbar or lower in accordance with EN 378-4. Sight glass/moisture indicators can be used with HFC refrigerants and lubricants. However, they will only show the moisture content of the refrigerant. The actual moisture level in the oil is likely to be higher than indicated by the sight glass. This is due to the high hygroscopicity of the POE oil. If there is uncertainty as to the moisture content in the system, or to measure the actual moisture level, oil samples should be taken and analysed.

6.8 Oil additives

Although Copeland cannot comment on any specific product, from our own testing and past experience, we do not recommend the use of any additive to reduce compressor bearing losses or for any other purpose. Furthermore, the long-term chemical stability of any additive in the presence of refrigerant, low and high temperatures, and materials commonly found in refrigeration systems is complex and difficult to evaluate without rigorously controlled chemical laboratory testing. The use of additives without adequate testing may result in malfunction or premature failure of components in the system and, in specific cases, in voiding the warranty on the component.

7 Dismantling & disposal



Removing oil and refrigerant:

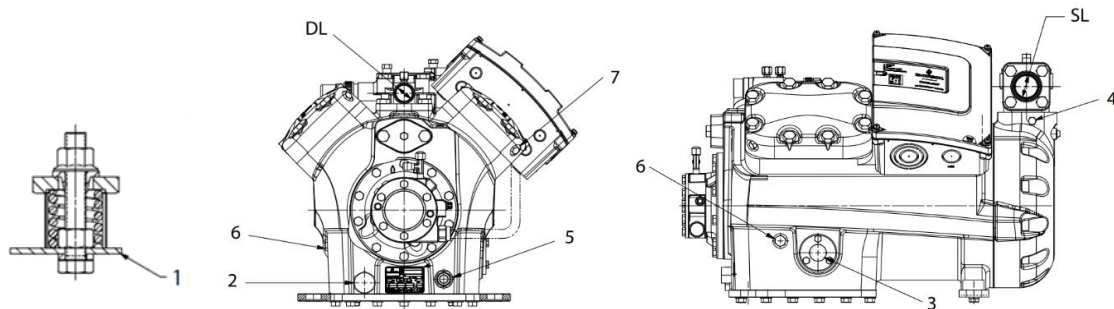
- Do not disperse in the environment.
- Use the correct equipment and method of removal.
- Dispose of oil and refrigerant in compliance with national legislation and regulations.

Dispose of compressor in compliance with national legislation and regulations.

Appendix 1: Stream compressor connections

4M*

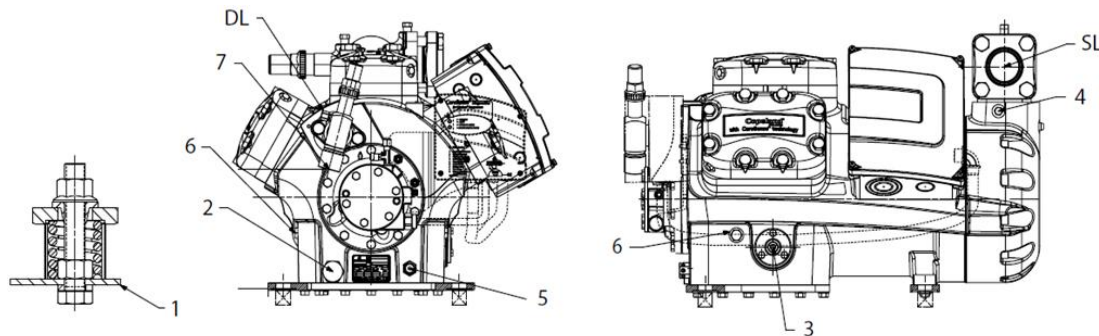
4MF-13 4ML-15 4MM-20 4MT-22 4MU-25
4MA-22 4MH-25 4MI-30 4MJ-30 4MK-32



SL	Suction line size (sweat) 4MF-13, 4ML-15, 4MA-22	Ø 1 5/8"	DL	Discharge line size (sweat) 4MF-13, 4ML-15, 4MA-22, 4MM-20, 4MH-25, 4MI-30	Ø 1 1/8"
SL	Suction line size (sweat) 4MM-20, 4MH-25, 4MI-30, 4MT-22, 4MJ-33, 4MU-25, 4MK-35	Ø 2 1/8"	DL	Discharge line size (sweat) 4MT-22, 4MJ-33, 4MU-25, 4MK-35	Ø 1 3/8"
1	Base mountings	Ø 25.5 mm	5	Crankcase heater	
2	Magnetic plug	1" - 16 UN	6	Plug oil charge	1/4"
3	Oil sight glass	1/4" - 20 UNC	7	Plug high pressure connection	1/8"
4	Plug low pressure connection	1/8"			

6M*

6MM-30 6MT-35 6MU-40
6MI-40 6MJ-45 6MK-50



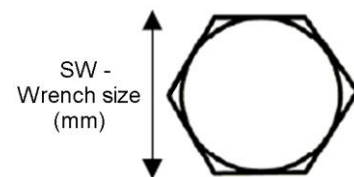
SL	Suction line size (sweat) 6MM-30, 6MT-35, 6MI-40, 6MJ-45	Ø 2 1/8"	DL	Discharge line size (sweat) 6MT-35, 6MU-40, 6MJ-45, 6MK-50	Ø 1 5/8"
SL	Suction line size (sweat) 6MK-50, 6MU-40	Ø 2 5/8"	DL	Discharge line size (sweat) 6MI-40, 6MM-30	Ø 1 3/8"
1	Base mountings	Ø 25.5 mm	5	Crankcase heater	
2	Magnetic plug	1" - 16 UN	6	Plug oil charge	1/4"
3	Oil sight glass	1/4" - 20 UNC	7	Plug high pressure connection	1/8"
4	Plug low pressure connection	1/8"			

Appendix 2: Tightening torques in Nm

Suction shut-off valve	1/2"-13 UNC 53 - 84 Nm SW 19	Discharge shut-off valve	1/2"-13 UNC 53 - 84 Nm SW 19
	5/8"-11 UNC 104 - 164 Nm SW 23.8	Rotalock nut	1 3/4"-12 UNF 41 - 54 Nm SW 50
Bottom plate	3/8"-16 UNC 57 - 68 Nm SW 14.2	Mounting foot	3/8"-16 UNC 57 - 68 Nm SW 14.2
Stator cover	1/2"-13 UNC 68 - 79 Nm SW 18	Housing cover	3/8"-16 UNC 57 - 68 Nm SW 14.2
Oil pump	5/16"-18 UNC 31 - 37 Nm SW 12.7	Oil sight glass	1/4"-20 UNC 4.5 - 6 Nm SW 11
Oil pressure switch OPS2	60 - 75 Nm	Magnetic plug	1"-16 UN 102 - 136 Nm SW 25.4
Terminal stud	10-32 UNF 3 - 4 Nm SW 9	Terminal stud thermistors	10-32 UNF 3.4 - 4 Nm SW 9
	1/4"-28 UNF 5 - 6.5 Nm SW 10	Mounting plate for terminals	3/8"-16 UNC 57 - 68 Nm SW 14.2
Cylinder head	1/2"-13 UNC 129 - 149 Nm SW 18	Bolt for connecting rod	1/4"-28 UNF 15 - 18 Nm Torx screws*
Plug 4	1/4"-18 NPTF 27 - 50 Nm SW 17.5	Magnetic plug	1"-16 UN 102 - 136 Nm SW 25.4

* In case of replacement of the piston con-rod assemblies, clean the Torx screws and apply Loctite 2701.

The ranges of torque values given in this specification are assembly torques. Torque after joint relaxation must be within 15 % of the minimum assembly torque unless re-torque is called for and must not be above 10 % of the maximum assembly torque.



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