

Installation Manual for the Flexible Joint
(Copper end)

Z-10000ZU • Z-14000



Installation Procedure

1. Before installation

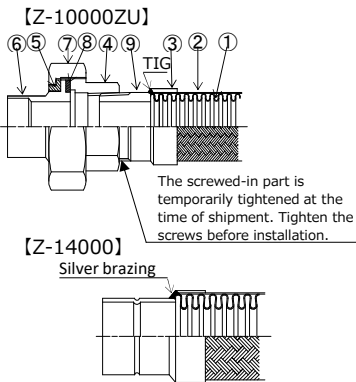
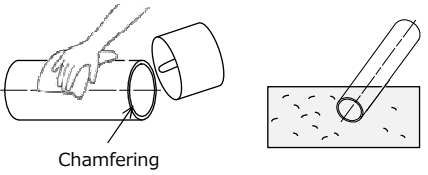


Table1 Parts List (Z-10000ZU)

No.	Name	Material
1	Bellows	Stainless steel 304
2	Braid	Stainless steel 304
3	Braid cover	Stainless steel 304
4	Union screw	SCS13
5	Insulator	Bakelite
6	Copper socket	C1220BD
7	Union nut	SCS13
8	Gasket	Rubber
9	Male screw	Stainless steel 304

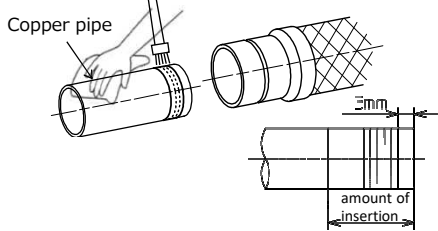
- Please confirm whether the diameter is correct.
- Please confirm whether there is any damage of sealing surface.

2. Chamfering, polishing/degreasing



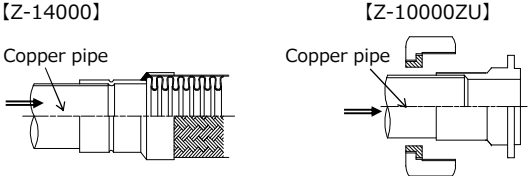
After cutting the copper pipe, chamfer the pipe end and then use a sizing tool or similar tool to make the end of the pipe a perfect circle. Next, polish the joint (outer surface of the pipe and inner surface of the fitting) well with a non-woven or abrasive cloth until it becomes shiny, remove oxide film and dust, and wipe well with a rag.

3. Flux application



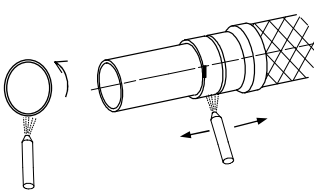
Apply a small amount of flux about 3mm away from the pipe end.
(Be careful not to allow flux to enter the inner surface of the flexible joint.)

4. Pipe Insertion



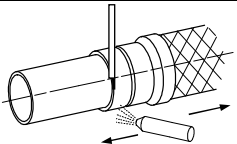
Insert the copper pipe into the fitting.
※Please insert firmly, as insufficient insertion may cause insufficient strength.
※If flux is applied, insert as soon as possible to allow the flux to acclimate.

5. Preheating (for air conditioning)



Heat copper pipe and fitting with a burner. (600~650℃)

6. Brazing/Soldering

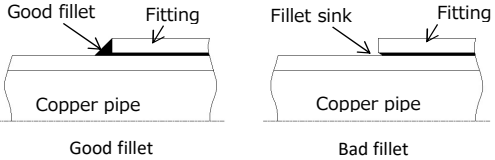


【For water supply and hot water supply】
Heat the joint to the proper temperature using a burner to melt the solder. (280~300℃)
【For air conditioning】
Heat the joint to the proper temperature using a burner and braze it. (700~800℃)
※Solder and brazing alloy should be melted from the base metal.
※When installing, wrap a wet towel around the silver brazing part on the flexible side.

7. Post-processing

【For water supply and hot water supply】
When solder has completely hardened, wipe the joint with a rag to remove the flux and oxide film on the outer surface.
【For air conditioning】
When brazing alloy has completely hardened, wipe the joint with a rag to remove the flux and oxide film on the outer surface.

8. Inspection and fillet verification



Check for defects such as defective fillets and pinholes.

NOTES

- The threaded part of Z-10000ZU is temporarily tightened. Tighten the screws before installation.
- When installing Z-10000ZU, wrap a wet towel around the copper pipe section to protect the bakelite.
- When installing Z-14000, wrap a wet towel around the silver brazing part on the flexible side to prevent heat transfer.