Installation Manual for the Flexible Joint (Cupper end)

Z-14000HP・Z-14000P

ZENSHN

Installation Procedure

1. Before installation

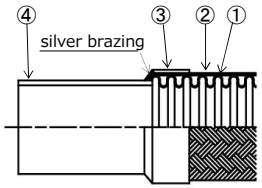
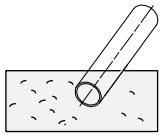


Table1 Parts List

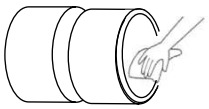
No.	Name	Material
1	Bellows	Stainless steel 304
2	Braid	Stainless steel 304
3	Braid cover	Stainless steel 304
4	Copper pipe	C-1220

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

2. Chamfering, polishing/degreasing



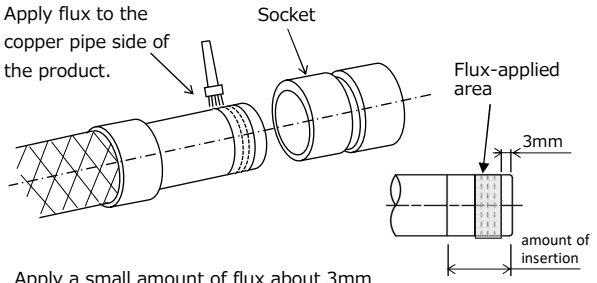
Polishing of outer surface of copper pipe (example)



Polishing the inner surface of the socket (example)

Polish the joint (outer surface of copper pipe and inner surface of fitting) well with a non-woven or abrasive cloth until it becomes shiny, remove oxide film and dust, and wipe well with a rag.

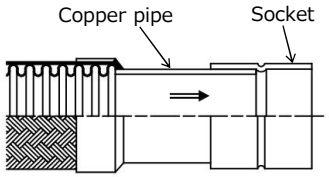
3. Flux application



Application detail

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.)

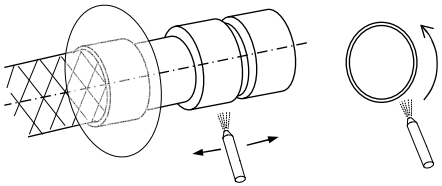
4. Pipe Insertion



Insert the copper pipe portion of the flexible joint into the socket.

Please insert firmly, as insufficient insertion may cause insufficient strength.

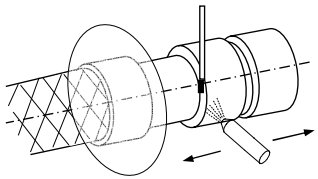
5. Preheating



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

When preheating, wrap a wet towel around the silver brazing part on the flexible side to prevent heat transfer.

6. Brazing



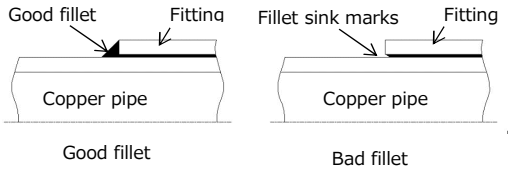
Heat the joint to the proper temperature using a burner, etc., and braze it. (700-800℃)
※Brazing alloy should be melted from the base metal.

When installing, wrap a wet towel around the silver brazing part on the flexible side to prevent heat transfer.

7. Post-processing

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



Good fillet　　Bad fillet

Check for fillet defects, pinholes, etc.

NOTES

- When installing Z-14000, wrap a wet towel around the silver brazing part on the flexible side to prevent heat transfer.