



# KIT DISCHARGE FLANGE

100152, 100152-1, 100153, 100153-1, & 100254.



**Installation and servicing of Danfoss Turbocor® compressors by qualified and product trained personnel only. Follow these instructions and sound refrigeration/electrical/servicing practices relating to installation, commissioning, maintenance and service.**

<p>Consult the appropriate Danfoss Turbocor Compressors Inc. (DTC) Service Manual on <a href="http://turbocor.danfoss.com">turbocor.danfoss.com</a> for detailed service instructions.</p>	<p><b>Never power compressor without covers in place and secured.</b></p> <p><b>Removing the mains input cover will expose you to a voltage hazard of up to 575V. Ensure the mains input power is off and locked out before removing cover.</b></p> <p><b>Before removing top cover, wait at least 20 minutes after isolating AC power to allow the high voltage capacitors to discharge.</b></p>	<p>Always wear appropriately rated safety equipment when working around equipment and/or components energized with high voltage.</p> <p><b>This equipment contains hazardous voltages that can cause serious injury or death.</b></p>	<p><b>Recover all refrigerant from compressor in accordance with local codes and ensure pressure is fully vented before the removal of refrigerant containing components.</b></p>
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1 - Introduction:

DISCHARGE FLANGE replacement.

This kit contains the Discharge Flange, O-ring, and associated hardware.

We have made the **TTS/TGS/TTH/TGH Service Manual** available to anyone. To access the manual, you may scan the applicable QR code below or you may go to our DTC website at [www.turbocoroem.com](http://www.turbocoroem.com). At the top of the page there is a pull-down menu called "Quick Links." Click this menu and select the appropriate service manual.

Refer to the applicable QR code below to download the TTS/TGS/TTH/TGH Service Manual.

**English**



**Chinese**



2 - Removal and Installation Instructions:

1. Isolate compressor power.
1. Isolate the compressor and recover the refrigerant according to industry standards
2. Remove the blind flange and align the discharge pipe and flange.
3. Complete the flange welding or brazing process.
4. Clean the O-ring groove and mating surface with a lint-free cloth.
5. Apply the O-ring lube on O-ring.
6. Insert the O-ring onto the O-ring groove on the main housing.
7. Assemble the four sets of M10 x 40 hex head screws, lock washers, and flat washers.
8. Align the discharge valve/flange with the compressor discharge port (see Figure 1) and insert the four hex head screws. Finger-tighten the screws and then torque, in a diagonal pattern, to 17 Nm (12.5 ft.lb.).
9. Torque the screws a final time to 32 Nm (23.6 ft. lb.).
10. Leak test and evacuate compressor in accordance with standard industry practices.
11. Return the compressor to normal operation.

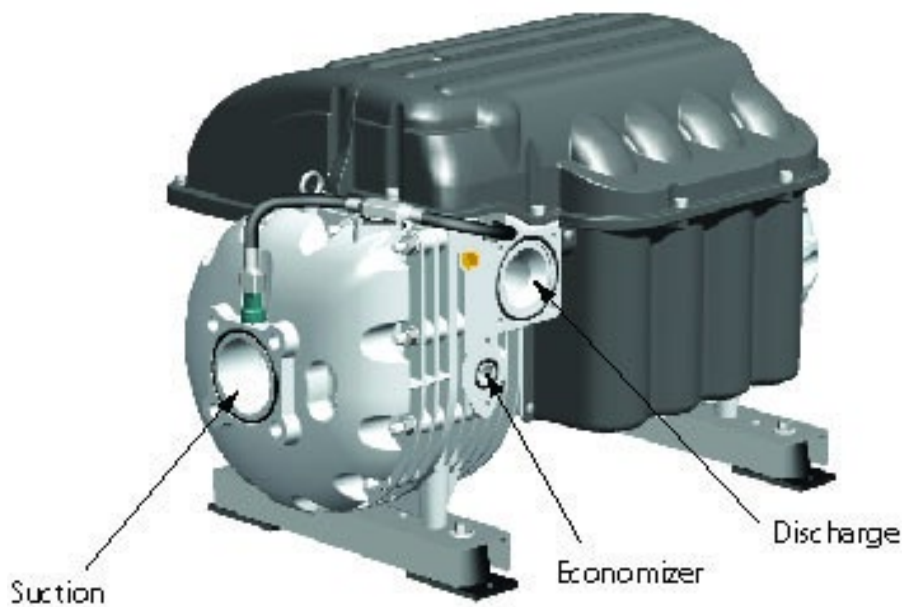
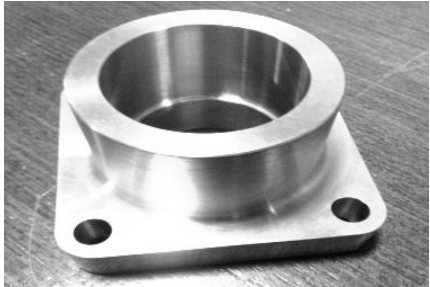

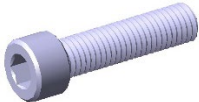





Figure 1

3 - Kit Contents:

QTY	Part(s) Description	Picture(s)
1	DISCHARGE FLANGE 2 1/8" or 2 5/8"	
4	WASHER, M10 SPLIT LOCK	

4	SCREW, M10X40 SOCKET HEAD CAP	
4	WASHER, M10 FLAT	
1	O-RING	
1	LUBRICATION-SUPER-O-LUBE-2G	

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