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DAIKIN

Marine type

Container Refrigeration Unit

Service manual

Model

LKEN5BD5

DAIKIN INDUSTRIES, LTD.

DANGER

Do not disconnect plug until power supply is shut off.

CAUTION

Do not start the unit until plugs are connected and generator plant is operated.

NOTE

- 1 . Confirm the function of the recorder when the chart paper is replaced with a new one. Do not mistake the chart of chilled cargo for that of frozen cargo.
- 2 . Accurately tighten the covers for the control box and the recorder.
- 3 . Confirm that the stop valves in the refrigeration circuits are opened before operation.

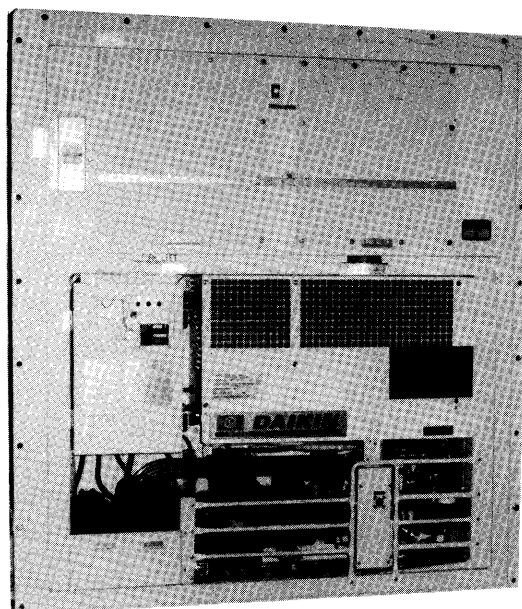
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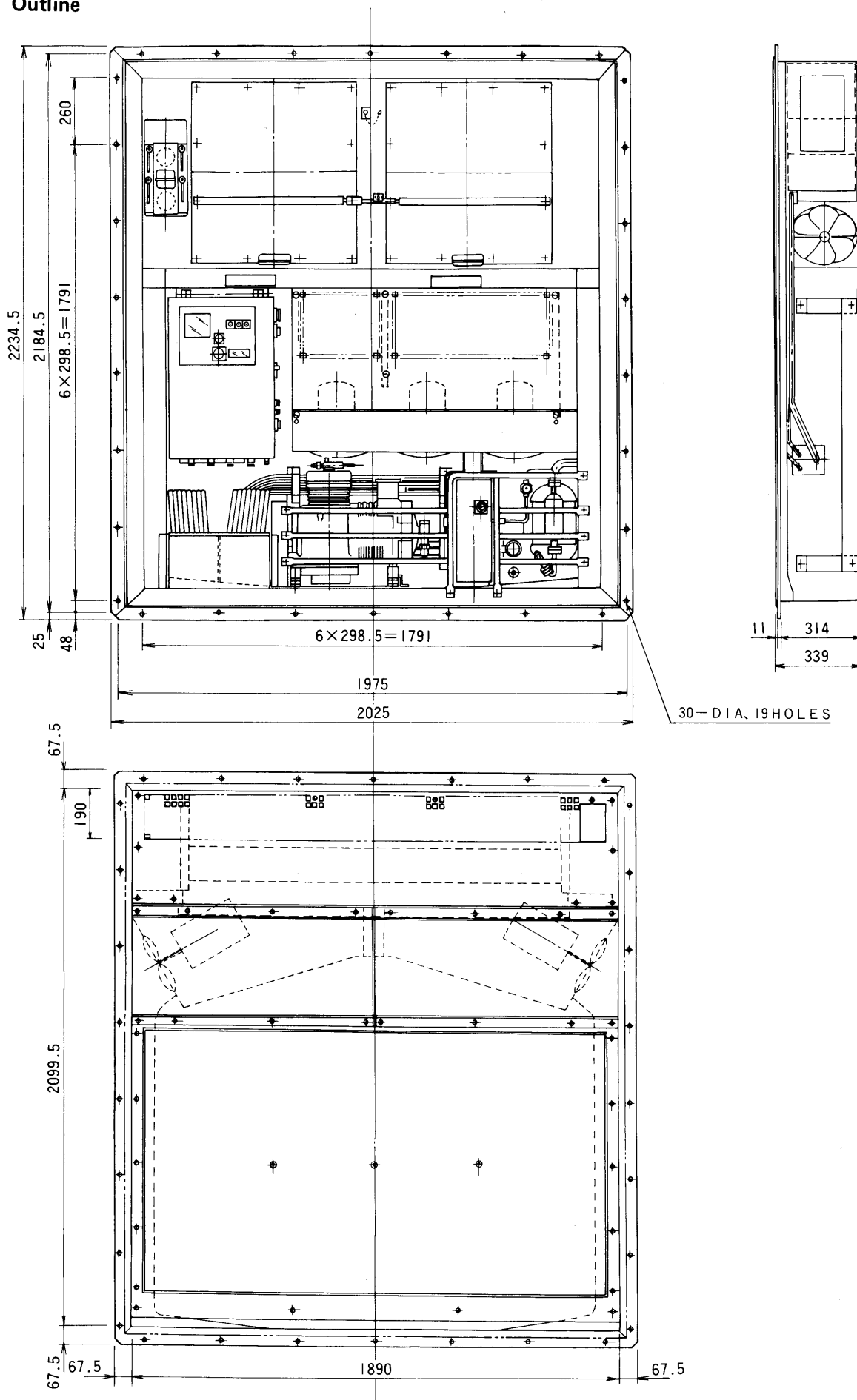
1. Specification

1.1 General specification

Power supply	AC 200V	3 Phase 50/60Hz
	AC 220V	3 Phase 60 Hz
	AC 380 ~ 415V	3 Phase 50 Hz
	AC 440V	3 Phase 60 Hz
	(Dual voltage rating with voltage selector)	
Compressor	Semi hermetic type (3.75 kW)	
Evaporator	Cross finned coil type	
Air cooled condenser	Cross finned coil type	
Water cooled condenser	Hairpin-shaped tube-in-tube type	
Accumulator-receiver with heat exchanger	Vertical cylinder type	
Fan	Motor direct driven propeller type	
Fan motor	Single-phase squirrel-cage induction motor	
Defrost		
Heat source	Electric heater	
Initiation	Air pressure switch (detecting evaporator pressure difference), timer or manual switch.	
Termination	Sensing evaporator temperature by defrost termination thermostat	
Refrigerant control	Thermostatic expansion valve	
Capacity control	Hot gas bypass control with modulating control valve	
Protection devices	Circuit breaker, Over current relay, Fuse, Dual pressure switch, Oil pressure protection switch, Fusible plug, Firestat, Compressor motor protection thermostat, Fan motor protection thermostat.	
Refrigerant	R-12 : 4.5 (kg) / 9.9 (lbs)	
Lubricant	SUNISO 3GS-DI (2.3 ℓ)	
Weight	Approx. 620 kg/1367 lbs	

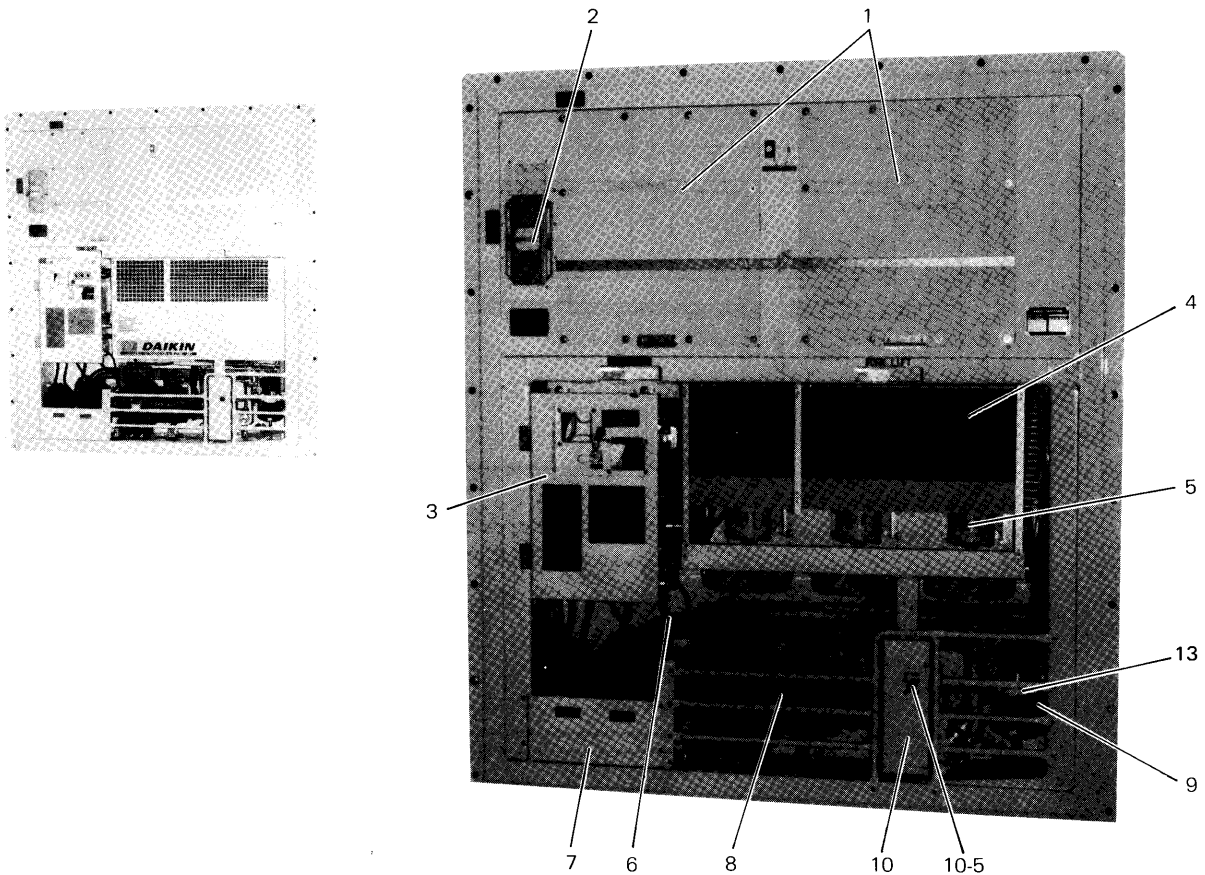


1.2 Outline

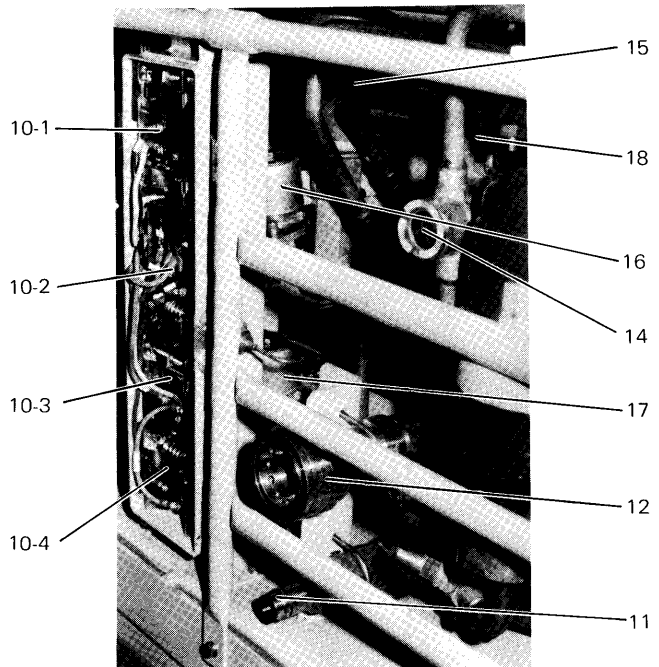


1.3 Construction

(1) Outside

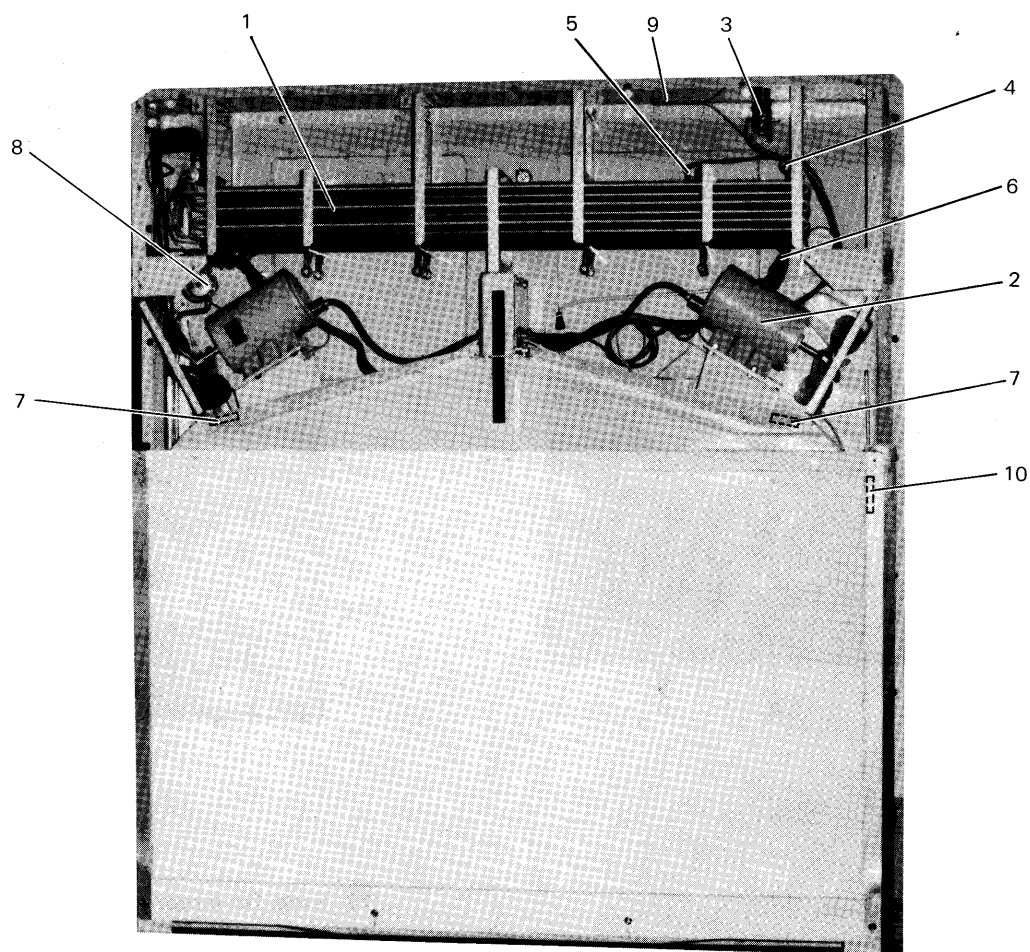


- 1 Access panel
- 2 Ventilator
- 3 Control box
- 4 Air cooled condenser
- 5 Condenser fan motor
- 6 Water cooled condenser
- 7 Cable stowage
- 8 Compressor
- 9 Accumulator-receiver with heat exchanger
- 10 Pressure switch box
 - 10 - 1 Dual pressure switch (63HL)
 - 10 - 2 Oil pressure protection switch (63QL)
 - 10 - 3 High pressure control switch (63CL)
 - 10 - 4 Water pressure switch (63W)
 - 10 - 5 Reset button for oil pressure protection switch
- 11 Water inlet coupling
- 12 Water outlet coupling
- 13 Dryer
- 14 Liquid/moisture indicator
- 15 Modulating control valve (20M)
- 16 Solenoid valve
(20S₁ for main line)
- 17 Solenoid valve
(20S₂ for liquid control)
- 18 Stop valve for hot gas line

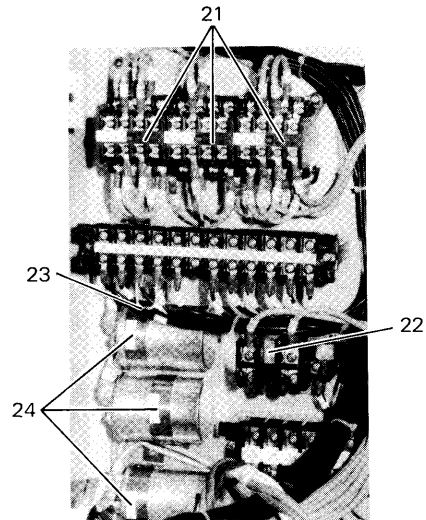
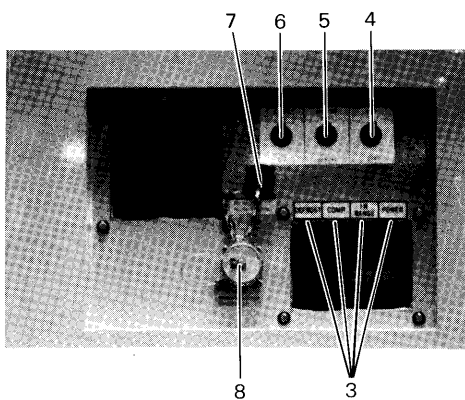
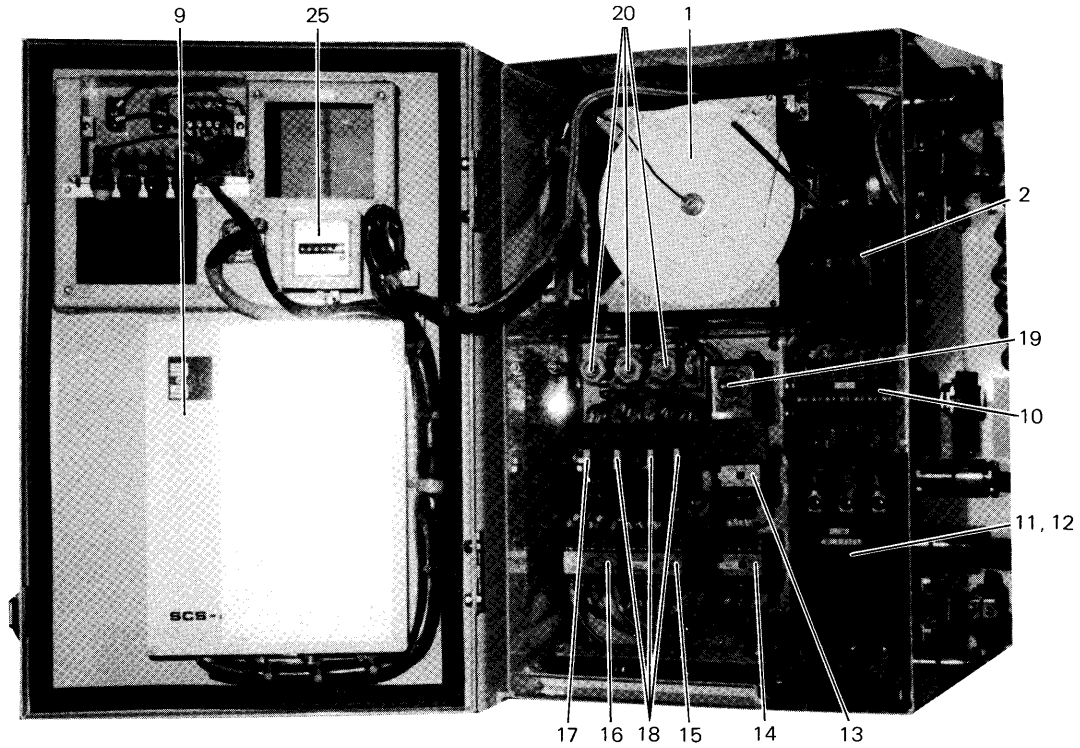


(2) Inside

- 1 Evaporator
- 2 Evaporator fan motor
- 3 Air pressure switch
- 4 Defrost termination thermostat
- 5 Firestat
- 6 Defrost heater
- 7 Drain port heater
- 8 Expansion valve
- 9 Return air sensor
- 10 Supply air sensor

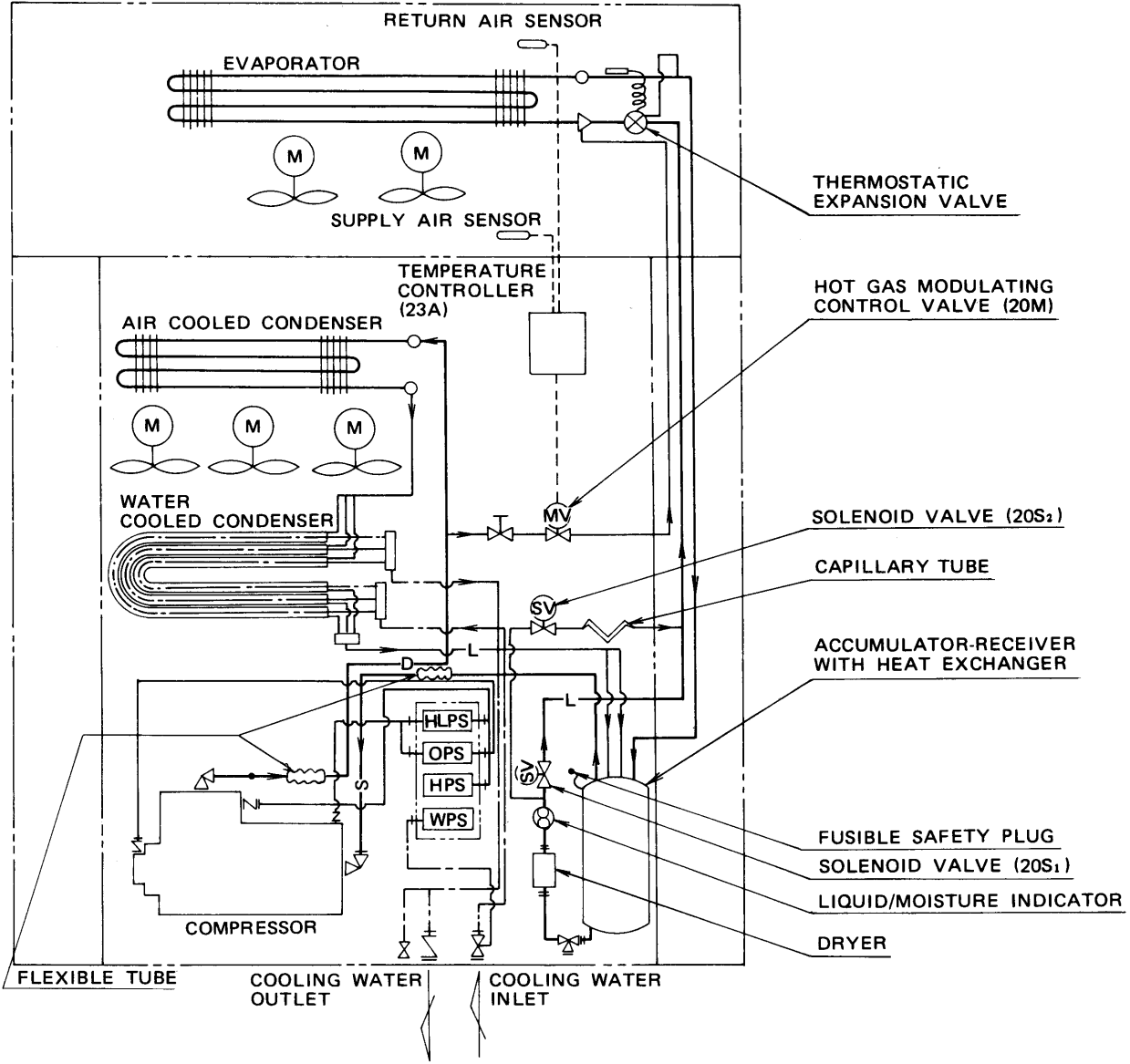


(3) Control box



- | | |
|------------------------------------|--|
| 1 Recorder | 13 Evap. fan motor relay (88F) |
| 2 Setpoint selector | 14 Heater relay (88H ₁) |
| 3 Pilot lamp (WL, GL, RL, OL) | 15 Heater relay (88H ₂) |
| 4 Unit ON-OFF switch (3-88) | 16 Compressor relay (88C) |
| 5 Manual defrost switch (3D) | 17 Defrost relay (2DX) |
| 6 Lamp switch (3-30L) | 18 Auxiliary relay (2X _{4, 5, 6}) |
| 7 Cannon receptacle for pilot lamp | 19 Defrost timer (2D) |
| 8 Cannon receptacle for controller | 20 Fuse (Fu _{1, 2, 3}) |
| 9 Controller (23A) | 21 Voltage selector relay (2X _{1, 2, 3}) |
| 10 Voltage selector switch | 22 Over current relay (51C) |
| 11 Circuit breaker (52C) | 23 Capacitor (C _{1, 2, 3}) |
| 12 Transformer (Tr) | 24 Diode (CPD) |
| | 25 Hour meter |

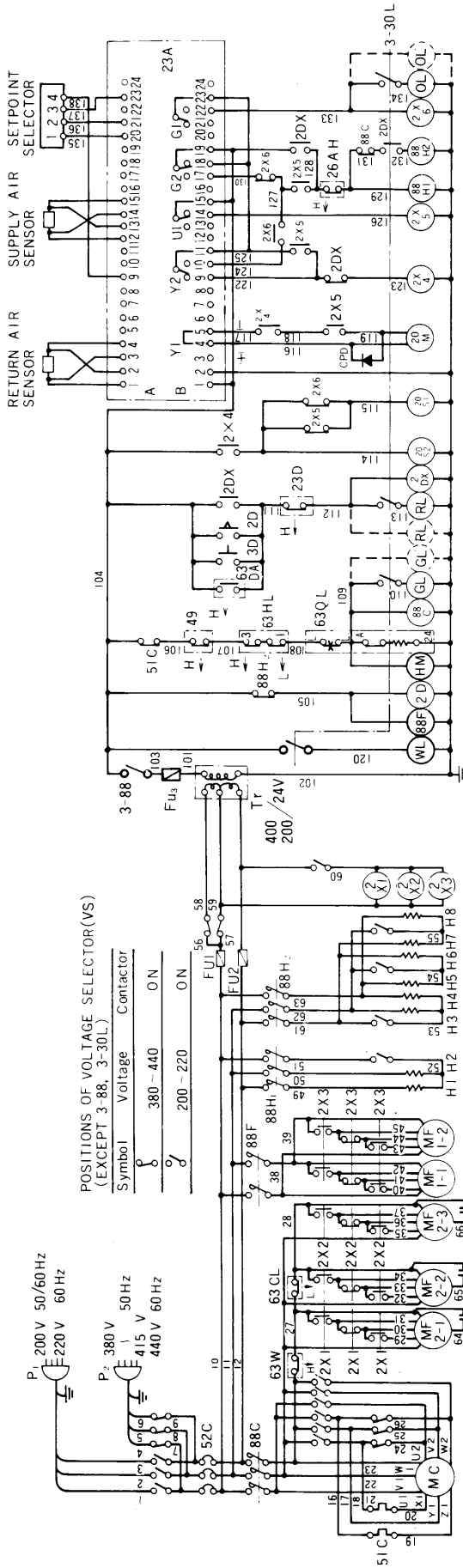
1.4 Piping diagram



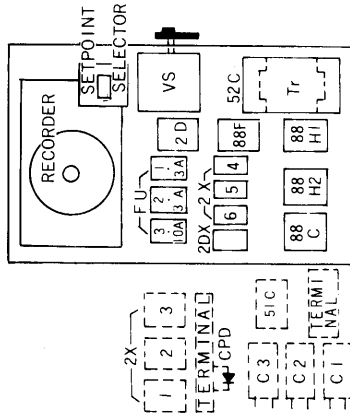
- | | | | |
|-----------|-----------------|------|------------------------------|
| L | LIQUID PIPE | HLPS | DUAL PRESS. SWITCH |
| S | SUCTION PIPE | OPS | OIL PRESS. PROTECTION SWITCH |
| D | DISCHARGE PIPE | HPS | HIGH PRESS. CONTROL SWITCH |
| — — | FLARE CONN. | WPS | WATER PRESS. SWITCH |
| —H— | FLANGE CONN. | | |
| — — — | WATER PIPE | | |
| - - - - - | ELECTRIC WIRING | | |

1.5 Wiring diagram

1.5.1 Sequence wiring

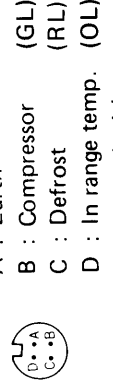


P	FUSE	FU	2DX	DEFROST RELAY
52C	CIRCUIT BREAKER	Tr	2D	DEFROST TIMER
88C	COMPRESSOR RELAY	3-88	63HL	DUAL PRESSURE SWITCH
88F	EVAP. FAN MOTOR RELAY	3-30L	63QL	OIL PRESSURE PROTECTION SWITCH
88H	HEATER RELAY	3D	63DA	DEFROST INITIATION SWITCH
2X	AUXILIARY RELAY	23D	63W	WATER PRESSURE SWITCH
MC	COMPRESSOR MOTOR	26AH	FIRESTAT	
MF ₁	EVAPORATOR FAN MOTOR	23A	TEMPERATURE CONTROLLER	CPD CONTACT PROTECTION DIODE
MF ₂	CONDENSER FAN MOTOR	WL, GL	LAMP	C CAPACITOR
H ₁ ~H ₆	EVAPORATOR COIL HEATER	51C	OVER CURRENT RELAY	63CL HIGH PRESSURE CONTROL SWITCH
H _{7,8}	DRAIN PORT HEATER	49	COMPRESSOR PROTECTOR	HM HOUR METER
20M	MODULATING CONTROL VALVE	20S	SOLENOID VALVE	

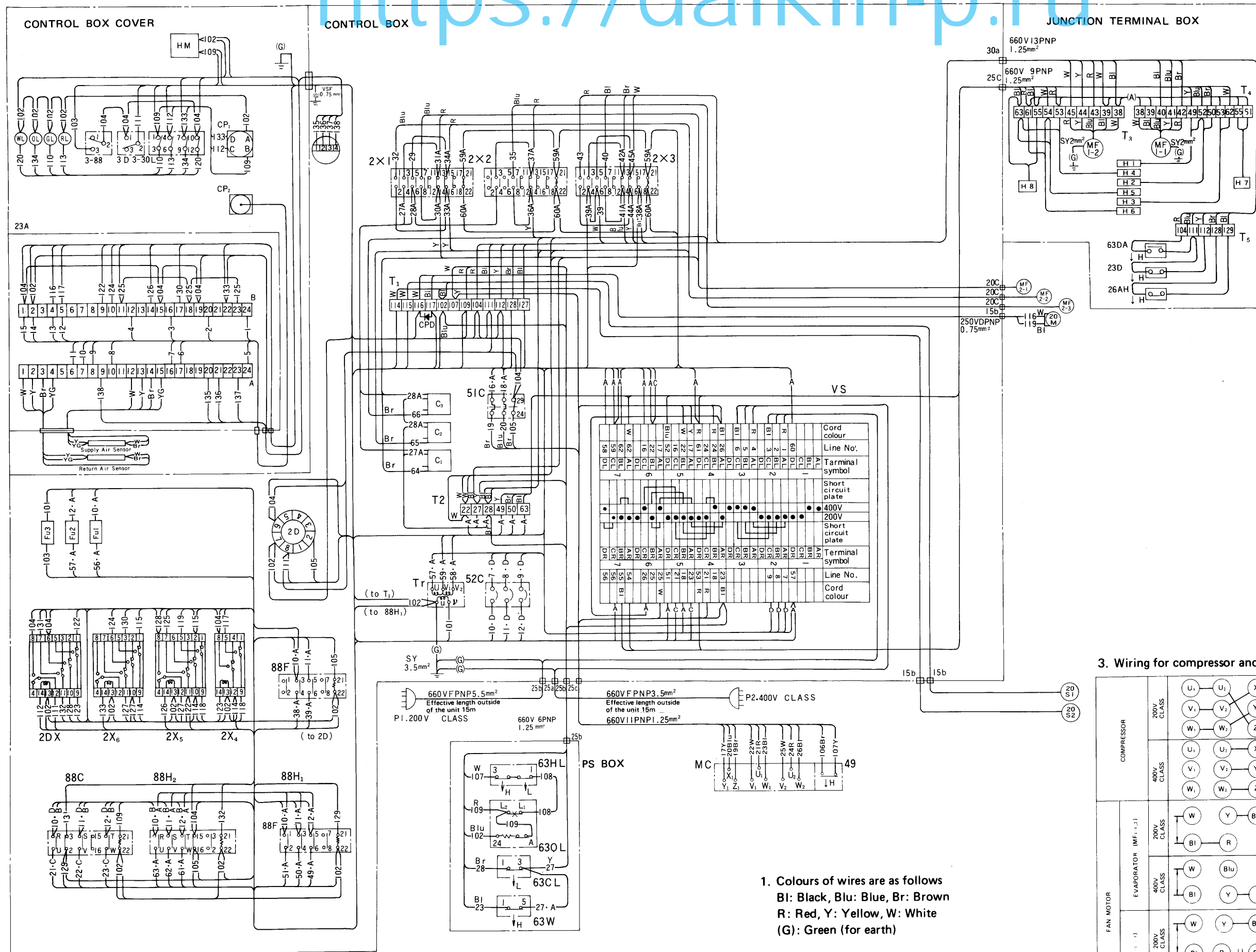


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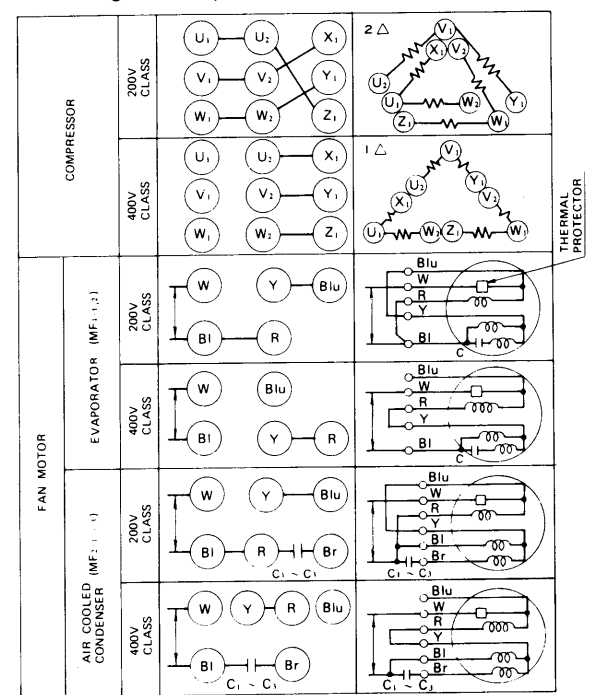
1. Monitoring plug connected as follows.



2. Broken line shows external wiring.

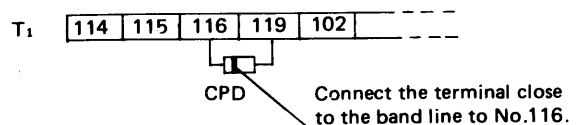


3. Wiring for compressor and fan motor



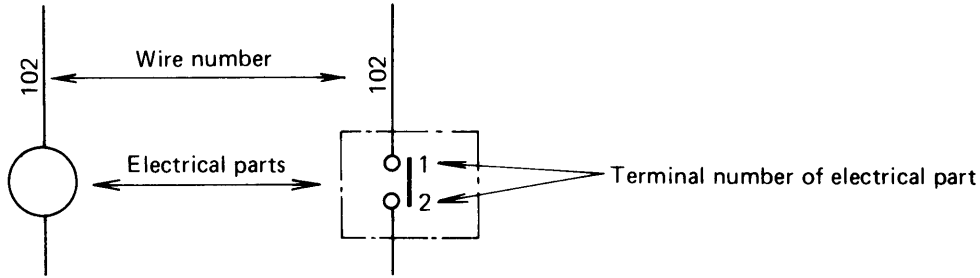
- Colours of wires are as follows
Bl: Black, **Blu:** Blue, **Br:** Brown
R: Red, **Y:** Yellow, **W:** White
(G): Green (for earth)

2. Connecting CPD (Contact protection diode)



1.5.3 How to read wiring diagram

(1) In the wiring diagram, marks and numbers have the meanings given below.



(2) Operation of contacts

- a. The wiring diagram indicates the stationary state in which the circuits are not activated.
- b. When a coil is energized (supplied with power), the associated contact changes its position.

a-contact (normal contact)		b-contact (reverse contact)	
Contact is OFF when coil is not energized	Contact is ON when coil is energized	Contact is ON when coil is not energized	Contact is OFF when coil is energized

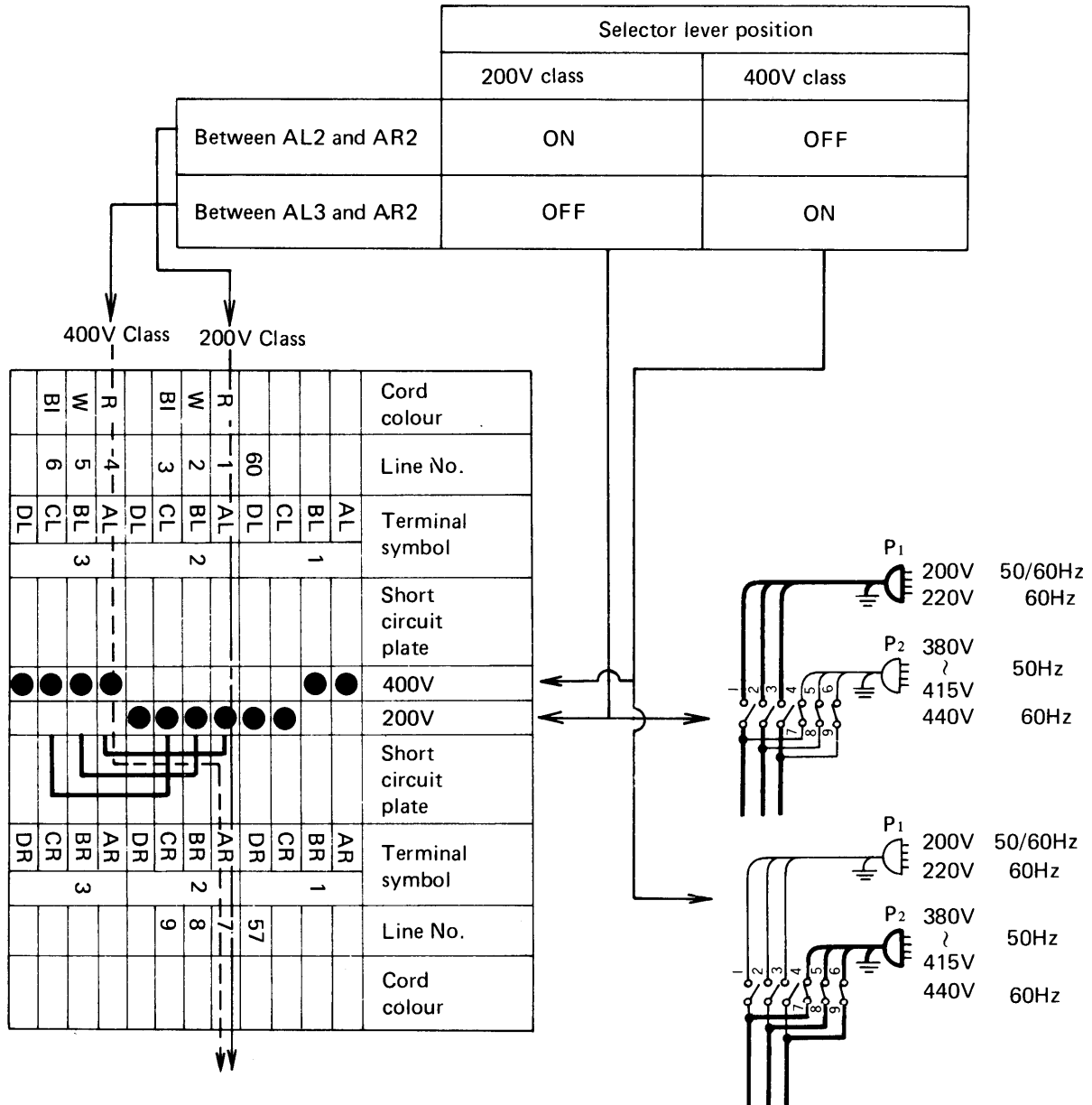
c. Kinds of contacts

	a-contact	Operated by electromagnetic force, temperature, or pressure. ("x" denotes the reset button.)
	b-contact	
	Time-limit a-contact	Operates when the timer counting has completed.
	3D Manual contact	Contact of a snap switch. This turns on as long as the switch is kept pressed and turns off immediately when released.
	3-88, 3-30L Manual contact	Contact of a snap switch. This turns on and holds the on state once the switch is turned on.
	Voltage selector contact (except 3-88, 3-30L)	200V class
		400V class
		200V class
		400V class

d. How to read the wiring diagram of the voltage selector switch.

In the chart, "●" denotes that the contact is on.

The following example shows the states between terminals AL2 and AR2, and between AL3 and AR2.



2. Operation

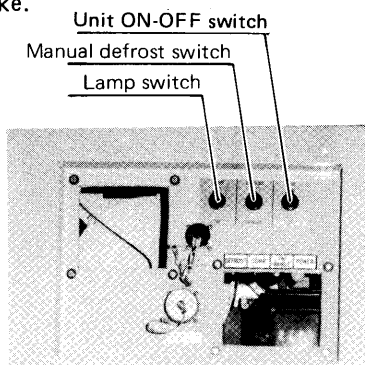
Operate the unit by the procedures given below.

- Preparation and operation
- Checking during operation
- Maintenance after operation

2.1 Preparation and operation

(1) Confirm that supply power is off.

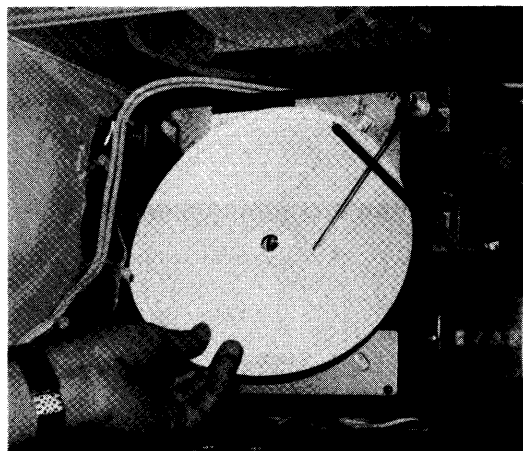
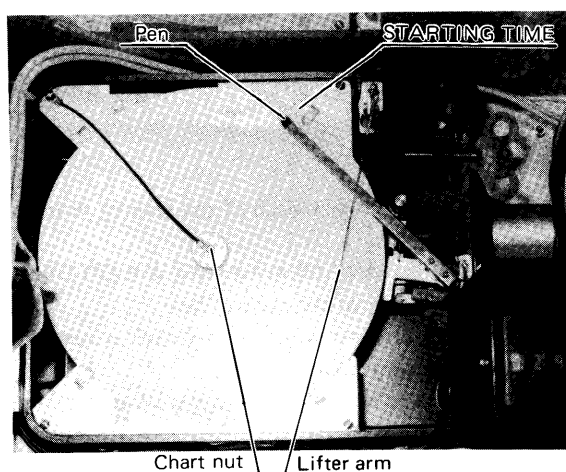
Confirm that the power source, the circuit breaker and unit ON-OFF switch are turned off before checking for safety's sake.



The cover of control box

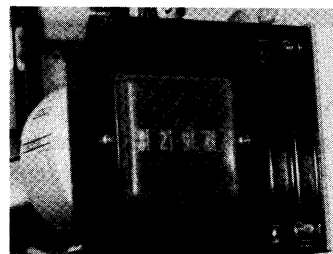
(2) Replace the chart and set up a new one.

- Wind up the spring of the chart drive clock by the clock key provided.
- Confirm that the clock is running by its noise.
- Remove the chart nut and set a new chart.
- Fasten the chart nut after bringing the date on the chart to the marking of "STARTING TIME".
- Set down the pen by moving lifter arm.



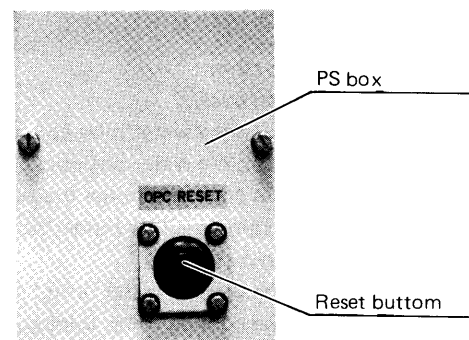
(3) Set the setpoint selector.

- Select a designated temperature by pressing the buttons arranged above and beneath the digital selector displays.

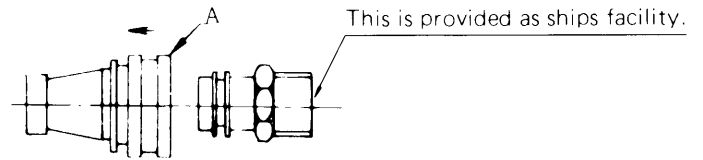
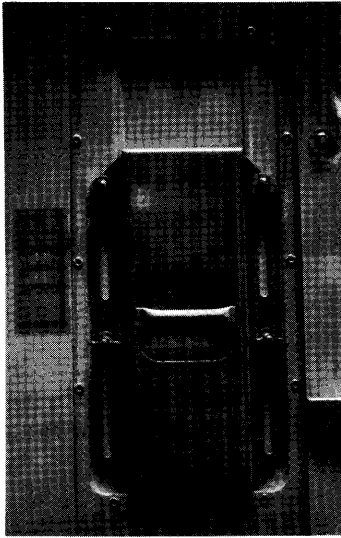


(4) Reset the oil pressure protection switch.

Reset by pressing the button on the front panel of the PS (Pressure switch) box. The unit does not start unless the switch is reset.

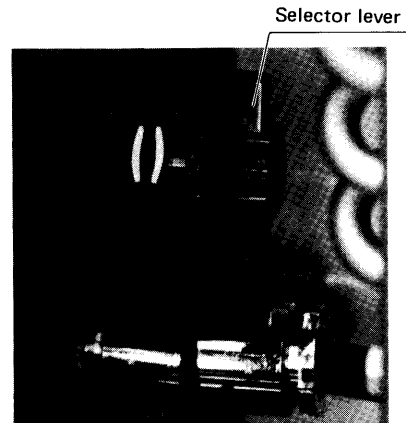


- (5) Open or close the ventilator.
Open or close the ventilator according to the cargo.
(Be sure to keep it closed during transportation of frozen cargo.)



Water connection at outlet side

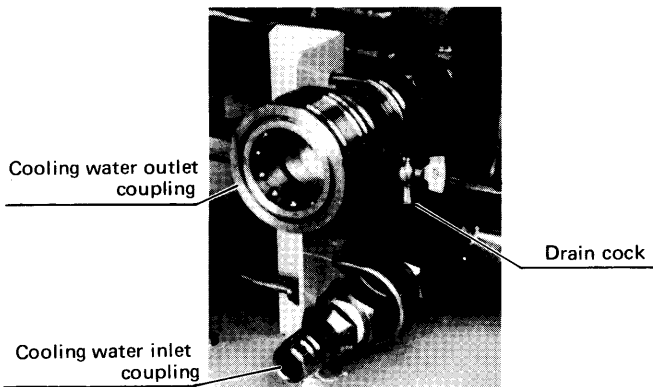
- (7) Check that all refrigerant stop valves are opened.
(8) Set the voltage selector according to the supply voltage.



Voltage selector

- (6) Connect the cooling water piping.
● In the case of water-cooled operation, connect the water piping, and supply water through it.

- (9) Plug in the power source which supplies the proper voltage, and fasten the plug firmly.

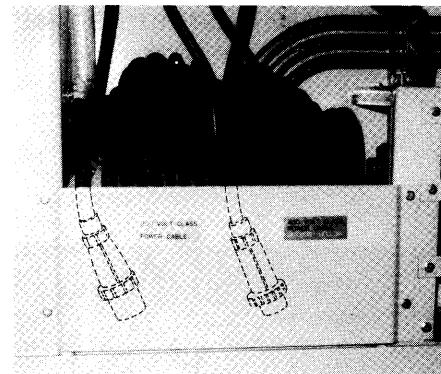


- Connecting method
1. Close the drain cock.
 2. Connect the cooling water inlet coupling.
 3. Connect the cooling water outlet coupling.
 4. Open the drain cock and purge the air.
 5. After having completed air purge, close the cock.

- Disconnecting method
1. Disconnect the cooling water outlet coupling.
 2. Disconnect the cooling water inlet coupling.
 3. Open the cock and drain off.

When the cooling water couplings are connected, insert the coupling on the ship side into the coupling on the unit side until a "click" is heard.

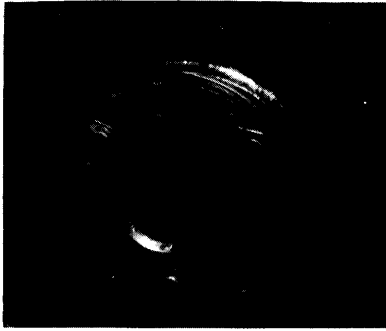
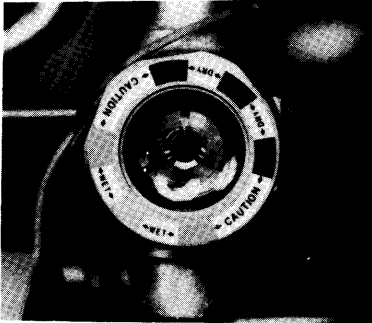
When disconnecting them, pull the coupling on the ship side toward you while pushing the A part of the female coupling in the direction pointed by an arrow mark.



- (10) Turn on the power switch of the facility (outside the unit).
(11) Turn ON the circuit breakers and unit ON-OFF switch.
(12) Close the cover of the control box.
If it is loose, water will escape. Check around the packing and tighten the cover securely.

Note: If the unit stops 2 ~ 3 minutes after starting, the oil pressure protection switch in many cases has been activated.
If this happens, depress the reset button a few minutes after the unit stops. If it stops again, repeat the same action.

2.2 Checking during operation

Checking items (precautions)	Method of check	
1. Check if unusual noise and vibration is produced from compressor, fan and piping etc.	Visual, sensuous and touching.	
2. Check to ensure oil pressure protection switch functions, and the unit does not stop.		
3. Check suction and discharge pressures of the compressor. (For installation of a gauge, refer to "Section 9, page 59".)	Compare observed data with standard ones.	
4. Check for proper oil level of compressor. Check to see the oil is clean. (Oil level may fall for a while after starting, but it rises gradually.)		Visual Oil level should be approx. ¼ to ¾ of its full scale.
5. Check to see if refrigerant is sufficient. (The refrigerant bubbles immediately after starting, but this does not mean that refrigerant is lacking.)		Lack of refrigerant is indicated by bubbles in the moisture indicator.
6. Check if any moisture is present in refrigerant circuit. (The color of moisture indicator may turn to orange if it has been exposed to gaseous refrigerant for a long time, but this is no indication of trouble.)	Visual The moisture indicator should normally appear deep blue. Orange color is a sign of trouble.	
7. Check operating conditions with the pilot lamps and check instrument (Stäfa).	Visual	
8. Check if the recorder operates according to the inside temperature.	Visual	

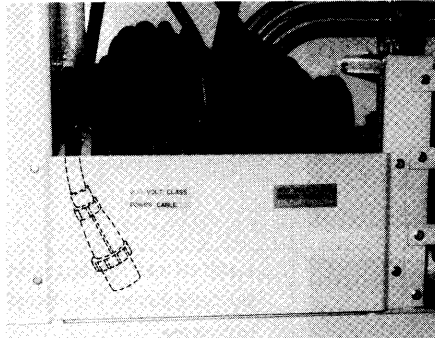
2.3 Maintenance after operation

(1) Stopping

To stop the unit, perform defrosting operation with the manual defrost switch and immediately turn off the unit ON-OFF switch after the compressor has stopped, (stop the unit with "pump-down" state.) After pump down, turn off the circuit breakers.

(2) Stowing the power cable

Turn the plug's opening downward so that sea and rain water cannot enter the plug when stowing it.



(3) After water-cooled operation

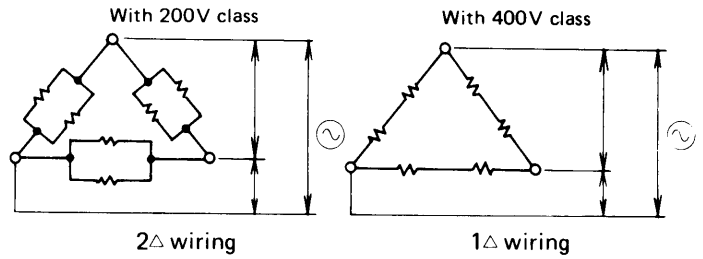
Remove the water piping, open cocks, and drain off.

(4) Close the cover of the control box.

3. Operating modes and circuits

3.1 Voltage selection system (switching over 200V and 400V class)

(1) This unit is adaptable to either of two supply voltages (dual rated voltage). Set the voltage selector (multi-contact cam switch) according to the supply voltage by hand. The voltage selector changes wiring of the motors, electric heaters, and the transformer of the control circuits to supply the relevant voltage. For example, the internal wiring of the compressor is changed as follows.

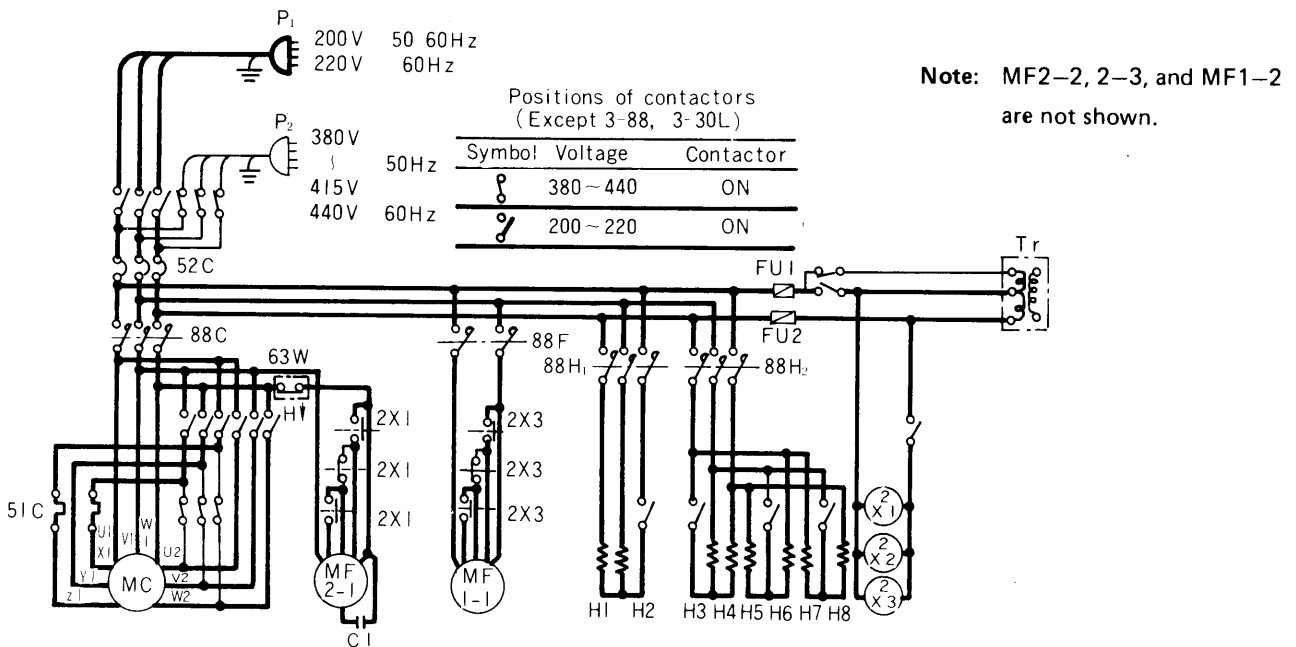


(2) Circuitry

- With 200V class (Set the selector lever to "200V CLASS".)

The contacts marked "☐" in the sequence chart (except 3-88 and 3-30L) are turned on.

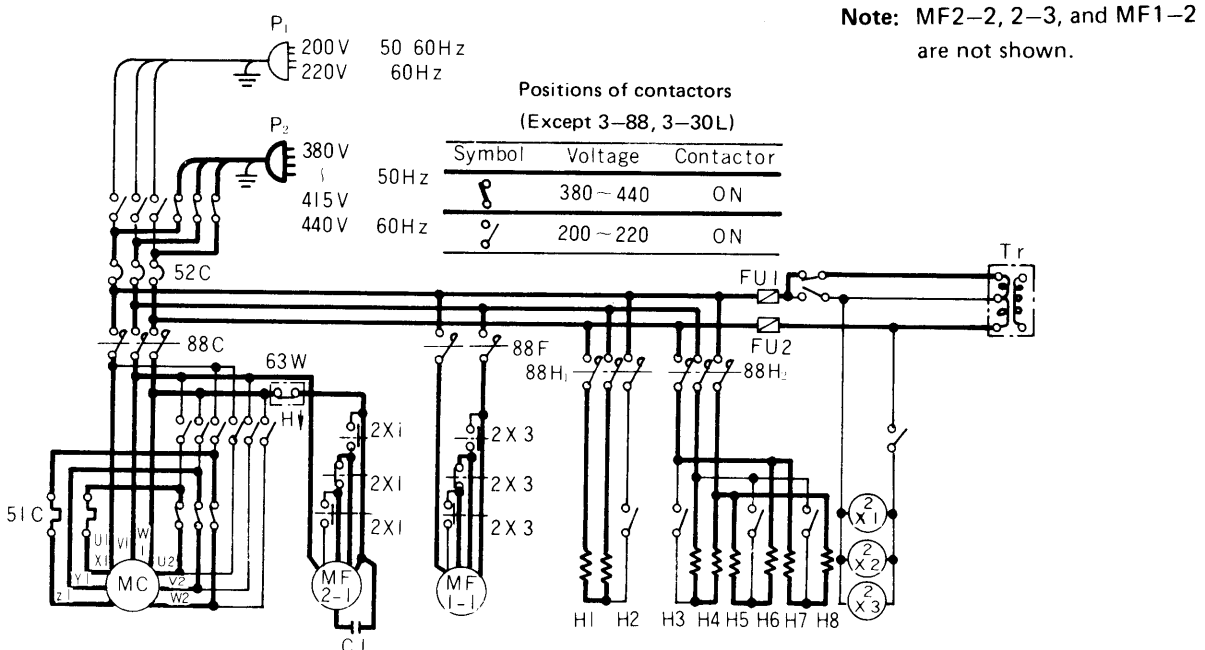
The circuits for 200V class will be set up with the contacts and the voltage selector relay (2X1.2.3) are energized.



- With 400V class (Set the selector lever to "400V CLASS".)

The contacts marked "☐" in the sequence diagram are turned on and the circuits for 400V class will be set up (2X1.2.3 are off).

A. With main power supply



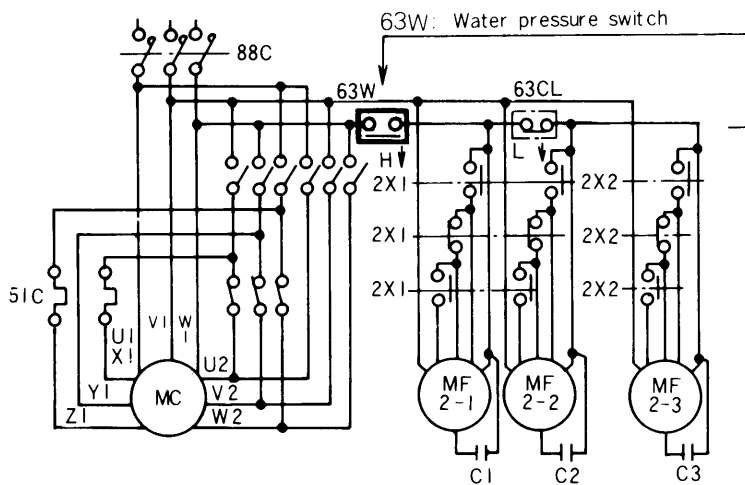
3.2 Air cooled and water cooled operation

The unit will operate on either air cooled or water cooled condenser operation.

During transit on land, in depot or on a vessegs deck, the air cooled operation will function, and the operation in ship holds is normally water cooled.

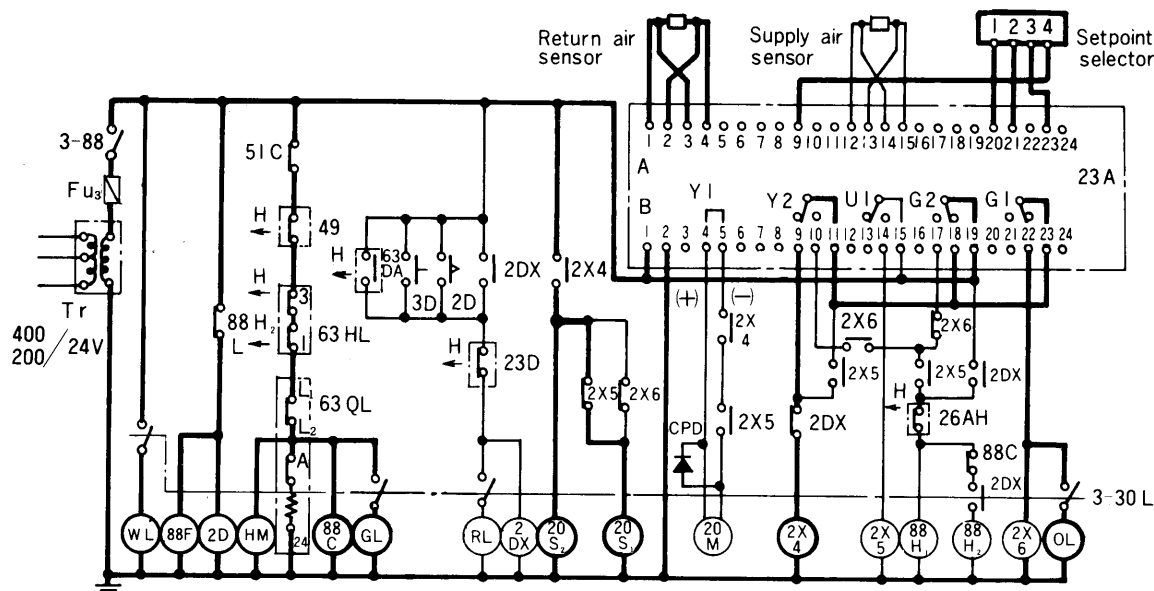
The operation will be changed from air cooled to water cooled automatically by the water pressure switch; i.e. when water pressure at the inlet of the water cooled condenser rises higher than the presetting value, the contact points of the water pressure switch are opened, so the condenser fan motors stop, and the water cooled operation starts.

When the water supply is disconnected. The contacts of the water pressure switch are made and the condenser fan motors rotate.



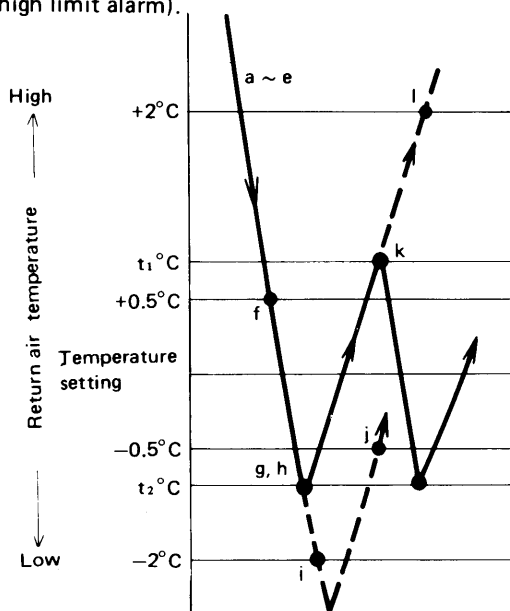
This diagram indicates air-cooled operation mode. When water pressure is applied to the switch, the switch mechanism moves in the direction of H ↓, so the condenser fan motors (MF2-1, 2, 3) stop, and water-cooled operation starts.

3.3 Frozen operation

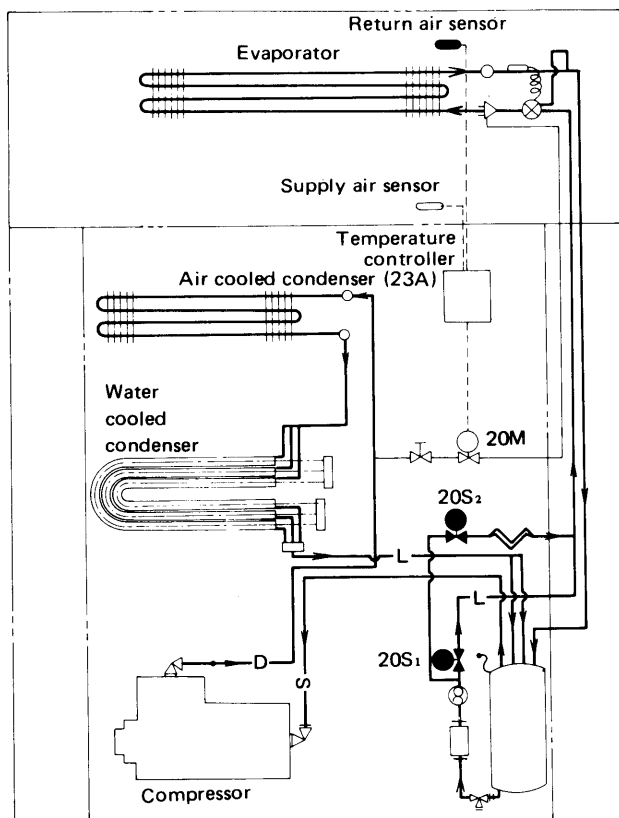


- (1) Switching over frozen and chilled modes
One of the modes will be automatically selected according to the setting of the setpoint selector.
 - When the setting is above -6.5°C : chilled mode
 - When the setting is below -7.0°C : frozen mode
- (2) During frozen mode, the compressor will be automatically turned on and off, sensing return air temperature to the evaporator.
 - a. Turn on 3-88 (unit ON-OFF switch).
 - b. With 88F (evaporator fan relay) energized, MF1-1 and 1-2 (evaporator fan motors) start.
 - c. Solenoid valves (20S₁ and 20S₂) are open, with relay 2X₄ energized by Y₂ relays (for compressor and heater) and G₂ (for low limit alarm) of 23A (controller).
 - d. When 20S₁ and 20S₂ are open, refrigerant flows and low pressure rises. As it reaches 0.2 kg/cm^2 , LP of 63HL (dual pressure switch) are turned on.
 - e. With LP on, 88C (compressor relay) gets energized. MC (compressor) and MF2-1, 2 and 3 (air-cooled condenser fan motors) will start and WL (white lamp) will light up. --- The unit enters in the normal operation and container inside temperature begins to fall. ---
 - f. When return air temperature to the evaporator falls to 0.5°C above the preset temperature, (preset temperature plus 0.5°C), G₁ relay (high limit alarm) of 23A is turned on and GL (green lamp) lights up by G₂ → G₁ (indicating that inside temperature is with in range).
 - g. When the temperature falls lower than the preset temperature, Y₂ relay is turned off (continuity between 9 and 11 of terminal B of 23A is lost); 2X₄ becomes unenergized; 20S₁ and 20S₂ close; and "pump down" starts.
 - h. When the low pressure falls down to 40 cmHgV , LP of 63HL is turned off; 88C becomes unenergized; MC, MF2-1, 2, and 3, etc. stop; and frozen operation stops.

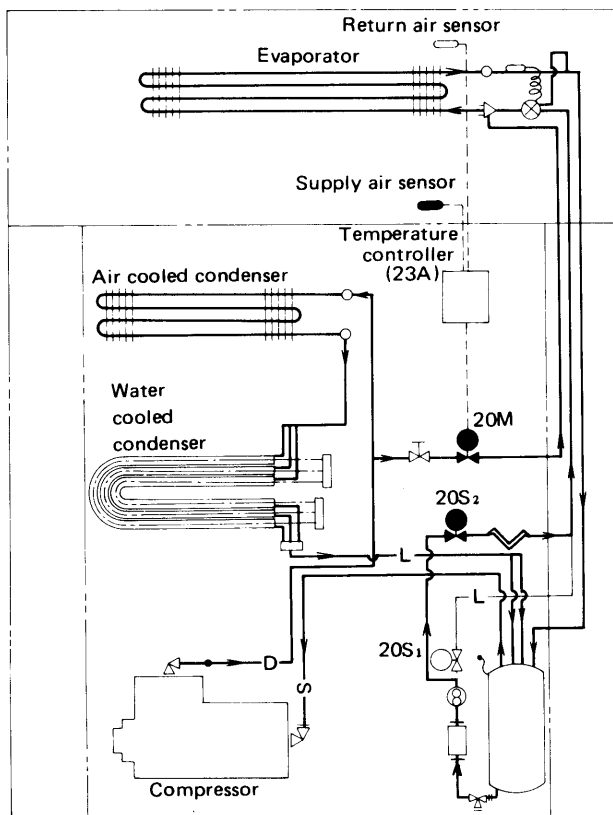
- i. If the temperature falls down to 2°C below the preset temperature after MC (compressor) has stopped, G₂ relay is turned off after a delay of approximately 20 seconds and GL goes out (low limit alarm).
- j. When the temperature rises to the preset temperature minus 0.5°C , G₂ relay is turned on and GL lights up.
- k. When the temperature rises higher than the preset temperature. Y₂ relay is turned on and frozen operation starts by steps "c" through "e" described above.
- l. If the temperature rises further up to the preset temperature plus 2°C , G₁ relay is turned off after a delay of approximately 20 seconds and OL will go out (high limit alarm).



Note: t_1 and t_2 °C (point of Y₂ relay function) are determined depending on temperature and time by means of P.I.D. (P: proportional action, I: integral action, D: derivative action) of the controller.

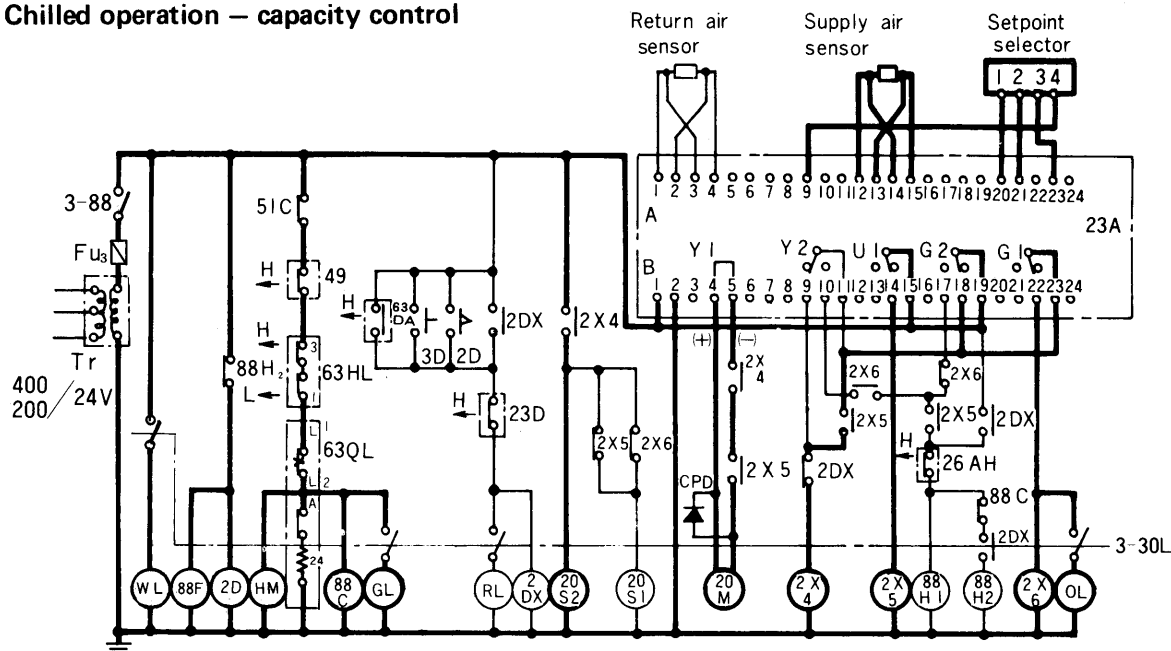


Flow of refrigerant during frozen operation

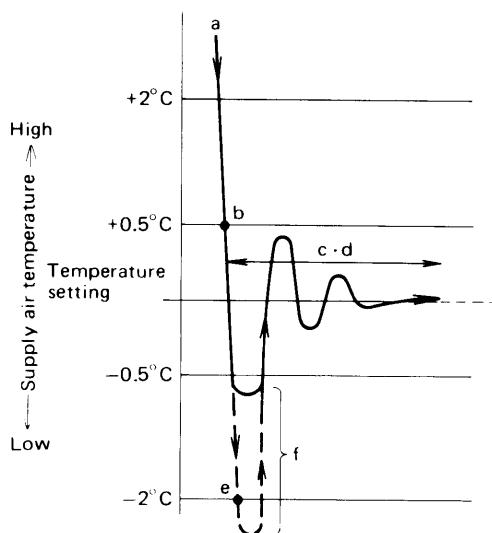


Flow of refrigerant during chilled operation

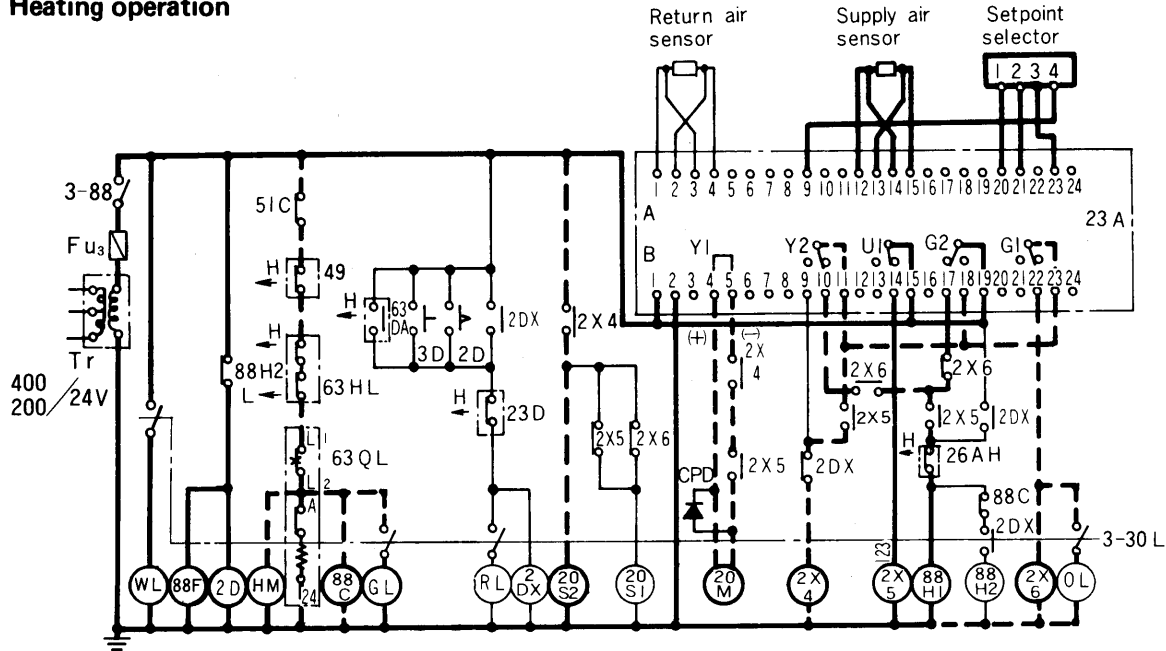
3.4 Chilled operation – capacity control



- (1) Chilled operation is performed when the preset temperature is -6.5°C or higher. U_1 relay (which switches over frozen and chilled modes) of 23A is turned on, $2X_5$ relay becomes energized and the circuit of the chilled mode is made.
- (2) Chilled operation is controlled sensing supply air temperature from the evaporator; i.e., the modulating control valve (20M) controls the amount of hot gas to be bypassed continuously while a capillary tube controls the liquid refrigerant.
 - a. The operation is the same with that (step "a" ~ "e") of the frozen mode while supply air temperature falls to the preset temperature plus 0.5°C from the pull down period.
 - b. When the supply air temperature reaches the preset temperature plus 0.5°C , G_1 relay is turned on (GL lights), $2X_6$ relay gets energized, $20S_1$ closes; and, the capillary tube controls the liquid refrigerant. ($20S_1$ remains closed after that.)
 - c. As the supply air temperature rises to the preset value, Y_1 voltage rises slowly from zero, which opens the modulating control valve (20M) gradually, permitting hot gas to flow through.
 - d. After the temperature has been reached the preset temperature, it takes about an hour for the unit to reach a steady state. (the opening of 20M is nearly fixed; i.e., the flow of bypassing hot gas is nearly constant.) (This interval varies somewhat with the preset and ambient temperatures.) During this time, the valve changes its openings to control the flow of hot gas until the supply air temperature becomes stable.
 - e. Depending on operating conditions (such as when the difference between the ambient and preset temperature is small), G_2 relay is turned off and lamp GL goes out (after a delay of approximately 20 seconds) if the supply air temperature becomes -2°C lower than the preset temperature before stabilizing hot gas bypass volume (low limit alarm). At the same time, $2X_4$ relay is turned off; $20S_2$ and 20M are closed, after "pump down", the compressor stops to prevent over-cool.
 - f. If Y_2 relay has been turned off during step "e" above, the electric heaters (H_1 and H_2) may be turned on tentatively, but they will be turned off when the temperature rises. (Refer to the section on Heating Operation for the details.)



3.5 Heating operation



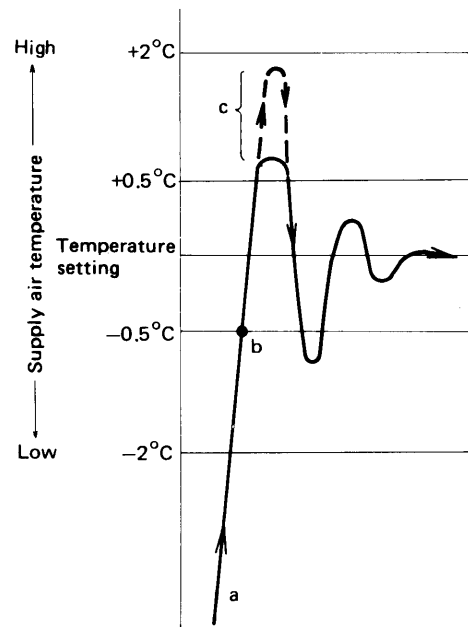
- (1) Heating operation will be performed only when the preset temperature is -6.5°C or higher as in the chilled mode. Inside temperature will be controlled, sensing the supply air temperature.
- (2) There are three modes in the heating operation.
 - Pull up – Heated only by electric heaters
 - Steady state – Heated by hot gas bypass and electric heaters (when large heating capacity is needed)
 - Heated only by hot gas bypass (when small heating capacity is enough)
- c. If heating load is small as stated in step “b”, the inside temperature will rise: Y_2 relay is operated (the function point varies depending on PID operation): $88H_1$ becomes unenergized: and the heaters (H_1 and H_2) are turned off, and heating operation only with hot gas bypass is performed. (The circuit is the same as that of chilled operation in the sequence diagram.)

One of these three modes will be automatically selected according to load conditions.

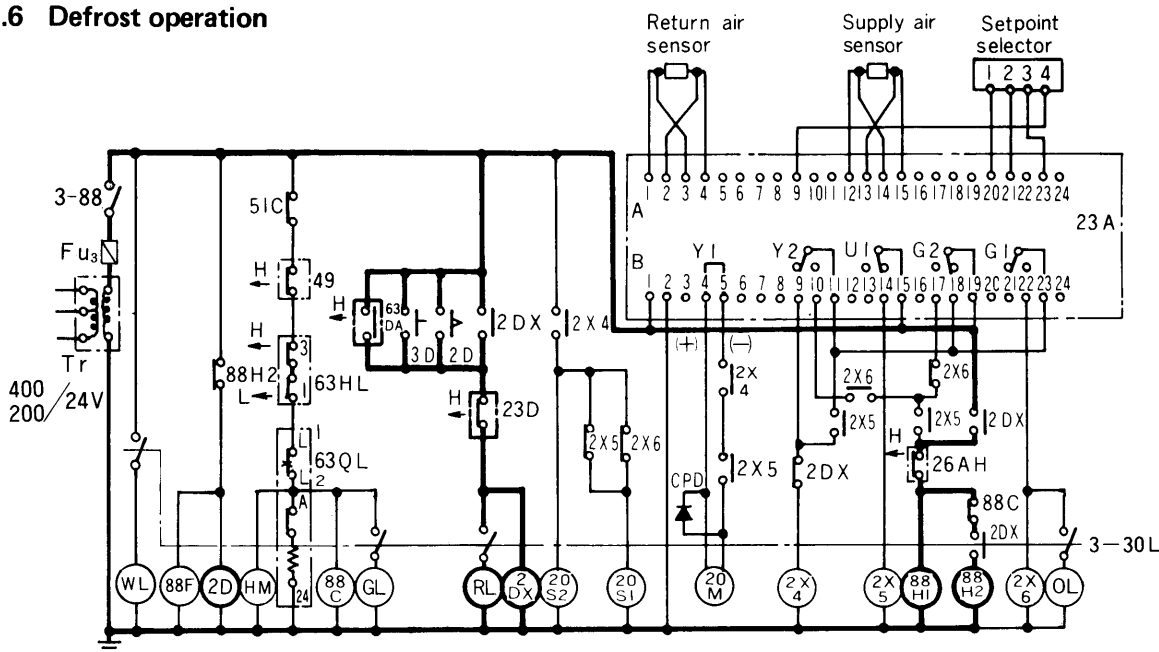
- a. Pull up (The circuit indicated with bold lines in the sequence diagram functions)

Until the supply air temperature rises to the preset temperature minus -0.5°C , G_2 relay is turned off, which unenergizes $2X_6$, energizes the heater relay ($88H_1$) and operates the electric heaters (H_1 and H_2). (compressor stops.)
- b. When the supply air temperature raises the preset temperature minus 0.5°C , G_2 relay is turned on and GL lamp light up. At the same time, $2X_6$ relay becomes energized,, so $88H_1$ is energized by Y_2 relay. Since G_2 relay is on, $2X_4$ relay is energized, $20S_2$ is open, and the compressor runs and heating starts with electric heaters and hot gas. (The circuit indicated by dotted lines in the sequence diagram functions.)

Afterwards, operation will become stable as time afterwards, elapses.



3.6 Defrost operation

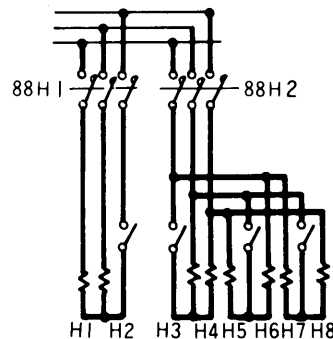


(1) Defrosting operation starts based on the following three conditions.

- The air pressure switch (63DA) is turned on when the pressure difference of air draft at the inlet and outlet of the evaporator becomes large with much frost developing on the evaporator coil.
 - Timer (2D) is turned on.
 - Manual defrost switch (3D) is turned on.
- If one of those stated above is on, defrost relay (2DX) becomes energized, and RL (red lamp) lights up.

(2) When 2DX is energized:

- Electric heaters H₁ and H₂ are operated with 88H₁ energized.
- 20S₁ and 20M are closed with 2X₄ relay unenergized. After "pump down", the compressor stops; 88H₂ becomes energized and electric heaters H₃~₈ are operated. (Now all electric heaters H₁~₈ are turned on.)

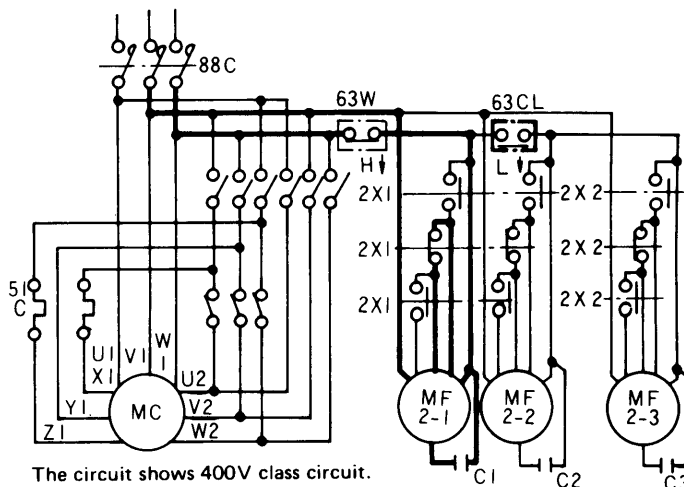


The circuit shows 200V class circuit

- (3) With 88H₂ energized, the evaporator fan stops and defrosting operation starts.
- (4) When the evaporator coil temperature rises to 7.2°C after having removed frost, defrost termination thermostat (23D) is turned off and 2DX becomes unenergized. Now defrosting operation is completed.

3.7 High pressure control

(1) The condensing pressure (high pressure) falls when the ambient temperature falls during air-cooled operation, and the lower pressure also falls accordingly. If operation is still continued in this condition, the low pressure switch will be turned off (LP of 63HL is turned off) and the compressor will stop so that the required refrigeration capacity is not available. To prevent the high pressure from falling, a pressure switch (63CL) (which controls the high pressure) stops two condenser fans (MF2-2 and 2-3) automatically when the high pressure falls to 7 kg/cm² (99.6 psi).

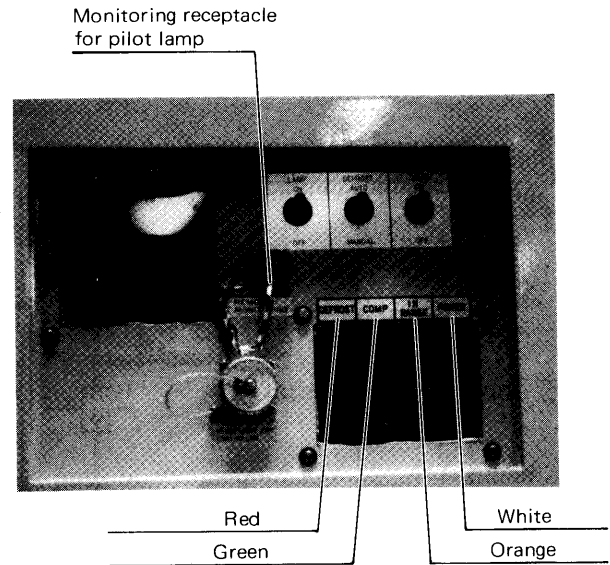
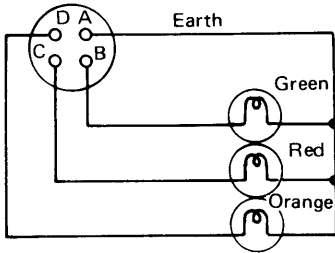


The circuit shows 400V class circuit.

3.8 Pilot lamps and monitoring circuit

- (1) Three lamps which indicate operating mode are mounted on the front panel of the control box.
- Red : indicates defrosting mode
 - Green : indicates that the compressor is running
 - Orange : indicates that storage temperature is with in range (within $\pm 2^{\circ}\text{C}$ of the preset temperature)

Receptacles for monitoring pilot lamp is also equipped and its connections is shown at below.



- (2) How to judge operation state by pilot lamps and function of the components.

Be sure to check first that the pilot lamps are not blown out before check.

Part name		Set point selector set above -6.5°C ($+20.3^{\circ}\text{F}$) — Air cooled operation				
		Cooling		Heating		Defrost
		Pull down	In range	Pull up	In range	
Light	Defrost —Red	X	X	X	X	○
	Comp. —Green	○	○	X	○	X
	In range —Orange	X	○	X	○	※ ○
Magnetic switch	Comp. cond. fan motor	○	○	X	○	X
	Evaporator fan motor	○	○	○	○	X
	Heater (88H1)	X	X	○	○	○
	Heater (88H2)	X	X	X	X	○
Solenoid valve (20S1)		○	X	X	X	X
Solenoid valve (20S2)		○	○	X	○	X
Modulating valve (20M)		X	○	X	○	X
Compressor		○	○	X	○	X

Part name		Set point selector set below -7.0°C ($+19.4^{\circ}\text{F}$) — Air cooled operation			Water cooled operation
		Cooling		Defrost	
		Pull down	In range		
Light	Defrost —Red	X	X	○	Water cooled condition is the same as air cooled except ○ Water press. switch (63W) open ○ Condenser fan motor (MF2) de-energized
	Comp. —Green	○	○	X	
	In range —Orange	X	○	※ ○	
Magnetic switch	Comp. cond. fan motor	○	○	X	
	Evaporator fan motor	○	○	X	
	Heater (88H1)	X	X	○	
	Heater (88H2)	X	X	○	
Solenoid valve (20S1)		○	○	X	
Solenoid valve (20S2)		○	○	X	
Modulating valve (20M)		X	X	X	
Compressor		○	○	X	

Notes 1. ○ : Energized or ON, X : De-energized or OFF

4. Major components and maintenance

4.1 Components related with refrigeration circuit

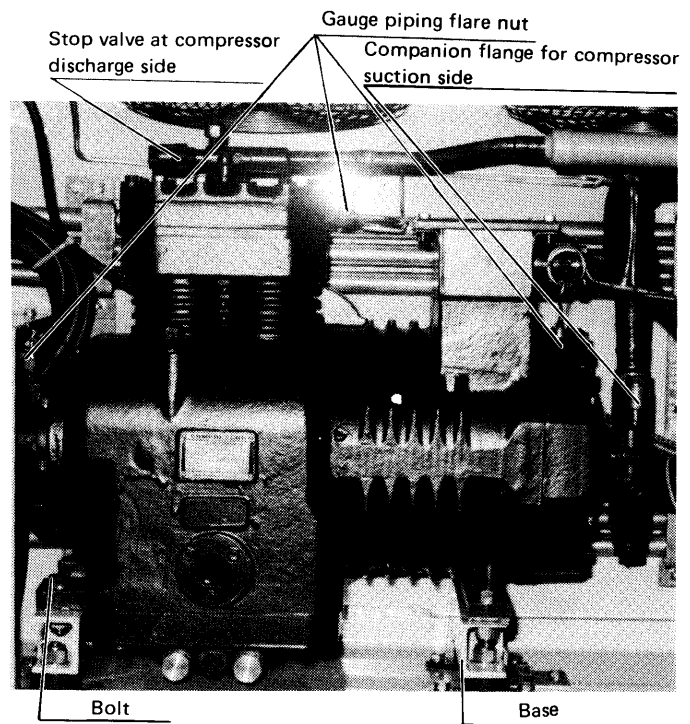
4.1.1 Compressor

The compressor is of a semi-hermetic type with built-in motor so that there are few places where leakage of refrigerant may occur. The reversible lubricating oil pump used produces the required oil pressure regardless of the direction of rotation of the built-in motor.

(a) Replacement

Remove the compressor by the following procedure.

- 1 Remove the front and base plates and protective bar of the cable stowage.
- 2 Remove the discharge stop valve, suction stop valve gauge piping flare nut (compressor side) and cable.
- 3 Remove four bolts (two on each side) fastening the compressor and base.
- 4 Take out the compressor to the front of the unit.



(b) Installing procedure

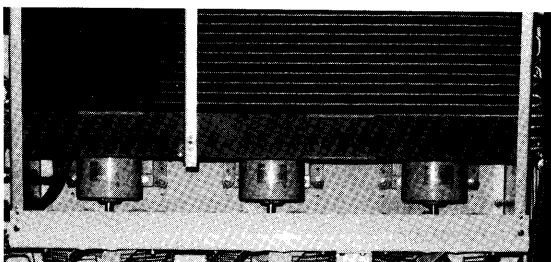
Install the compressor according to reverse procedure given above. When tightening the bolts, refer to the torque values listed.

4.1.2 Air-cooled condenser and evaporator

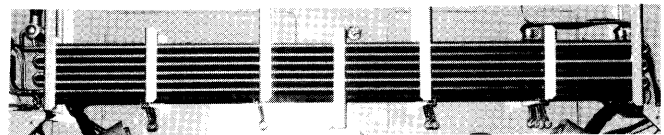
The "cross fin" coil has special corrugated fins. They are compact and very efficient in producing uniform heat exchange efficiency.

(a) Maintenance

Service the air-cooled condenser after removing the air suction grille. Service the evaporator after removing the air return grille or the access panels from outside.



Air cooled condenser



Evaporator

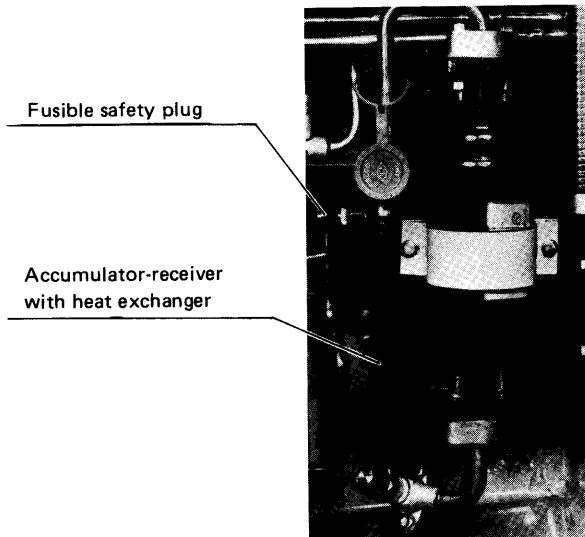
4.1.3 Water-cooled condenser

Of the tube-in-tube type in which cooling water flows in the inner tube while the refrigerant flows between the outside wall and the wall of the inner tube. Since special fins are fitted, the condenser is compact and light.

4.1.4 Accumulator-receiver with heat exchanger

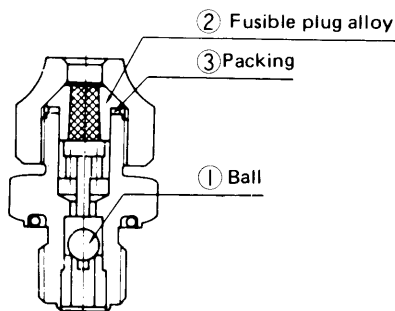
Consists of the accumulator, receiver, and heat exchanger, which are encased in a vertical cylindrical construction; i.e. the heat exchanger passes through the accumulator from its top to the bottom and reaches to the receiver.

This construction reduces heat loss. A fusible safety plug is fitted to the receiver body.



(a) Replacement procedure of the fusible safety plug

When pressure rises abnormally in the system, the fusible safety plug melts itself, so if the fusible safety plug is melted, check possible causes thoroughly. When fusible safety plug functions, the centre of the fusible safety plug alloy ② melts, from which the refrigerant escapes. When the flare nut is removed, ① (ball) will come out under pressure and block the passage of the refrigerant outlet, which prevents the refrigerant from escaping and also the air from entering. Thus, refrigerant loss is extremely minimized.

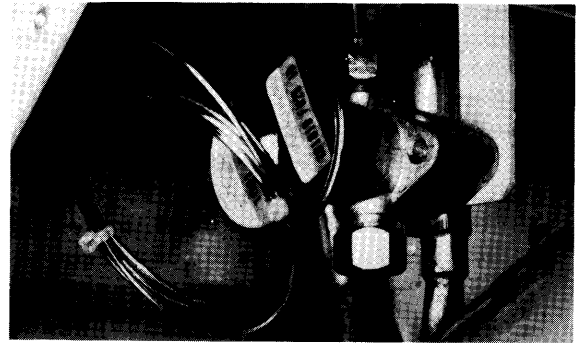


Construction of fusible safety plug

Insert a new ② by means of ③, and tighten the flare nut.

4.1.5 Expansion valve

The externally equalized expansion valve which is fitted before the evaporator and senses over-heat degree of leaving evaporator refrigerant and controls flow of the refrigerant automatically according to operating conditions. The expansion valve with MOP (motor overload protection) is adopted to protect the compressor motor from overload.





“CAUTION” Whenever adjusting and replacing the expansion valve, the unit should be isolated from the mains supply for safety.

(a) Adjusting the expansion valve

There are two methods to adjust the expansion valve; i.e. one is the adjustment based on the suction operation standard and the other is that based on the frost conditions on the compressor.

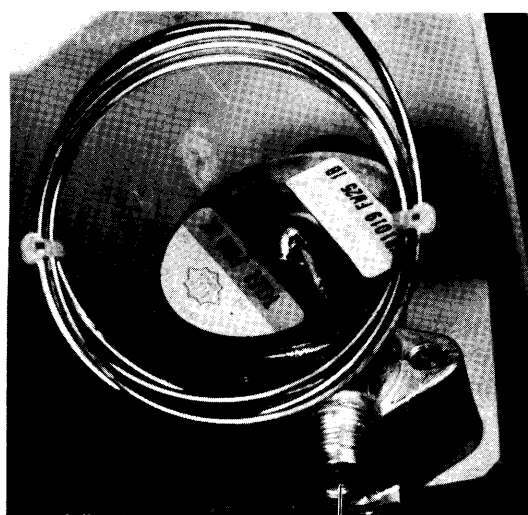
- (1) Adjustment based on the suction operation pressure
 - 1) Conform that the predesigned volume of the refrigerant has been charged.
 - 2) Attach a pressure gauge to each gauge port and operate the refrigeration unit, maintaining inside temperature at -18°C (-0.4°F). (See connecting of pressure gauge).
 - 3) When inside temperature comes to the preset temperature, compare the suction pressure reading with the standard pressure. (See Standard operation pressure curve)
 - 4) If suction pressure reading differs with the standard pressure, adjust the expansion valve as stated below.
 - 5) After loosening the clamp screw, turn the adjusting screw.
 - 6) Note that pressure will not change after a certain lapse of time.
- (2) The adjustment based on frost stated on the compressor.
 - 1) Refer to the caution for adjustment of expansion valve as above. At this time, inside temperature should be maintained to -18°C (-0.4°F).
 - 2) Regulate the adjusting screw as stated below based on frost state on the suction pipe and the stop valve of the compressor.
 - 3) Whether or not the adjustment required is judged by frost state of the flange on the suction side of the suction valve.
 - 4) However note that frost state differs with ambient air conditions (temperature and humidity).

Adjusting points for expansion valve

Adjusting screw	Turning direction		Operation state
Adjusting screw of expansion valve	Clockwise		Suction pressure is higher than the standard pressure (Frost forms on the suction pipe rather than the suction flange of the stop valve). Clockwise rotation of the adjusting screw decreases running pressure.
	Counter-clockwise		Suction pressure is lower than the standard pressure (frost forms on the compressor side rather than the suction flange of the stop valve). Counterclockwise rotation of the adjusting screw increases running pressure.

(3) Countermeasures after operation

- Remember the original setting of the expansion valve.
If any change is found with the setting after adjustment of the expansion valve, return the adjusting screw to the original position, as trouble occurred caused by other reasons.
- When the adjusting screw is returned to its original position, firstly turn it passing the original position and then return it to the original position.
- After adjustment, be sure to tighten up the clamp screw and cap it to prevent the refrigerant from leaking.
- After completion of the adjustment, operate the unit, keeping inside temperature at -18°C (-0.4°F) and confirm that low pressure does not go down below $0\text{ kg/cm}^2\text{ G}$ (0 PSIG).

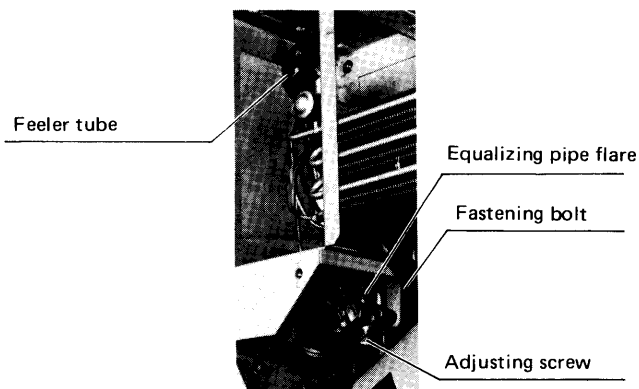


Adjusting screw

(b) Replacement

For replacement of the expansion valve, remove the access panel located on the front of the unit or by removing the evaporator bulkhead inside the container, and the drain pan back plate located at the left side.

- Remove the feeler tube, equalizing pipe flare, and fastening bolts. (To replace the cage alone, there is no need to remove the feeler tube.)
- Remove the power assembly, cage, and packing.
- Be sure to install a new packing when replacing it.



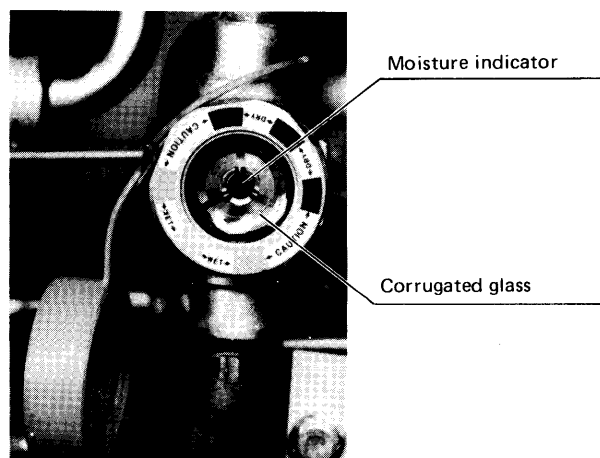
4.1.6 Liquid/moisture indicator

This indicator permits checking of flow of the refrigerant and moisture content in the refrigerant.

(a) Moisture content

The indicator indicates moisture content by the color at the center of the window.

Color	State
Deep blue	Dry
Orange	Wet (moisture contained)



Note: The indicator may appear orange if it has been exposed to gaseous refrigerant for a long time.

(b) Flow of the refrigerant

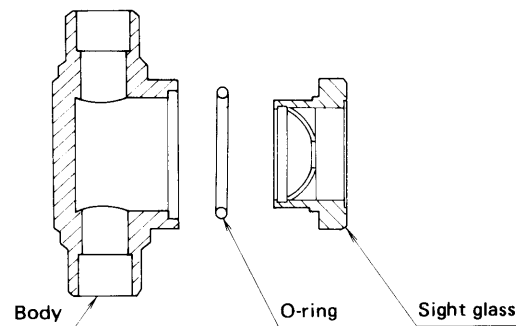
- When the liquid refrigerant is sealed, corrugation on the sight glass disappears.
- Check

Operation	Indicator state
At start	Bubbles appear but liquid refrigerant is sealed in 30 minutes to an hour after starting.
During operation	Bubbles may appear more or less.

If bubbles develop continuously, the refrigerant is possibly running short.

(c) Replacement

- 1) Put the system in "pump down" state.
- 2) Turn the sight glass counterclockwise, and remove it together with the O-ring.
- 3) Apply refrigeration oil to the new O-ring, and fasten the sight glass with torque of 70 ± 5 kg-cm. (Do not apply excessive torque, or the O-ring will break.)



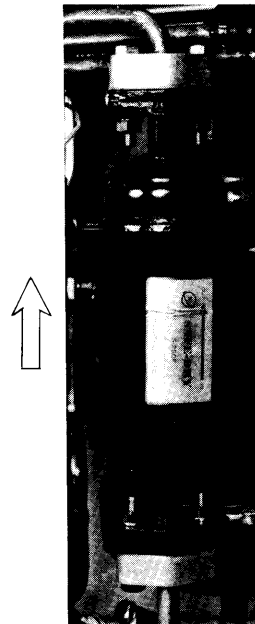
4.1.7 Dryer

This removes moisture and dust from the refrigerant while it is circulated. Replace the dryer if it does not remove moisture or is clogged.

When installing the new dryer, follow the directions given on the nameplate and do not make any mistake about the direction of the dryer.

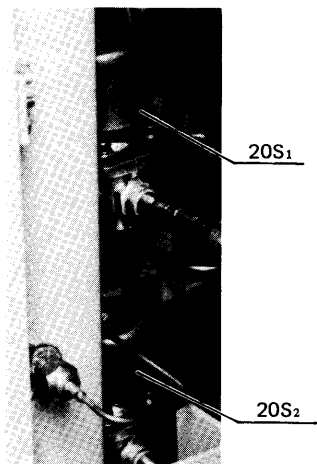
(a) Replacement

- 1) In "pump down" state (see Service), close the compressor suction stop valve.
- 2) Remove the flange bolts before and behind the dryer and replace the dryer with a new one as quick as possible. At this time, be careful not to lose the O-ring on the flange.
- 3) Be careful not to get air into the piping on the solenoid valve side while removing the dryer.
- 4) After reattachment of the dryer, open the stop valve a little to vent the air in the dryer from the flange on the solenoid valve side and then close it at once.
- 5) Loosen the flange on the other side, forcedly turn off the low pressure of the dual pressure switch, turn on the master control switch and open the solenoid valve only to vent the air.
- 6) After completion of the work, restore the stop valve to its original state and then inspect the system for gas leakage. Confirm no gas leakage is found.



4.1.8 Solenoid valves

There are two solenoid valves (20S1 and 20S2) in the liquid line. They operate as follows according to operating mode.



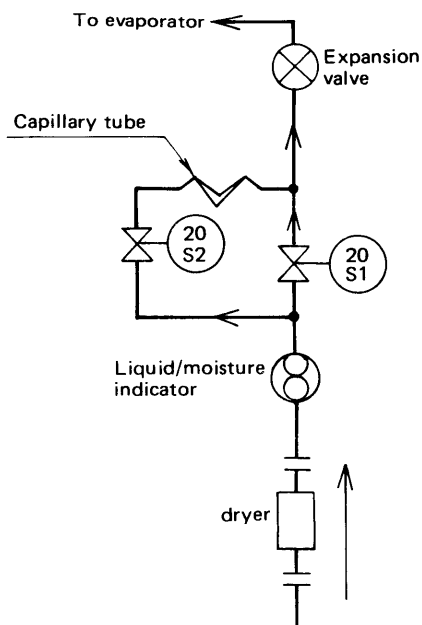
(a) During freezing mode

Both 20S1 and 20S2 are open during operation. When stopping the compressor by the controller, they are closed and stop flow of the refrigerant, performing "pump down".

(b) During chilling mode

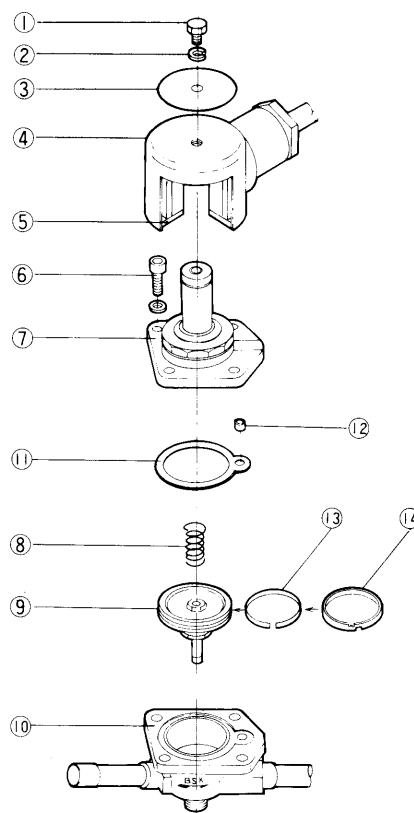
The two valves are open during "pull down". When the supply air temperature falls to the preset temperature plus 0.5°C, 20S1 alone is closed by directions of the controller. The refrigerant then flows through the capillary tube via 20S2 (liquid control).

Both 20S1 and 20S2 are open when the solenoid is energized and closed when not energized.



(c) Disassembly

- The structure of the solenoid valve is shown at below. (For disassembly, checking, and reassembly, refer to this diagram.)
- When brazing a pipe to the valve, cool the valve body with a wet cloth. (It is not required to disassemble the valve. Remove the coil ass'y from the body.)
- During reassembly, tighten the four bolts x4 with torque of 70–80 kg-cm.



No.	Parts name
①	Set bolt
②	Spring lock washer
③	Name plate
④	Coil ass'y
⑤	Retaining plate
⑥	Set bolt
⑦	Cover ass'y
⑧	Spring
⑨	Piston
⑩	Valve body
⑪	Packing
⑫	Sleeve
⑬	Inner ring
⑭	Piston ring

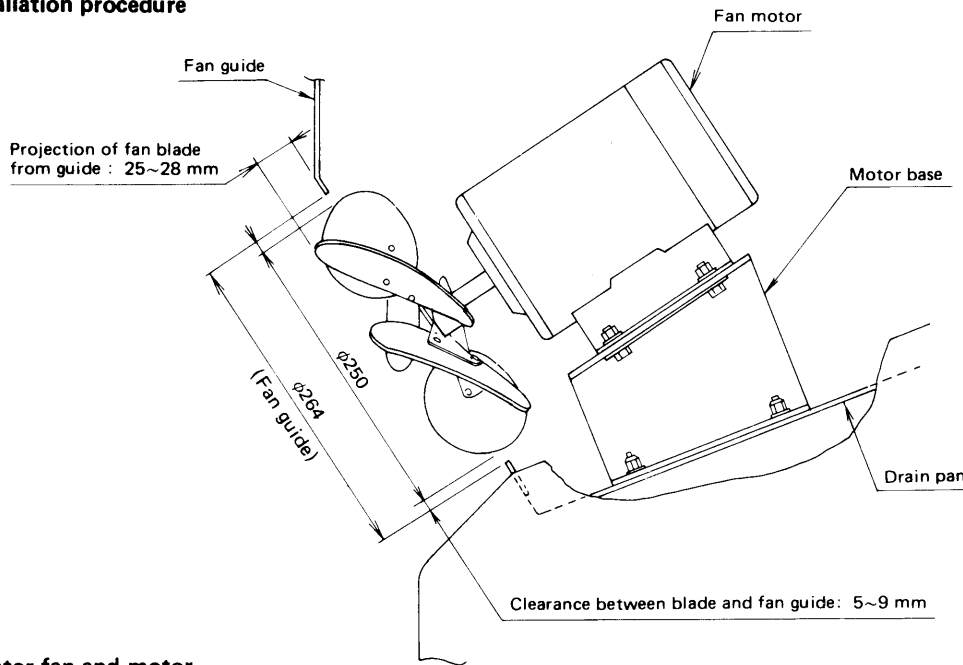
4.2. Components related with the air system

4.2.1 Fans and motors

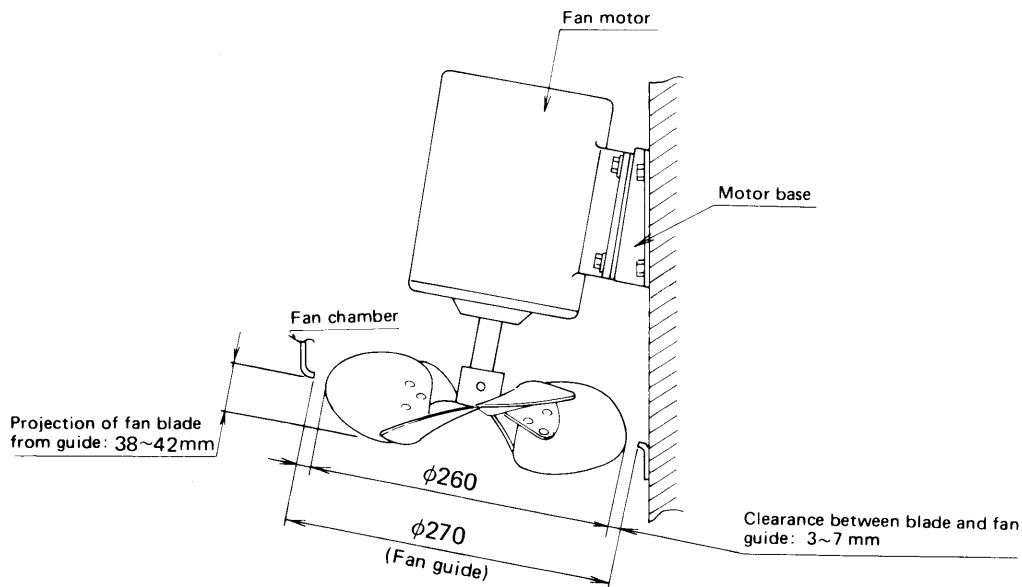
(a) Specifications

		Evaporator	Condenser
Fan	Type	propeller fan	propeller fan
	Number of blades	6 pcs.	6 pcs.
	Blade diameter	φ250	φ260
Motor	Type	Single-phase, squirrel-cage induction motor	
	Motor output (number of poles)	465W (2P)	60W (4P)
	Capacitor	Built-in	Separate
	Bearing	Ball bearing, 6203 contactless type, rubber shield	

(b) Installation procedure



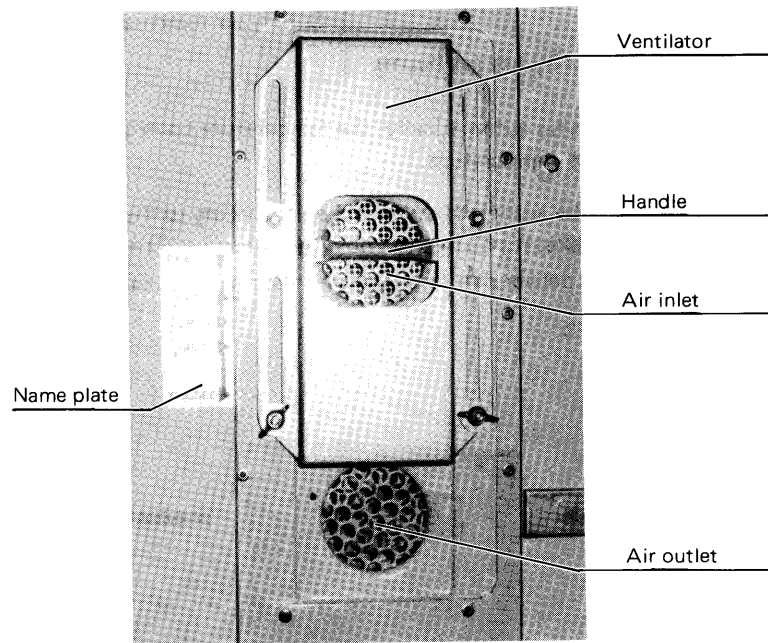
Evaporator fan and motor



Condenser fan and motor

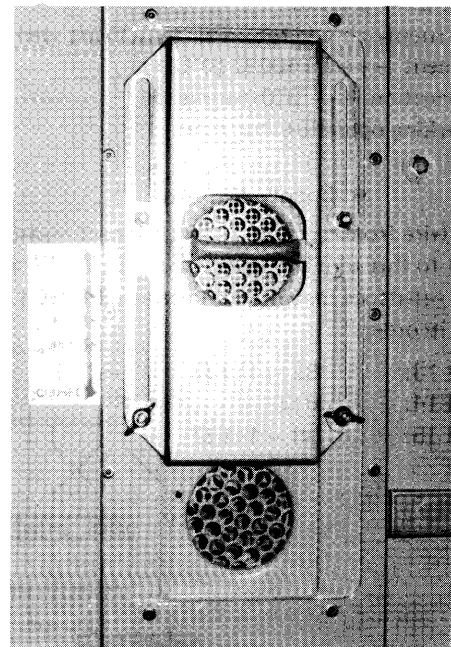
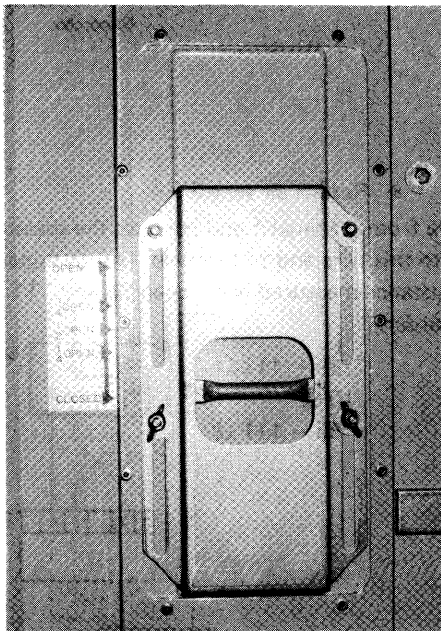
4.2.2 Ventilator

(a) View



(b) Operation

- If ventilation is not needed:
Set the handle to CLOSED.
- If ventilation is needed:
The ventilation opening may be varied over four steps:
1/4, 1/2, 3/4 and 1. Adjust the opening
according to ventilation volume.



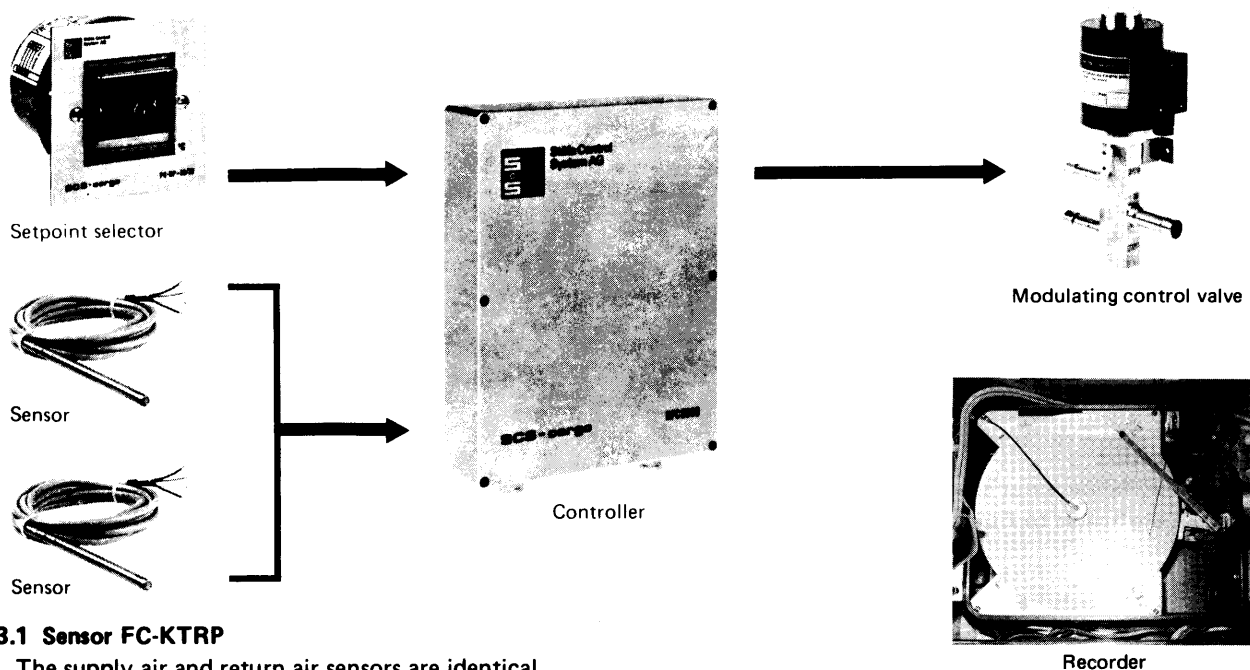
4.3 Temperature control system

This unit performs temperature control in three modes.

- I Frozen operation: compressor on-off control: Return air temperature is controlled (return air sensor).
 - II Chilled-operation: capacity control by hot gas bypass
 - III Heating operation: capacity control by hot gas bypass and electric heater control.
- } Supply air temperature is controlled (supply air sensor).

Selecting one of these operating modes automatically, the temperature control system controls the inside temperature according to the preset temperature.

- The supply and return sensors will be automatically switched according to the preset temperature.
- Adoption of a check instrument makes it possible to know the control state easily.
- Recorder continuously records the delivery air temperature inside the container, and the chart is driven by the spring-wound clock.



4.3.1 Sensor FC-KTRP

The supply air and return air sensors are identical.

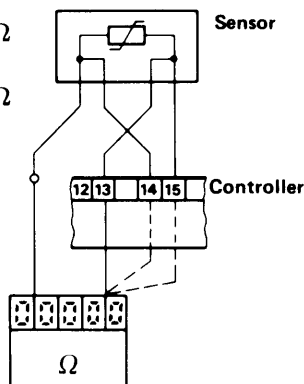
- Element — PT100 Ω (0°C)
- Connection — with four leads

(a) Checking operation

- Supply air sensor

Remove wire from terminal 12 and connect measuring instrument to this wire and to terminal 13 of terminal block A. If the resistance measured is between 88 and 111 Ω , the sensor is in order.

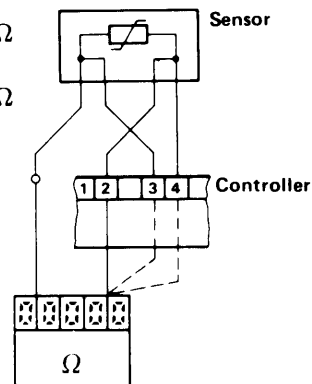
- Terminal 13: 88 – 111 Ω
- Terminal 14: 0 Ω
- Terminal 15: 88 – 111 Ω



- Return air sensor

Remove wire from terminal 1 and connect the measuring instrument to this wire and to terminal 2 on terminal block A. If the resistance measured is between 88 and 111 Ω the sensor is in order.

- Terminal 2: 88 – 111 Ω
- Terminal 3: 0 Ω
- Terminal 4: 88 – 111 Ω



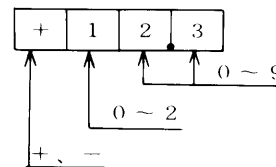
● Temperature vs. resistance table

Temperature °C	Resistance Ω	Temperature °C	Resistance Ω	Temperature °C	Resistance Ω	Temperature °C	Resistance Ω
-30	88.17	-9	96.46	5	101.95	18	107.02
-25	90.15	-8	96.86	6	102.34	19	107.40
-20	92.13	-7	97.25	7	102.73	20	107.79
-19	92.52	-6	97.65	8	103.12	21	108.18
-18	92.92	-5	98.04	9	103.51	22	108.57
-17	93.31	-4	98.43	10	103.90	23	108.96
-16	93.71	-3	98.82	11	104.29	24	109.35
-15	94.10	-2	99.22	12	104.68	25	109.73
-14	94.49	-1	99.61	13	105.07	26	110.12
-13	94.89	0	100.00	14	105.46	27	110.51
-12	95.28	1	100.39	15	105.85	28	110.90
-11	95.68	2	100.78	16	106.24	29	111.28
-10	96.07	3	101.17	17	106.63	30	111.67
		4	101.56				

4.3.2 Setpoint selector PC-RP30/30

Temperature setting is of digital indication. Press the buttons arranged both upper and lower of each indication for setting.

Temperature range -29.9 ~ +29.9°C



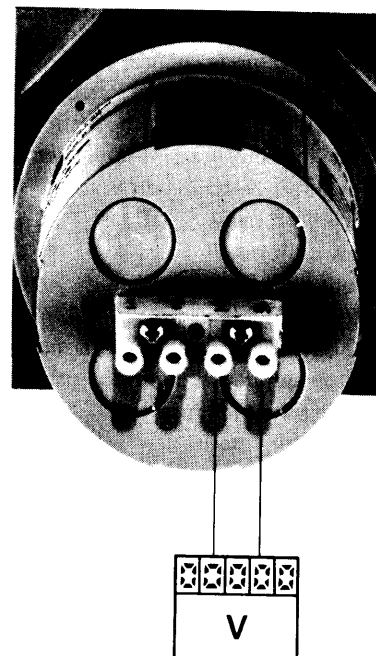
a. Operating check

1. Switch on controller (Unit ON-OFF switch)
2. Measure -15 V DC ± 0.5 V, terminal 3 (⌊) -1
3. Measure +15 V DC ± 0.5 V, terminal 3 (⌋) -2

If the measured values agree, the voltage supplied to the setpoint selector is correct.

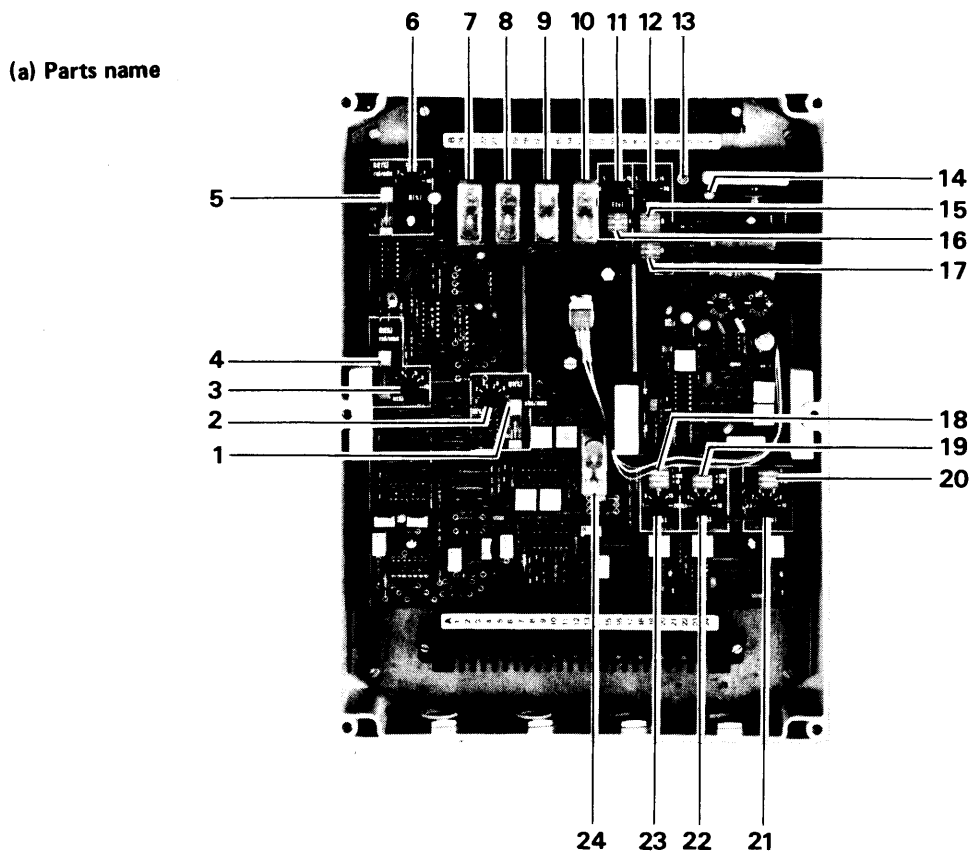
4. Setpoint adjustment

- 29.9 °C = 0.017 V
- 0 °C = 5.000 V Terminal 3 (⌊) -4
- +29.9 °C = 9.983 V
- Tolerance ± 0.017 V



4.3.3 Controller RFC-92GS

According to the preset temperature, one of two sensors (supply or return) is selected to control the modulating control valve, compressor, and electric heaters and gives alarm at high and low limits of the inside temperature. In addition, according to controlled temperature, output is delivered to the recorder.



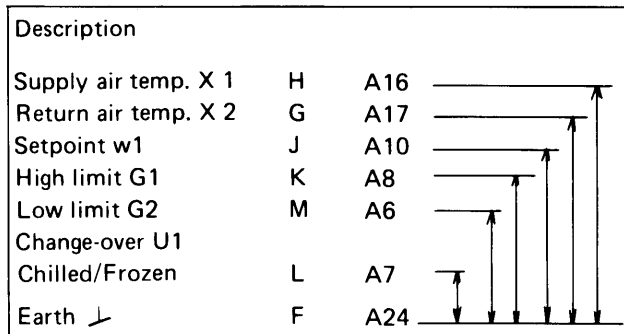
Item	Description		Factory setting
1	Operating mode change-over cut-in point potentiometer	U1	39.2 % (-6.5°C)
2	Operating mode change-over switching differential potentiometer	H	1 % (0.6 K)
3	High limit switching differential potentiometer	H	2.5 % (1.5 K)
4	High limit cut-in point potentiometer	G1	3.33 % (+2°C)
5	Low limit cut-in point potentiometer	G2	3.33 % (-2°C)
6	Low limit switching differential potentiometer	H	2.5 % (1.5 K)
7	High limit relay	G1	
8	Low limit relay	G2	
9	Mode change-over relay	U1	
10	Y2 output relay	Y2	
11	Y2 output cut-in point potentiometer	E	11 V
12	Y1 output cut-in point potentiometer (modulating)	E	15 V
13	Spare transistor fuse	BC 107	
14	Transistor fuse		
15	A/B direction of operation change-over switch	Y1	A
16	A/B direction of operation change-over switch	Y2	A
17	2/9 operation change-over switch*	Y1	9
18	Integral action tens selector dial	I x 10	I x 10
19	Proportional band tens selector dial	xp x 10	out
		x 100	out
20	Derivative action and tens selector dial	D x 10	D
21	Derivative action preset time potentiometer	T _v [s]	10
22	Proportional band potentiometer (% of measuring range)	xp [%]	8
23	Integral action reset time potentiometer	T _n [s]	6
24	Recorder output change-over relay		

*2 (on/off), 9 (modulating)

(b) Temperature-voltage conversion table

The temperature on the right and preset temperature can be converted to voltage with the terminal board of the controller or the receptacle of the checker.

- Examples: 1. Supply air temperature (X1) is 0°C when voltage is 5V across A24-A16 of the terminal board (F-H of the receptacle).
2. The change-over point (U1) between chilled and frozen modes are switched over is -6.5°C when voltage is 3.9166V across A24-A7 of the terminal board (F-L of the receptacle).

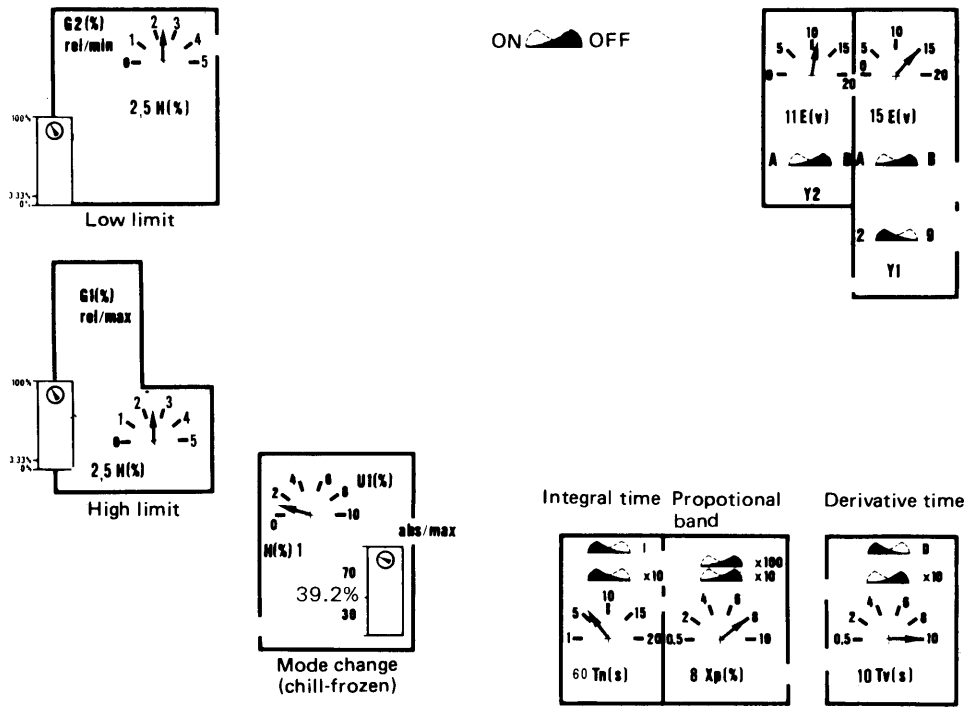
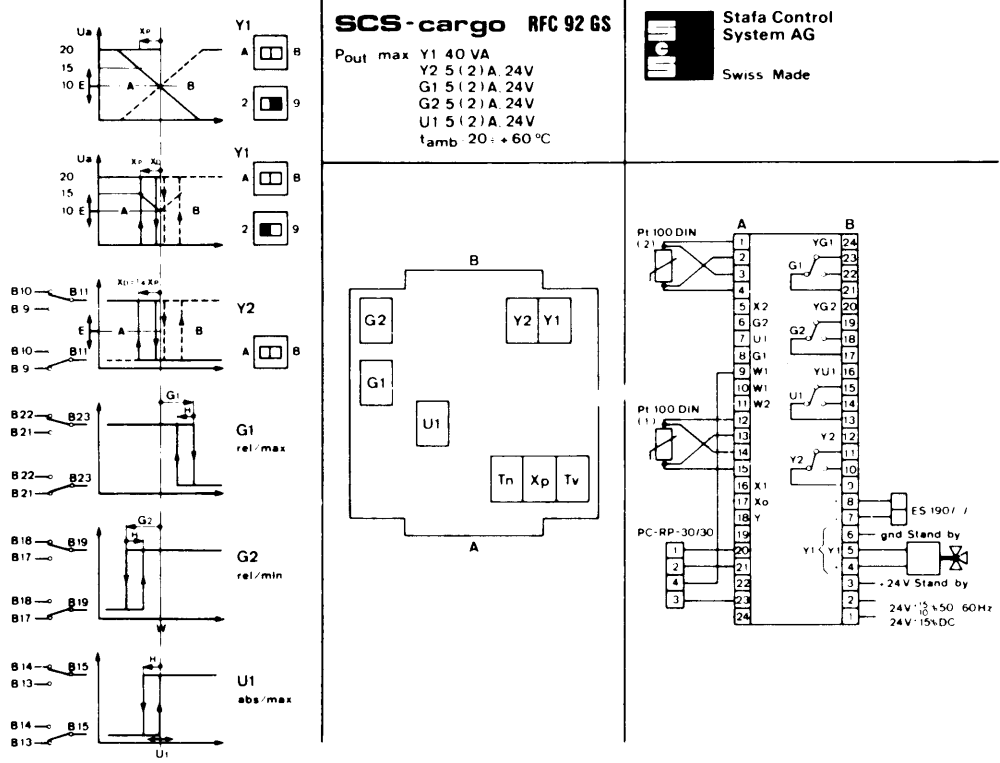


Temperature/voltage conversion table

°C	V	°C	V	°C	V
-30	0	-10.0	3.3333	10.0	6.6666
-29.5	0.0833	- 9.5	3.4166	10.5	6.750
-29	0.1666	- 9	3.5	11	6.8333
-28.5	0.250	- 8.5	3.5833	11.5	6.9166
-28	0.3333	- 8	3.6666	12	7.0
-27.5	0.4166	- 7.5	3.750	12.5	7.0833
-27	0.5	- 7	3.8333	13	7.1666
-26.5	0.5833	- 6.5	3.9166	13.5	7.25
-26	0.6666	- 6	4.0	14	7.3333
-25.5	0.750	- 5.5	4.0833	14.5	7.4166
-25	0.8333	- 5	4.1666	15	7.5
-24.5	0.9166	- 4.5	4.25	15.5	7.5833
-24	1.0	- 4	4.3333	16	7.6666
-23.5	1.0833	- 3.5	4.4166	16.5	7.75
-23	1.1666	- 3	4.5	17	7.8333
-22.5	1.25	- 2.5	4.5833	17.5	7.9166
-22	1.3333	- 2	4.6666	18	8.0
-21.5	1.4166	- 1.5	4.750	18.5	8.0833
-21	1.50	- 1	4.8333	19	8.1666
-20.5	1.5833	- 0.5	4.9166	19.5	8.25
-20	1.6666	± 0	5.0	20	8.3333
-19.5	1.750	0.5	5.0833	20.5	8.4166
-19	1.8333	1	5.1666	21	8.5
-18.5	1.9166	1.5	5.25	21.5	8.5833
-18	2.0	2	5.3333	22	8.6666
-17.5	2.0833	2.5	5.4166	22.5	8.750
-17	2.1666	3	5.5	23	8.8333
-16.5	2.25	3.5	5.5833	23.5	8.9166
-16	2.3333	4	5.6666	24	9.0
-15.5	2.4166	4.5	5.75	24.5	9.0833
-15	2.5	5	5.8333	25	9.1666
-14.5	2.5833	5.5	5.9166	25.5	9.25
-14	2.6666	6	6.0	26	9.3333
-13.5	2.750	6.5	6.0833	26.5	9.4166
-13	2.8333	7	6.1666	27	9.5
-12.5	2.9166	7.5	6.25	27.5	9.5833
-12	3.0	8	6.3333	28	9.6666
-11.5	3.0833	8.5	6.4166	28.5	9.75
-11	3.1666	9	6.5	29	9.8333
-10.5	3.25	9.5	6.5833	29.5	9.9166
				30	10.0

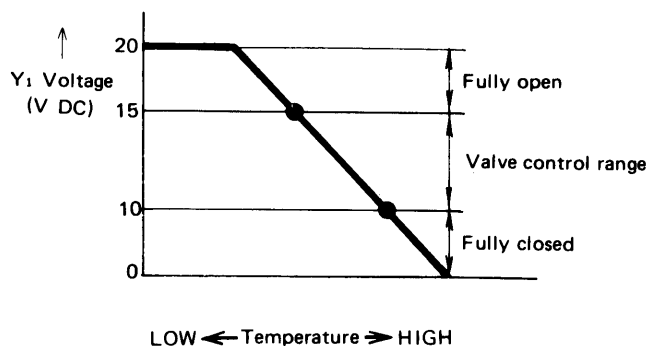
[Note]

for temperature sensor output X1, X2 setpoint switch output w1, settings G1, G2, U1. $U/°C = \frac{10[V]}{60[°C]} = 0.16667 V/°C$



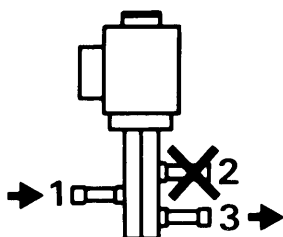
4.3.4 Modulating control valve M3F15L

Output (Voltage Y_1) of the controller drives this valve. As a two-way valve, this controls the flow of hot gas bypass continuously. The valve opening may be read from voltage Y_1 with a checker.



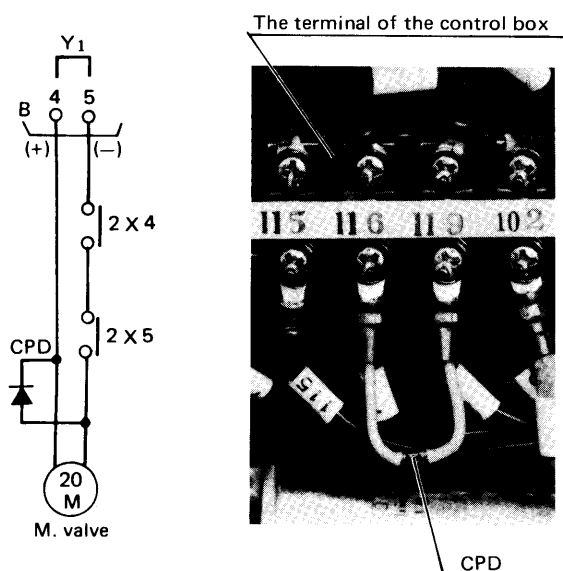
(a) Valve position

- De-energized period: 1–3 closed
- The coil resistance of the valve is approximately 20Ω at 21°C .



(b) CPD (contact protective diode)

A CPD is inserted in the valve circuit. This protects the relay contacts from surge current which flows when the circuit is opened and closed. The CPD is fitted to the terminal of the control box.



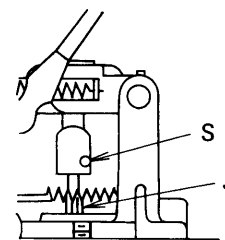
4.3.5 Recorder (TRLW—J925)

The mercury-filled sensing bulb of this recorder is placed under the evaporator fan, and it continuously records the delivery air temperature inside the container.

- Recording range $-25^\circ\text{C} \sim +25^\circ\text{C}$
- Chart drive Spring-wound clock and 31 days/rev.
- Chart Pressure sensitive, Partlow PSD-217C (REV. A) or equivalent.

(a) Adjusting

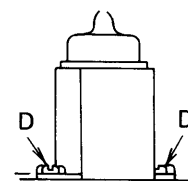
- 1) Be sure that temperature at the Partlow sensing bulb (and test thermometer bulb) is stabilized.
- 2) Loosen set screw S. Adjusting is accomplished by turning hex shaft J. Lengthening shaft J (counterclockwise) raises penindicated temperature; shortening shaft J (clockwise) lowers pen reading.
- 3) Turning shaft J, accordingly, and adjust pen reading to agree with reading of test thermometer. Retighten set screw S.



(b) Element replacement

To change a thermostatic element:

- 1) Withdraw screws D and drop element from instrument body.
- 2) Install new element and tighten screws D.

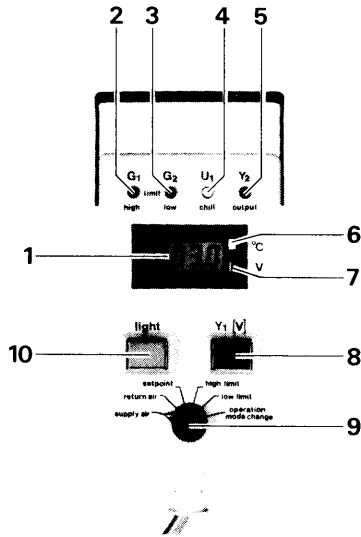


Note—After element replacement, temperature setting should be checked, and adjusting may be necessary.

4.3.6 Check instrument

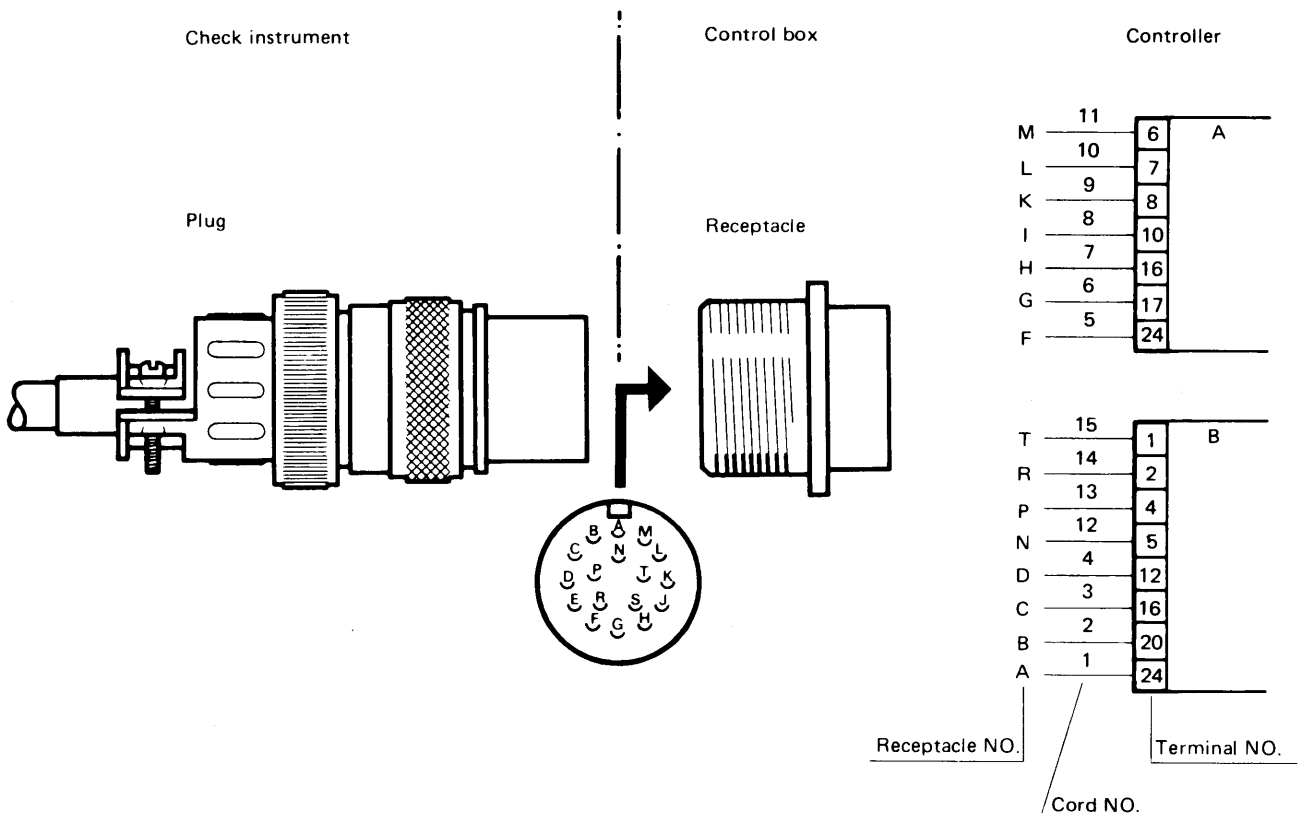
Connect the plug of the check instrument to the receptacle on the front panel of the control box, and check the following, operating the unit.

Note: When the check instrument is used do not subject it to direct sun light. Further, each inspection and adjustment should be done after 10 ~ 20 minutes energization.



- 1 Liquid crystal indication
- 2 Alarm temperature too high --- G₁
- 3 Alarm temperature too low --- G₂
- 4 Chilled operation ----- U₁
- 5 Electrical heating "on" with chilled operation } Y₂
compressor "stop" with frozen operation }
- 6 Lamp for temperature indication --- °C
- 7 Lamp for voltage indication } V (Y₁)
- 8 Modulating valve voltage button }
- 9 Selector for:
 - Setting upper limit
 - Setting lower limit
 - Setting operating mode change-over point
 - Supply air temperature
 - Return air temperature
 - Setpoint
- 10 Scale illumination button

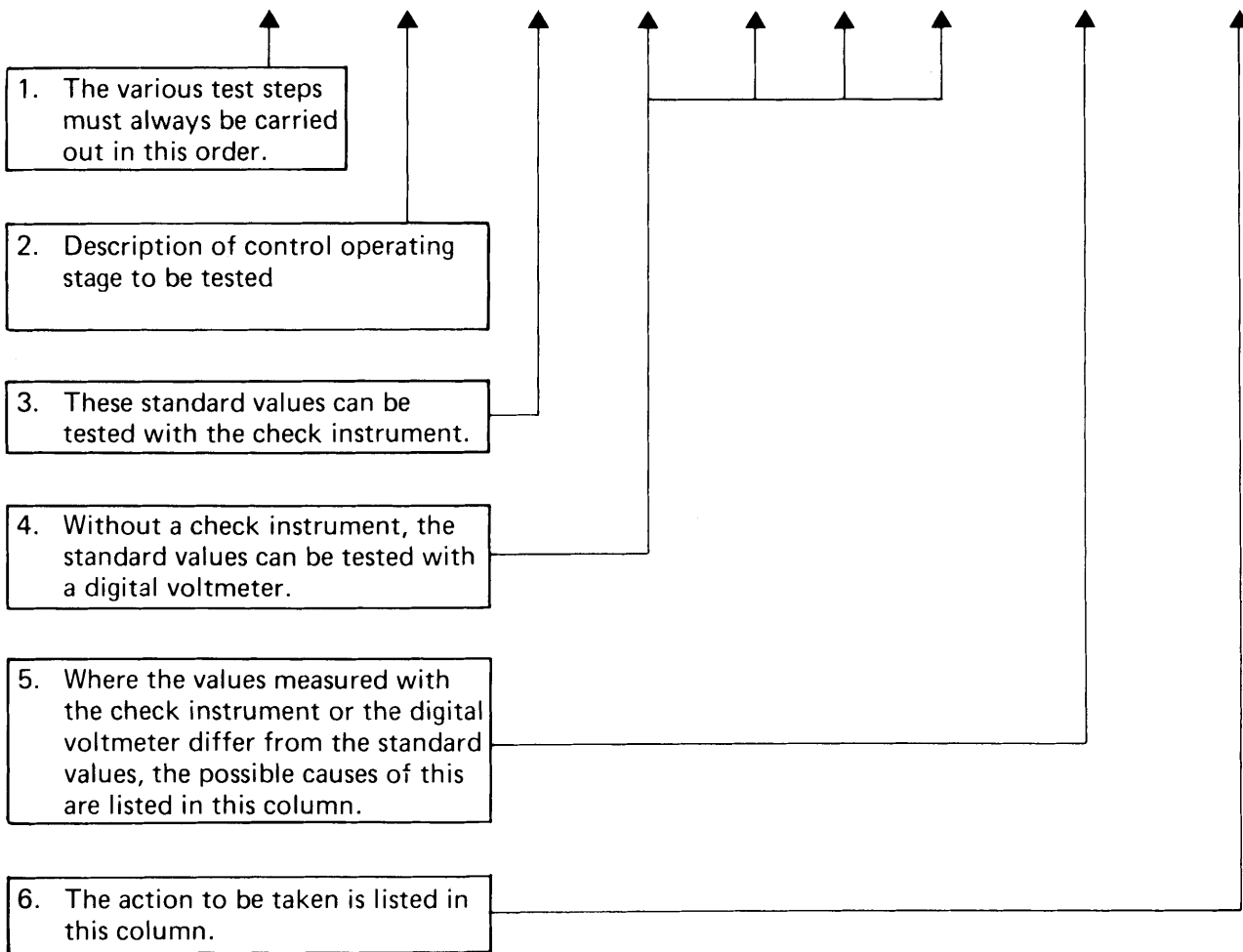
Note: 2 ~ 5 signify the state when the lamp lights up



4.3.7 Checking operation of the controlling devices

Note: Before checking, operate the compressor for 10 minutes.

Test procedure	Operating stage (Module)	Standard value		Measuring points			Possible causes of deviations from the standard value	Action
		Check instrument	Digital volt meter $R_{i \text{ min}} \geq 10 \text{ k}\Omega$	Control-ler terminal	Setpoint selector terminal	Test socket		



Test procedure	Operating stage	Standard value		Measuring points			Possible causes of deviations from the standard value	Action
		Check instrument	Digital voltmeter Ri min ≥ 10kΩ	Controller terminal	Setpoint selector terminal	Test socket		
1	A/C power supply	Yellow "light" button depressed, display illumination ON					Controller and test socket disconnected	Check wires and connections
			24V +15% -10% 50...60Hz	B1 B2			Mains switch off Control switch off Fuse defective	Check devices
2	DC power supply Power section	Indicator lamp Y ₂ , U ₁ , G ₁ or G ₂ illuminates					Controller and test socket disconnected	Check wires and connections
			22V +15% -10%	A24 B4			Rectifier defective	Replace controller board or rectifier
3	DC power supply Bridge	Selector on in "setpoint" position, indication same as selected setpoint Tolerance ± 0.3°C					Controller and test socket disconnected	Check wires and connections Measure with digital voltmeter as per test procedure 3a
3a			-15V ±0.05V +15V ±0.05V		3 (⊥) 1 3 (⊥) 2		Controller and setpoint selector disconnected	Check wires and connections Measure with digital voltmeter as per test procedure 3b
3b			-15V ±0.05V +15V ±0.05V	A24 A20 A24 A22			DC supply defective Possible cause: short circuit with earth potential	Replace controller board Measure resistance between terminal A24 and ⏚ Standard value: >600 kΩ
4	Setpoint selector	Selector in "setpoint" position					Controller and test socket disconnected	Check wires and
		Indication of same value as setpoint selector Tolerance ±0.3°C					Controller and setpoint selector disconnected	Measure with digital voltmeter as per test procedure 4a
4a			0.017V ... 9.983V DC see table "temperature/voltage conversion"		3 (⊥) 4		Setpoint selector	Replace setpoint selector
4b			0.017V ... 9.983V DC see table "temperature/voltage conversion"	A24 A10		F J	Controller and setpoint selector disconnected	Check wires and connections
5	Supply air sensor (sensor signal X ₁)	Selector in "supply air" position Indication of same value as the temp. measured in the supply air (-30...+30°C)					Disconnection	Measure with digital voltmeter as per test procedure 5a

Test procedure	Operating stage	Standard value		Measuring points			Possible causes of deviations from the standard value	Action
		Check instrument	Digital voltmeter Ri min ≥ 10kΩ	Control- ler terminal	Setpoint selector terminal	Test socket		
5a			0...10V DC see table "tempera- ture/voltage conversion"	A24 A16		F H	Controller and test socket disconnected	Check wires and connections
							Controller and sensor disconnected	Measure sensor resistance. See table page "tempera- ture VS. resistance" Replace defective sensor
								If the sensor is in order, replace controller board
6	Return air sensor (sensor sig- nal X ₂)	Selector in "return air" position. Indication of same value as the temp. measured in the return air (-30...+30° C)					Disconnection	Measure with digital voltmeter as per test procedure 6a
6a			0...10V DC see table "tempera- ture/voltage conversion"	A24 A5		F G	Controller and test socket disconnected	Check wires and connections
							Controller and sensor disconnected	Measure sensor resistance See table page "tempera- ture VS. resistance" Replace defective sensor
								If the sensor is in order, replace controller board
7	Controller output Y ₁ (to control valve)	Depress blue button "Y ₁ [v]"					Connection between controller and test socket reversed	Check wires and connections
	Set setpoint selector at -29° C Set setpoint selector at +29° C	Indication 0V Indication 15...20V DC					Controller and test disconnected	Check wire and connections Measure with digital voltmeter as per test procedure 7a
7a			0...20V DC	B4(+) B5		P (+) N	External short circuit between terminals B4 and B5 on controller Transistor fuse defective	Rectify short circuit (protective diode (CPD), see "MC valve") Replace transistor fuse see "controller-b"
8	Controller output Y ₂ (on/off)							Check wires and Measure with digital voltmeter as per test procedure 8a
	Set setpoint selector at +29° C Set setpoint selector at -29° C	Lamp Y ₂ illuminated Lamp Y ₂ off					Controller and test socket disconnected Connection between and test socket reversed	

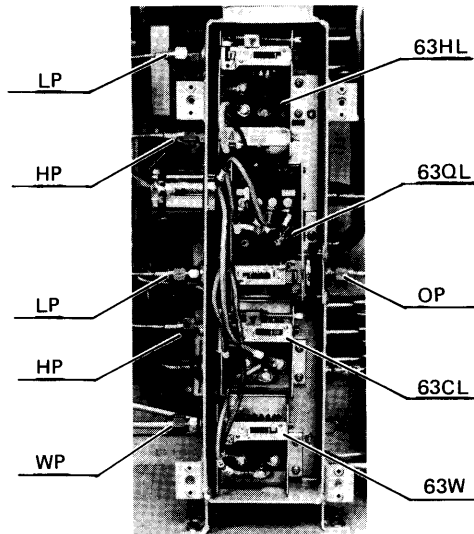
Test procedure	Operating stage	Standard value		Measuring points			Possible causes of deviations from the standard value	Action		
		Check instrument	Digital voltmeter Ri min ≥ 10kΩ	Control- ler terminal	Setpoint selector terminal	Test socket				
8a	Set setpoint selector at -29°C		0V			P D	Connection between controller and test socket reversed	Check relay Y ₂ -29°C = B11-B9 (contact closed) +29°C = B11-B10 (contact closed)		
				B4 B12			Controller defective			
	Set setpoint selector at +29°C		22V DC +15% -10%			P D	Controller and test socket disconnected	Check wires and connections		
				B4 B12			Controller defective	Replace controller board		
9	Alarm unit G ₁ "temperature" too high	Selector in high limit position					Out of calibration	Calibrate high limit according to test procedure 9b		
		Indication 2°C higher than setpoint Tolerance ±0.3°C					Controller and test socket disconnected	Check wires and connections		
	Set setpoint selector at -29°C	Lamp G ₁ illuminated after approx. 20 s					Controller and test socket disconnected	Check wires and connections		
	Set setpoint selector at +29°C	Lamp G ₁ off				Connection between controller and test socket reversed	Measure with digital voltmeter as per test procedure 9a			
9a	Set setpoint selector at -29°C		0V after approx 20s				Connection between controller and test socket reversed	Test relay G1 "controller-b" -29°C = B23-B21 (contact close) +29°C = B23-B22 (contact closed)		
									B4 B24	Controller defective
	Set setpoint selector +29°C		22V DC +15% -10%					P A	Controller and test socket disconnected	Replace controller board
9b	Limit value setting	Selector in "high limit" position	5.333V DC	A24 A8			Limit value shifted	Turn potentiometer G1 until the check instrument shows +2°C "controller-b"		
	Set setpoint selector at 0.0°C	Indication +2°C					F K	Turn potentiometer G1 until the digital voltmeter shows 5.333 V		
10	Alarm unit G ₂ "temperature" too low	Selector in "low limit" position					Out of calibration	Calibrate low limit according to test procedure 10b		
		Indication 2°C lower than setpoint Tolerance ±0.3°C					Controller and test socket disconnected	Measure with digital voltmeter as per test procedure 10a		
	Set setpoint selector at +29°C	Lamp G2 illuminated after approx. 20 s					Connection between controller and test socket reversed	Check wires and connections		
	Set setpoint selector at -29°C	Lamp G2 off								

Test procedure	Operating stage	Standard value		Measuring points			Possible causes of deviations from the standard value	Action	
		Check instrument	Digital voltmeter Ri min ≥ 10kΩ	Controller terminal	Setpoint selector terminal	Test socket			
10a	Set setpoint selector at -29°C		22V DC +15 % -10			P B	Controller and test socket disconnected	Check relay G2 "controller-b" -29.9°C = B19-B18 (contact closed) +29.9°C = B19-B17 (contact closed)	
				B4 B20					Controller defective
	Set setpoint selector at +29°C		0V after approx. 20s			P B	Connection between controller and test socket reversed	Replace controller board	
				B4 B20					Controller defective
10b	Limit value setting	Selector in "low limit" position	4.667V DC	A24 A6			Limit value shifted	Turn potentiometer G2 until the check instrument shows -2°C	
	Set setpoint selector at 0.0°C	Indication -2°C						F M	Turn potentiometer G2 until the digital voltmeter shows 4.667V
11	Operating mode change over U ₁	Selector switch in operation mode change position					Out of cablibration	Cabibrate according procedure 11b	
		Indication -6.5°C Tolerance ±0.3°C							
	Set setpoint selector at -29°C	Lamp U ₁ off							Connecting between controller and test socket reversed
	Set setpoint selector at +29°C	Lamp U ₁ illuminated				Controller and test socket disconnected	Check wires and connections		
11a	Set setpoint selector at +29°C		22V DC +15 % -10			P C	Controller and test socket disconnected	Check relay U1 +29°C = B15-B14 (contact closed) -29°C = B15-B13 (contact closed)	
				B4 B16					Controller defective
	Set setpoint selector at -29°C		0V			P C	Controller and test socket connections reversed	Replace controller board	
				B4 B16					Controller defective
11b	Mode change-over setting	Selector in "operation" mode change position	3.9166V DC	A24 A7			Shift in mode change value	Turn potentiometer U1 until the check instrument shows -6.5°C	
		Indication -6.5°C						F L	Turn potentiometer U1 until the digital voltmeter shows 3.9166V

4.4 Description on electrical and functional parts.

4.4.1 Dual pressure switch (63HL)

This stops the compressor when the pressure has risen or fallen excessively in the unit. The high pressure may rise above preset of HP if the condenser fan fails or cooling water does not circulate properly, etc. The low pressure may fall below preset of LP if "pump down" has been performed because the refrigeration circuit is blocked or the solenoid valves are closed. In these cases, the switch stops compressor.









Pressure switch box

LP : Low pressure
 HP : High pressure
 OP : Oil pressure
 WP : Water pressure

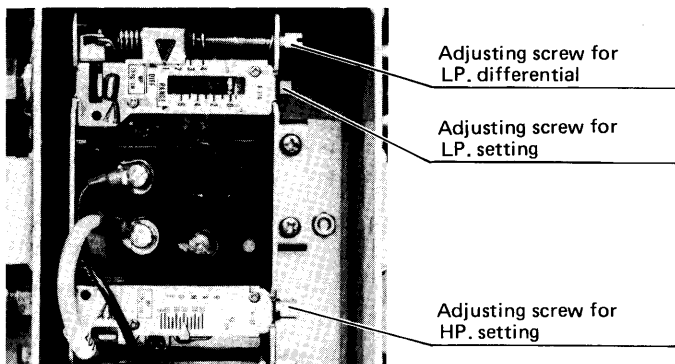
(a) Adjustment method

Adjust the switch by turning the adjusting screw as described below;

Adjusting points of dual pressure switch

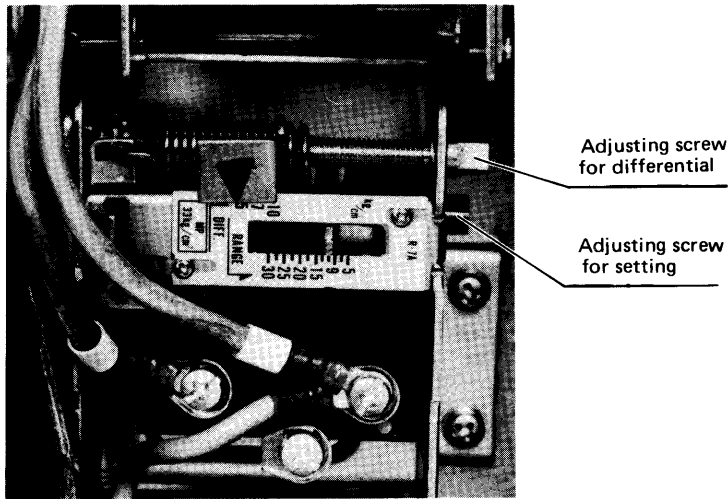
	Adjusting screw	Rotary direction		Function
High pressure side	Setting of adjusting screw	Clockwise		Setting (OFF value) becomes high, and pressure at the stopping of the refrigeration unit becomes high.
		Counter-clockwise		Setting (OFF value) becomes low, and pressure at the stopping of the refrigeration unit becomes low.
Low pressure side	Setting of adjusting screw	Clockwise		Setting (ON value) becomes low, and pressure at the starting of the refrigeration unit becomes low.
		Counter-clockwise		Setting (ON value) becomes high, and pressure at the starting of the refrigeration unit becomes high.
	Setting of adjusting screw for differential	Clockwise		Pressure difference between ON and OFF becomes large and difference between pressure on the starting and on the stopping becomes large.
		Counter-clockwise		Pressure difference between ON and OFF becomes closer and difference between pressure on the starting and on the stopping becomes closer.

- Notes:**
- 1) If it is necessary to adjust the adjusting screw for differential, be sure to adjust pressure setting first and then adjust differential.
 - 2) After adjusting the adjusting screw, apply chemical to the bolt head to prevent the bolt from being loosened vibration.



4.4.2 High pressure control pressure switch (63CL)

If the ambient temperature is low during air cooled operation, two out of three condenser fans are turned off so that the high pressure should not fall. (As for more details, refer to "high pressure control")



(a) Adjusting method

Adjust the adjusting screw as staged below.

Adjusting points for high pressure control switch

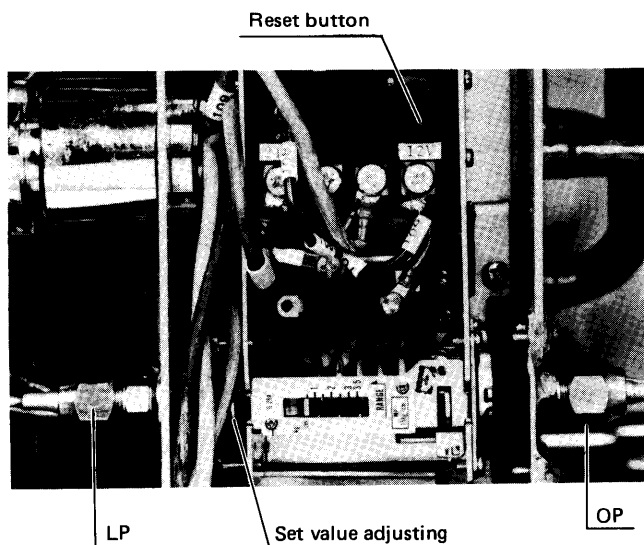
Adjusting screw	Turning direction		Function
Adjusting screw for setting	Clockwise		Setting value (ON value) becomes low and fan speed increases
	Counter-clockwise		Setting value (ON value) becomes high and fan speed decreases
Adjusting screw for differential	Clockwise		Pressure difference between ON and OFF becomes large and stopping period of certain fans is prolonged.
	Counter-clockwise		Pressure difference between ON and OFF becomes small, and stopping period of certain fans is shortened.

- Notes:**
- 1) In case it is necessary to adjust the adjusting screw for differential, be sure to adjust setting first and then differential.
 - 2) After adjustment of the adjusting screws, be sure to apply the following chemical to the bolt heads to prevent them from loosening by vibration.

4.4.3 Oil pressure protection switch (63QL)

Oil pressure (difference between oil pressure and low pressure) falls due to oil pump failure, clogging and oil foaming.

This stops the compressor automatically when oil pressure continuously remains low, because the compressor may be burnt because of oil shortage.

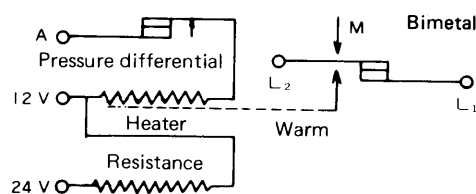


(a) Operation

The oil pressure (pressure difference) normally rises when the compressor has started. If the pressure does not rise, power will be supplied to the heater of a timer and a bimetal operate after a preset interval, thereby stopping the compressor will stop.

Note: Timing device is affected by ambient temperature and its set period differs with ambient temperature. (Standard temperature 25°C)

Ambient temperature	Set period
Higher	Shorter
Lower	Longer



Electric wiring in oil pressure protection switch

(b) Resetting

If 63QL has operated, depress the reset button several minutes after when the compressor stops. (The button will not be reset unless the bimetal is cold.)

(c) Adjustment method

Adjust the oil pressure protection switch by turning the adjusting gear as described below.

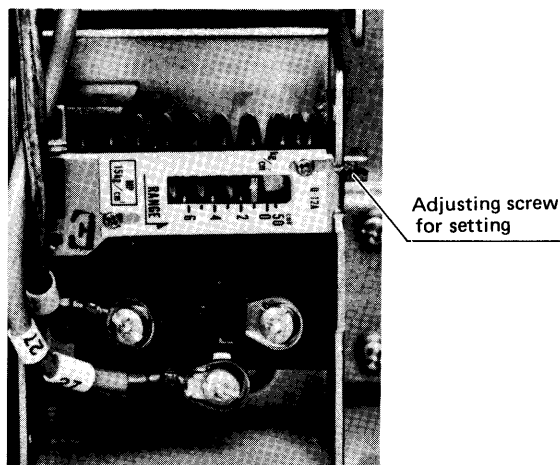
Adjusting points for oil pressure protection switch

Adjusting gear	Turning direction		Function
Adjusting gear for settings	Clockwise		Functional pressure (differential) becomes low and heater circuit is disconnected with low pressure difference.
	Counter-clockwise		Functional pressure (differential) becomes high and heater circuit is disconnected with high pressure difference.

Note: The following turning directions are viewed from the low pressure connection side.

4.4.4 Water pressure switch (63W)



This switches over air and water cooled modes. If cooling water flows and water pressure rises above a preset water pressure at the inlet, the contact is turned off to stop the condenser fan motors and water cooled operation will start.



(a) Adjusting method

Turn the adjusting screw as stated below.

Adjusting points of water pressure switch

Adjusting screw	Turning direction		Function
Adjusting screw for setting	Clockwise		Setting (OFF value) becomes low, and fans stops quicker
	Counter-clockwise		Setting (OFF value) becomes high, and fan is delayed in stopping.

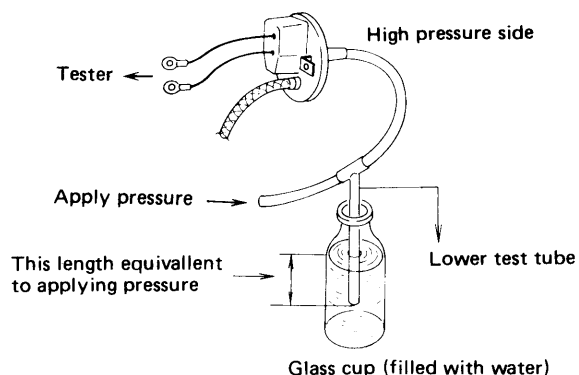
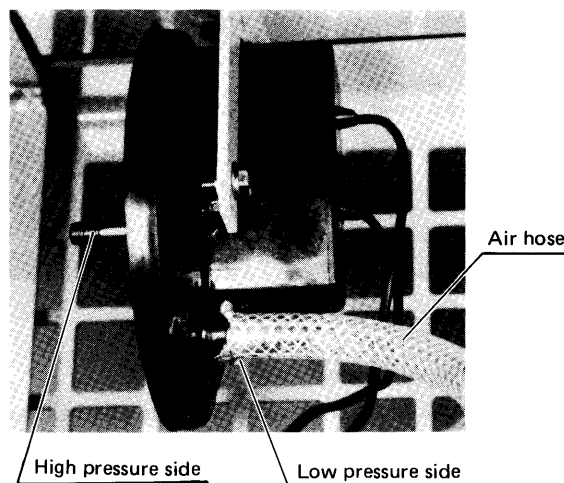
Note: After the adjustment, be sure to apply the chemical to the bolt head to prevent it from being loosened due to operation vibration.

4.4.5 Air pressure switch (63DA)

If the evaporator is frosted, difference of the air pressures at the inlet and outlet of the evaporator becomes large. If the pressure difference rises above a preset value, the air pressure switch operates and defrosting will start.

(a) Checking operating value

- Set the checker device as shown on the right.
- Applying pressure to the high pressure side, lower the test tube slowly. (At this time, small bubbles must come out at the bottom of the tube.)
- Read the length of H (length of the tube which is below the water surface) when the tester indicates continuity. The operating point of the air pressure switch is the value of H plus 5 mmH₂O. Check this value a few times.
- To apply pressure, you may blow air into the tube. Alternative methods use a pump, APS tester, or manometer.



4.4.6 Defrost termination thermostat (23D)

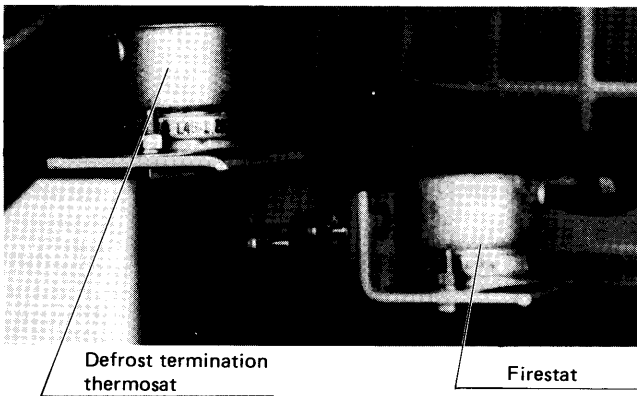
This senses ambient temperature around the thermostat and will terminate defrosting.

OFF: 7.2°C
ON : 1.7°C

4.4.7 Firestat (26AH)

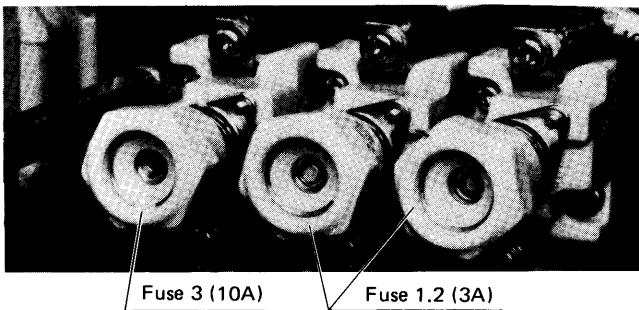
This prevents the electric heaters from overheating. If the heaters is overheated, the ambient temperature around the thermostat rises and the thermostat cuts off the heaters.

OFF: 71°C
ON : 49°C



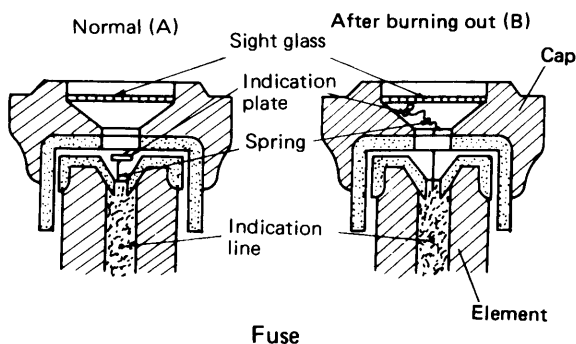
4.4.8 Fuses (FU1/2/3)

Three fuses which protect the control circuit and devices are mounted in the control box.



(a) Element replacement

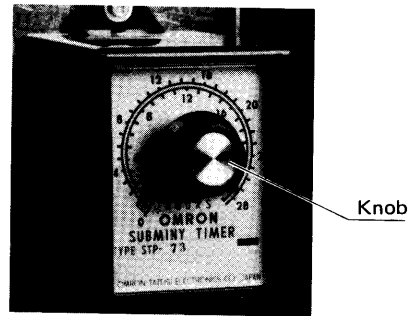
It is possible to see, through the access whether the fuses are burnt out. To replace the element, remove the cap at the top.



4.4.9 Defrost timer (2D)

The defrost timer activates defrosting operation automatically at preset intervals. The timer setting is controlled by a knob on its front face. Do not adjust it while operating. Do not set to "0" (hr) it will cause erratic operation.

- Adjustable range : 1~24 hours (60 Hz), 1~28½ hours (50 Hz).
- Once power has been turned off, the timer is reset to the initial state.

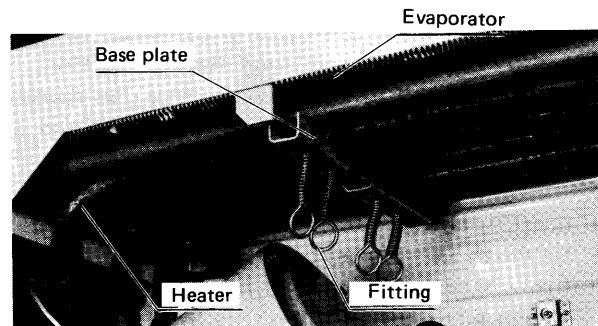


4.4.10 Electric heaters

Two kinds of electric heaters are used.

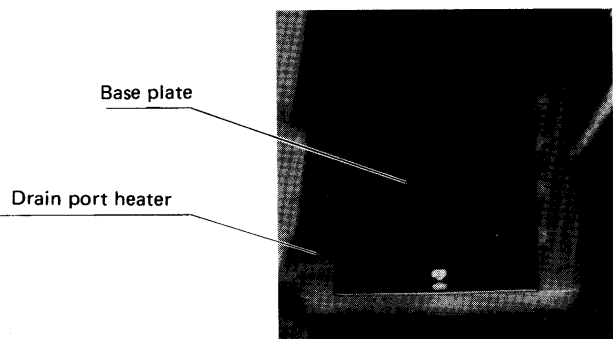
(a) Sheathed heaters (220V AC, 0.65 kW x 6)

These are fitted at the bottom of the evaporator. H₁ through H₆ are used for defrosting. H₁ and H₂ are used as auxiliary heaters during heating operation. To replace them, lift the fittings up and remove them together with the base plate.



(b) Molded heaters (220V AC, 12W x 2)

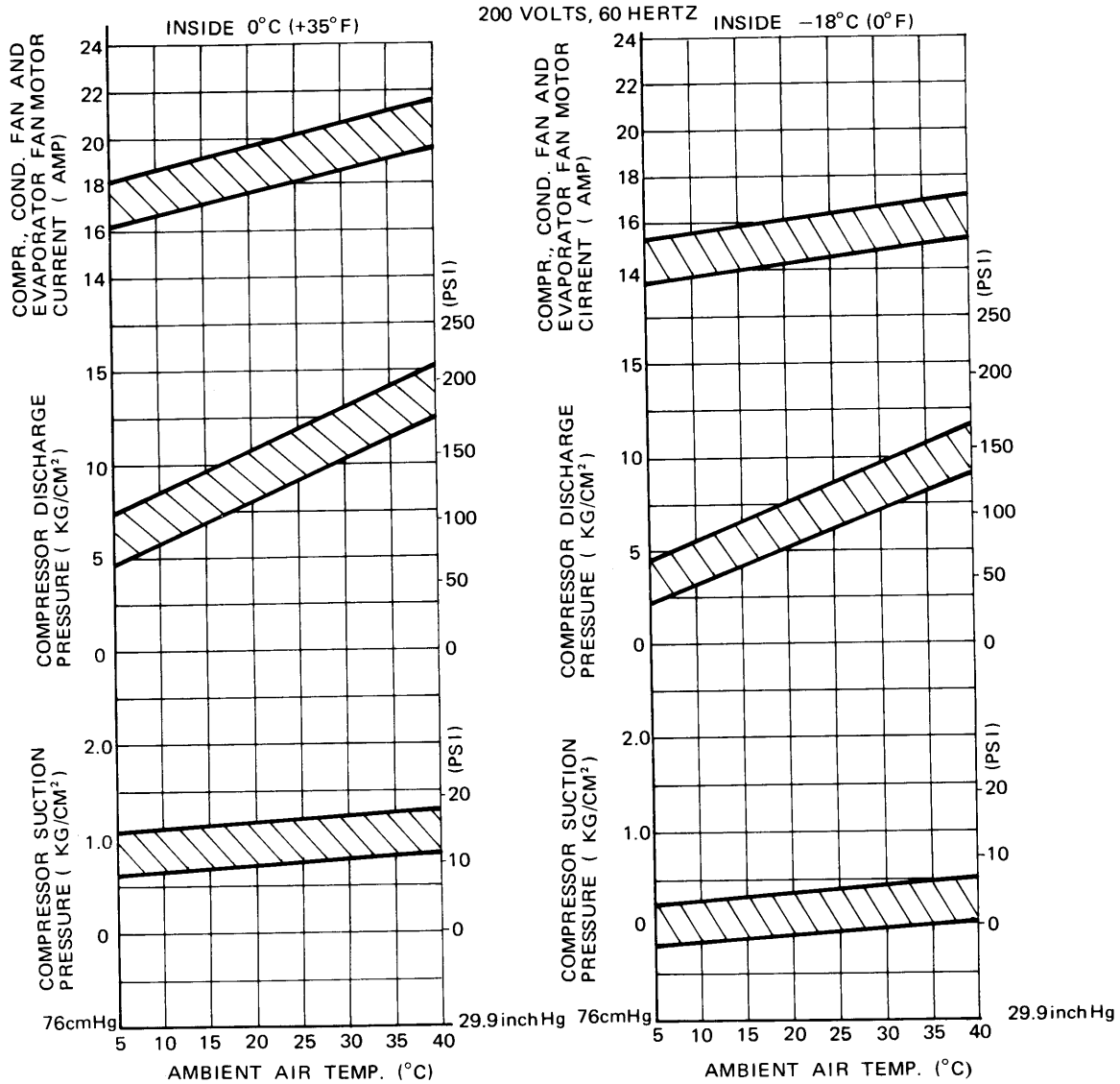
These are fitted at the left and right of the drain pan to prevent the drain port from freezing (H₇ and H₈).



5. Set values of functional parts

Part name	Function	Set value
Oil pressure protection switch ONS-C106Q	Heater circuit OFF ON Timer	1.0kg/cm ² 0.5kg/cm ² 110 seconds (ambient temperature 25°C) More than 5 seconds (ambient temperature 70°C)
Dual pressure switch DNS-D306Q	Low pressure OFF ON High pressure OFF ON	40cmHgV 0.2kg/cm ² 20kg/cm ² 16.5kg/cm ²
High pressure control switch SNS-C130Q _{1 1}	OFF ON	7kg/cm ² 12.5kg/cm ²
Water pressure switch SNS-C106Q6	OFF ON	1.0kg/cm ² 0.4kg/cm ²
Firestat KLIXON 20420L/L160-4	OFF ON	71°C (160°F) 49°C (120°F)
Defrost termination thermostat KLIXON 20420L/L45-1	OFF ON	7.2°C (45°F) 1.67°C (35°F)
Air pressure switch for defrost SDS-K102	ON	20mmH ₂ O
Defrost timer STP-73	ON	24h (60Hz) 28½h (50Hz)
Overcurrent relay CR-20-NP ₂ S ₄	OFF	10.0A
Circuit breaker MK-53	OFF	32A
Fuse AFac-3 (main circuit) AFac-10 (control circuit)	OFF OFF	3A 10A
Thermal protector KLIXON 9700L-01-11 (cond. fan motor) 9700K-01-11 (evap. fan motor) KLIXON 7895 (compressor)	OFF OFF	120°C (248°F) 105°C (221°F)

6. Operating pressure and running current



< For reference >

	Item	Unit	Value
1	Heater current – during defrosting Measure at primary side of 88H ₂	A	10.5 (AC 220V)
2	Running current of condenser fan motor	A	0.7 (AC 220V)
3	Running current of evaporator fan motor	A	3.0 (AC 220V)
4	Bolt tightening torque	Compressor	240 ± 20/17.3 ± 1.4
		Compressor stop valve flange	140 ± 15/10.1 ± 1.1
		Fan motor	70 ± 7/5.0 ± 0.5
		Solenoid valve	75 ± 5/5.4 ± 0.4
		Expansion valve	140 ± 10/10.1 ± 0.7

7. Troubles and countermeasures

If the unit does not work properly, inspect it in accordance with "Troubles and countermeasures" to find cause of trouble and repair it.

Troubles and countermeasures

State	Phenomena	Functioning places	Cause	Countermeasures	
I. Operation inoperative	A: Condenser evaporator fans and compressor are inoperative.	a. No trouble with unit	Current interruption	Trace cause	
		b. Circuit breaker functions	Power source is disconnected.	Connect power source plug to power source.	
			It functions due to over current.	Trace causes and replace.	
	c. Fuse is burnt out.	—do—	—do—		
	B: Evaporator fans operate but condenser fans and compressor are inoperative.	a. No trouble with unit	The unit halts by function of the temperature recording controller or in heating operation.	Setpoint selector is high	Readjust temp. setting as designed.
				b. Oil pressure control	It is not reset yet.
		c. Solenoid valve does not function.	Coil is cut out.	Replace it.	
		d. Controller malfunctions.	Sensor is damaged or other reasons.	Replace it.	
	II. Operation stops soon	A: Condenser fans and compressor stop, keeping evaporator fans in operation.	a. Oil pressure protection switch is functioning.	Oil pressure will not rise. Oil is short or oil pump is out of order.	Additional oil charge, or repair oil pump.
			b. No trouble with unit	Controller functions and stops unit.	
B: Condenser fans and compressor operate on and off repeatedly with evaporator fans in operation.		a. Pressure switch functions. High pressure side	Excessive charge of refrigerant.	Discharge refrigerant.	
			Air in system	Air purge	
			Insufficient air flow for air cooled operation.		
			Condenser or passage clogged.	Clean or remove obstacles	
			Fan blade damaged.	Repair or replace.	
			Fan motor does not rotate.		
			Capacitor inoperative.	Replace it.	
		Lower pressure side	Fan motor thermostat has functioned.	Trace causes.	
			Insufficient water volume for cooling operation.		
			Condenser is clogged with scale.		
			Insufficient refrigerant charge.	Additional charge, seek leaking positions and repair.	
			Dryer clogging	Replace	
			Moisture chokes	Exchange dryer.	
b. Over-current relay or compressor protection thermostat has functioned.	Gas leakage from feeler tube of expansions valve.	Exchange it.			
	Excessive large current due to over-load operation.	Trace causes.			

State	Phenomena	Functioning places	Cause	Countermeasures
III. Storage temp. is lower than temperature setting	A: Compressor inoperative.	a. Solenoid valve will not close.	Clogged with dust.	Replace it.
		b. Controller does not function.	Sensor is disconnected	Replace it.
		c. Sensor is installed wrongly.		Reattach it.
IV. Storage temperature does not drop	B: Hotgas bypass does not work	Modulating control valve does not open	Clogged with dust Controller is defective	Repair or replace Replace transistor or controller
		A: Storage temperature does not reach to preset temperature (Fans and compressor work)	a. Modulating control valve does not close. b. Capillary tube is defective	Clogged with dust Repair or replace
V. Storage temperature is not stable	A: Storage Temperature is not stable during chilling and heating operations (Fans and compressor work properly)	a. Opening of modulating control valve (valve control voltage Y ₁) is not stable	Controller is improperly adjusted	Adjust or replace
VI. Heating	A: Heater is inoperative.	a. No trouble with unit	Setting of set point selector is under -6.5°C.	
		b. Firestat	Insufficient evaporator air volume	
VII. Defrosting operation	A: Defrosting does not start.	a. Air switch does not function.	Band connection, damage or clogging of connecting hose.	Repair or replace.
	B: Defrosting and refrigerating operation are repeated in a short period of time.	a. Air switch makes an error.	Improper adjustment	Replace.

8. PTI (Pre Trip Inspection)

To keep the unit in good operating condition, check adjust or repair the unit when necessary. The following is the checking items of PTI (an example of container refrigeration unit checklist).

Container refrigeration unit inspection card

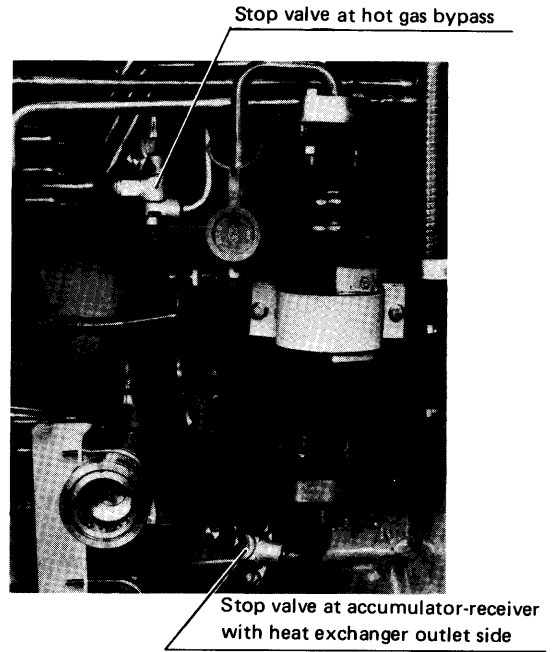
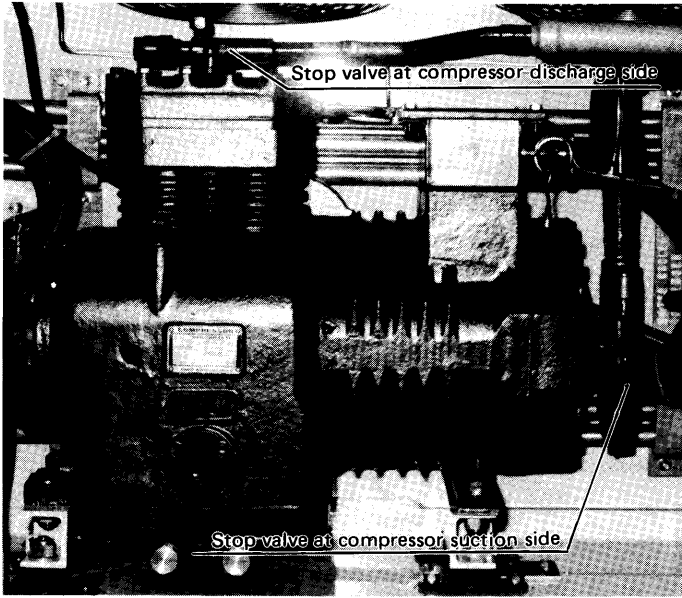
Installed ship name		Date of Inspection			
Container No.		Place of Inspection			
Loaded cargo		Loaded or none			
Customer's staff		Unit Model No.			
Service staff		Unit No.			
		Compressor No.			
Check No.	Check point	Check method	Reference value		
Check before operation	1	External appearance of important parts of container (doors, equipment mount, damaged points)	Visual		
	2	Cleaning interior and exterior of container	Visual		
	3	Checking the smudge of the unit (air-cooled condenser, evaporator)	Visual		
	4	Checking "through" points inside and outside unit	Visual		
	5	The refrigeration circuit for leakage of gas and oil (mainly at joints)	Halide torch, Visual	Flame reaction should be bluish purple	
	6	Checking external appearance of power cable and plug	Visual		
	7	Cleaning drain hose	Visual	Shall be free from clogging	
	8	Cleaning defrost air hose and checking to ensure that there is no trap	Visual	Shall be free from clogging	
	9	Mounted condition of electric heaters	Visual	Make sure that leads are not in contact with heaters	
	10	Checking exterior of firestat	Visual	Shall have no damaged part	
	11	Tightened condition of cable glands and monitoring receptacle	Retighten with tool	Make sure that they are firmly tightened	
	12	Bolts for compressor, fans, and motors, etc. for fastening state	Retighten with tool	Make sure that they are firmly tightened	
	13	Clearance between fan and fan guide	Visual	Evaporator fan : 5~9 mm Condenser fan : 3~7 mm	
	14	Sealing at control box, and PS box, etc.	Visual	Packing and sealing should be intact	
	15	Wire terminals for loosening correction	Visual, driver		
	16	Contact and/or coil of magnetic contactor for burning	Visual		
17	Unit insulation resistance	Compressor circuit <input type="checkbox"/> MΩ Electric heater circuit <input type="checkbox"/> MΩ Evaporator fan circuit <input type="checkbox"/> MΩ	DC 500V megger	2MΩ or more	
18	Checking operation of oil pressure protection switch	CUT OUT <input type="checkbox"/> kg/cm ² CUT IN <input type="checkbox"/> kg/cm ²	Tension gauge Timer	1.0 kg/cm ² 110 seconds 0.5 kg/cm ² (25°C)	
19	Checking operation of air pressure switch		Checker	20 mm H ₂ O	
20	Supply voltage		Check line voltage at primary side of circuit breaker	Within ±10% of related voltage	
Check during operation	21	Checking condenser and evaporator fan motors for vibration and noise	Touch and listen		
	22	Checking amount of circulating refrigerant	Check liquid indicator	Make sure that it is sealed	
	23	Checking for water in refrigerant	Check liquid indicator	Deep blue	
	24	Checking compressor oil level (operating condition)	Check compressor oil level gauge	⊖ (oil level 1/4 - 3/4)	
	25	Confirm function of the recorder	Visual		
	26	Checking operation of controller and pilot lamps	Check instrument		
	27	Checking manual defrosting operation	Manual defrost switch		
	28	Electric heater operation and current R <input type="checkbox"/> S <input type="checkbox"/> T <input type="checkbox"/>		Clamp meter	
	29	Checking operation of defrost termination thermostat (Completing temperature) <input type="checkbox"/> °C		Mount thermistor to termination thermostat mounting position	OFF 7.2±1.7°C
	30	Unit operating current R <input type="checkbox"/> S <input type="checkbox"/> T <input type="checkbox"/>		Clamp meter	-18°C <input type="checkbox"/> V <input type="checkbox"/> Hz

Check	No.	Check point	Check method	Reference value		
Check during operation	31	Checking operation of dual pressure switch	H-CUT OUT <input type="text"/> kg/cm ²	Blind air inlet	20 kg/cm ²	
			L-CUT OUT <input type="text"/> mm HgV	Accomplish pump down by use of the stop valve at the accumulator receiver outlet	400 mmHgV	
			L-CUT IN <input type="text"/> kg/cm ²		0.2 kg/cm ²	
	32	Checking operation of water pressure switch	Checking switchover from water-cooled to air-cooled operation	Disconnect water coupling	Condenser fan motor shall operate	
			Checking switchover from air-cooled to water-cooled operation	Connect water coupling and supply water	Condenser fan motor shall stop	
	33	Checking power supply changeover switch	Checking 400V class operation	Place changeover switch lever upward		
			Checking 200V class operation	Place changeover switch lever downward		
	34	Storage temperature °C	<input type="text"/>	0°C	-18°C	Automatic operation at -18°C
		Ambient temperature °C	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/> in one cycle
		LP kg/cm ²	<input type="text"/>	<input type="text"/>	<input type="text"/>	COMP OFF <input type="text"/> M
HP kg/cm ²		<input type="text"/>	<input type="text"/>	<input type="text"/>	COMP ON <input type="text"/> M	
Operating time		Immediately after operation	Operation starting 0°C <input type="text"/> Hr <input type="text"/> M	Operation starting -18°C <input type="text"/> Hr <input type="text"/> M	Automatic operation at -18°C <input type="text"/> Hr <input type="text"/> M	
Operation starting time <input type="text"/> <input type="text"/>						
	35	Checking automatic defrosting	Defrost time <input type="text"/> M			
Check after operation	36	Place new chart				
	37	Close caps for control box and PS box, etc.				
	38	Write down details of service on history cards				

9. How to maintenance

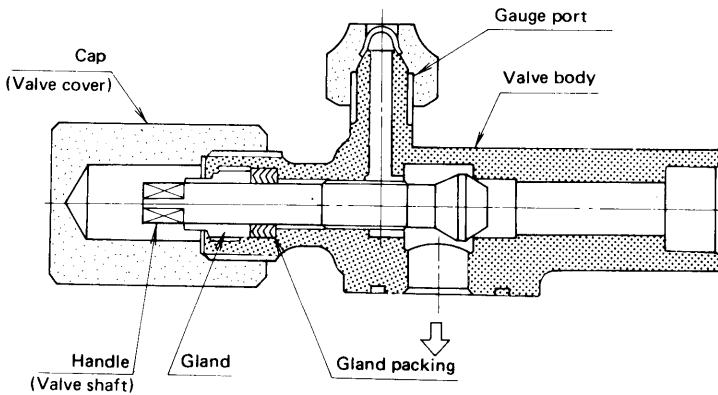
9.1 Handling method of the stop valve

(1) Place of the stop valve and its kind

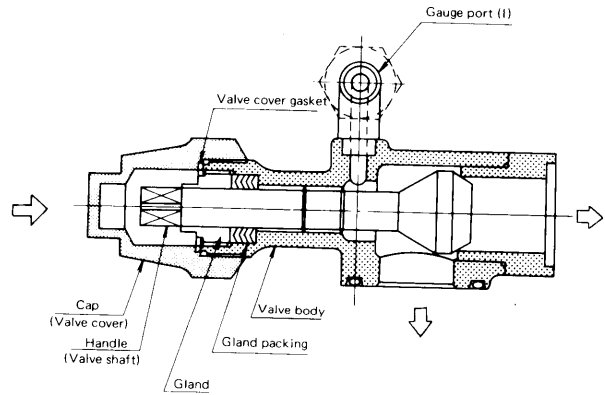


(2) Structure of stop valve

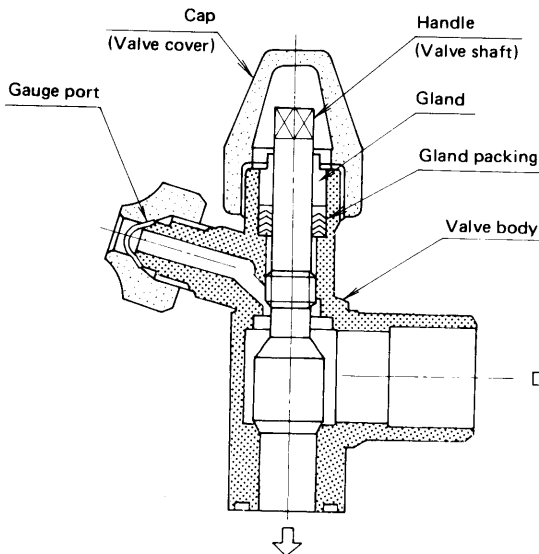
1 Stop valve at compressor discharge side (VSH10VAP-5S)



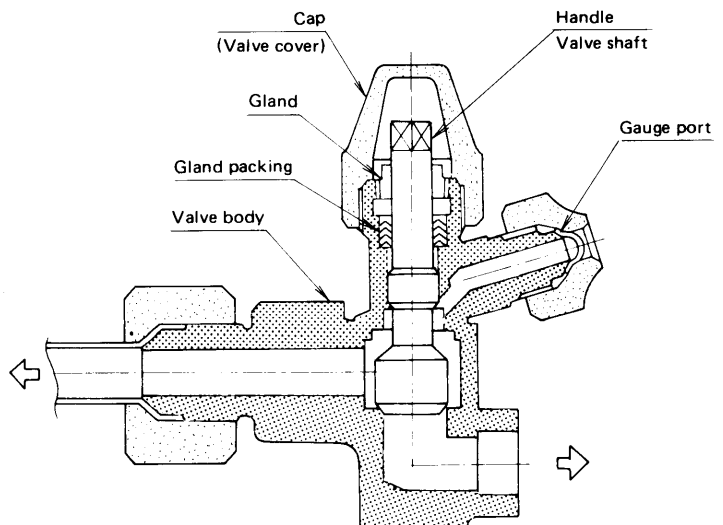
2 Stop valve at compressor suction side (VSH22XBP)



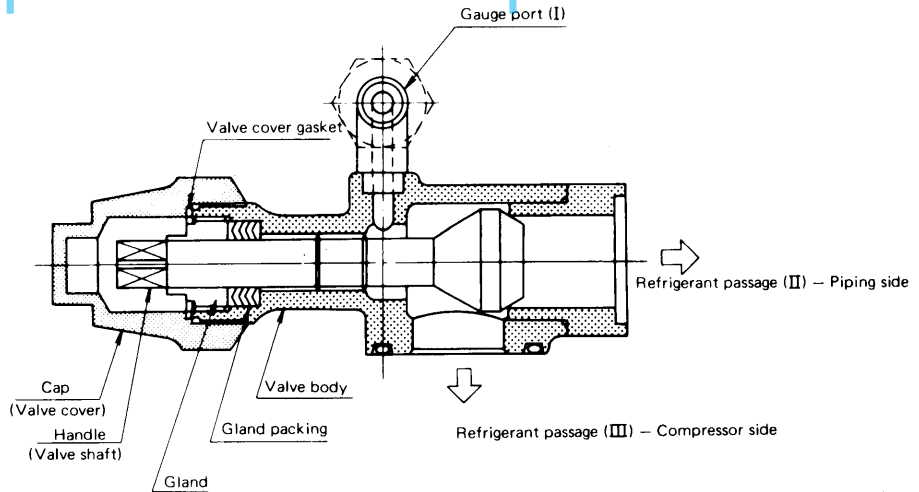
3. Stop valve at accumulator-receiver with heat exchanger outlet side (VSV10CB-4S)



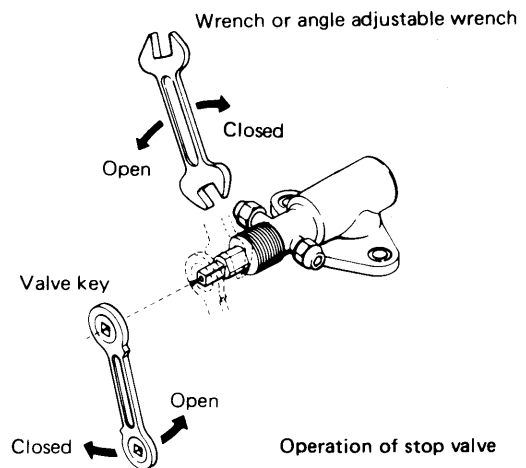
4. Stop valve at hot gas bypass (VSV10CBP-4S-4F)



(3) Handling method



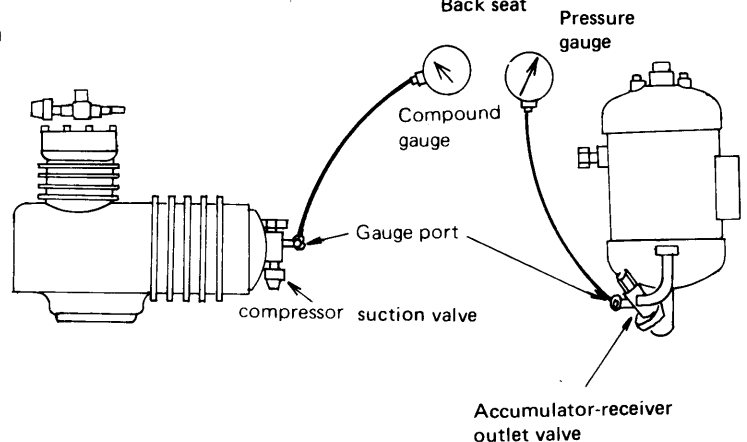
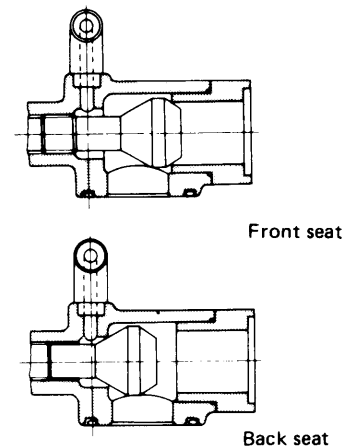
- 1) Remove the valve cap. At this time, be careful not to lose the gasket.
- 2) Loosen the gland in a way the refrigerant is not extracted.
- 3) Fully close the handleThe refrigerant passage I is connected to III (Front seat)
- 4) Fully release the handleThe refrigerant passage II is connected to III (Back seat)
- 5) Set the handle at the neutral positionThe refrigerant passage I is connected to II and III.
- 6) The refrigerant passage differs with the procedure mentioned in 3, 4, or 5. So select the best passage by necessity.
- 7) Operate the handle, tighten the gland and place the valve cap as it was after completion of the work. At this time, do not forget to attach the gasket.



9.2 Attaching or removing points of pressure gauge

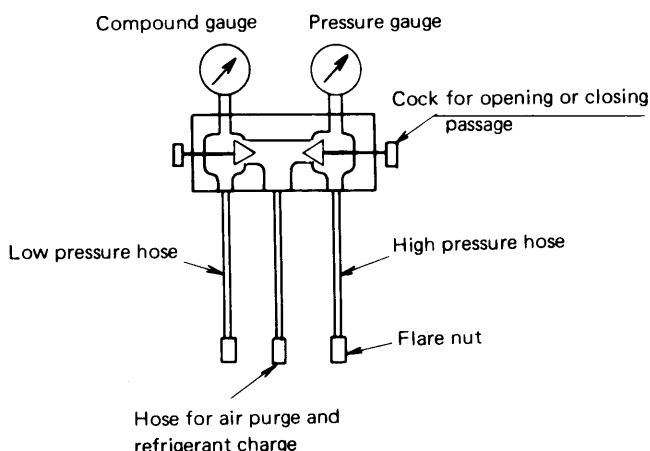
(1) Attaching a general pressure gauge

- 1) After opening the compressor suction valve and the accumulator-receiver valve fully (back seat), connect a pipe to the gauge port.
- 2) Loosen a little the flare nut on the pressure gauge side and tighten the handle of the stop valve a little (Middle seat) and return it at once. Thus the air is purged.
- 3) After purging the air, accurately tighten up the flare nut on the pressure gauge side.
- 4) Close the handle of the stop valve a little, and confirm that the needle of the gauge rises.
- 5) Be certain that the needle of the pressure gauge does not oscillate during the operation of the unit. If it oscillates, do not close the gauge port fully and open the handle of the stop valve a little.
- 6) In case the pressure gauge is attached to the low pressure side, if the low pressure is lower than the atmospheric pressure, the air is drawn in the piping during the air purging. So install the pressure gauge after confirming that low pressure is higher than the atmospheric pressure.
- 7) Operate the unit and confirm that the unit is stopped without pump down.

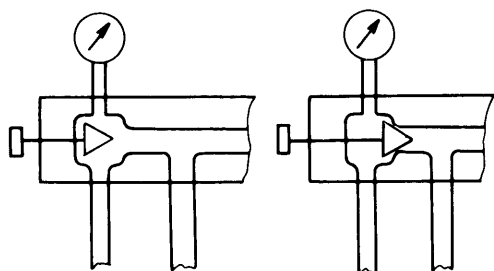


(2) Attaching the gauge manifold

- 1) With regard to mounting points, note the same caution as that for general pressure gauges.
- 2) Open the cocks which are attached to the both sides of the gauge manifold when mounting. Loosen the blind cover of the centre hose, and close the gauge port for the compressor suction valve and the accumulator-receiver outlet valve. (Back seat)
- 3) Attach the flare nut of the hose of the manifold on the high pressure side tightly and the on the low pressure side loosely.
- 4) Loosen the accumulator-receiver outlet valve and vent the air from the hose on the low pressure side and the centre hose and then once again keep the stop valve in the back seat state. After that tighten up the flare nut on the low pressure side.
- 5) After closing the cocks of the gauge manifold, keep the cock of the compressor suction valve and accumulator-receiver outlet valve at the neutral seat and measure pressure.



Structure of gauge manifold



Opening and closing states of gauge manifold

- (3) Removing the pressure gauge and the gauge manifold, as stated below.
When the high pressure hose is removed, note that the liquid refrigerant in the hose may jet out, which is very dangerous.
- 1) Hold the handle of the stop valve in the back seat state, and close the gauge port.
- 2) Open the cock (in case of gauge manifolds) or the flare nuts (in case of general pressure gauges) a little to extract the refrigerant from the hose.

At this time, do not open it suddenly so as not to joint out liquid refrigerant.

- 3) After extracting the refrigerant from the hose, remove the pipe connection for the gauge piping.
- 4) Place the blind cover on the gauge port of the stop valve, accurately tighten up the flare nut and confirm no refrigerant leaks.

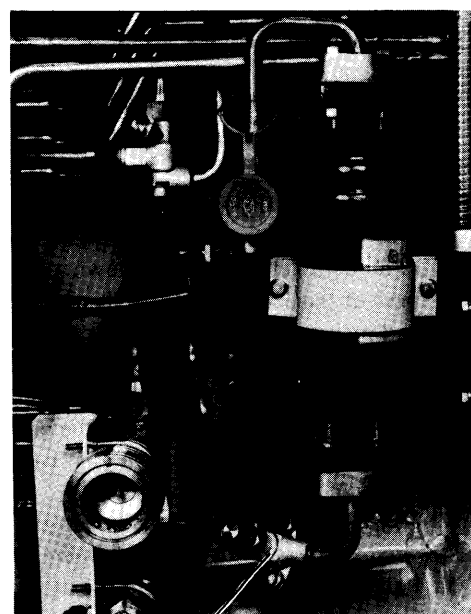
Note: Since the blind cover is very small, be careful not to lose it.

9.3 Pump down

Pump down means that the refrigerant in the refrigeration circuit is liquidized and collected in the Accumulator-receiver with heat exchanger. This work is required to repair the refrigeration circuit for minimizing leaking volume of the refrigerant and risks due to pressure rising.

< Working procedure >

- 1) Install pressure gauges to the high pressure side.
- 2) Operate the refrigeration unit (either on water cooled or air cooled operation)
- 3) Close the accumulator-receiver outlet valve.
- 4) Stop the operation when reading of the low pressure gauge becomes 0.1 kg/cm² and close the compressor discharge valve.
- 5) After a short while, read the low pressure gauge. If pressure rises, open the compressor discharge valve and repeat the same procedure.
- 6) Repeat the same procedure two or three times, and the refrigerant is collected in the accumulator-receiver with heat exchanger. If no pressure gauge is attached, the unit is stopped by the low pressure setting of the dual pressure switch.



Stop valve at the accumulator-receiver with heat exchanger outlet

9.4 Charging and purging the refrigerant

(1) Purging non-condensable gas

If non-condensable gas such as air exists in the refrigeration circuit, it is collected by the accumulator-receiver with heat exchanger, which raise pressure in the accumulator-receiver with heat exchanger abnormally high and reduces heat transferring ratio of the condenser surface. It is, therefore, very important to extract non-condensable gas.

If discharge pressure is abnormally high (even though cooling water volume is increased, in case of water cooled operation) and will not return to the normal pressure, inspect if non-condensable gas such as air exists in the following method.

- Stop the compressor, close the accumulator-receiver outlet valve and wait until leaving and entering cooling air (or water) of the air (water) cooled condenser become equal. If there is any difference between saturated pressure corresponding to cooling air (water) and condensing pressure, non-condensable gas exists.

In this case, purge non-condensable gas as stated below.

- 1) Accomplish pump down
- 2) Condense the refrigerant as much as possible, and then discharge it from the gauge port of the compressor discharge valve.
- 3) Discharge the condensed refrigerant repeatedly reading the pressure gauge until condensing pressure becomes saturated pressure.

(2) Refrigerant purge

There are two methods of refrigerant purge; i.e. one is for collecting the refrigerant extracted in a cylinder and the other is for discharging it to the atmosphere.

(a) Collecting the refrigerant in a cylinder

- 1) Prepare an empty cylinder which has been dried by forming vacuum inside and weigh it.
- 2) The cylinder is connected to the gauge port of the Accumu-receiver with heat exchanger by piping with the cylinder cock closed, and then loosen the flare nut on the cylinder side a little to vent the air from the piping.
- 3) Operate the refrigeration unit to pump down the refrigerant.
- 4) After completion of pump down, open the gauge port of the accumulator-receiver with heat exchanger and then open the cock of the cylinder to collect the liquid refrigerant into the cylinder.
- 5) After collecting the refrigerant, close the gauge port and the cock and then remove the piping.
- 6) Be certain that the refrigerant has been collected in the cylinder by weighing it.
- 7) As for the refrigerant remaining in the refrigeration circuit, extract it to the atmosphere.

(b) Extracting the refrigerant to the atmosphere

- 1) Open the gauge port on the suction side of the compressor to extract the gaseous refrigerant to the atmosphere.
- 2) Do not open the compressor discharge valve or the gauge port of the accumulator-receiver with heat

exchanger, otherwise the refrigerant oil and the liquid refrigerant are discharged, which may result in shortage of oil or getting chillblains.

- 3) Do not extract the refrigerant in a closed room and also confirm there is no fire around it. Although the refrigerant is non-toxic, there may be fear of suffocation. In addition, if the refrigerant contacts with fire, it yields phosgene gas (toxic gas).

(3) Vacuum drying and charging refrigerant and refrigeration oil

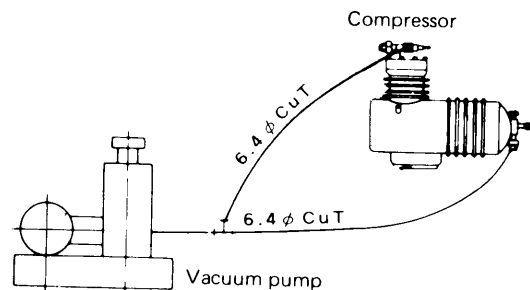
If all the refrigerant has leaked out and the air is intermixed in the refrigeration circuit, repair a cause of trouble and do vacuum drying. Then charge the predesigned volume of refrigerant. In case the refrigerant oil is replaced, do the same.

(Required tools)

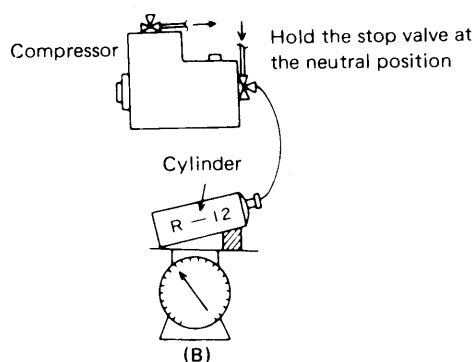
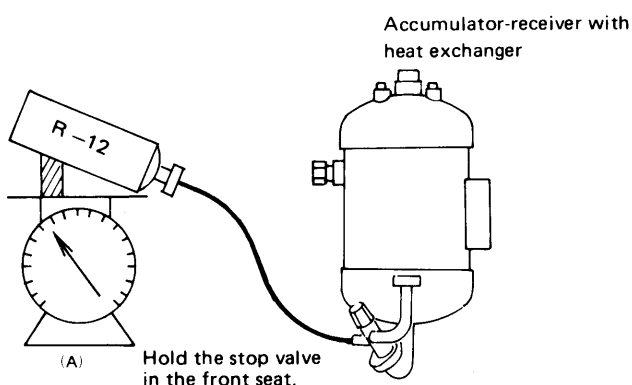
1. Refrigerant cylinder (20 kg) for R-12 (CCl_2F_2) with mouth piece
2. Refrigeration oil (20ℓ can) SUNISO 3GS-DI
3. $\phi 6.4$ CuT (with two flare nuts)
4. Pressure gauge (20 kg/cm^2), compound gauge ($10 \text{ kg/cm}^2 \times 75 \text{ cmHg}$) } or gauge manifold
5. Weighing scale (Up to 50 kg)
6. Tools
7. Vacuum pump

- (a) In case the refrigerant is replenished without exchanging the refrigeration oil.

- 1) Connect the vacuum pump to the gauge ports of the compressor suction and discharge valves, form vacuum down to 76 cmHg, hold the stop valve in the back seat state and then remove the vacuum pump, leaving the vacuum state in the refrigeration circuit. However, when air enters in the refrigeration circuit, form the vacuum in the circuit down to 76 cmHg and leave it for more than 2 hours (vacuum drying).



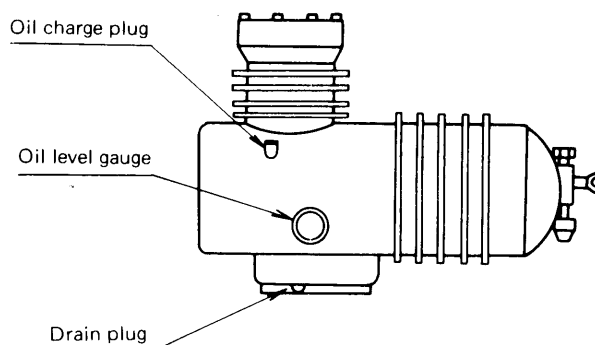
- 2) To evacuate the refrigeration circuit between the solenoid valve and expansion valve, reduce pressure of the circuit below the preset level of the low pressure switch lower the presetting level of the set point selector, operate the refrigeration unit, and open the solenoid valve for evacuation. At this time (vacuum drying), the compressor remains idle since the low pressure switch is off, and the solenoid valve alone open.



- 3) Place a refrigerant cylinder on the weighting scale, and record its weight.
- 4) In case the refrigerant is charged in the liquid state, do it as shown in the above figure (A). Prevent the liquid refrigerant collected in the accumulator-receiver with heat exchanger from flowing to the low pressure side. If the refrigerant is hardly charged, operate the compressor to charge it.
- 5) In case the refrigerant is charged in the gaseous state, do it as shown in the above figure (B). If the refrigerant is hardly charged, operate the compressor to charge it.
- 6) Charge the predesigned volume of the refrigerant in the above stated methods either in 4 or 5.
- 7) After completion of refrigerant charge, hold the stop valve in the back seat state and confirm that if the predesigned volume of the refrigerant has been charged by operating the refrigeration unit.

- (b) Charging the refrigerant as well after replenishment of refrigerant oil

- 1) Extract the refrigerant oil. → Firstly discard all the gas so that pressure in the refrigerant circuit becomes 0. Then loosen the drain plug at the bottom of the compressor to extract all the oil. At this time, firstly open the oil charge plug and then the drain plug to prevent the oil from jetting out.



- 2) Tighten up the drain plug.
 - 3) Charge the predesigned volume of the oil from the charge plug of the compressor.
 - 4) Accomplish vacuum drying and refrigerant charge stated in (1).
 - 5) Be sure to stop the compressor while this work is accomplished.
 - 6) When the refrigeration oil is discarded, be sure to remove the oil level gauge for cleaning.
 - 7) Recommendable refrigeration oil is SUNISO 3GS-DI. SUNISO 3GS – DI is superior to SUNISO 3GS in heat resistance. Maker of SUNISO 3GS – DI is SUN OIL CO., LTD. (U.S.A.)
 - 8) Do not mix two refrigeration oils.
 - 9) Do not use oil which is left opened to the atmosphere for a long time, as it may contain water. In case oil still remains in the oil can after charging, be sure to cap it.
- (c) In case only the refrigeration oil is exchanged.
 - 1) Operate the refrigeration unit to pump down the refrigerant by use of the accumulator-receiver outlet valve and stop it when low pressure becomes 0.1 kg/cm₂.
 - 2) Tighten up the discharge valve of the compressor.
 - 3) Open the gauge port on the suction side to extract the refrigerant on the low pressure side.
 - 4) Charge the oil from the oil charge plug. At this time, form the vacuum gradually to hasten oil charge.
 - 5) Restore the stop valve to its original state.

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