

SMART SPLICE™ LINE REPAIR

Safety

Line Splice/Terminator installation for qualified repair technicians.

Use Safety Glasses & Gloves.

Disconnect battery/power if applicable.

If repairing an A/C line, all refrigerant must be properly recovered and system must be at atmospheric pressure.

Information

Line Splice requires at least 2" of straight tubing (DO NOT USE on curved section of tubing) and may add 1/8" to overall line length.



Line Terminator requires at least 1" of straight tubing (DO NOT USE on curved section of tubing)



Verify that the line has enough "play" to accommodate.

Preparation

Using a POE, PVA or PAO oil, lubricate the Seal Sleeve, brass Anti-Vibration Tension Ring (AVTR), the threads of the Splice/Terminator body and the threads of the nut.

Do NOT use PAG oil.

LINE SPLICE/TERMINATOR INSTALLATION

Use with COPPER, ALUMINUM or STEEL tubing.

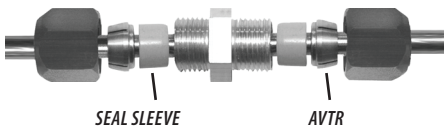
- 1. Cut damaged section from line using a tube cutter. If line is out-of-round, utilizing a re-rounding tool or equivalent, make line as round as possible.*
- 2. Clean away any burrs and remove oxidation, scale or other surface contamination.*
- 3. Line Splice: Ensuring the threads on the nut are lubricated, assemble nut on each tube end.
Line Terminator: Ensuring the threads on the nut are lubricated, assemble nut on end of tube to be blocked.*



- 4. Making sure brass Anti-Vibration Tension Ring (AVTR) is lubricated, assemble the lubricated brass AVTR onto end of tubing slotted side first (slotted side faces the nut).
– The AVTR ID and Seal Sleeve ID must match the tubing OD.*



- 5. Making sure the Seal Sleeve is lubricated, assemble the lubricated Seal Sleeve onto tube end.*



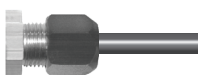
- 6. Ensure the threads on the coupler/terminator body are lubricated, Press line and Seal Sleeve into the splice coupler body or terminator body.*

Ensure the line is fully seated and comes to a stop inside the coupler / terminator body.

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7. Slide the AVTR and nut against the Seal Sleeve and hand tighten.



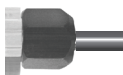
8. Using one wrench to hold the body, tighten the nut with another wrench. Repeat steps 4-8 for other side if using a Line Splice.

NOTE: If you are connecting two lines of different diameter, be sure that the Seal Sleeve and AVTR you install on each end is the same size as the line on that side.

Torque specifications are as follows:

SIZE	ALUMINUM / SOFT COPPER	HARD COPPER / STEEL
1/4"	Close Nut to Body	Close Nut to Body
5/16"	Close Nut to Body	Close Nut to Body
"5/16" 45° and 90°"	15 -18 ft-lbs	Min 40 ft-lbs
3/8"	Close Nut to Body	Close Nut to Body
"3/8" 45° and 90°"	15 -18 ft-lbs	Min 40 ft-lbs
3/8" to 5/16"	15 -18 ft-lbs	Min 40 ft-lbs
1/2"	Close Nut to Body	Close Nut to Body
1/2" to 5/16"	15 -18 ft-lbs	Min 40 ft-lbs
1/2" to 3/8"	15 -18 ft-lbs	Min 40 ft-lbs
"1/2" 45° and 90°"	15 -18 ft-lbs	Min 40 ft-lbs
5/8"	Close Nut to Body	Min 50 ft-lbs
"5/8" 45° and 90°"	18-20 ft-lbs	Min 50 ft-lbs
3/4"	Close Nut to Body	Min 60 ft-lbs
"3/4" 45° and 90°"	18-20 ft-lbs	Min 60 ft-lbs
7/8"	Close Nut to Body	Min 60 ft-lbs

FINISHED LINE TERMINATOR / SPLICE REPAIR



Line Terminator



Line Splice

NOTE: Leak-Check your work after completion.
Re-Connect The Battery/Power If Applicable.

For technical support call

1-678-973-2287

Mon–Fri, 9am–5pm EST
or visit

WWW.AIRSEPT.COM



"THE SPLICE IS RIGHT"



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US Patent 8,272,671 B1
Additional Patents Pending