ALCRKT01
ALUMINUM COIL REPAIR KIT
INSTALLATION INSTRUCTIONS

5151 San Felipe, Suite 500, Houston, TX 77056
www.goodmanmfg.com -or- www.amana-hac.com
P/N: IO-719 Date: February 2009

Attention Installing Personnel
As a professional installer, you have an obligation to know the product better than the customer. This includes all safety precautions and related items.

Prior to actual installation, thoroughly familiarize yourself with this Instruction Manual. Pay special attention to all safety warnings. Often during installation or repair, it is possible to place yourself in a position which is more hazardous than when the unit is in operation.

Remember, it is **your** responsibility to install the product safely and to know it well enough to be able to instruct a customer in its safe use.

Safety is a matter of common sense...a matter of thinking before acting. Most dealers have a list of specific good safety practices...follow them.

The precautions listed in this Installation Manual are intended as supplemental to existing practices. However, if there is a direct conflict between existing practices and the content of this manual, the precautions listed here take precedence.

Kit Contents
Using the following parts list, ensure that all parts included in this list are present and in an undamaged condition.

ALCRKT01 COMPONENTS		
Items	**Part No.**	**Qty.**
Braze Rod	0328M00000	3
Stainless Steel Brush	358804	1
Kit Instructions	IO-719	1

Please read and follow these instructions carefully.

⚠ WARNING

HIGH VOLTAGE!
Disconnect ALL power before servicing or installing this unit. Multiple power sources may be present. Failure to do so may cause property damage, personal injury or death.

1. Turn off all power to the unit.
2. Recover all refrigerant from the unit in accordance with EPA regulations.
3. Remove the black plastic cap from the brass Schrader assembly.
4. Remove the Schrader valve stem from the brass Schrader body to ensure there is no pressure remaining in the unit and also to prevent overheating of the Schrader valve stem if repairing a leak near the valve stem.
5. Clean the joint area of any visible excess oil and or dirt. A clean rag should be sufficient to remove the excess oil or dirt.
6. "Sweep" the refrigerant line with nitrogen or inert gas during brazing to prevent the formation of aluminum-oxide inside the refrigerant lines.

   Apply heat to the joint area with the torch. **Note: Set the flame at about half the heat of a normal copper brazing application**. Brush the alloy out of the joint using a stainless steel brush. It may be necessary to continue to heat the joint lightly while using the brush to remove the alloy.

⚠ CAUTION

Watch the color of the flame. When an orange tint is seen, the aluminum is approaching its melting point.

See figure 1.

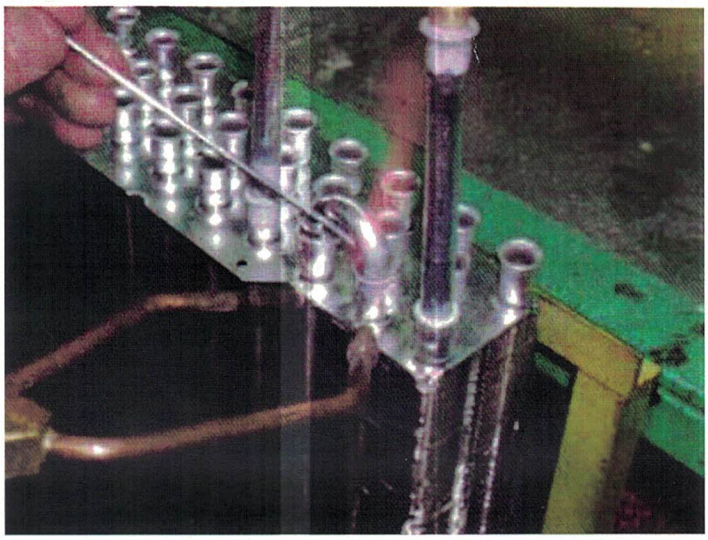

Figure 1

8. Once the alloy has been brushed from the joint area, reapply the torch flame to the joint and when an orange tint to flame is seen, apply the braze alloy to complete the joint.

9. When repairing a leak on coil hairpin, apply heat to the hairpin with the torch in the same manner as joint repair. When an orange tint to flame is seen, apply the braze alloy to complete the joint.
10. Allow the joint to cool down before applying pressure to verify that the leak was successfully repaired.
11. Evacuate the system to 250 microns or less using suction and liquid service valves. Using both valves is necessary as some compressors create a mechanical seal separating the sides of the system.
12. Charge the system by weighing the charge into the unit based on charge specifications on the rating plate, along with making any charge adjustments as needed based on line set length.
13. Set thermostat to call for cooling and then heating mode of operation (if heat pump) and verify proper unit operation.

5151 San Felipe, Suite 500, Houston, TX 77056
www.goodmanmfg.com -or- www.amana-hac.com