

### Brazing on Suction Connectors (Compressors with Direct Suction Intake)

Nidec GA Compressors use a telescope pipe inside the suction tube on some T- and N-Series compressors and on all D- and X-Series compressors to optimize energy consumption.

You can identify the compressors by the thicker suction tube area near the compressor shell (see figure 1-5).

This telescope pipe (see figure 6) is made out of plastic and is sensitive to high heat exposure.

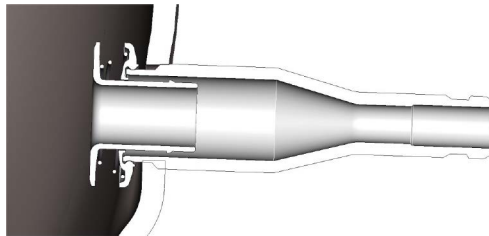
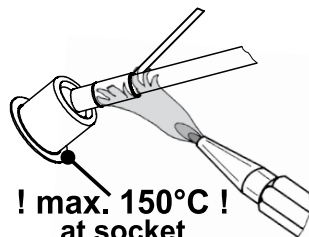


Fig.6 Suction connector with internal telescope pipe

Make sure when brazing a tube into the suction connector that the section with the telescope never exceeds 150 °C.



brazing solder: phosphor (LP7) or silver

Use a fork burner (see figure 7) and/or a damp cloth, if necessary. A protective plate can also serve to protect the telescope from direct heat from a flame.

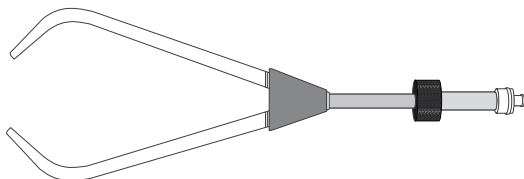


Fig.7 Fork burner



Fig.1 TLX compressor with copper connectors



Fig.2 NLU compressor copper-plated steel connectors



Fig.3 NLE compressor with copper connectors



Fig.4 DLE compressor with copper connectors



Fig.5 XV compressor with copper connectors