ENGINEERING TOMORROW

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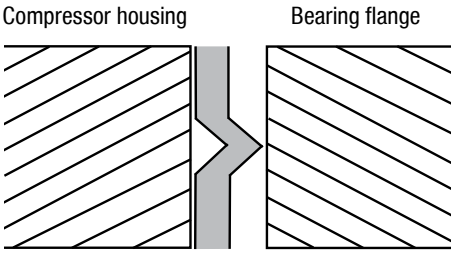
SAFETY INSTRUCTIONS

Caution! Refrigerating compressors are pressurised machines and therefore require particularly careful and meticulous handling.

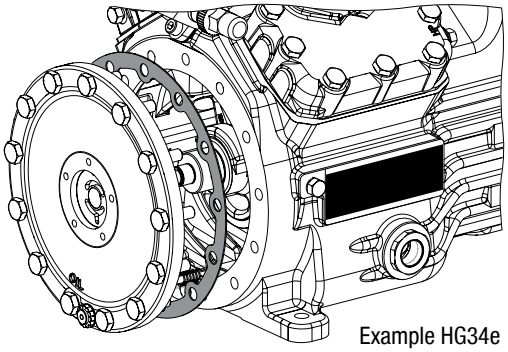
- **Only qualified staff are allowed to perform repairs.**
- **National safety regulations, accident prevention regulations, technical rules and other valid specifications must be observed.**
- **The compressor may only be operated in refrigerating systems, and only with refrigerants approved by Bock.**
- **The maximum tolerable operating overpressure may not be exceeded (not even for test purposes).**
- **Pressure switches are required to safeguard the machine from excess pressures.**
- **New compressors are provided with an overpressure filling ex works (inert gas, approx. 3 bar nitrogen). Before connecting up the refrigerating system, the pressure in the compressor must be relieved.**
- **Before starting the compressor, the discharge shut-off valve and suction shut-off valve are to be opened.**
- **Before starting up, check that all components mounted by the user have been properly mounted and are connected pressure-tight with the compressor (e.g. replaced parts, etc.).**
- **When starting up, do not start the compressor in a vacuum. Only operate the compressor when the whole system has been filled.**
- **Surface temperatures of more than 60°C are possible on the pressure side respectively under 0°C on the suction side, depending on the operating conditions.**

1. Release screws, bearing flange
11 screws M8 x 25 for HG(HA)12
13 screws M10 x 35 for HG(HA)22+34

Installation position of the steel seal



2. Dismounting bearing flange
Remove bearing flange and seal. The oil pump and the plug must be disassembled.



Example HG34e

3. Mounting bearing flange for HG(HA)12
11 screws M8 x 25 (Pos. 1 - 11)
1 copper seal under oil drain screw (Fig. 1)

Important! Observe sequence as listed in numbering.
M8 x 25: 37 Nm

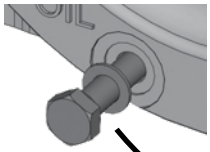
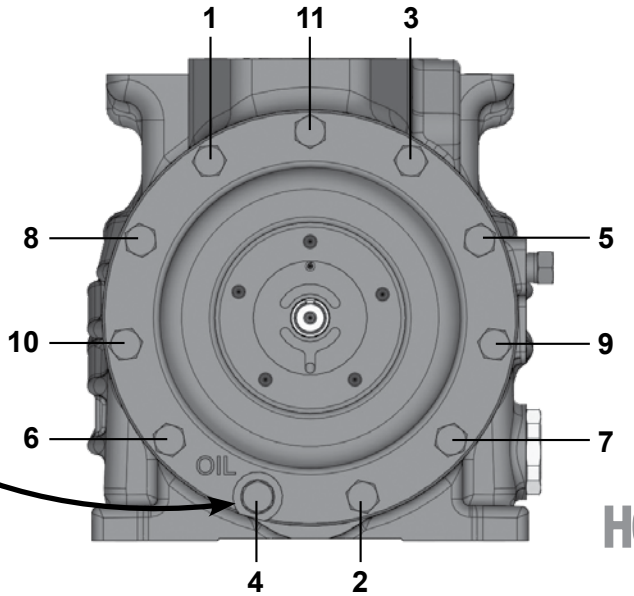


Fig. 1



HG(HA)12

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4. Mounting bearing flange for HG(HA)22+34

13 screws M10 x 35 (Pos. 1 - 13)
1 locking screw M12 x 1,5, 1 seal ring and 1 oil strainer (fig. 2)

Important! Observe sequence as listed in numbering.
M10 x 35: 75 Nm

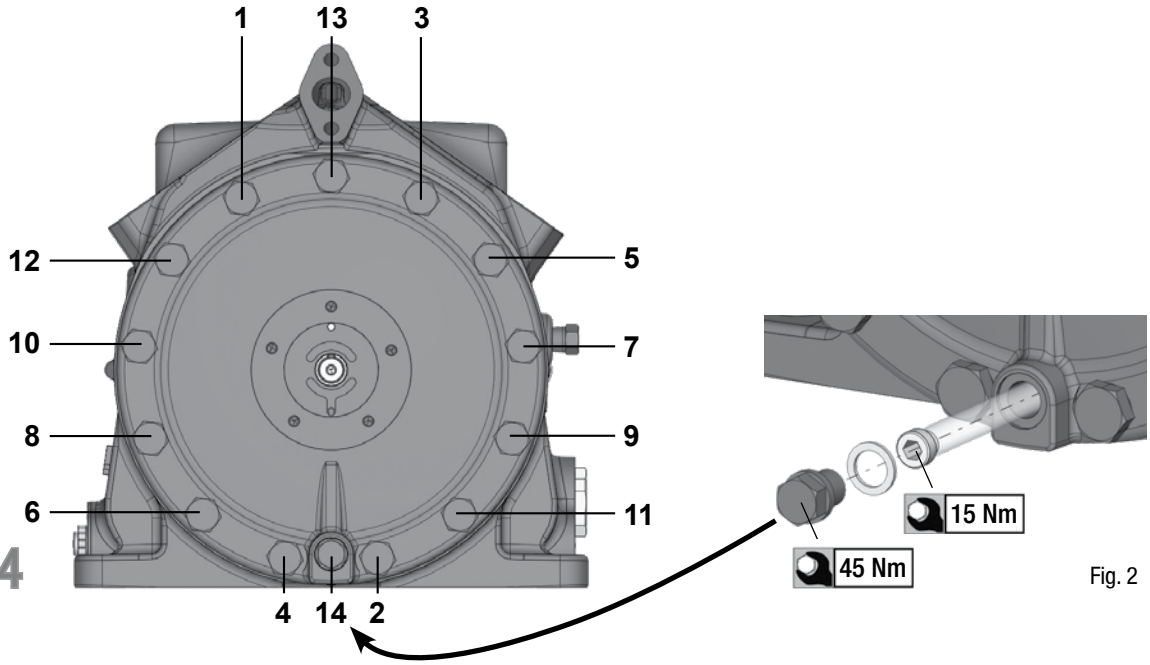
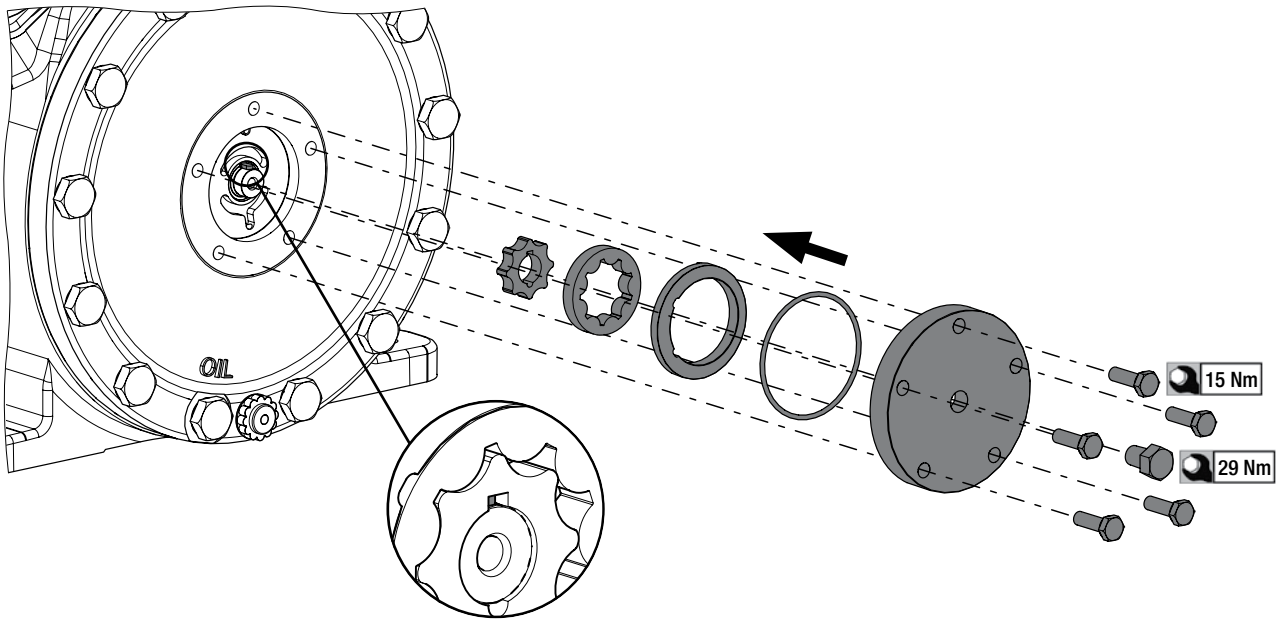


Fig. 2

5. Mounting oil pump

Pay attention to the correct position of the inner rotor to the feather key on the crankshaft!
Important! Observe the tightening torques.



Danfoss A/S
Climate Solutions • danfoss.com • +45 7488 2222