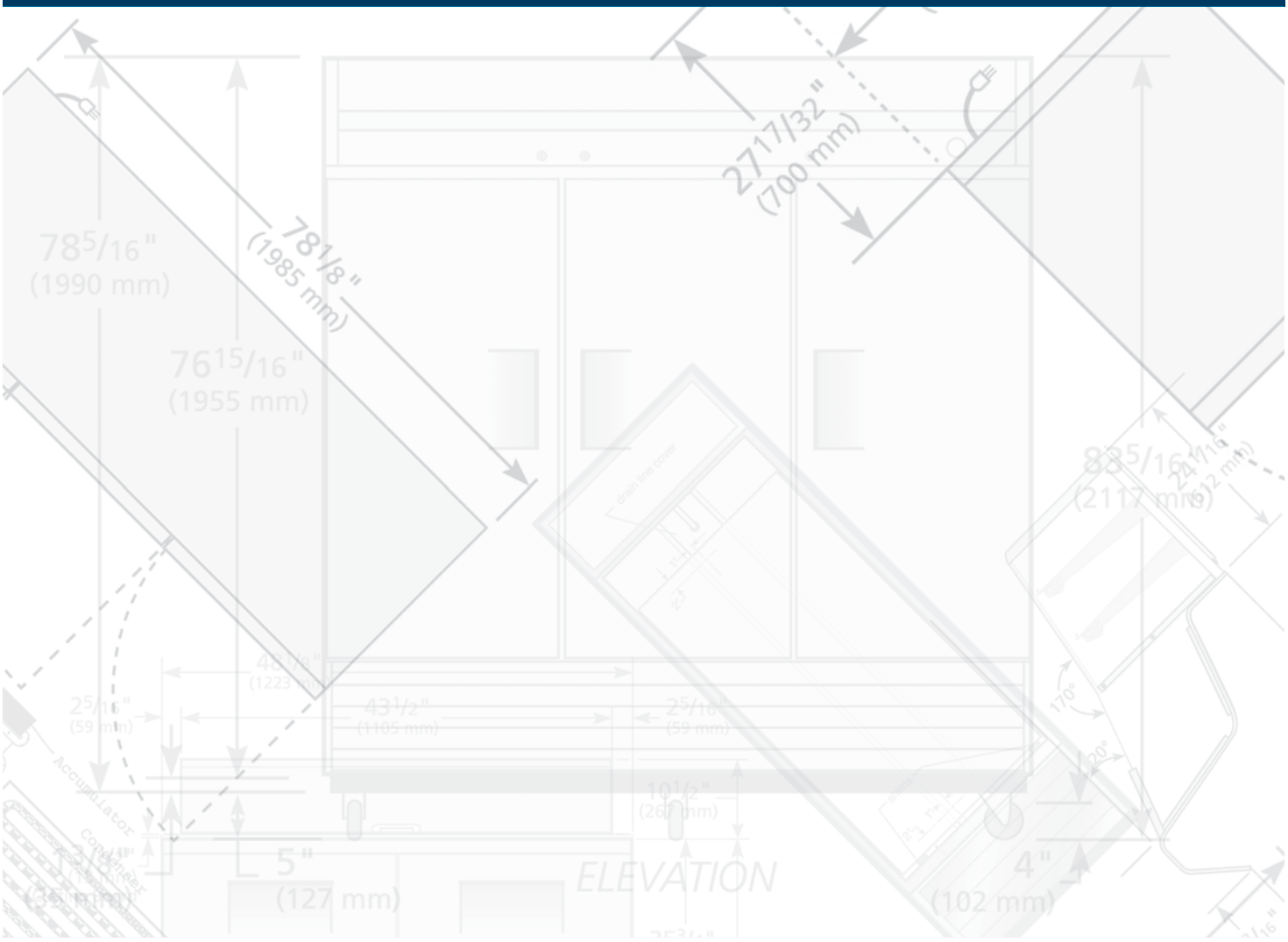
REFRIGERATION REPAIRS



NOTES

REFRIGERATION REPAIRS

Capillary Tube Replacement

CAPILLARY TUBE REPLACEMENT INSTRUCTIONS (UPRIGHT GDM/T-SERIES EQUIPMENT / SINGLE DOOR CABINETS)

INSTALLATION INSTRUCTIONS

Tools Required

- Drill
- 5/8" Hole Saw
- (2) - 1/2" Copper Coupling
- Torch
- Heat Shield
- Tube Cutter
- Foam Insulation
- Cap Tube Suction Line Assembly (Supplied)
- Liquid Line Filter Drier (Supplied)
- Cover (Supplied)
- Wire Back Guards (Supplied in freezers only).

NOTE: GDM/T-23 Freezer Model only requires ordering two of the following part number: 872977.

STEP 1 - Inspect supplied cap tube suction line assembly. The kit should include one 1/2" suction line, cap tube, accumulator section (shipped loose).

NOTE: You may have to secure the cap tube to the suction line with the supplied foil tape. Be sure to use all of the supplied cap tube. The excess cap tube should be coiled up and left inside the evaporator section.

STEP 2 - Remove the power supply to the cabinet.

STEP 3 - Recover the refrigerant from the unit.

STEP 4 - For high elevation installations, it may be necessary to "warm up" the set points. To make the adjustment, insert the appropriate tool in each adjustment screw and turn 1/4 of a revolution clockwise (to the right). This procedure will adjust both the cut-in and cut-out about 2°F warmer.

STEP 5 - Make sure to reconnect the wires to the proper spade terminal when reinstalling.

STEP 4 - Remove all of the shelves.

STEP 5 - Disconnect the evaporator drain line.

STEP 6 - Drop down the evaporator housing by removing the 1/4" screws that hold it in place. Remove the temperature control wires and remove the housing

STEP 7 - Locate the two 1/4" screws that hold the left side evaporator up and remove them.

STEP 8 - Un-solder the capillary tube from the evaporator.

NOTE: The use of a heat shield is recommended.

STEP 9 - Un-solder the evaporator and suction line from the accumulator. After the old suction lines cools down you can crimp it closed.

NOTE: The use of a heat shield is recommended.

STEP 10 - Drill a 5/8" hole in the floor as close to the left rear corner of the cabinet as possible. See Illustration 1.

STEP 11 - Place the cap tube suction line and accumulator assembly in the cabinet to prefit the assembly before doing any brazing.

NOTE: Illustration 2a will need to be cut to fit.

STEP 12 - Remove the assembly from the cabinet to solder all of the connections.

STEP 13 - Reinstall the assembly and solder the new assembly to the evaporator coil, liquid line and compressor pull out.

STEP 14 - Pressurize the system using nitrogen to leak and repeat this step.

STEP 15 - Silicone the hole in the floor and insulate the suction line where the line comes out under the cabinet.

STEP 16 - Pull a vacuum on the unit.

NOTE: The use of a micron gauge is recommended.

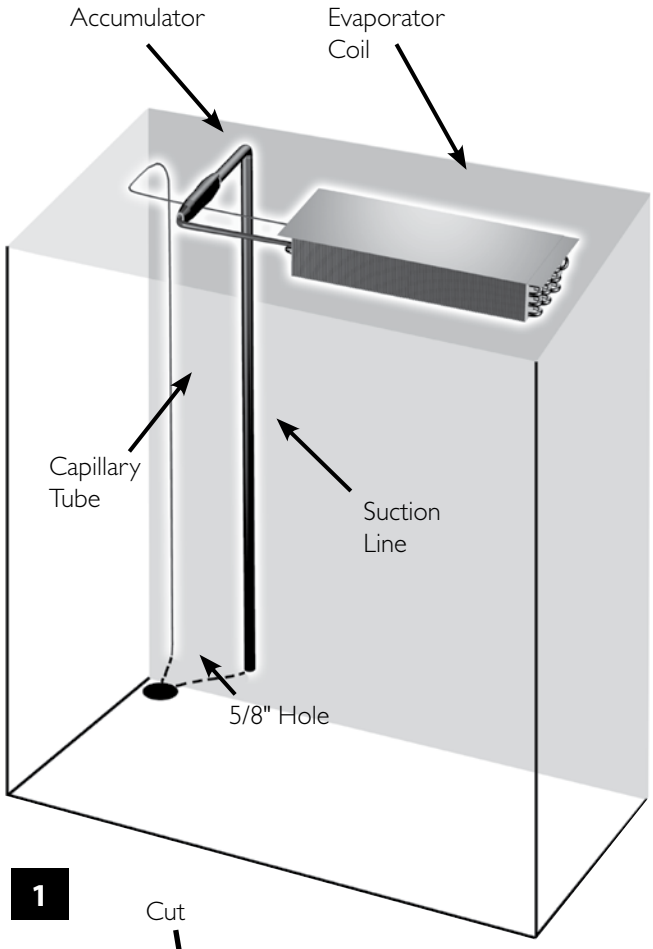
STEP 17 - Reassemble the evaporator section.

STEP 18 - Place the cover over the new cap tube suction line assembly and secure it to the back wall using several small sheet metal screws or some white pop rivets.

STEP 19 - Place the new or existing back guards back in the unit.

STEP 20 - Check the cabinet operation

STEP 21 - Finish reassembling the cabinet.



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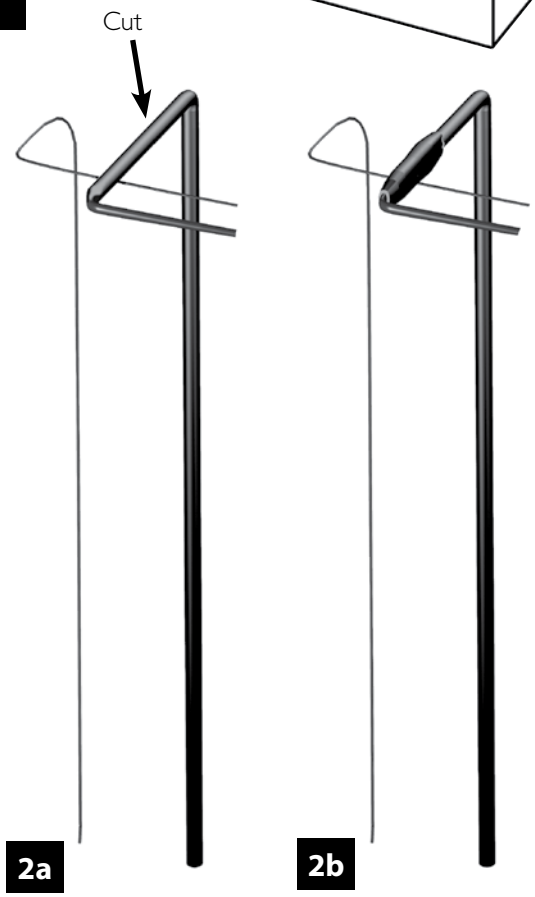


2a **2b**

CAPILLARY TUBE REPLACEMENT - GDM-72F (HERMETIC COMPRESSOR ONLY)

INSTALLATION INSTRUCTIONS

Tools Required

- Drill
- 1/4" Drill Bit
- 3/4" Cone Drill Bit
- Tube Cutter
- Torch/Solder/Vacuum Pump
- Heat Shield
- Perma Gum or Silicone

CAPILLARY TUBE REPLACEMENT KIT INCLUDES:

- 1) 6' x 1/2" Suction Line (925123)
- 1) 12' x .054 Cap Tube Assembly (925124)
- 1) Foil Tape 10ft (925125)
- 1) 1/2" Copper Elbow (851153)
- 1) 4' Foam or Tar Tape 18" (820223)
- 2) 3/4" Black Bushings (811287)
- 1) Refrigerant Line Cover (925126)
- 2) Wire Back Guards (883389)
- 1) Drier (052S) (800805)

NOTE:

It is recommended that the system is flushed thoroughly. Additionally, if the compressor or the compressor oil is being replaced, this procedure should be done last, not to compromise the compressor oil.

STEP 1 - Inspect the supplied cap tube suction line assembly kit. The kit should include a cover (white or stainless steel to match the interior of the cabinet). Approximately 6' of 1/2" copper with a 90° bend. Two each 12' x .054 cap tubes, 1/2" elbows and two wire back guards. Additionally, there should be foil tape, and a liquid line filter drier and two 3/4" plastic bushings.

NOTE: Be sure to use all of the supplied cap tube. The excess cap tube should be coiled up and left under the cabinet insulated.

These parts will be shipped loose and some assembly will be required. (Image 1).


1

STEP 2 - Remove the power supply from the cabinet.

STEP 3 - Recover the refrigerant from the unit.

STEP 4 - Remove all the shelves and left front and rear shelf standards from the cabinet.

STEP 5 - Remove the clear drain line from the evaporator housing drain fitting.

STEP 6 - Remove the evaporator housing. To do this, remove all the 1/4" hex head screws that hold the cover in place. Also be sure remove the temperature control and light switch from the housing. This will allow you to pull evaporator cover out of the unit. You will also have to remove the center pilasters from the cabinet.

STEP 7 - Remove the temperature control cap tube from the evaporator coil.

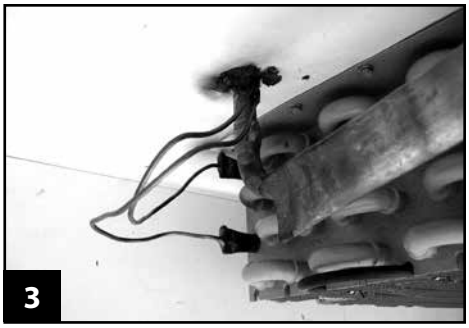
STEP 8 - Remove the existing left rear wire rack on the back wall. Be sure to save all the screws and white plastic p-clips (Image 2).


2

STEP 9 - Cut and pinch off the two cap tubes coming out of the evaporator section from the ceiling.

NOTE: Be sure to leave yourself enough cap tube to solder shut. Do the same thing with the 1/2" suction line running into the ceiling from the accumulator outlet.

NOTE: When you cut the 1/2" suction line leave a stub of copper in the accumulator.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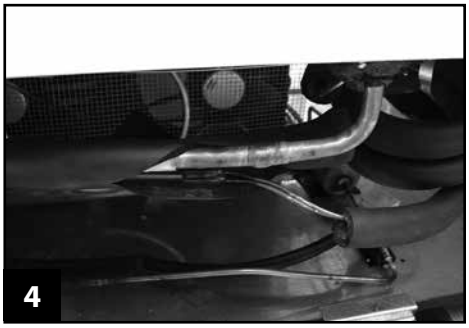
Carefully unsolder the 1/2" copper stub in the accumulator and remove. Then solder shut the two cap tubes and the 1/2" copper line in the ceiling. (Image 3)

STEP 10 - Go under the cabinet were the 1/2" suction line comes out of the cabinet, cut and pinch shut the 1/2" line right above the 90° bend. Locate the copper line going to the inlet of the cap tubes. You should see the two cap tubes setting inside a piece of crimped copper that is about 4" long. Cut the copper line in the middle. Be sure to remove the foam insulation around the coiled up cap tubes. Save this to use again later. Cut and pinch off the cap tubes about 1" from where they go into the cabinet. (Images 4, 5, and 6)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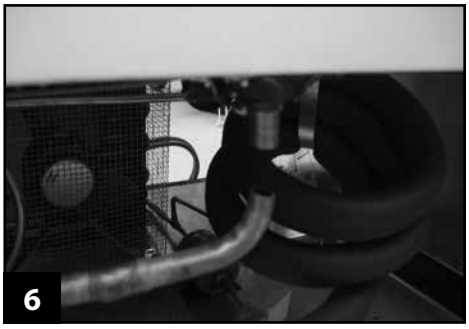
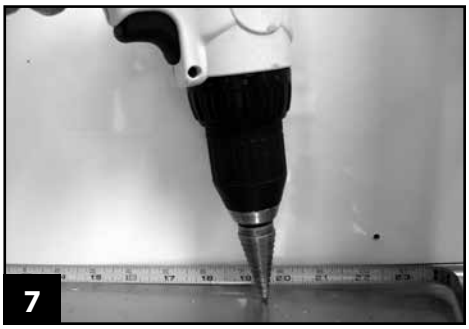

6

STEP 11 - Locate the left center seam on the back wall. Measure over to the left of this seam 61/4" and place a mark on the floor as close to the back wall and the seam in the floor as possible. Using the 1/8" drill bit, drill a hole all the way through the floor so that the drill bit comes out on the bottom of the cabinet. (Image 7)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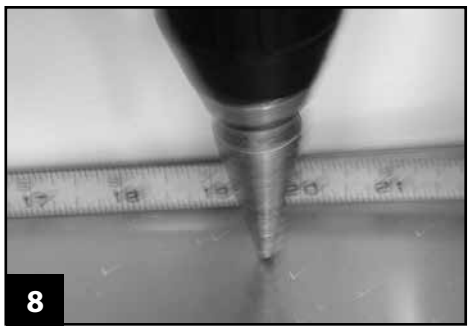
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STEP 12 - Using the 3/4" cone bit drill a hole in the floor on the inside of the cabinet. Do the same thing for the hole on the underside of the cabinet. (Images 8 and 9)


9


10

STEP 13 - Place the 3/4" black bushing in the holes inside the cabinet as well as under the cabinet. (Image 10)

STEP 14 - Run the two cap tube through the hole under the cabinet through the floor up to the evaporator coil.

NOTE: Be sure to place caps of tape over the cap tubes when you push them through the floor. The excess cap tube will remain under the cabinet, not in the evaporator section. (Image 12)

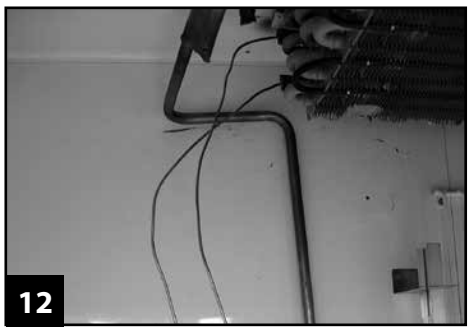

11

STEP 15 - Take the 1/2" suction line and place it through the hole drilled into the floor in Step 12. This is the same place that the two capillary tubes were placed into.

NOTE: You should have some excess copper line sticking out of the bottom of the cabinet.

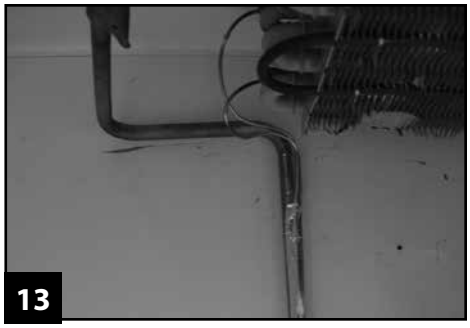
Inside the cabinet, the 1/2" line should go into the outlet of the accumulator. You will need to trim off some of the 1/2" copper line.

NOTE: The end of the 1/2" line should be about 2" into the accumulator.


12

Then solder in the 1/2" line into the accumulator and the new cap tubes into the evaporator. Wait for the copper lines to cool down and using the supplied foil tape, secure the cap tube to either side of the suction line. Doing this will insure that the cap tube will not rub up against the cover. Wrap two or three pieces of the tar tape around this new suction line cap tube assembly horizontally equal distance apart. (Images 11, 12, and 13)

STEP 16 - Place the insulation removed in Step 10 around the new cap tube under the cabinet in the condensing unit area.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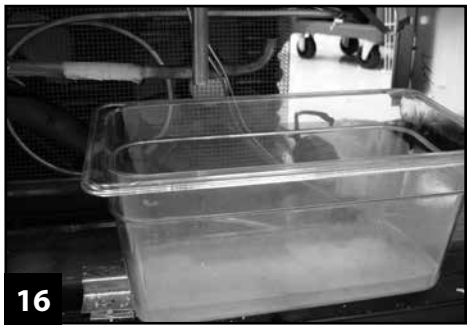
STEP 17 - Drill a 1/4" hole in the side of the accumulator at the lowest point to allow any oil to drain out. (Image 14)


14

STEP 18 - Place a Schrader valve into the end of the new line with the two cap tubes crimped into it. Solder in place. Using nitrogen, blow through the cap tubes, the evaporator and the accumulator.

NOTE: You may want to place something under the accumulator to catch any oil that may come out. (Images 15 and 16)


15


16

STEP 19 - Cut the Schrader valve off the end of the 5/16" cap tube assembly. Attach this line to the 1/4" liquid line. Connect the supplied 1/2" elbow to the end of the new suction line and the existing 1/2" compressor pull out. Solder all these connections. Additionally, you will need to go and solder the hole made in the accumulator in Step 17. (Image 17)


17


18


19


20

STEP 20 - Secure the coiled up and insulated cap tube to the underside of the cabinet. (Image 18)

STEP 21 - Pressurize with 200 psig of nitrogen to leak check. If everything checks out, you should change the drier and evacuate to a minimum of 500 microns.

NOTE: If you are going to change out the compressor or the compressor oil, do this prior to changing out the dryer and evacuating the system.

STEP 22 - Install the cover over the new cap tube suction line assembly as shown in the pictures. (Images 19 and 20) Be sure that the right edge of the cover is up against the left center shelf pilaster bracket.

STEP 23 - Install the new back guards on the back left rear wall of the using the existing screws and "p" clips. You will have to make new hole in the wall. (Image 21)

NOTE: If the compressor and or the compressor oil need to be changed, it should be done at this point.

STEP 24 - Weigh in the correct charge, leak check again and start the cabinet up.

STEP 25 - Reset the time clock and check the operation of the cabinet.


21

CAPILLARY TUBE REPLACEMENT - GDM-72F (SEMI-HERMETIC COMPRESSOR ONLY) PART # 932292

INSTALLATION INSTRUCTIONS

Tools Required

- Drill
- 1/4" Drill Bit
- 3/4" Cone Drill Bit
- Tube Cutter
- Torch/Solder/Vacuum Pump
- Heat Shield
- Perma Gum or Silicone

CAPILLARY TUBE REPLACEMENT KIT INCLUDES:

- 1) 6' x 1/2" Suction Line (931840)
- 1) 7' x .046" Cap Tube Assembly (931841)
- 1) Refrigerant Line Cover (925126)
- 1) 4' Foam or Tar Tape (820223)
- 2) 3/4" Black Bushings (811287)
- 2) Wire Back Guards (872979)
- 1) 1/2" Copper Elbow (851153)
- 1) 052S Drier (800805)

NOTE:

It is recommended that the system is flushed thoroughly. Additionally, if the compressor or the compressor oil is being replaced, this procedure should be done last, not to compromise the compressor oil.

STEP 1 - Inspect the supplied cap tube suction line assembly kit. The kit should a cover (white or stainless steel to match the interior of the cabinet). Approximately 6' of the 1/2" copper with two 90° bends, cap tube assembly made up with two 7' x .046", 1/2" copper elbow, and two wire back guards. Additionally, there should be foil tape, tar or foam tape, a liquid line filter drier and two 3/4" plastic bushings.

NOTE: Be sure to use all of the supplied cap tube. The excess cap tube should be coiled up and left under the cabinet insulated.

These parts will be shipped loose and some assembly will be required. (Image 1).


1

Step 2 - Remove the power supply from the cabinet.

Step 3 - Recover the refrigerant from the unit.

Step 4 - Remove all the shelves from the cabinet and the left and right front and rear shelf standards from the middle of the cabinet.

Step 5 - Remove the clear drain line from the evaporator housing drain fitting.

Step 6 - Remove the evaporator housing. To do this, remove all the 1/4" hex head screws that hold the housing in place. Also be sure remove the light switch by unscrewing the lock nut around the switch and unscrew the temperature control mounting plate. This will allow you to remove the evaporator cover from the unit.

Step 7 - Remove the temperature control cap tube from the evaporator coils.

Step 8 - Remove the existing left rear top and bottom wire racks from the back wall. Be sure to save all the screws and white plastic p-clips. (Image 2)

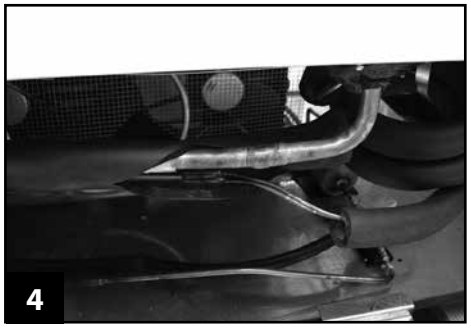

2


3

Step 9 - Cut and pinch off the two cap tubes coming out of the evaporator section from the ceiling.

NOTE: Be sure to leave yourself enough cap tube to solder shut.

Do the same thing with the 1/2" suction line running into the ceiling from the accumulator. Carefully, unsolder the 1/2" copper stub in the accumulator and remove. Then solder shut the two cap tubes and the 1/2" copper line in the ceiling. (Image 3)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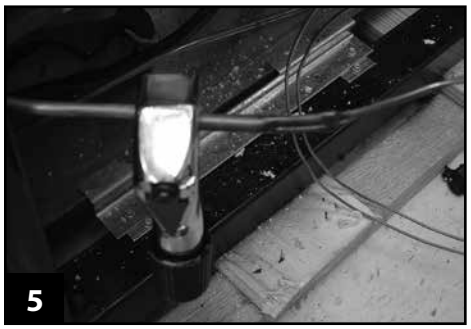
STEP 10 - Go under the cabinet were the 1/2" suction line come out of the cabinet, cut and pinch shut the 1/2" line right above the 90° bend. Locate the copper line going to the inlet of the cap tubes. You should see the two cap tubes setting inside a piece of crimped copper that is about 4" long. Cut the copper line in the middle. Be sure to remove any foam insulation around the cap tubes. Cut and pinch off the cap tubes about 1" from where they go into the cabinet. (Images, 4, 5, and 6)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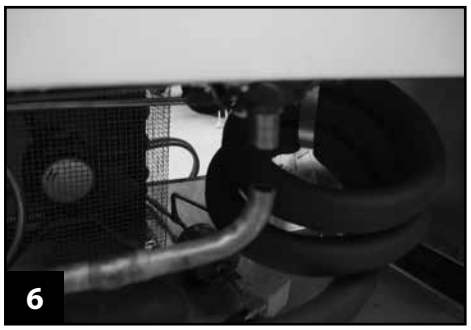
STEP 11 - Install the new back guards on the back wall. Use the existing right side holes as your guide. (Images 18, 19)

STEP 12 - Measure over from the left side wall approximately 4" and mark this spot on the floor of the cabinet. Using the 1/4" drill bit, drill a hole all the way through the floor so that the drill bit comes out the bottom of the cabinet.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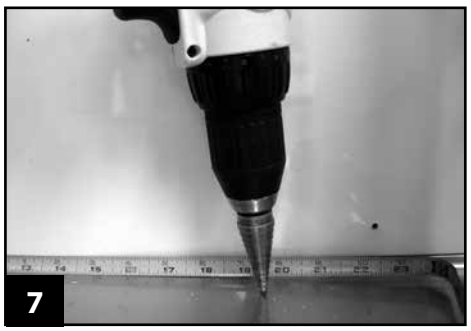
STEP 13 - Using the 3/4" cone bit, drill a hole in the floor on the inside of the cabinet. Do the same thing on the underside of the cabinet. (Image 7, 8, 9)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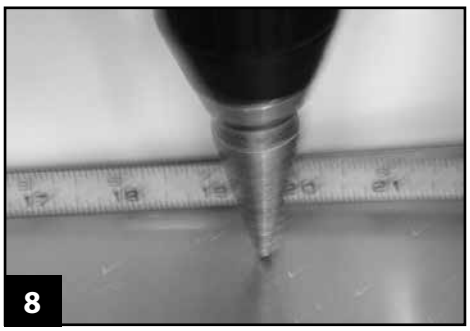
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9

STEP 14 - Place the 3/4" black bushing in the holes inside the cabinet as well as under the cabinet. (Image 10)

STEP 15 - Run the two cap tubes through the hole drilled in Step 13 through the floor up to the evaporator coil.

NOTE: Be sure to place tape over the ends of the cap tubes when you push up through the floor. (Image 12)

STEP 16 - Take the new 1/2" suction line and place it through the hole that was drilled into the floor of the cabinet in Step 13 that has the two cap tubes in them. You will have to bow the copper line some to do this.

NOTE: You should have some excess copper line sticking out of the bottom of the cabinet.

Inside the cabinet, the 1/2" line should go into the outlet of the accumulator. You will need to trim off some the 1/2" copper line.

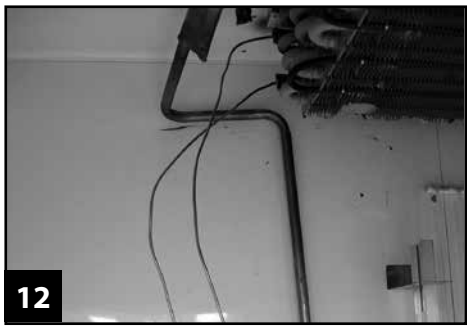
NOTE: The end of the 1/2" copper line should be about 2" into the accumulator.

Solder in the 1/2" line in the accumulator and the new cap tubes into the evaporator. Wait for the copper lines to cool and then secure the cap tubes to either side of the 1/2" suction line using the supplied foil tape. This will insure some heat exchange as well as prevent the cap tubes from vibrating around and rubbing against the cover and the suction line. Wrap two of three pieces of tar tape around this new suction line cap tube assembly horizontally equal distances apart. (Image 11, 12, 13)

STEP 17 - Drill a 1/8" hole in the side of the accumulator at the lowest point to allow any oil to drain out. (Image 14)


10


11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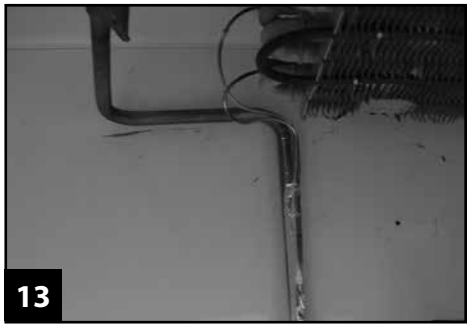
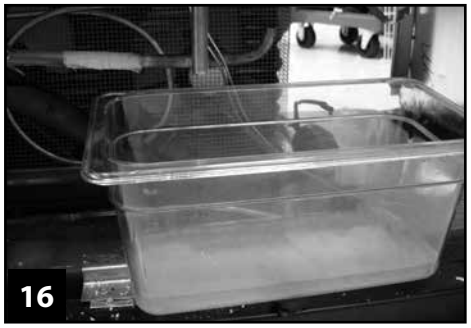

13


14


15

STEP 18 - Place a Schrader valve into the end of the new line 5/16" line with the two cap tubes crimped into it and solder it in place. Using nitrogen, blow through the cap tubes, the evaporator and the accumulator.

NOTE: You may want to place something under the accumulator to catch any oil that may come out. (Image 15 and 16)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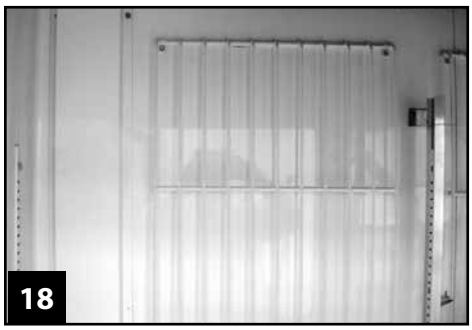
17

STEP 19 - Once the copper line cools down, cut and remove the Schrader valve from the 5/16" line. Attach this line to the 1/4" liquid line. Connect the supplied 1/2" elbow to the end of the new suction line and the existing 1/2" compressor pull out. Solder all these connections. Additionally, you will need to go and solder the hole made in the accumulator in Step 17. (Image 17)

STEP 20 - Pressurize with a minimum of 200 psig of nitrogen to leak check. If everything checks out, you should know change the drier and evacuate to a minimum of 500 microns.

NOTE: If you're going to change out the compressor or the compressor oil, do this prior to changing the drier and evacuating the system.


18

STEP 21 - Install the cover over the new cap tube suction line assembly as show in the pictures. (Images 18 and 19)

STEP 22 - Weigh in the correct charge, leak check again and start the cabinet up.

STEP 23 - Reset the defrost time clock and check the operation of the cabinet.

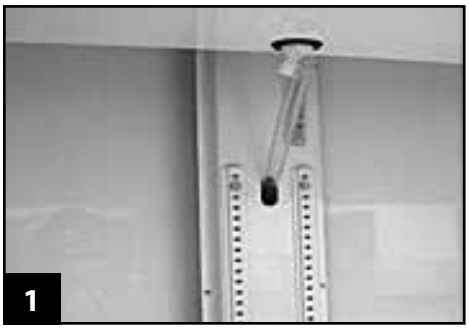

19

CAPILLARY TUBE REPLACEMENT - GDM-72 AND T-72

INSTALLATION INSTRUCTIONS

Tools Required

- Drill
- 5/8" Hole Saw or Drill Bit
- 1/2" Copper Elbows
- 1/2" Copper Couplings
- Tube Cutter
- Torch/Solder/Vacuum Pump
- Heat Shield
- Perma Gum or Silicone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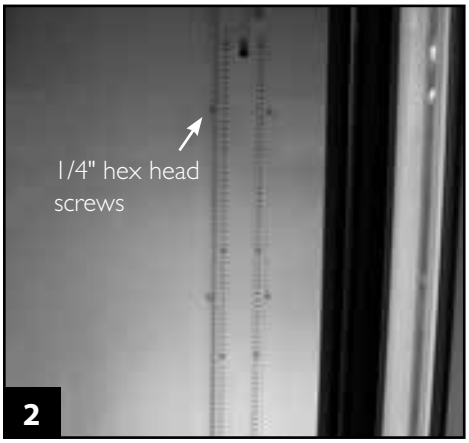

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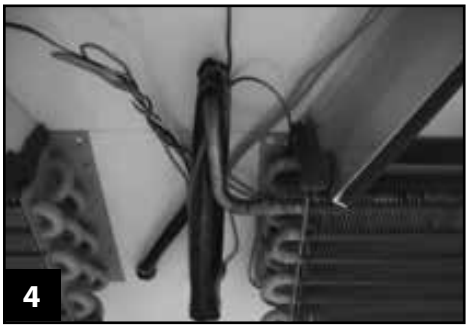
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STEP 1 - Inspect the supplied cap tube suction line assembly kit. The kit should include three corner covers (white or stainless steel to match the interior of the cabinet). Two each of the 1/2" suction line, cap tube, accumulator, 5/8" plastic bushing. Additionally, there should be foil tape, and a liquid line filter drier.

NOTE: Be sure to use all of the supplied cap tube. The excess cap tube should be coiled up and left inside the evaporator section. These parts may be shipped loose and some assembly will be required.

STEP 2 - Remove the power supply from the cabinet.

STEP 3 - Recover the refrigerant from the unit.

STEP 4 - Remove all the shelves from the cabinet..

STEP 5 - Remove the drain lines from the evaporator. (Image 1)

STEP 6 - Remove the evaporator housing. To do this, remove all the 1/4" hex head screws that hold the housing in place. Also be sure remove the light switch by unscrewing the lock nut around the switch and unscrew the temperature control mounting plate. This will allow you to remove the evaporator cover from the unit.

STEP 7 - Remove the temperature control cap tube from the evaporator coils.

STEP 8 - Remove the existing left rear top and bottom wire racks from the back wall. Be sure to save all the screws and white plastic p-clips. (Image 2)

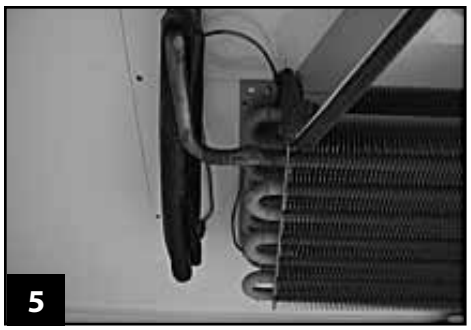
STEP 7 - Remove the evaporator housing. To do this remove all the 1/4" hex head screws that hold the housing in place. Also be sure to remove the light switch by unscrewing the lock nut around the switch and unscrew the temperature control mounting plate. This will allow you to pull evaporator cover out of the unit. You will also have to remove the center pilasters from the cabinet. (Image 3).


3

STEP 8 - Remove the temperature control cap tube from the evaporator coils.

STEP 9 - Remove the existing cap tube and suction line from the right evaporator coil. Cut the copper lines coming out of the ceiling and solder them shut. (Image 4)

STEP 10 - Starting with the right evaporator line set. Drill a 5/8" hole in the floor in the middle of the area where the drain line cover sits. Approximately 25" from the right side wall or between the two screws holes on the back wall for the drain line cover.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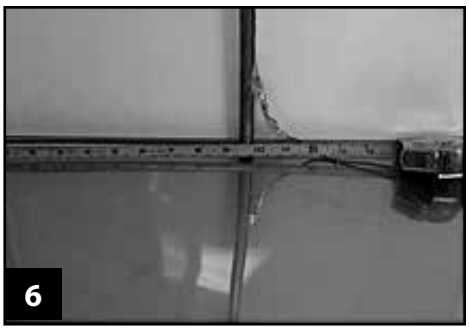
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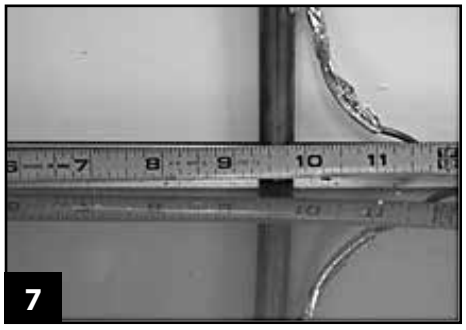
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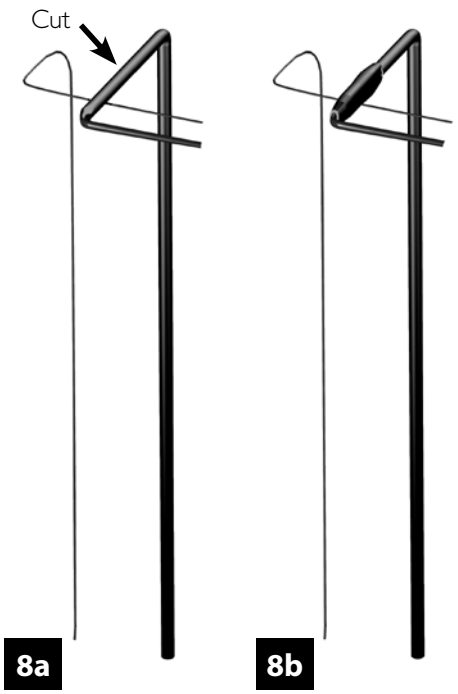


8a 8b

STEP 11 - Place one of the 5/8" bushings in the hole and then run the cap tube suction line assembly through it. You should have at least 6-8" of cap tube sticking out past the end of the suction line into the condensing area. Fill the hole in the floor with perma gum or silicone.

STEP 12 - Take the drain line cover that was removed in Step 6 and trim approximately 1 3/4" from the top using a tin snips. Place the drain line cover back over the refrigeration lines.

STEP 13 - Add the accumulator to suction line to the assembly to pre-fit prior to doing any soldering. After sizing the assembly, solder it to the evaporator.

NOTE: Will need to be cut to fit and possibly add additional 1/2" after.

STEP 14 - Repeat this step for the left hand side cap tube suction line assembly. Drill a 5/8" hole in the floor approximately 9 1/2" from the left wall.

STEP 15 - Remove the existing cap tube and suction line from the left evaporator coil. Cut the copper lines coming out of the ceiling and solder them shut. (Image 5)

STEP 16 - Measure in approximately 9 1/2" from the left wall and drill a 5/8" hole in the floor. Place the other 3/8" bushings in the hole and then run the cap tube suction line assembly through it. You should have at least 6-8" of cap tube sticking out past the end of the suction line into the condensing area. Fill the hole in the floor with perma gum or silicone. (Images 6 and 7)

STEP 17 - Add the accumulator to suction line to the assembly to pre-fit prior to doing any soldering. After sizing the assembly, solder it to the evaporator.

NOTE: Illustration 8 will need to be cut to fit.

STEP 18 - Down below in the condensing area find the new cap tubes and suction lines that have been pushed through the floor and solder then into respective lines.

STEP 19 - Pressurize the system with nitrogen and your choice of refrigerant to leak check.

STEP 20 - Change the drier. Pull a vacuum on the unit. Weigh-in the charge of the unit.

NOTE: The use of micron gauge is recommended.

STEP 21 - Place the evaporator cover back in place. As well as all other covers that may have been removed.

STEP 22 - Plug the unit back in and check its operation.

CAPILLARY TUBE REPLACEMENT - GDM-10PT PART # 921789

INSTALLATION INSTRUCTIONS

Tools Required

- Screwdriver
- 1/4" Nut driver
- Tape measure
- Marking utensil
- Electric drill
- 5/8" Hole saw or drill bit
- Tube cutter
- Utility knife
- Wire stripper

CAPILLARY TUBE REPLACEMENT KIT INCLUDES:

a. Copper, suction line, tubes (2)

b. Copper, capillary tube (1)

c. Accumulator (1)

d. Aluminum cover (1)

e. 5/8" clear plastic tubing (1)

f. Aluminum tape

g. Cork tape

h. Crimp connectors (2)

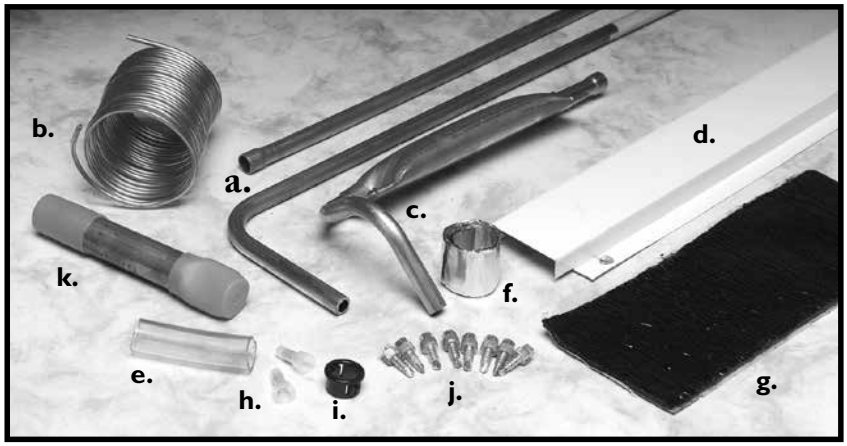
i. Plastic bushing (1)

j. Self-tapping screws (8)

k. Drier

NOTE:

Once it has been determined that you have a restriction in the refrigeration system it is essential to follow **GOOD REFRIGERATION PRACTICES.** This would include but is not limited to flushing the refrigeration system with nitrogen, replacing the refrigerant oil, changing the filter drier and pulling a minimum 500 micron vacuum to help ensure a successful long term repair.



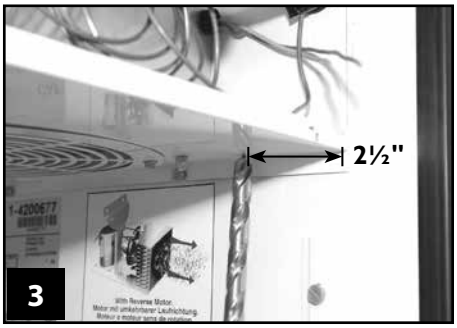
Included in kit

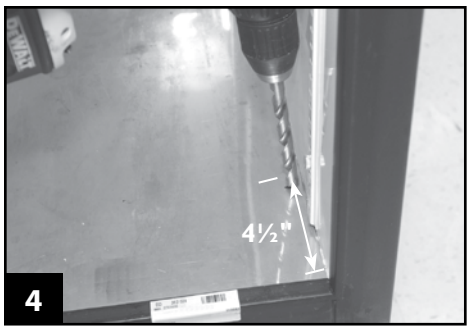
STEP 1 - Disconnect power and locate rear of cabinet. Remove lower grill with Phillips head screwdriver. Remove bulb from top of cabinet, inside door. Remove evaporator housing with 1/4" nut driver (Image 1).

NOTE: Once the cover is removed you should see the capillary tube & accumulator, if so, you are on the correct side.

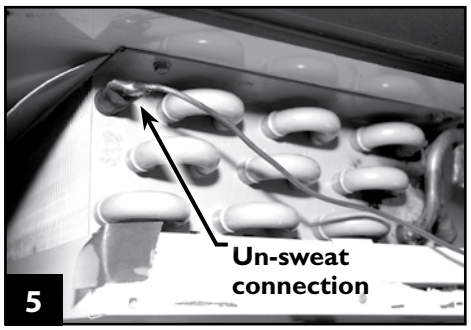
STEP 2 - Cut both red and blue wires, set aside evaporator housing (Image 2).

STEP 3 - Make a mark on the evaporator cover 21/2" in from the front of the evaporator compartment, close to the side wall. Check to be sure drill path does not interfere with any interior components and drill a 5/8" hole using the hole saw (Image 3). Insert the supplied plastic bushing into the hole.

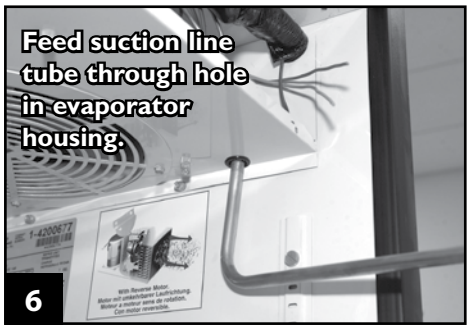




STEP 4 - Make a mark on the floor of the cabinet 41/2" in from the cabinet rear, close to the side wall. Drill a 5/8" hole using the hole saw (Image 4).



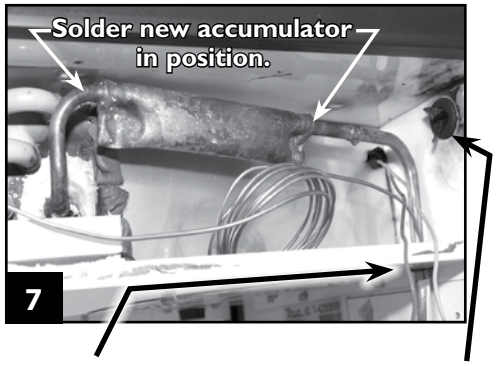
STEP 5 - Using utility knife, carefully trim black cork tape from accumulator. Un-sweat connection from accumulator to evaporator and cut copper tube 1" from side wall. Remove accumulator, pinch and seal old line. Un-sweat capillary tube connection from the evaporator and cut connection 1" from side wall (Image 5). Remove capillary tube, pinch and seal old line (Image 7).



STEP 6 - Locate new copper suction line tube and feed elbow end through plastic bushing in evaporator compartment (Image 6).

Solder replacement accumulator in position at evaporator connection and also to suction line tube (Image 7).

STEP 7 - Locate replacement capillary tube. Carefully uncoil tube and feed down through top hole in evaporator compartment, along side suction tube. Loosely measure and uncoil only enough tube to reach through the bottom hole in cabinet floor to capillary tube line at compressor. Leave the excess capillary tube in the evaporator section.



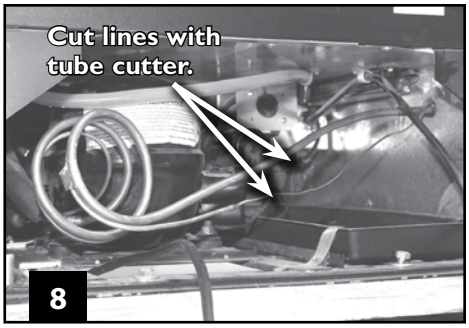
CAUTION: Do not crimp capillary tube line while uncoiling.

STEP 8 - Solder capillary tube line to evaporator and leave excess coiled in compartment.

WARNING:

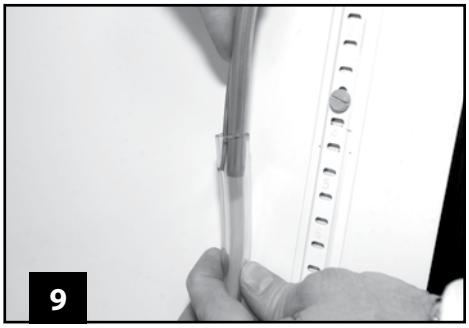
DO NOT CUT CAPILLARY TUBE LINE
length is specific to cabinet refrigeration requirements.

STEP 9 - In compressor compartment, remove or pull back the insulation from suction line. Using tube cutter, cut suction line approximately 8" from right side wall. Using a tubing cutter, cut the 3/16" liquid line 1" left of capillary tube connection, cut the old lines off at the wall and pinch the lines closed. (Images 8 and 10).



STEP 10 - Locate second copper suction line tube (straight) and line up end next to capillary tube line end. Feed tubes side by side through 5/8" clear plastic tubing. Insert into hole in cabinet floor so end of plastic tubing is approximately 1/2" above cabinet floor (Images 9 and 12). Be sure to feed enough suction line tube and capillary tubes to reach their respective connections.

NOTE: Carefully bend copper tubing towards connections without crimping or puncturing.

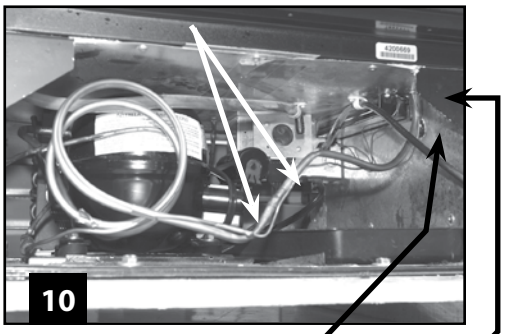


STEP 11 - Solder new capillary tube line to liquid line and new suction line to existing suction line.

STEP 12 - Line up two sections of replacement copper suction line tubes running up the side wall of cabinet. Using tube cutter, trim off excess tubing from top of lower tube to fit into upper tube swedge.

NOTE: Prior to soldering, protect cabinet surfaces from flame and melted solder.

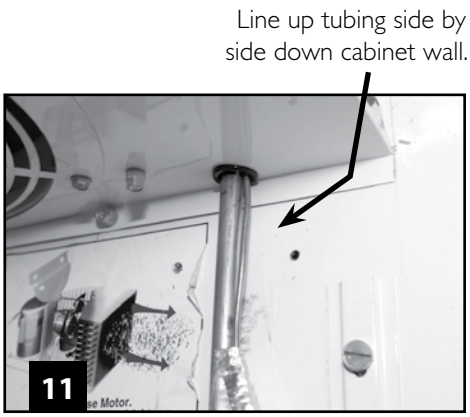
Solder pieces together.



STEP 13 - Line up capillary tube line and suction line side by side (with respect to the side wall) and bind together top to bottom with aluminum tape (Image 11).

WARNING:

To avoid damaging capillary tube line be sure it will not come in contact with the side wall or the new cover.



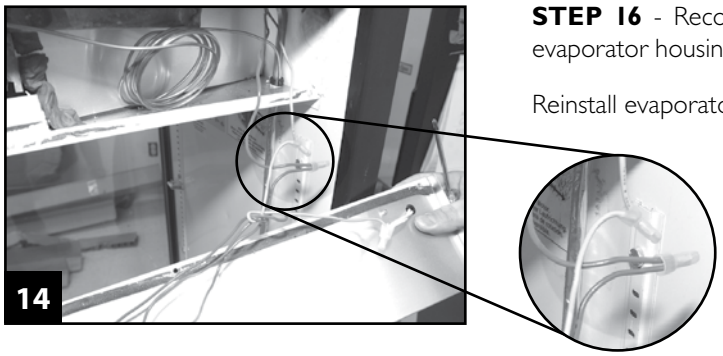

12

STEP 14 - Use sealant to plug crevices in hole through cabinet floor (Image 12).


13

STEP 15 - Locate aluminum cover and line up over copper tube lines allowing at least 1/2" from shelf standard. Install cover using eight self-tapping screws through pre-drilled holes (Image 13).

NOTE: Aluminum cover may require trimming for proper fit.


14

STEP 16 - Reconnect blue and red wires in evaporator compartment to ballast on evaporator housing with crimp connectors (Image 14).

Reinstall evaporator housing and light bulb.

STEP 17 - Reinstall insulation over copper tubing in compressor compartment and cork tape the accumulator.

Reinstall lower rear grill.