

Repair should be completed by a qualified technician. Use safety glasses/gloves. Always disconnect negative battery terminal. All refrigerant must be recovered and system brought to atmospheric pressure. Install requires 2.25" of straight line (no curved) and may add 1/4" to overall length of line.

Use tube cutter to remove damaged portion of line. Remove burrs, oxidation and any other surface contamination making sure ends of tube to be repaired are square and clean. Use **ONLY** refrigerant lubricant whenever necessary. Do **NOT** introduce foreign lubricants to the system. Study illustration closely and follow steps below in exact order they are listed.

Aluminum Tube-to-Tube SPLICE-LOK™ Repair



1. Lightly lubricate tubing ends. Slide nut and correct tubing size brass ferrule (fit will be snug) on each tube, threads and taper on ferrule facing ends of tube. Allow 1.5" of tube to stick out past ferrule.
2. Match correct seal with tubing. Lubricate and insert into body, making sure seal is seated into sealing groove, fitting squarely.
3. Slide body onto one tubing end, twisting slightly if necessary, making sure tube slides into seal and bottoms in body. Slide ferrule into body and thread nut onto end, tightening by hand only.
4. Repeat step #3 for other tubing end.
5. Using appropriate wrenches tighten one end lightly, using center to hold body in place. Repeat other end, tightening lightly, and making sure both tubes are still bottomed in body.
6. Continue to tighten each end alternately until both ends are tightened very firmly and tube nuts feel as though bottomed out.
7. Evacuate system checking for pressure loss. Retighten SPLICE-LOK™ if necessary. Reconnect battery.
8. Recharge and test system using appropriate equipment.

Aluminum Tube Block-Off SPLICE-LOK™ Repair



1. Lightly lubricate tube end. Slide nut and correct tubing size brass ferrule (fit will be snug) on tube, threads and taper on ferrule facing end of tube. Allow 1.5" of tube to stick out past ferrule.
2. Match correct seal with tubing. Lubricate and insert into block-off, making sure seal is seated into sealing groove, fitting squarely.
3. Slide block-off onto tubing end, twisting slightly if necessary, making sure tube slides into seal and bottoms in block-off. Slide ferrule into body and thread nut onto end, tightening by hand.
4. Using appropriate wrenches on both nut and block-off lightly tighten; making sure tube is bottomed in block-off.
5. Continue to tighten until tube nut feels as though it is bottomed out.

Aluminum Tube-to-Hose SPLICE-LOK™ Repair



1. Follow above instructions for the connection to the tube end of the SPLICE-LOK™ tube-to-hose union.
2. Cut the hose squarely and make sure there are no cracks or damage to the cut end.
3. Locate hose clamps within the cage in the provided slots and slip over the end of the hose until it reaches the hose end.
4. Force the end of the hose over the barbed end of the SPLICE-LOK™ tube-to-hose union until it stops against the back of the center barrel. **NOTE: Lubricate the barb and inside of hose with PAG oil to ease installation of barb into hose.**
5. Crimp the clamps using a crimping tool to complete the repair.

