NOTES:
1. ASSEMBLE FITTINGS ACCORDING TO T/A PROCEDURE NO. 002397.
2. EACH HOSE END ON CLIP-LOCK FITTINGS WILL REQUIRE ONE CLIP HOLDER AND TWO CLIPS.
3. ALL FITTINGS MUST BE LUBRICATED WITH REFRIGERANT OIL.
4. TORQUE ALL FITTINGS TO SPECIFICATIONS IN CHART BELOW.
5. MUST USE CRIMP TOOL, P/N 916176 FOR CRIMPING CLIP-LOCK FITTINGS.
6. USE CLAMPS, TYPHRS AND SCREWS PROVIDED TO SECURE HOSES TO CHASSIS, AWAY FROM ENGINE HEAT.
7. WRAP SUCTION LINE FITTINGS IN EVAPORATOR WITH NO DRIP TAPE.
8. COMPLETE CHARGING LABEL, AND APPLY TO A VISIBLE LOCATION.
9. PLACE ITEM 34 (TAMPER EVIDENT TYPR) OVER SERVICE VALVES.

NOTES: (PACKAGING)
1. PLACE ITEM 23 (O-RING) INTO PLASTIC BAG.
2. PLACE ITEM 28 (SCREWS) INTO OTHER PLASTIC BAG.
3. PLACE ALL ITEMS INTO BOX WITH A COPY OF THIS DRAWING AND IDENTITY BOX WITH PART NUMBER & REVISION LEVEL.

OEM DASH EVAPORATOR
OEM LIQUID LINE #8 HOSE
OEM SUCTION LINE
OEM DISCHARGE LINE

ORIGINAL EQUIPMENT RADIATOR-CONDENSER AREA: O.E.M. DISCHARGE LINE WAS CONNECTED TO O.E.M. RADIATOR-CONDENSER

FTG TORQUE REQUIREMENTS
3/8 FTG 11-13 FT-LBS.
1/2 FTG 15-20 FT-LBS.
5/8 FTG 21-27 FT-LBS.
3/4 FTG 28-33 FT-LBS.

GAS LINE #10 HOSE
LIQUID LINE #8 HOSE
LIQUID LINE #8 HOSE
DISCHARGE LINE #10 HOSE

COMP.
O.E.M. LIQUID LINE
O.E.M. SUCTION LINE
O.E.M. DISCHARGE LINE

REUSE OEM NUT

117009 TYPHR, TAMPER EVIDENT, BLUE W/ T/A LOGO
117009 THREADLOCK, NON-REMOVABLE
810002 TAPE, NO DRIP T-3/4 X 3/4" INSULATED
616760 SCREW, SELF TAP, #10 X 3/4" X 3/4"
616761 BOLT, HEX FLANGE, M-1.25 X 55MM
976533 LABEL, R-134A, CARE/CAUTION
911009 BOLT, M-10 X 1.25
313620 FTG, CLIP-LOCK, 45°, 1/2 F.O. X 3/8 HOSE
313621 FTG, CLIP-LOCK, 90°, 3/4 F.O. X 1/2 HOSE
117002 TYPHR, TAMPER EVIDENT, BLUE W/ T/A LOGO
810002 TAPE, NO DRIP T-3/4 X 3/4" INSULATED
616760 SCREW, SELF TAP, #10 X 3/4" X 3/4"
616761 BOLT, HEX FLANGE, M-1.25 X 55MM
313488 FTG, STR, FORO PEANUT X #8 MNC
313527 FTG, CLIP-LOCK, 45°, 1/2 F.O. X 1/8 HOSE
313518 FTG, CLIP-LOCK, 90°, 5/8 M.O. X 1/2 HOSE
313514 FTG, CLIP-LOCK, 90°, 3/4 M.O. X #8 HOSE
313519 FTG, CLIP-LOCK, STR, 3/4 F.O. X 1/2 HOSE
313512 FTG, CLIP-LOCK, STR, 3/4 M.O. X #8 HOSE
313511 FTG, CLIP-LOCK, 90°, 1/2 F.O. X #8 HOSE
313522 FTG, CLIP-LOCK, TEE, #8 X #8 X #8 HOSE
313513 FTG, CLIP-LOCK, STR, 5/8 M.O. X #10 HOSE
313510 FTG, CLIP-LOCK, 90°, 5/8 F.O. X #10 HOSE

WRITING AND DRAWING

COMMENTS:

Multiple revisions of this drawing may exist. To ensure you have the correct revision for your application, please contact Trans/Air (717-246-2627) before printing or use.

Trans/Air Mfg Corp
Piping Installation, 2004 Ford Tie-In, Skirt Condenser
Trans/Air Clip-Lock

Trans/Air 503930