

Application Guidelines

Copeland™ Scroll
Variable-Speed Compressors
for R32 Applications
YPV030* & YPV038*



COPELAND™

 **EMERSON™**

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About these guidelines

The purpose of these guidelines is to provide guidance in the application of Copeland™ scroll variable-speed compressors in users' systems. They are intended to answer the questions raised while designing, assembling and operating a system with these products.

Besides the support they provide, the instructions listed herein are also critical for the proper and safe functioning of the compressors and motor control drives. The performance and reliability of the product may be impacted if the product is not used according to these guidelines or is misused.

These application guidelines cover stationary applications only. For mobile applications, please contact the Application Engineering department at Emerson as other considerations may apply.

1 Safety instructions

Copeland scroll variable-speed compressors are manufactured according to the latest relevant European and US safety standards. Particular emphasis has been placed on the user's safety.

The YPV030/038 variable-speed compressors are intended for installation in systems in accordance with the European Machinery Directive MD 2006/42/EC, the Pressure Equipment Directive PED 2014/68/EU, the Low Voltage Directive LVD 2014/35/EU and the Electromagnetic Compatibility Directive EMC 2014/30/EU. They may be put to service only if they have been installed in systems according to instructions and conform to the corresponding provisions of legislation.

NOTE: Only dedicated compressors are allowed to be used with flammable refrigerants. Emerson marks all compressors that are qualified for flammable refrigerants with a sticker indicating the usage of such refrigerants. Systems using flammable refrigerants must be executed correctly while observing safety rules, as specified in corresponding safety standards such as, but not limited to EN 378. They must comply with any and all applicable legislation and regulations. Ensuring compliance remains the user's responsibility.

The Material Safety Datasheet (MSDS) for individual A2L refrigerants shall be checked and considered when working with such refrigerants. The MSDS is provided by the gas supplier.

These instructions shall be retained throughout the lifetime of the compressor and the drive.

You are strongly advised to follow these safety instructions.

1.1 Icon explanation

	WARNING This icon indicates instructions to avoid personal injury and material damage.		Fire hazard This icon indicates a risk of flammable atmosphere.
	High voltage This icon indicates operations with a danger of electric shock.		CAUTION This icon indicates instructions to avoid property damage and possible personal injury.
	Danger of burning or frostbite This icon indicates operations with a danger of burning or frostbite.		IMPORTANT This icon indicates instructions to avoid malfunction of the compressor.
	Explosion hazard This icon indicates operations with a danger of explosion.		NOTE This word indicates a recommendation for easier operation.
	Danger of explosive atmosphere This icon indicates a risk of explosive atmosphere.		

1.2 Safety statements

- Refrigerant compressors must be employed only for their intended use. The system has to be labelled according to the applicable standards and legislation.
- Only qualified and authorized RACHP (refrigeration, air conditioning and heat pump) personnel are permitted to install commission and maintain this equipment. Only competent personnel (as specified in EN 13313) qualified for flammable refrigerant handling is permitted to commission, initiate and maintain the compressor/refrigeration systems; non-trained personnel, including the user, are not allowed to do so and must call on an expert.
- The maximum refrigerant charge is specified in standards such as, but not limited to EN 378, EN 60335-2-40 and EN 60335-2-89. The system designer shall implement all safety measures defined by the applicable standards and the maximum refrigerant charge shall not be exceeded.
- If a flammable atmosphere is detected, immediately take all necessary precautions to mitigate the risk as determined in the risk assessment.
- Electrical connections must be made by qualified electrical personnel.
- All valid standards for connecting electrical and refrigeration equipment must be observed.
- The national legislation and regulations regarding personnel protection must be observed.



Use personal safety equipment. Safety goggles, gloves, protective clothing, safety boots and hard hats should be worn where necessary.

1.3 General instructions



WARNING

Pressurized system! Serious personal injuries and/or system breakdown! Accidental system start before complete set-up must be avoided. Never leave the system unattended without locking it out electrically when it is on vacuum and has no refrigerant charge, when it has a holding charge of nitrogen, or when the compressor service valves are closed.



WARNING

System breakdown! Personal injuries! Only approved refrigerants and refrigeration oils must be used.



WARNING

Earth leakage current! Danger of electric shock! This product can cause both AC and DC earth leakage current. To protect against both kinds of leakage current it is recommended to use an AC/DC sensitive RCD on the power supply side.



WARNING

High voltage! Danger of electric shock and/or system breakdown! Disconnect and lock out power before servicing. Allow drive components to electrically discharge before servicing. Respect the time according to drive application guidelines before servicing the drive. Use compressor with grounded system only. Refer to original equipment wiring diagrams. Electrical connections must be made by qualified electrical personnel.



WARNING

High shell temperature! Burning! Do not touch the compressor or piping until they have cooled down. Ensure that other materials in the area of the compressor do not come into contact with it. Lock and mark accessible sections.



CAUTION

Contact with POE! Material damage! POE lubricants must be handled carefully and the proper protective equipment (gloves, eye protection, etc.) must be used at all times. POE must not come into contact with any surface or material that it might damage, including without limitation, certain polymers, eg, PVC/CPVC and polycarbonate.

**CAUTION**

Overheating! Bearing damage! Do not operate compressor without refrigerant charge or without it being connected to the system.

**IMPORTANT**

Transit damage! Compressor malfunction! Use original packaging. Avoid collisions and tilting.

2 Product description

2.1 Compressor range

These application guidelines deal with Copeland™ scroll variable-speed compressor models YPV030 & YPV038 for use with R32. These compressors are intended for use in air-conditioning applications. They have a speed range of 1200 to 7200 revolutions per minute, corresponding to 20 up to 120 Hz. They feature a three-phase brushless permanent magnet (BPM) motor.

NOTE: Motor parameters for a drive configuration are available on request from your local Application Engineering representative.

Compressor	Cooling capacity with R32			
	2400 rpm	3000 rpm	4500 rpm	5400 rpm
YPV030	3.44	4.63	7.73	9.58
YPV038	5.03	6.54	10.20	12.35

Table 1: Cooling capacity in kW at below conditions

Conditions:

Evaporating dew temperature.... -7 °C
Suction gas superheat..... 5 K

Condensing dew temperature ..50 °C
Condenser sub-cooling5 K



The control system must include discharge temperature protection, current overload protection, and a soft start-and-stopping routine. Stator heat control when cold start is also recommended for optimal performance and reliability. It should also include the operating map parameters. Contact the Application Engineering department at Emerson for compressor motor specifications and speed adjustment requirements.

It is important to ensure correct wiring at both the compressor and drive connections prior to starting the compressor to avoid miswiring or powered reverse situation. Both situations could potentially cause compressor damage.

Figure 1: YPV* compressor

2.2 Compressor nomenclature

The compressor model designation contains the following technical information:

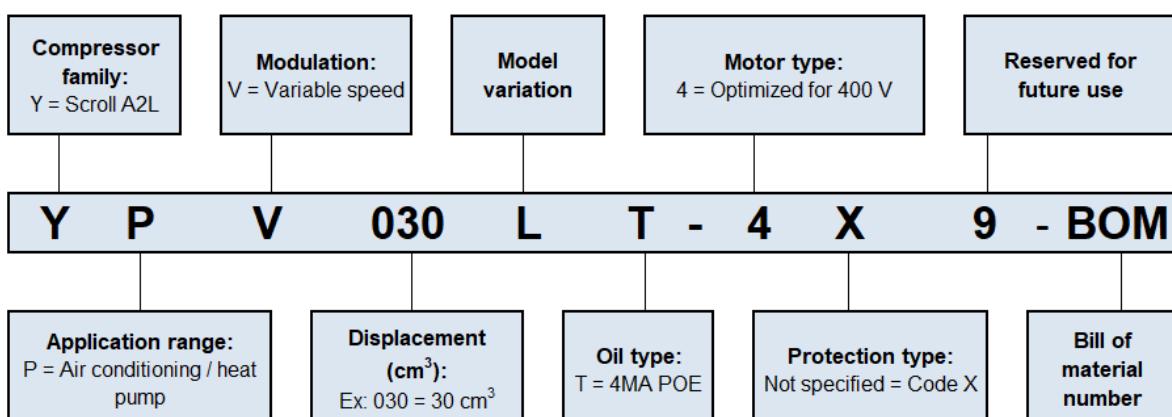


Figure 2: Compressor nomenclature

2.3 Application considerations

2.3.1 Qualified refrigerant and oil

Oil recharge values can be taken from Copeland scroll compressors brochures or Copeland Select software available at www.climate.emerson.com/en-gb.

Compressors	YPV030, YPV038
Qualified refrigerant	R32
Standard & servicing oil	4MA POE

Table 2: Qualified refrigerant and oil

NOTE: R32 is classified as A2L (mildly flammable) refrigerant.

2.3.2 PED category and maximum allowable pressure PS

The YPV030/038 compressors covered in these guidelines are PED Class 2, according to the Pressure Equipment Directive PED 2014/68/EU.

The pressure PS is the maximum allowable pressure at the low- and high-pressure sides of the compressor. The maximum pressure value PS for the individual compressor type is printed on the nameplate of the compressor. Safety is established in compliance with the relevant standards applicable to the given product.

Compressor	PS High-pressure side	PS Low-pressure side	TS Low-pressure side (min)	PED Class
YPV030 YPV038	43.3 bar(g)	28 bar(g)	-35 °C	2

Table 3: Maximum allowable pressures, TS low-pressure side and PED category

2.3.3 Admissible temperature and relative humidity ranges

The scroll compressor must comply with the ambient temperature and humidity ranges specified in **Table 4** below, both for storage and in operation.

Compressor	Min/max relative humidity	Min/max ambient temperatures in storage or at standstill	Min/max ambient temperatures in operation
YPV030 YPV038	30 % / 95 % No condensing	-35 °C / 50 °C	-35 °C / 46 °C

Table 4: Acceptable ambient temperature and humidity ranges for the compressor

2.3.4 Application limits – Operating envelopes

CAUTION



Inadequate lubrication! Compressor breakdown! Copeland scroll compressors are qualified for operation inside the envelope published by Emerson. The envelope is defined according to Emerson's testing and experience. Operating a compressor outside the envelope might lead to compressor failure which would be the system manufacturer's responsibility.

The superheat at the compressor suction inlet must always be sufficient to ensure that no refrigerant droplets enter the compressor. For a typical evaporator-expansion valve configuration a minimum stable superheat of at least 5 K is required. In the same way, the superheat at the compressor suction must always stay below a maximum limit specified by Emerson, depending on the model and for which the operating envelope is defined.

The operating envelopes of the YPV030/038 compressors depend upon the running speed. The envelope limitations are mainly related to lubrication and power limitation. They are shown in **Figure 3** below.

The lower right boundary of the operating envelope is the minimum compression ratio required to keep the scrolls loaded. Operation below this boundary could result in the compressor intermittently loading and unloading and noisy operation.

The upper left boundary of the envelope represents the maximum compression ratio. If the operating condition approaches this boundary the compressor discharge temperature will begin to approach the maximum scroll temperature allowed by the discharge line temperature sensor – see details in **section 3.6 "Discharge gas temperature protection"**. The temperature sensor must signal the drive or system unit controller to shut down if the discharge line temperature exceeds the specified temperature on the operating envelope.

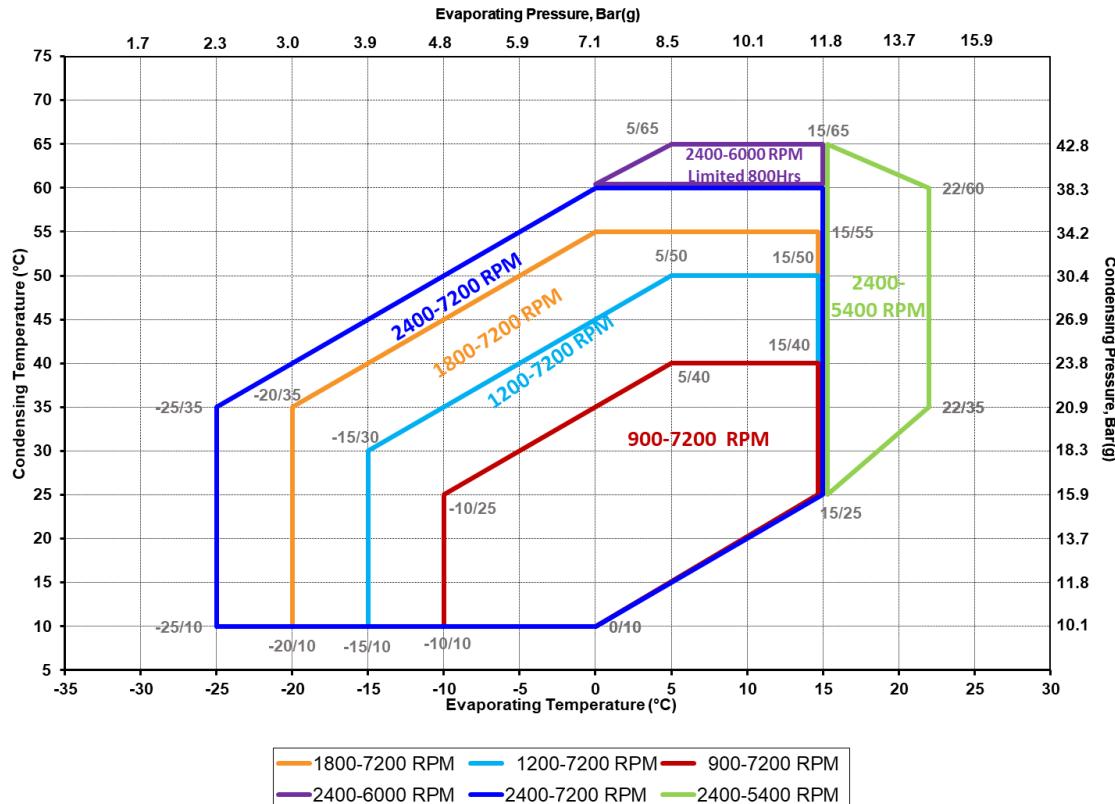


Figure 3: Operating envelope for YPV030/038 compressors with R32

For DLT-control mode with YPV* compressors in the upper left boundary of the envelope, please also refer to **section 2.3.5 "Discharge line temperature control mode"**.

Please consider the following about operating envelopes:

- An oil return test for the system must be performed. If required, the system design must be improved to ensure sufficient oil return from the system to the compressor – also see **section 5.14 "Oil level"**.
- At start-up the system should be able to bring the compressor to a point inside the envelope as fast as possible and to keep the compressor running there. Running outside the envelope is not allowed. Emerson's recommendation is to start with a speed of 3000 rpm and to freeze the speed for minimum 30 seconds or longer until the system is in stable operation – see **Figure 4 "Ramp up"**.
- Running/oscillating the compressor in and out of the envelope borders is not allowed and should be avoided.
- Running the compressor below the envelope at low condensing temperatures is possible for no longer than 30 minutes but the user must be aware that unloading noise from the compressor can occur. In this area the speed limits according to the evaporating temperatures in the envelope should be respected.
- The qualified application envelope will change with the compressor speed. At all operating conditions the minimum and maximum speed limits according to **Figure 3** have to be respected. With changing operating conditions, the speed limits have to be determined by linear interpolation between the limits given in **Figure 3** – also see speed limits animation in Select software available at www.climate.emerson.com/en-gb.
- Fast speed changes can cause instable control, eg., on the superheat control. Per Emerson experience speed changes should be in the range of 10 to 60 rpm/s depending on the system reaction.

- The user should adequately take care of controlling the envelope.
- To stop the compressor, reduce the speed to 3000 rpm then stop the compressor – see **Figure 4 "Controlled shutdown"**.

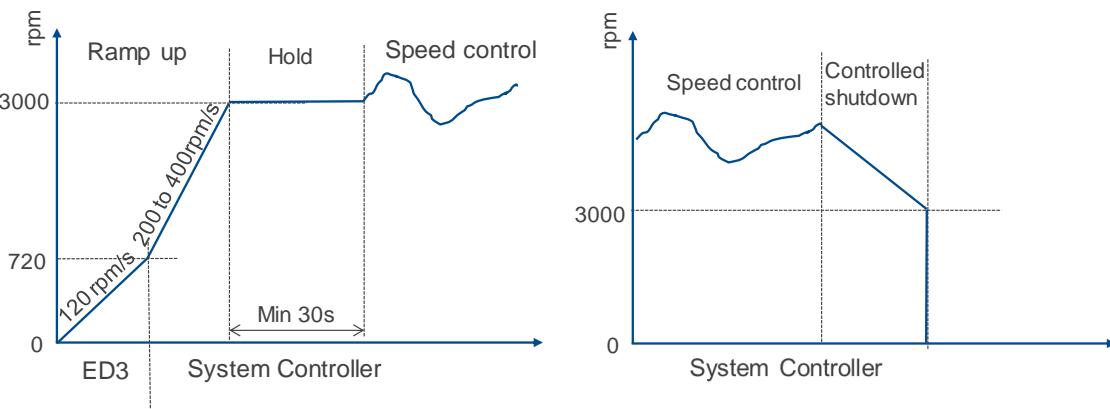


Figure 4: Ramp-up and controlled shutdown

2.3.5 Discharge line temperature control mode

In the lower part of the envelope (Control Suction Superheat) shown below the suction gas at the compressor inlet has to be superheated without liquid droplets. For superheat requirements please also refer to **section 2.3.4 "Application limits – Operating envelopes"**.

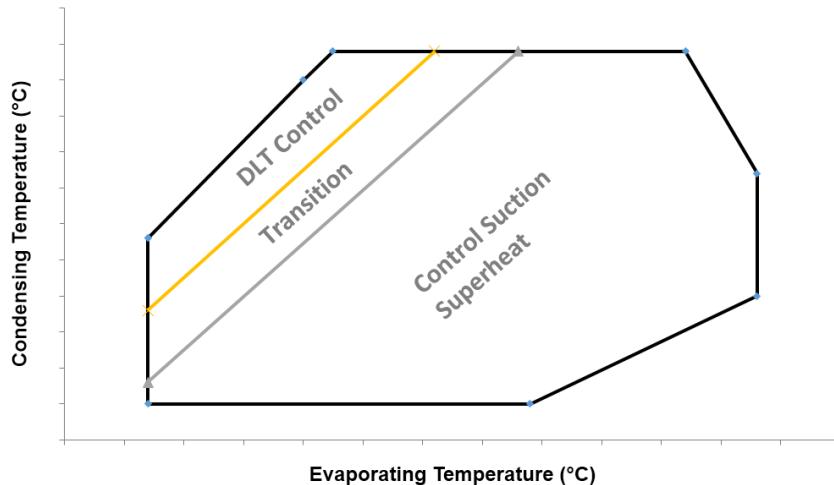


Figure 5: Schematics of expansion valve control mode

In the upper part of the envelope (DLT Control) with operation at low evaporating and high condensing with superheat control mode, the discharge temperature will exceed the limit of 125 °C inside the application envelope – also see **section 3.14 "Suction line accumulators"**. In this area, the expansion valve of the evaporator is to be controlled not by superheat but by the discharge line temperature so that some liquid droplets return to the compressor to cool it down. The discharge line temperature DLT must be controlled to stay between minimum 115 °C and maximum 125 °C.

The move from superheat control to DLT control is demand-driven by the discharge line temperature. In the transition phase DLT control and superheat control have to be balanced by the system controller. The superheat at compressor inlet should be reduced gradually to 0 K. As the demand to move to DLT control depends, eg, on system design such as compressor insulation and ambient temperature, there is no specified line at which this will happen.

2.3.6 Oil recovery

For oil return, the exact parameters for an oil recovery cycle need to be evaluated by oil return tests for each system, as they may differ depending on system application. Please contact and review with Application Engineering at Emerson for any desired change to the oil recovery cycle requirements.

The Compressor Oil Circulation Rate varies with the running speed. **Figure 6** shows the safe oil level for compressor operation. **The compressor oil level must be higher than the minimum oil level when the compressor is running**. Oil return testing is required to evaluate if additional oil or an oil

separator is needed especially for applications with multiple evaporators (VRF), long system piping and below 2400 rpm running speed.

The influence of liquid refrigerant floodback on oil level must also be considered. When the compressor is running, liquid refrigerant floodback to the compressor will accelerate the compressor oil pump flow rate. Continuous liquid refrigerant floodback may result in an oil level lower than the minimum acceptable oil level. Increasing the suction superheat to reduce liquid refrigerant flooded back is helpful in ensuring proper oil level for compressor reliability.

Emerson can provide compressor samples with sight tubes and/or sight glasses for monitoring oil levels during system development. The pressure used for leak checking of compressor sample with sight tubes and/or sight glasses must not be higher than 10 bar. Please consult with Emerson Application Engineering for detailed suggestions about safety oil level of system and safety requirement of compressor sample with sight tubes and/or sight glasses.

The compressor also needs to raise up the speed to 3600 rpm and to run at 3600 rpm for 5 minutes if it has run at a speed below 2000 rpm for 2 hours.

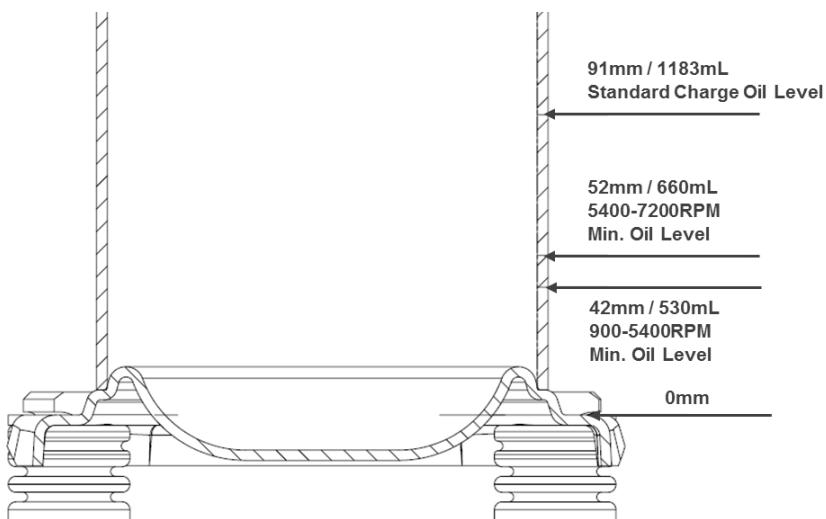


Figure 6: Oil level in YPV030/038 compressors

2.4 Compressor design

2.4.1 Compressor dimensions

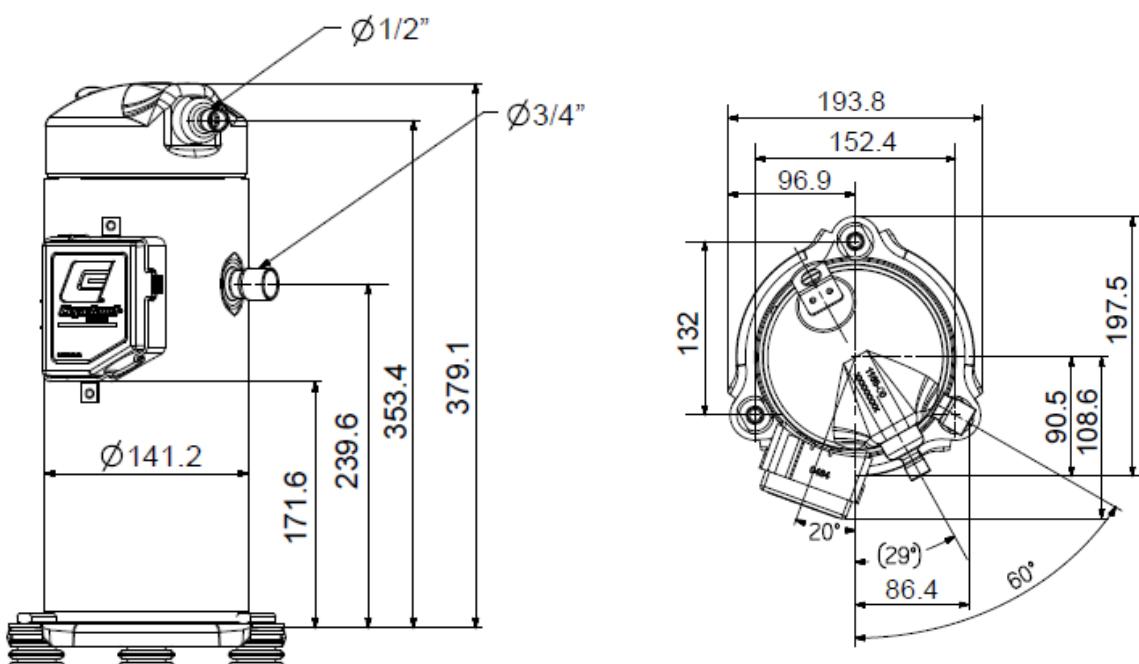


Figure 7: External dimensions of compressor models YPV030/038

2.4.2 Compressor features

The variable-speed scroll compressors YPV030/038 have a number of design features that improve efficiency and reliability.

All YPV* compressors are equipped with a positive displacement oil pump to ensure an adequate supply of oil to the bearing system throughout the operating speed range.

The motor in the variable speed-scroll is a three-phase, brushless permanent magnet (BPM) design coupled with a rotor embedded with high energy magnets. The input voltage is a series of +DC pulses, spaced in time to create an alternating current frequency.

3 Installation



WARNING

High pressure! Injury to skin and eyes possible! Be careful when opening connections on a pressurized item.



IMPORTANT

The compressor mounting area must be in **Zone 2** or outside of any ATEX zone and in line with the requirements of "**Pollution Degree 3**" classification.

3.1 Compressor and drive handling



WARNING

Static electricity! Personal injuries! Personnel handling the drives in a manufacturing plant environment should guard against static electricity by using the appropriate equipment, eg, antistatic wrist straps and mats.

3.1.1 Compressor transport and storage



WARNING

Risk of collapse! Personal injuries! Move compressors only with appropriate mechanical or handling equipment according to weight. Keep in the upright position. Respect stacking loads according to **Figure 8**. Check the tilting stability and if needed take action to ensure the stability of the stacked loads. Keep the packaging dry at all times.



Respect the maximum number of identical packages which may be stacked on one another, where "n" is the limiting number:

- **Transport: n = 1**
- **Storage: n = 2**

Figure 8: Maximum stacking loads for transport and storage

The compressor tilt angle should not exceed 30° during transport and handling. This will prevent oil from exiting through the suction stub. A tilt angle of maximum 45° is allowed for a very short time. Tilting the compressor more than 45° might affect its lubrication at start-up.

3.1.2 Compressor positioning and securing



IMPORTANT

Handling damage! Compressor malfunction! Only use the lifting eyes whenever the compressor requires positioning. Using discharge or suction connections for lifting may cause damage or leaks.

The compressor should be kept vertical during handling.

The discharge connection plug should be removed first before pulling the suction connection plug to allow the dry air pressure inside the compressor to escape. Pulling the plugs in this sequence prevents oil mist from coating the suction tube making brazing difficult. The copper-coated steel suction tube should be cleaned before brazing.

The compressor plugs must be removed as late as possible before brazing so that the air humidity does not affect the oil characteristics.

As oil might spill out of the suction connection located low on the shell, the suction connection plug must be left in place until the compressor is set into the unit.

No object, eg, a swaging tool should be inserted deeper than 51 mm into the suction tube as it might damage the suction screen and motor.

3.1.3 Installation location

Ensure the compressors are installed on a solid level base. For single compressor applications, the compressor tilt angle during operation should not exceed 15° to allow adequate lubrication. For multiple compressor parallel configurations, the compressors must be positioned completely vertically on a totally horizontal surface or rail.

3.2 Mounting parts

The compressors are designed to be mounted on vibration absorber grommets (part of the standard delivery). The grommets dampen the start-up surge of the compressor and minimise sound and vibration transmission to the compressor base during operation. The metal sleeve inside is a guide designed to hold the grommet in place. It is not designed as a load-bearing member, and application of excessive torque to the bolts can crush the sleeve. Its inner diameter is approximately 8.5 mm to suit a M8 screw. The mounting torque should be 13 ± 1 Nm. It is critically important that the grommet is not compressed.

Mounting parts YPV030/038 – Soft mountings

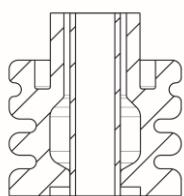


Figure 9: Rubber mounting part with sleeve

NOTE: For more information please refer to Technical Information C7.11.2 "Scroll Mounting Parts".

3.3 Brazing procedure



WARNING

Air/flammable refrigerant mixture! Creation of a potentially flammable atmosphere! Fire hazard! Remove all refrigerant before opening the system. When working on a refrigerant-filled system, make sure to follow the safety and working instructions given in Chapter 6 "Maintenance & repair".



WARNING

High temperature! Burning! Proceed with caution when brazing system components. Do not touch the compressor until it has cooled down. Ensure that other materials in the area of the compressor do not come into contact with it.



IMPORTANT

Blockage! Compressor breakdown! Maintain a flow of oxygen-free nitrogen through the system at very low-pressure during brazing. Nitrogen displaces the air and prevents the formation of copper oxides in the system. If allowed to form, the copper oxide material can later be swept through the system and block screens such as those protecting capillary tubes, thermal expansion valves, and accumulator oil return holes.

Contamination or moisture! Bearing failure! Do not remove the plugs until the compressor is set into the unit. This minimises any entry of contaminants and moisture.

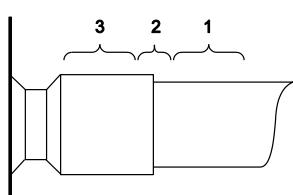


Figure 10: Suction tube brazing areas

Copeland scroll compressors have copper-plated steel suction and discharge tubes. These tubes are far more robust and less prone to leaks than copper tubes. Steel and copper have different thermal properties; this must be taken into account when considering brazing procedures.

Refer to Figure 10 and procedure below for the brazing of the stub tube connections of a scroll compressor.

- For systems with flammable A2L refrigerant, it is mandatory to flush oxygen-free nitrogen through the piping during the brazing process.
- The copper-coated steel tubes on scroll compressors can be brazed in approximately the same manner as any copper tube.
- Recommended brazing materials: any Silfos material is recommended, preferably with a minimum of 5 % silver. However, 0 % silver is acceptable.
- Be sure tube fitting inner diameter and tube outer diameter are clean prior to assembly.
- Using a double-tipped torch, apply heat in area 1.
- As the tube approaches brazing temperature, move the torch flame to area 2.
- Heat area 2 until braze temperature is attained, moving the torch up and down and rotating around the tube as necessary to heat the tube evenly. Add braze material to the joint while moving the torch around the joint to flow braze material around the circumference.
- After the braze material flows around the joint, move the torch to heat area 3. This will draw the braze material down into the joint. The time spent heating area 3 should be minimal.
- As with any brazed joint, overheating may be detrimental to the final result.

NOTE: Since the discharge stub contains a check valve, care must be taken not to overheat it to prevent brazing material from flowing into it.

NOTE: YPV030/038 compressors include a suction funnel to guide the suction gas internally directly to the scrolls. Since the funnel is made of plastic, a wet rag or any other suitable heat protection must be used when brazing the suction line to the compressor.



Figure 11: Suction funnel (purple part) in YPV* compressors

3.4 Pressure protection devices

3.4.1 High-pressure protection

Applicable regulations and standards, for example EN 378-2, shall be followed to apply appropriate control and ensure that the pressure never exceeds the maximum pressure limit.

High-pressure protection is required to stop the compressor operating outside the allowable pressure limit. The high-pressure control must be installed correctly, which means that no service valve is allowed between the compressor and the pressure protection.

The high-pressure cut-out setting shall be determined according to the applicable standard, the type of system, the refrigerant and the maximum allowable pressure PS.

3.4.2 Low-pressure protection



WARNING

Operation below ambient pressure! Fire hazard! During operation below ambient pressure, a flammable mixture can form inside the system. Make sure that air does not enter the system.



IMPORTANT

Operation outside the application envelope! Compressor breakdown! A low-pressure protection shall be fitted in the suction line to stop the compressor when it operates outside the envelope limits.

Applicable regulations and standards shall be followed to apply appropriate control and ensure that the pressure is always above the required minimum limit.

In order to avoid any air entering the system during operation, make sure that the system pressure never falls below atmospheric pressure. If it does, immediately de-energize the power supply of the compressor and check the cause of the low pressure before restarting the compressor.

Emerson requires that YPV* compressors be fitted with a low-pressure control, with no service valve between the low-pressure side and the pressure control.

For hermetically sealed system, in the case the approved application envelope is below atmospheric pressure, the following rules shall be observed:

- valid only for hermetically sealed systems – see safety standards for definition;
- the minimum absolute pressure is 0.5 bar;
- a discharge temperature control is mandatory to stop the compressor when the maximum discharge temperature is exceeded – see **section 3.6 "Discharge gas temperature protection"**.

3.5 Crankcase heating function



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard!

Incorrect wiring during installation or service could create a spark on the connection.



CAUTION

Overheating and burnout! Compressor damage! Never apply power to the crankcase heater in free air, before the crankcase heater is installed on the compressor or when it is not in complete contact with the compressor shell.



IMPORTANT

Oil dilution! Bearing malfunction! Follow the off-cycle migration statement described below for long term reliability and to minimize nuisance associated with flooded start conditions.

Contrary to standard fixed-speed scroll compressors, the YPV030/038 models do not require any optional external crankcase heater to be mounted on the compressor.

Instead this function can be achieved by a drive with a programmable feature that will utilize the motor windings to provide up to 50 Watts DC of heating to serve as a crankcase heater.

The crankcase heating function activation is required when the system charge exceeds the refrigerant charge limit indicated in **Table 5** below:

Compressor	Refrigerant charge limit
YPV030/038	3.6 kg

Table 5: Refrigerant charge limit

If this function is required and no off-cycle migration testing across the envelope for winter and summer situations is performed, the crankcase heating function must always be powered to 50 Watts when the compressor is off.

To use less than 50 Watts, off-cycle migration testing must be performed. To perform migration testing, a sample compressor fitted with a sight tube showing the oil level and any accumulation of liquid in the compressor is required and can be ordered from Emerson.

NOTE: At first start, the crankcase heating function must be turned on a minimum of 12 hours prior to starting the compressor.

3.6 Discharge gas temperature protection



IMPORTANT

Overheating and inadequate lubrication! Compressor damage! YPV* compressors must be equipped with an external discharge gas temperature protection.

A good system control should prevent the system from operating outside the published operating envelope and acceptable superheat range, whatever the climatic conditions and the heating demand. However, under some extreme operating conditions (such as loss of charge or improper control operation), the internal discharge gas temperature reached can cause compressor damage. To guarantee positive compressor protection, discharge gas temperature protection is required for any application with Copeland brand compressors. This protection must not be used as an operating envelope controller but as a safety device.

The maximum discharge gas temperature is 125 °C for models YPV030/038.

YPV* compressors do not have an internal discharge temperature protection. In order for the drive to operate properly a thermistor must be attached to the compressor discharge line less than 12 cm from the compressor discharge fitting. For best response the sensor must be insulated and placed in a sleeve braced on the discharge pipe – see **Figure 12**. If thermal compound is used to improve the heat transfer from sleeve to sensor, make sure it is approved for these temperatures. Also protect the sensor from being removed from its position by transport; vibration or any other incident. Refer to the operating map for maximum operating discharge line temperatures.

The discharge line temperature must be limited to 125 °C.

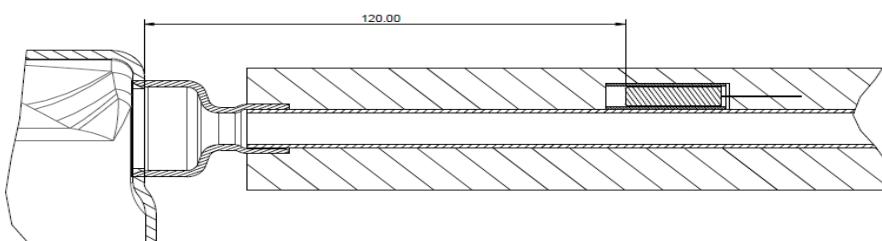


Figure 12: Discharge temperature sensor mounting

3.7 Filter screens



CAUTION

Screen blocking! Compressor breakdown! Use screens with at least 0.6 mm openings.

The use of screens finer than 30 x 30 meshes (0.6 mm openings) anywhere in the system should be avoided with these compressors. Field experience has shown that finer mesh screens used to protect thermal expansion valves, capillary tubes or accumulators can become temporarily or permanently plugged with normal system debris and block the flow of either oil or refrigerant to the compressor. Such blockage can result in compressor failure.

3.8 Mufflers

Gas flow through scroll compressors is continuous with relatively low pulsation. External mufflers may not be required on Copeland scroll compressors. Due to system variability, individual tests should be conducted by the system manufacturer to verify acceptable levels of sound and vibration.

If adequate attenuation is not achieved, use a muffler with a larger cross-sectional area to inlet area ratio. A ratio of 20:1 to 30:1 is recommended. A hollow shell muffler will work quite well. Locate the muffler at minimum 15 to maximum 45 cm from the compressor for the most effective operation. The farther the muffler is placed from the compressor within these ranges, the more effective. Choose a muffler with a length of 10 to 15 cm.

3.9 Sound shell

No sound shell attenuation for YPV* compressors is available from Emerson at this time. If a sound shell is needed, particular attention shall be paid to the electrostatic charge of the material, which could be a potential ignition source.

3.10 Insulation material

Insulation material is commonly used in a system to insulate the suction line, suction accumulator, expansion valve bulb or discharge line thermostat. When choosing the insulation material for A2L applications, particular attention shall be paid to its non-electrostatic properties, as it could be a potential ignition source.

3.11 Reversing valves

A variable-speed scroll brings a significant benefit during the defrost cycle. By taking advantage of the higher speeds and flow rates, the defrost time will typically be shorter than in a fixed-speed compressor system, which will reduce the time electric resistance heat is used during the defrost cycle.

Caution: Reversing valve sizing must be within the guidelines of the valve manufacturer. The pressure drop required to ensure valve shifting must be measured throughout the operating range of the unit and compared to the valve manufacturer's data. Low ambient heating conditions with low flow rates and low pressure drop across the valve can result in a valve not shifting. This can lead to a condition where the compressor appears not to be pumping, ie, balanced pressures. It can also cause elevated compressor sound levels.

Since Copeland scroll compressors have a very high volumetric efficiency their displacements are lower than those of equivalent capacity reciprocating compressors. As a result, Emerson recommends that the capacity rating on reversing valves be no more than 1.5 to 2 times the nominal capacity of the compressor in order to ensure proper operation of the reversing valve under all operating conditions.

During a defrost cycle, when the reversing valve abruptly changes the refrigerant flow direction, the suction and discharge pressures will go outside of the operating envelope. The condition will usually cross the diagonal line representing the lower right-hand side corner of the envelope. The sound that the compressor makes during this transition period is normal, and the duration of the sound will depend on the coil volume, outdoor ambient and system charge.

The preferred method of mitigating defrost sound for the variable-speed scroll is to signal the drive to go to low speed when a defrost signal is received from the system. When low speed is reached, the reversing valve is signalled to change positions. The system should be allowed to operate for 30 to 60 seconds at low speed for the suction and discharge pressures to stabilize. After 30 to 60 seconds the compressor speed should be increased to some predetermined speed based on the outdoor ambient temperature. The routine at the end of the defrost cycle should be similar. The above method is a suggestion and the system design engineer should develop the routine that best mitigates compressor sound during defrost while ensuring a defrost cycle that is as short as possible.

The reversing solenoid valve should be wired so that the valve does not reverse when the system is shut off by the system controller in the heating or cooling mode. If the valve is allowed to reverse at system shut-off, suction and discharge pressures are reversed to the compressor. This results in a condition of system pressures equalizing through the compressor which can cause the compressor to slowly rotate until the pressures equalise. This condition does not affect compressor durability but can cause unexpected sound after the compressor is turned off.

3.12 Sound and vibration



WARNING

Vibrations! Creation of a flammable atmosphere! Carefully check the system for vibrations in applications with A2L refrigerants.

Vibrations during compressor operation can cause cracks which could lead to refrigerant leakage. This situation must be avoided by the system manufacturer/installer. To this end, the pipework must be carefully designed when connecting a scroll compressor to a system.

A scroll compressor makes both a rocking and twisting motion and enough flexibility must be provided in the pipelines to allow starting, stopping and steady state running of the compressor without transmitting excessive stress into any line attached to the unit. In a split system, the most important goal is to ensure minimal vibration in all directions to avoid transmitting vibrations to the structure to which the lines are fastened.

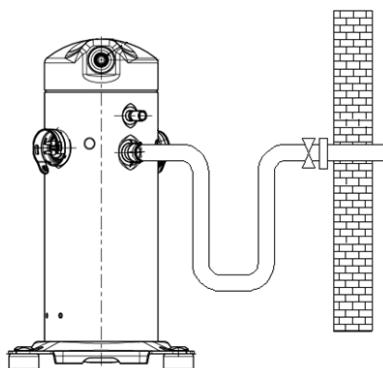


Figure 13: Flexible tube design

Under some conditions, the Copeland scroll has a normal starting rotational motion that can transmit a transient noise along the lines. This may be particularly pronounced in compressors using a three-phase motor due to their inherently higher starting torque. This phenomenon, like the one described previously, can easily be avoided by using standard line isolation techniques.

Since the variable-speed scroll has a broad running frequency range (15-120 Hz), it is almost impossible to avoid all of the natural frequencies that may exist in the system piping. The system designer must carefully evaluate these resonant frequency conditions and either a) avoid them by not allowing the compressor speed to align with the resonant frequency, or b) evaluate the risk and life of the piping system when the compressor is allowed to run at frequencies that are coincident with the natural frequencies of the piping system. If option "b" is chosen, strain gauging of the system piping is required.

The sound level of a system is the result of design, quality and application. Scroll compressors sound power levels generally increase with the compressor model capacity and the condition pressure ratio. For variable speed scroll compressors, they also and mainly increase with the compressor speed.

3.13 Compressor oil return, oil balancing, floodback and oil dilution tests



CAUTION

Inadequate lubrication! Bearing and moving parts destruction! Ensure adequate oil return from the system into the compressor at any time. No liquid refrigerant return to the compressor. Liquid refrigerant dilutes the oil, could wash the oil off the bearings and moving parts and could lead to overheating and compressor failure.

The system piping must be carefully designed to ensure sufficient refrigerant gas velocity, so that oil returns to the compressor at all times and conditions. Individual piping diameter calculation depends on the refrigerant properties, pressure, mass flow, and density.

Once a new system design is set and assembled, a functional test is required. The functional test includes a qualification for the general system oil return and a refrigerant floodback and oil dilution test. Systems with multiple compressors (two, three, or more) require additional oil balancing qualification between the parallel compressors.

A sample compressor equipped with an external oil sight tube can be ordered from Emerson for lab testing.

Records of the evaporating temperature and the bottom shell temperature shall be taken with a high sampling rate during the entire oil return or oil balance testing and under all tested conditions. The liquid level in the sight tube has to be observed and recorded too. Testing conditions shall include the different operation modes and varying loads. If the system is reversible, the tests should be conducted in cooling, heating and defrost modes.

System engineers should review the system design and operation to identify the critical conditions and to check oil return, oil balancing, liquid floodback and oil dilution. Typically, the following situations should be considered:

- **In single compressor systems:** to check oil return, testing conditions shall be at minimum mass flow and minimum density of suction gas in continuous and frequent start/stop-cycling.
- **In multiple compressor systems:** to check oil return and oil balancing in the tandem or trio, testing conditions shall be at the corner points of the system application envelope in continuous and frequent start/stop-cycling.
- **In all systems:** to test liquid floodback and oil dilution, all possible transient operation conditions in the system should be checked, eg, compressor frequent start/stop, compressor start after long off time with migration, defrost, switching between the operation modes in reversible systems, load changes, fans or pumps cycling at low load and more. To evaluate the risk of liquid floodback and oil dilution, please refer to the chart in **Figure 14**.

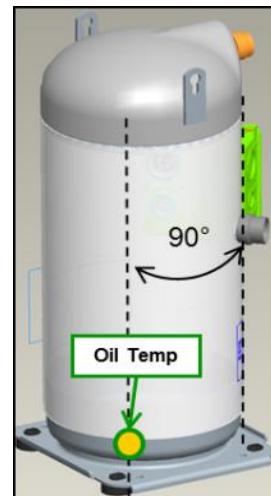
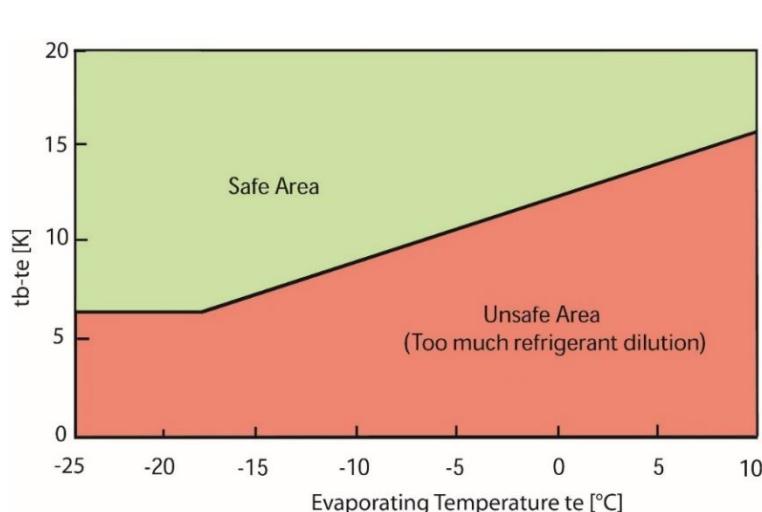


Figure 14: Oil dilution chart (tb = bottom shell temperature; te = evaporating temperature) and position for oil temperature sensor

The bottom shell temperature together with the evaporating temperature gives an indication whether liquid refrigerant is returning or diluted in the compressor oil sump. The compressor sump temperature must remain in the (green) safe area, as shown in the oil dilution chart in **Figure 14**. In case of operation in the (red) unsafe area, adjustments are required in order to modify the system design, refrigerant charge or superheat setting of the expansion device(s). The bottom shell temperature should be measured accurately. The thermo-probe must be properly insulated and positioned on the opposite side at an angle of 90° clockwise from the suction inlet with view on the top.

3.14 Suction line accumulators

Due to Copeland scroll's inherent ability to handle liquid refrigerant, for example in flooded start and defrost cycle operation, an accumulator is not required in most systems.

To determine if a suction line accumulator is required, the system designer must check this with an appropriate test scenario – see **section 3.13 "Compressor oil return, oil balancing, floodback and oil dilution tests"**.

If an accumulator is used, the oil-return orifice should be from 1 to 1.4 mm in diameter for all YPV* models depending on compressor size and compressor floodback results. To protect this small orifice from plugging with system debris a large-area protective screen no finer than 30 x 30 mesh (0.6 mm openings) is required. Tests have shown that a small screen with a fine mesh can easily become plugged causing oil starvation to the compressor bearings. The size of the accumulator depends upon the operating range of the system and the amount of sub-cooling and subsequent head pressure allowed by the refrigerant control. For the correct selection and size of the suction line accumulator, refer to the manufacturer's specifications.

Check with supplier whether an extra charge of oil for the suction accumulator is required. If it is needed, pre-charge additional oil to the system accordingly.

4 Electrical connection

4.1 General recommendations



WARNING

High voltage! Electrical shock hazard! Serious personal injuries and/or system breakdown! The compressor must always have the ground wire attached to the compressor terminal fence. The other end of the ground wire must be connected to the appropriate ground terminal on the drive.

Disconnect and lock out power before servicing. Allow drive components to electrically discharge before servicing. Respect the time according to drive application guidelines before servicing the drive. Use compressor with grounded system only. Refer to original equipment wiring diagrams. Electrical connections must be made by qualified electrical personnel.



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! The electrical connection of the scroll compressors is not an ignition source during normal operation but could become one if not installed properly according to installation instructions. Ensure correct mechanical and electrical installation. System capacitors may remain charged for several minutes after shutdown. Before starting to work on the electrical installation make sure sparking is not possible. Continuously check if the ambient atmosphere is non-flammable when working on the electrical installation.



CAUTION

High voltage! Drive damage! The unit contactor must be installed upstream of the drive, ie, not between the drive and the compressor. Major faults and irreversible damage to the drive could occur if the drive output is open-circuit while the compressor is running.

Before connecting the drive to the power network, make sure that all the cables to and from the drive and to the compressor are correctly connected and that the supply voltage, phases and frequency match the drive nameplate data.

The wiring should remain physically separated to minimize the introduction of electrical noise.

For safety reasons, Emerson recommends that the electrical installation be executed in compliance with standard EN 60204-1 and/or other standards and regulations of application when dealing with A2L refrigerants. The wiring must conform to local regulations and codes of practice.

4.2 Electrical wiring



WARNING

Conductor cables! Electrical shock hazard! Shut off power supply before undertaking any task on electrical equipment.



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! Any work on the energized terminals in the compressor terminal box could create an ignition. Do not touch the energized terminals with a tool or cable when the compressor is energized



WARNING

Earth leakage current! Danger of electric shock! The combination of compressor and drive can cause both AC and DC earth leakage current. To protect against both kinds of leakage current it is recommended to use an AC/DC sensitive RCD on the power supply side.

The combination of YPV* compressors and inverters can cause earth leakage currents, both AC and DC, due to the presence of the inverter and an EMC filter in the system. Therefore, an AC/DC-sensitive Residual Current Device (RCD) should be used on the power supply side. The RCD can be either **type B or B+**.

NOTE: A K2 contactor is needed only on drives without STO (Safe torque off) safety input. If the drive has an STO input complying with EN 60335 then the contactor K2 is optional.

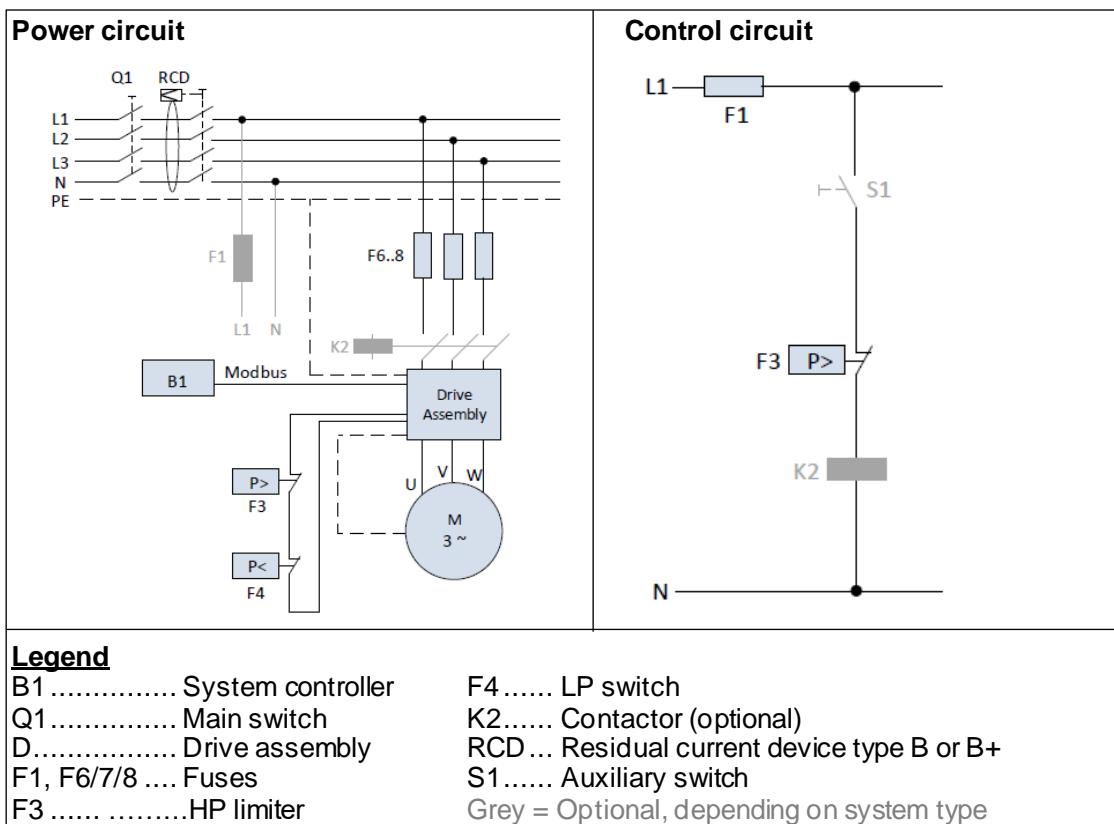


Figure 15: Wiring diagram for YPV* compressor with three-phase drive

4.3 Terminal box



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard! Any work on the energized terminals in the compressor terminal box could create an ignition. Do not touch the energized terminals with a tool or cable when the compressor is energized.

Compressors operating with flammable refrigerants shall use only the qualified terminal box supplied with the compressor.

Mechanical stress or shock! Overheating! Terminal Fusite damage and leakage! Mechanical stress and shocks to the Fusite must be avoided as they could damage the glass and/or ceramic. This might result in hermeticity failure or loss of terminal performance. Precautions are required to prevent striking or bending of pins. Bent or damaged pins may result in loss of hermeticity and/or terminal performance.

Ensure correct connection of cables to the compressor terminal Fusite to avoid local overheating of Fusite pins which might lead to refrigerant leaks.

The terminal box rating is IP21 for YPV030/038 compressors, it is not sealed. The compressor has to be protected by a cover which can only be opened with a tool.

4.4 Motor windings

YPV* compressors feature a three-phase brushless permanent magnet motor. The motor is connected in star.

4.5 Motor insulation

The motor insulation material is class "B" (maximum allowable operating temperatures according to IEC 34-1 or DIN 57530).

4.6 Protection devices

Fuses must be installed before the drive.

The selection of fuses has to be made according to EN 60269-1 or EN 60204-1 and drive maximum operating current (MOC). Not installing fuses or selecting inappropriate fuses may result in compressor and/or drive failure.

4.7 High-potential testing



WARNING

High-potential testing in a potentially flammable atmosphere! Fire hazard! Make sure the atmosphere is non-flammable before performing high-potential testing. Do not perform any high-potential test when the compressor is charged with flammable refrigerant.



WARNING

Conductor cables! Electrical shock hazard! Shut off power supply before high-potential testing.



CAUTION

Internal arcing! Motor destruction! Do not carry out high-voltage or insulation tests if the compressor housing is under vacuum.

Emerson subjects all scroll compressors to a high-voltage test after final assembly. Each motor phase winding is tested according to EN 60034-1 at a differential voltage of 1000 V plus twice the nominal voltage.

Since high-voltage tests lead to premature ageing of the winding insulation, further additional tests of that nature are not recommended. However, if it has to be done for any reason, it shall not be made with the compressor charged with refrigerant. Carry out the test with a lower voltage, as described above. Disconnect all electronic devices, eg, motor protection module, fan speed control, etc prior to testing.

Special attention should be paid when performing a high-potential test and reading the Megohm resistance on A2L compressors, as such tests can induce an electrical arc and cause a fire hazard.

For the same reason, compressors removed from a system with A2L refrigerant will need to have the oil drained and a nitrogen purge introduced to flush any remaining refrigerant from the compressor prior to high-potential testing and Megohm resistance reading.

5 Start-up & operation



WARNING

Diesel effect! System explosion! The mixture of air and oil at high temperature can lead to an explosion. Avoid operating with air.



WARNING

Air/flammable refrigerant mixture! Creation of a flammable atmosphere! Make sure the atmosphere is non-flammable before starting the system. Ensure that the system contains only refrigerant.



IMPORTANT

Oil dilution! Bearing malfunction! It is important to ensure that new compressors are not subjected to liquid abuse. It is mandatory to use the crankcase heating function of the drive if the refrigerant charge exceeds 3.6 kg. Turn the crankcase heating function on 12 hours before starting the compressor.

5.1 Compressor strength-pressure test



WARNING

High pressure! Personal injuries! Consider personal safety requirements and refer to test pressures prior to test.



IMPORTANT

System contamination! Bearing malfunction! Use only dry nitrogen for pressure testing. DO NOT USE other industrial gases.

The compressor has been strength-tested in the Emerson factory. Therefore, it is not necessary for the system manufacturer/installer to strength-test the compressor again.

Scroll compressors are divided into two pressure zones. The compressor high-side and low-side maximum allowable pressures PS have to be respected at all times.

5.2 Compressor tightness test



WARNING

High pressure! Personal injuries! Consider personal safety requirements and refer to test pressures prior to test.



IMPORTANT

System contamination! Bearing malfunction! Use only dry inert gases (for example nitrogen) for leak testing. DO NOT USE other industrial gases.

The compressor has been leak-pressure tested in the Emerson factory.

Never add refrigerant to the test gas (as leak indicator).

All compressors get a factory holding charge of dry air (about 1 to 2.5 bar, relative pressure). An intact holding charge serves as a proof of quality against penetrating moisture.

When removing plugs from the compressor, the plugs may pop out due to pressure and oil can spurt.

Any later modification to compressor connections can have an impact on the compressor tightness. Always leak-pressure test the compressor after opening or modifying the connections.

5.3 Preliminary checks – Pre-starting



WARNING

Air/A2L refrigerant mixture in a potentially flammable atmosphere! Fire hazard! Whenever starting up a system charged with A2L refrigerant, eg, after filling, repair, or maintenance, make sure not to start and operate accidentally in a flammable atmosphere.

Discuss details of the installation with the installer. If possible, obtain drawings, wiring diagrams, etc. It is ideal to use a check-list but always check the following:

- no flammable gas in the ambient;
- suitable ventilation according to the room volume and to the refrigerant charge;
- visual check of the electrics, wiring, fuses etc;
- visual check of the plant for leaks, loose fittings such as TXV bulbs etc;
- compressor oil level;
- calibration of HP & LP switches and any pressure-actuated valves;
- check setting and operation of all safety features and protection devices;
- all valves in the correct running position;
- pressure and compound gauges fitted;
- correctly charged with refrigerant;
- compressor main switch location & position.

5.4 Charging procedure



WARNING

Air/A2L refrigerant mixture in a potentially flammable atmosphere! Fire hazard! Only use filling equipment designed and approved for use and operation with A2L refrigerants. Make sure all connections are tight to avoid leakage. Make sure to fill with pure A2L refrigerant.



CAUTION

Low suction pressure operation! Compressor damage! Do not operate with a restricted suction. Do not operate with the low-pressure cut-out bridged. Do not operate the compressor at pressures not allowed by the operating envelope. Allowing the suction pressure to drop below the envelope limit for more than a few seconds may overheat scrolls and cause early drive bearing and moving parts damage.

Prior to charging or re-charging, the refrigerant system must be leak- and pressure-tested with appropriate purging gas.

Ensure that the system is grounded prior to charging with refrigerant.

The system shall be liquid-charged through the liquid-receiver shut-off valve or through a valve in the liquid line. The use of a filter drier in the charging line is highly recommended. Systems shall be liquid-charged on both the high and low sides simultaneously to ensure a positive refrigerant pressure is present in the compressor before it runs. The majority of the charge shall be placed in the high side of the system to prevent bearing washout during first-time start on the assembly line.

Extreme care shall be taken not to overfill the system with refrigerant.

The system manufacturer/installer must respect the charge limitations according to valid standards, such as EN 378.

5.5 Run-in time

Scroll compressors exhibit a slight decrease in input power during the initial running period. Published performance ratings are based on calorimeter testing which is carried out after run-in. Therefore, users should be aware that before the performance specified by EN 12900 is achieved the compressor needs to be run in.

For YPV* compressors it is recommended to run the break in at 2400 rpm, +7 °C evaporating temperature and 55 °C condensing temperature with a superheat of 10 K for a period of 16 hours.

5.6 Initial start-up



CAUTION

High discharge pressure operation! Compressor damage! Do not use compressor to test opening setpoint of high-pressure limiter. Bearings and moving parts are susceptible to damage before they have had several hours of normal running in.

Liquid and high-pressure loads could be detrimental to new bearings. It is therefore important to ensure that new compressors are not subjected to liquid abuse and high-pressure run tests. It is not good practice to use the compressor to test the high-pressure switch function on the production line.

The switch function can be tested with nitrogen prior to installation and the wiring can be checked by disconnecting the high-pressure switch during the run test.

5.7 Rotation direction

Scroll compressors, like several other types of compressors, will only compress in one rotational direction. Variable-speed compressors have three phases and the drive is either for 1~ or 3~ phase external power supply. Swapping phases between compressor and drive can result in reverse direction, please read carefully compressor and drive manual. **It is important to include notices and instructions in appropriate locations on the equipment to ensure proper rotation direction when the system is installed and operated.**

Observing that suction pressure drops and discharge pressure rises when the compressor is energized allows verification of proper rotation direction. There is no negative impact on durability caused by operating three-phase Copeland scroll compressors in the reversed direction for a short period of time (under one hour) but oil may be lost. Oil loss can be prevented during reverse rotation if the tubing is routed at least 15 cm above the compressor. After several minutes of operation in reverse, the compressor's protection system will trip due to high motor temperature. The operator will notice a lack of cooling. However, if allowed to repeatedly restart and run in reverse without correcting the situation, the compressor will be permanently damaged.

All three-phase scroll compressors are identically wired internally. Therefore, once the correct phasing is determined for a specific system or installation, connecting properly phased power leads to the identified compressor terminals will ensure proper rotation direction.

5.8 Start-and-stop routine

The drive controls the start-and-stop routine of the variable-speed scroll. This routine allows for soft starting and controlled stopping, an advantage over traditional On/Off control of fixed-capacity units.

5.9 Starting and shut-off sound

During the very brief start-up, a clicking sound resulting from the initial contacting of the spirals is audible which is normal. Due to the design of the Copeland scroll compressors, the internal compression components always start unloaded even if system pressures are not balanced. In addition, since internal compressor pressures are always balanced at start-up, low-voltage starting characteristics are excellent for Copeland scroll compressors.

Scroll compressors incorporate a device that minimizes reverse rotation. The residual momentary reversal of the scrolls at shut-off will cause a clicking sound, but it is entirely normal and has no effect on compressor durability.

5.10 Deep vacuum operation



WARNING

Operation below ambient pressure! Fire hazard! During operation below ambient pressure, a flammable mixture can form inside the system. Make sure that air does not enter the system and that the pressure never falls below atmospheric pressure.



CAUTION

Vacuum operation! Compressor damage! Copeland scroll compressors should never be used to evacuate refrigeration or air-conditioning systems. Operating scroll compressors in deep vacuum could damage internal motor parts and lead to unacceptable high temperatures in the compressor housing.

5.11 Shell temperature

During normal operation, the discharge gas as well as the compressor top shell and discharge line can reach temperatures up to the maximum discharge gas temperature of 125 °C – see **section 0 "Discharge gas temperature protection".**

In a failure mode, the discharge gas temperatures can even get higher. Care must be taken to ensure that wiring or other materials that could be damaged by these temperatures do not touch the shell.

5.12 Pumpdown cycle



WARNING

Operation below ambient pressure! Fire hazard! During operation below ambient pressure, a flammable mixture can form inside the system. Extreme attention shall be paid to system tightness. Make sure that air does not enter the system and that the pressure never falls below atmospheric pressure.



CAUTION

Vacuum operation! Compressor damage! Compressor operation outside the operating envelope is not allowed.

A pumpdown cycle to control refrigerant migration may have to be used for several reasons, for example when the compressor is located outdoors without any housing so that cold air blowing over the compressor makes the crankcase heater ineffective.

If a **pumpdown cycle is used, a separate external check valve must be added**. The scroll discharge check valve is designed to stop extended reverse rotation and prevent high-pressure gas from leaking rapidly into the low side after shut-off. The check valve will in some cases leak causing the scroll compressor to recycle more frequently. Repeated short-cycling of this nature can result in a low oil situation and consequent damage to the compressor. The hysteresis of the low-pressure control differential has to be reviewed since a relatively large volume of gas will re-expand from the high side of the compressor into the low side after shutdown.

For pressure control setting, never set the low-pressure limiter to shut off outside of the operating envelope. To prevent the compressor from running into problems during such faults as loss of charge or partial blockage, the low-pressure limiter shall not be set lower than the minimum suction pressure allowed by the operating envelope.

5.13 Minimum run time

Emerson recommends a maximum of 10 starts per hour. There is no minimum off time because scroll compressors start unloaded, even if the system has unbalanced pressures. The most critical consideration is the minimum run time required to return oil to the compressor after start-up. To establish the minimum run time, a sample compressor equipped with an external oil sight tube is available from Emerson. Install it in a system with the longest connecting lines that are approved for the system. The minimum on time becomes the time required for oil lost during compressor start-up to return to the compressor sump and to restore a minimal oil level that will ensure oil pick-up through the crankshaft. Cycling the compressor for a shorter period than this, for instance to maintain very tight temperature control, will result in progressive loss of oil and damage to the compressor.

5.14 Oil level

Some systems may contain higher than normal refrigerant charges. Systems with large coils, low ambient condenser flooding, or systems with multiple heat exchangers are among some system configurations that may require additional lubricant.

There is no oil sight glass on YPV030/038 compressors.

During the system development phase, adequate oil return from the system to the compressor in any operation should be evaluated and qualified. For this purpose, a sample compressor for lab testing, equipped with an external oil sight tube, is available from Emerson. See also the information in section 3.13 "Compressor oil return, oil balancing, floodback and oil dilution tests".

6 Maintenance & repair



WARNING

Conductor cables! Electrical shock hazard! Follow the lockout/tag out procedure and the national regulations before carrying out any maintenance or service work on the system.

Use compressor with grounded system only. Screwed electrical connections must be used in all applications. Refer to original equipment wiring diagrams. Electrical connections must be made by qualified electrical personnel.



WARNING

Ignition source in a potentially flammable atmosphere! Fire hazard!

When opening the system, the atmosphere could be flammable. All the electrical components that are a source of ignition must always be switched off during service and maintenance. Ensure that the surface temperatures of the components never exceed the limits set by the applicable safety standard, eg, EN 378-2.

Air/flammable refrigerant mixture! Fire hazard! Remove all refrigerant before opening the system. Make sure to remove refrigerant completely from all components such as heat exchangers, refrigerant accumulators, etc. Flush the system and the components with inert gas before undertaking any work and before brazing.



WARNING

Open flame in a potentially flammable atmosphere! Fire hazard! The area shall be checked with an appropriate refrigerant detector prior to and during work, to ensure the technician is aware of a potentially toxic or flammable atmosphere. Ensure that the leak detection equipment being used is suitable for use with all applicable refrigerants.

Personnel performing work on a refrigeration system that involves exposing the pipework shall avoid using any ignition source in a way that could lead to a fire or explosion hazard. All sources of ignition shall be kept sufficiently far from the site of installation, repair, removal or disposal during the entire time when refrigerant could be released into the surrounding space.

Open flames and smoking are strictly forbidden at all times.

During service make sure that:

- the area is well ventilated;
- the materials and equipment used are suitable for use under flammable conditions;
- only non-sparking tools are used;
- antistatic gloves and clothes are used;
- build-up of electrostatic charges is avoided;
- no unshielded or naked flame is used;

If parts of the refrigeration system are charged with flammable refrigerant, make sure that all the valves are tightly closed and that the open pipes after the valves are free of refrigerant and oil.

A risk analysis to evaluate all possible risks shall be carried out by the service technician before any repair work on the A2L systems.

6.1 Qualification of workers

Personnel working on maintenance, repair and decommissioning shall be adequately trained. Any work procedure affecting safety shall only be executed by qualified and trained personnel in compliance with national or other equivalent certification systems.

Examples of such work procedures are:

- breaking into the refrigerating circuit;
- opening sealed components;
- opening ventilated enclosures;
- etc.

6.2 Preparation and work procedure

A work procedure shall be provided in the preparation stage. All maintenance staff and other personnel working at the site shall be instructed on the nature of the work being carried out.

If any work is to be conducted on the refrigeration systems or any associated parts, appropriate fire extinguishing equipment shall be provided. Dry powder or CO₂ fire extinguishers are considered appropriate. Confirm that appropriate fire extinguishing equipment is available near the work area.

Prior to starting to work on systems containing flammable refrigerants, safety checks are necessary to ensure that the risk of ignition is minimized.

Work shall be undertaken under a controlled procedure so as to minimize the risk of a flammable gas or vapour being present while the work is being performed.

Avoid working on systems filled with flammable refrigerant in a confined space.

6.3 Disassembling system components

When disassembling system components please follow the main steps described hereunder:

1. Recover refrigerant and evacuate system using an A2L-dedicated recovery unit and vacuum pump. All the refrigerant shall be recovered to avoid significant release. Ensure that the outlet of the vacuum pump is not close to any potential ignition source and that ventilation is available.
2. Flush system with inert gas (dry nitrogen). Compressed air or oxygen shall not be used for purging refrigerant systems.
3. Disassemble components with a cutting tool.
4. Drain, recover and dispose of compressor oil as appropriate.

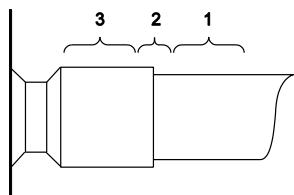


Figure 16: Tube connecting areas

To disconnect:

- Using a pipe cutting tool, cut off the suction and discharge lines in such a manner that the new compressor can easily be re-connected into the system.
- Heat joint areas 2 and 3 slowly and uniformly until the braze material softens and the tube end can be pulled out from the fitting.

To reconnect:

- Recommended brazing material: Silfos with minimum 5 % silver or silver braze used on other compressors.
- Due to the different thermal properties of steel and copper, brazing procedures may have to be changed from those commonly used.

NOTE: Since the discharge stub contains a check valve, care must be taken not to overheat it to prevent brazing material from flowing into it.

6.4 Exchanging the refrigerant



WARNING

Air/A2L mixture in a potentially flammable atmosphere! Fire hazard! In any case avoid air/A2L mixture in the refrigeration system. Make sure that the system is filled with pure A2L refrigerant. In the event that the refrigerant needs replacing, the charge should be recovered using A2L-qualified refrigerant recovery unit and recycling bottles.



CAUTION

Low suction pressure operation! Compressor damage! Do not operate with a restricted suction. Do not operate with the low-pressure limiter bridged. Do not operate compressor at pressures that are not allowed by the operating envelope. Allowing the suction pressure to drop below the envelope limit for more than a few seconds may overheat scrolls and cause early drive bearing and moving parts damage.

For qualified refrigerant and oil, see **section 2.3.1**.

It is not necessary to replace the refrigerant unless contamination due to an error such as topping up the system with an incorrect refrigerant is suspected. To verify correct refrigerant composition, a sample can be taken for chemical analysis. A check can be made during shutdown by comparing the refrigerant temperature and pressure using precision measurements at a location in the system where liquid and vapour phases are present and when the temperatures have stabilised.

In the event that the refrigerant needs replacing, the charge should be recovered using a suitable recovery unit.

6.5 Replacing a compressor



CAUTION

Inadequate lubrication! Bearing destruction! For systems with a refrigerant accumulator, exchange the accumulator after replacing a compressor with a burned-out motor. The accumulator oil return orifice or screen may be plugged with debris or may become plugged. This will result in starvation of oil to the new compressor and a second failure.

Remove the refrigerant and oil completely from the replaced compressor.

6.5.1 Compressor replacement

In the case of A2L refrigerant compressor replacement, the oil has to be drained out of the compressor and the compressor should be flushed with dry nitrogen. DO NOT close the stubs with plugs.

In the case of a motor burnout, the majority of contaminated oil will be removed with the compressor. The rest of the oil will be cleaned through the use of suction and liquid line filter driers. A 100 % activated alumina suction line filter drier is recommended but must be removed after 72 hours.

It is highly recommended that the suction accumulator be replaced if the system contains one. This is because the accumulator oil return orifice or screen may be plugged with debris or may become plugged shortly after a compressor failure. This will result in starvation of oil to the replacement compressor and a second failure.

When a compressor is exchanged in the field, it is possible that a major portion of the oil may still be in the system. While this may not affect the reliability of the replacement compressor, the extra oil will add to rotor drag and increase power usage.

6.5.2 Start-up of a new or replacement compressor

Rapid charging only on the suction side of a scroll-equipped system can occasionally result in a temporary no-start condition for the compressor. The reason for this is that, if the flanks of the scrolls happen to be in a sealed position, rapid pressurisation of the low side without opposing high-side pressure can cause the scrolls to seal axially. As a result, until the pressures eventually equalise, the scrolls can be held tightly together preventing rotation. The best way to avoid this situation is to charge on both the high and low sides simultaneously at a rate which does not result in axial loading of the scrolls.

A minimum suction pressure, specified in the published operating envelope, must be maintained during charging. Allowing the suction pressure to drop below that value may overheat the scrolls and cause early drive bearing and moving parts damage. Never install a system in the field and leave it unattended when it has no charge, a holding charge, or with the service valves closed without securely electrically locking out the system. This will prevent unauthorised personnel from accidentally operating the system and potentially ruining the compressor by operating with no refrigerant. **Do not start the compressor while the system is in a deep vacuum.** Internal arcing may occur when a scroll compressor is started in a vacuum causing burnout of the internal lead connections.

6.5.3 Compressor return procedure

If a compressor has to be returned to the manufacturer for analysis the procedure below shall be followed:

- During the entire working procedure continuously check if the ambient atmosphere is flammable. If a flammable atmosphere is detected, ensure proper ventilation of the working space and immediately cut-off the power supply.
- Resume working after the atmosphere is no longer dangerous.
- Recover the refrigerant from the system using a suitable recovery unit. During this action, the compressor crankcase heating function could be energized – immediately de-energize in case a flammable atmosphere is detected.
- Recover to 3 mbar absolute or lower. For best results and to recover also the refrigerant solved in the oil, run the recovery unit two or three times as necessary.
- Flush the whole system with oxygen-free dry nitrogen (OFDN).
- Open the system with a cutting tool and flush the entire system with OFDN.
- Disassemble the compressor with a cutting tool. Drain and recover compressor oil properly. Flush the compressor with OFDN for a few minutes.
- The compressor should be returned free of oil and with connections open – do not close connections with plugs.
- Collect and secure the oil properly. Provide information about the quantity of oil drained from the compressor and its colour. Ideally, send a good picture.
- Dispose of the oil according to local rules and regulations.
- Use a proper cardboard box package when preparing the compressor for shipment. Place



warning icons on each side and on the top of the box. Mention the following message on the box: "**Warning! Flammable A2L refrigerant compressor for analysis**".

- The compressor package must be kept in the upright position – mark it accordingly.
- If more than one compressor have to be returned, each compressor must be packed individually.

NOTE: Check with the transport company that all the requirements applying to such shipment are complied with.

6.6 Lubrication and oil removal



WARNING

Air/A2L flammable refrigerant mixture! Fire hazard! Use suitable recovery unit and recycling bottles also for oil disposal as A2L refrigerant may still be solved in the oil.



CAUTION

Chemical reaction! Compressor destruction! Do not mix up ester oils with mineral oil and/or alkyl benzene when used with chlorine-free (HFC) refrigerants.

The compressor is supplied with an initial oil charge. The standard oil for use with R32 is a polyolester 4MA POE lubricant. See nameplate for original oil charge shown in litres. A field recharge is from 0.05 to 0.1 litre less.

All compressors get a factory holding charge of dry air to prevent humidity entering the compressor during transport and storage (about 1 to 2,5 bar, relative pressure). An intact holding charge serves as a proof of quality against penetrating moisture.

One disadvantage of POE is that it is far more hygroscopic than mineral oil – see **Figure 17**. Only brief exposure to ambient air is needed for POE to absorb sufficient moisture to make it unacceptable for use in a refrigeration system. Since POE holds moisture more readily than mineral oil it is more difficult to remove it through the use of vacuum. Compressors supplied by Emerson contain oil with low moisture content, and it may rise during the system assembling process. Therefore, it is recommended that a properly sized filter-drier is installed in all POE systems. This will maintain the moisture level in the oil to less than 50 ppm. If oil is charged into a system, it is recommended to use POE with moisture content no higher than 50 ppm.

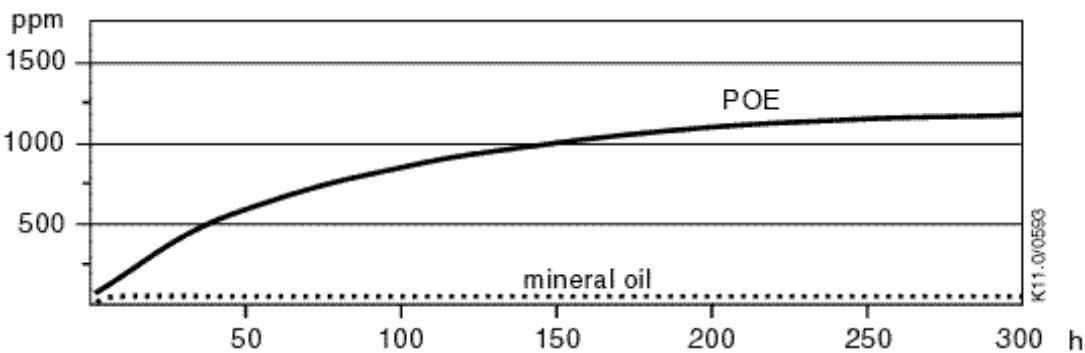


Figure 17: Absorption of moisture in ester oil in comparison to mineral oil in ppm by weight at 25 °C and 50 % relative humidity (h = hours)

If the moisture content of the oil in a refrigeration system reaches unacceptably high levels, corrosion and copper plating may occur. The system should be evacuated down to 0.3 mbar or lower. If there is uncertainty as to the moisture content in the system, an oil sample should be taken and tested for moisture. Sight glass/moisture indicators currently available can be used with the HFC refrigerants and lubricants; however, the moisture indicator will just show the moisture presence in the refrigerant. The actual moisture level of POE would be higher than the sight glass indicates. This is due to the high hygroscopicity of the POE oil. To determine the actual moisture content of the lubricant, samples have to be taken from the system and analysed.

6.7 Oil additives

Although Emerson cannot comment on any specific product, from our own testing and past experience, we do not recommend the use of any additives to reduce compressor bearing losses or for any other purpose. Furthermore, the long-term chemical stability of any additive in the presence of refrigerant, low and high temperatures, and materials commonly found in refrigeration systems is complex and difficult to evaluate without rigorously controlled chemical laboratory testing. The use of additives without adequate testing may result in malfunction or premature failure of components in the system and, in specific cases, in voiding the warranty on the component.

6.8 Provisions of legislation and leak check requirements

According to EN 378-4, systems with a refrigerant charge of 3 kg or more shall be subject to tightness inspection at least on an annual basis. The owner/operator shall keep an updated logbook of the refrigerant system containing all details with regard to maintenance and repair works (quantities and type of refrigerant charged or transferred, system components changes and replacements, etc.). The EN 378 legislation covers HFO's as well as natural refrigerants.

The F-gas Regulation (EU) No 517/2014 applies to operators of equipment such as stationary refrigeration/air-conditioning equipment and heat pumps that contain fluorinated greenhouse gases. Mandatory documented leak checks must be made based on how much damage could be caused to the atmosphere if the whole charge were released. The frequency of the test inspections is based on the GWP of the refrigerant multiplied by the estimated volume contained in each individual system – this gives the CO₂e (CO₂ equivalent) figure.

Leak checking shall be carried out with the following frequency:

- (a) once per year if the system contains between 5 and 50 tonnes CO₂e;
- (b) once every 6 months if the system contains between 50 and 500 tonnes CO₂e;
- (c) once every 3 months if the system contains more than 500 tonnes CO₂e.

NOTE: The leak checking frequency can be halved if permanent leak detection systems are fitted. Permanent leak detection systems are mandatory for system charges of 500 tonnes CO₂e and above.

NOTE: Hermetically sealed equipment that contains fluorinated greenhouse gases in quantities of less than 10 tonnes of CO₂e, shall not be subject to leak checks, provided the equipment is labelled as hermetically sealed.

Table 6 below sets out the:

- F-gas thresholds, in tonnes CO₂ equivalent, at which leak check intervals are specified;
- maximum allowed interval between leak checks for equipment that meets each threshold;
- quantities of commonly used HFCs/refrigerant equal to each threshold.

Refrigerant	GWP	Maximum interval between leak checks 1 year	Maximum interval between leak checks 6 months	Maximum interval between leak checks 3 months
		5 to <50 T CO ₂ e	50 to <500 T CO ₂ e	>500 T CO ₂ e
R32	675	7.41	74.07	740.7

Table 6: F-gas Regulation leak check intervals (based on refrigerant type and system charge thresholds)

The F-gas Regulation contains additional requirements depending on the system and stipulates training requirements for alternative refrigerants.

HFO refrigerants are covered by the F-gas Regulation as far as reporting of placing on the market is concerned.

7 Troubleshooting



WARNING

Electrical connections! Electrical shock hazard! Before attempting any electrical troubleshooting, make sure all grounds are connected and secure and there is ground continuity throughout the compressor system. Also ensure the compressor system is correctly grounded to the power supply. If you are not a qualified service person familiar with electrical troubleshooting techniques, DO NOT PROCEED until a qualified service person is available.

Most in-warranty electrical failures are the result of mechanical problems (particles in the oil, liquid refrigerant in the oil, etc.) and most mechanical problems are the result of system problems. Unless the reason for the failure is found, replacing the compressor will probably lead to another compressor failure.

If the compressor fails to start and run properly, it is important that the compressor be tested to determine its condition. It is possible that electrical components may be defective, the protector may be open, or a safety device may have tripped. The most common compressor problems encountered in the field are listed below.

When troubleshooting a compressor in combination with a drive please follow the recommendations below:

- Read and analyse the alarm registers from the drive and the system controller.
- Before servicing, shut off and secure the power supply and allow drive components to electrically discharge. Discharge times are given in the drive manual and must be respected.
- Drive: Check all the external wiring for miswiring, broken leads or a cable short circuit. Check for loose or burned contacts. Check for burned components on the board.
- Chokes/PFC: Check all the wiring and check for loose or burned contacts.
- External sensors: Make sure that the external sensors are properly connected and still working (discharge temperature sensor and high-pressure switch).
- Drive cooling: For air-cooled drives, make sure that the airflow is not obstructed.
- EMI filter: Check all the wiring and check for loose or burned contacts on the board.
- Compressor: Make sure the compressor is running within the envelope. Check the winding resistances from the compressor motor and the cables between compressor and drive. Check for loose or burned contacts.

Condition	Cause	Corrective action
The scroll compressor does not run, instead a buzz sound can be heard	Wired incorrectly	Check the power supply on the compressor terminals if there is voltage measured. Trace the wiring diagram to see where the circuit is interrupted.
	Low supply voltage	If the voltage falls below 90 % of the nameplate voltage, the motor may develop insufficient torque. Make sure the compressor is supplied with rated nominal voltage.
	Defective capacitor or relay	For a single-phase motor, a defective capacitor or relay may prevent the compressor from starting. Check these components by substituting "a known-to-be-good" component if available. Make sure that the capacitors are electrically discharged before checking.
	Shorted or grounded motor windings	Check the motor for ground by means of a continuity check between the terminals. If grounded replace compressor.
	Internal compressor mechanical damage	<ul style="list-style-type: none"> ▪ Refrigerant migration: When the compressor is switched off for a long period refrigerant can condense in the crankcase. If the compressor body is colder than the evaporator, refrigerant will move from the evaporator to the compressor crankcase. Refrigerant migration normally occurs when the compressor is installed in a cold area. A crankcase heater and/or a pump-down cycle provide good protection against refrigerant migration.

Condition	Cause	Corrective action
The scroll compressor does not run, instead a buzz sound can be heard	Internal compressor mechanical damage	<ul style="list-style-type: none"> ▪ Acid formation: Acid forms in the presence of moisture, oxygen, metal, salts, metal oxides and/or high discharge temperatures. The chemical reactions are accelerated at higher temperatures. Oil and acid react with each other. Acid formation leads to damage of the moving parts and in extreme cases to motor burnout. Several different test methods can be used to test for acid formation. If acid is present a complete oil change (including the oil in the oil separator) will help. A suction filter which removes acid should also be fitted. Check filter-drier condition.
The scroll compressor does not run, no buzz sound can be heard	Defective system control components	<p>Check if the pressure control or thermostat works properly or if the controls are open.</p>
	Power circuit open	<p>Check the fuse for a tripped circuit breaker or for an open disconnected switch.</p>
	Burned motor winding	<ul style="list-style-type: none"> ▪ If motor burned due to undersized contactors, you will observe that the contacts welded together. Complete motor burnout on all three phases despite the presence of a functioning protection system can be the result. For sizing information please consult with Contactor manufacturer data sheet. If the application of the compressor is changed the contactor sizing should be rechecked. ▪ Check for unbalanced voltage.
	High discharge pressure / suction pressure	<ul style="list-style-type: none"> ▪ For high discharge pressure: <ul style="list-style-type: none"> - Check for system leaks. - Check the system design. Make sure the discharge line is correctly sized: undersized discharge line can increase discharge pressure. This is also true for an undersized condenser. Correct the component selection as needed. - Check the fan motor, make sure it is running properly in the right direction. Check the condenser: if dirt has been accumulated it will clog the airflow; clean as necessary. High discharge pressure is also caused by an overcharged system and high ambient temperature surrounding the condenser. ▪ For high suction pressure, check the "evaporator superheat" first to diagnose the problem: <ul style="list-style-type: none"> - High superheat at the evaporator outlet: this is likely in case of excessive pressure-drop in the liquid line or too much vertical lift on the pipe work. ▪ Low superheat at the evaporator outlet is characterized by oversized selection of the expansion valve or incorrect bulb sensor mounting. The valve may freeze up in the open position due to accumulation of debris in the system. For a system with very short refrigeration lines an accumulator is recommended.

Condition	Cause	Corrective action
The scroll compressor trips on motor protection	Compressor operating outside the design limits	Check the compressor suction and discharge pressures while it is running. Make sure they are within the operating envelope.
	Defective motor protector	If all operating conditions are normal, the voltage supply at the compressor terminals is balanced and within limits, the compressor crankcase temperature is within normal limits, and the amperage drawn is within the specified range, the motor protector may be defective.
Excessive discharge temperature	Insufficient cooling medium injected	For compressors using vapour injection, make sure the expansion valve is connected at a distance between 150 mm and 200 mm from the economizer inlet and at a position not lower than inlet connection. The injection line economizer to compressor should be properly sized to avoid pressure drop. For good refrigerant distribution in the economizer respect the recommendations especially those regarding the inlet pipes for the vapour injection according to BHE-manufacturer. The liquid line from the BHE to the expansion valve(s) need to be well insulated as well. A solenoid valve should be installed on the liquid line to prevent refrigerant migration.
	Too high compressor superheat	Make sure the compressor operates within the acceptable superheat range published by Emerson.
The scroll compressor runs continuously	Excessive cooling/heating load or inadequate insulation	Check the load design; make sure that proper insulation is applied. Correct it as necessary.
	Control circuit inoperative	Check the thermostat, measure the temperature of the room and compare with the thermostat; replace or re-calibrate the thermostat. Check the LP control switch and replace it if it is found defective.
Compressor lubrication problem	Oil trap due to incorrect piping layout / sizing	Check the piping layout design. Installations of pipe being routed over or around obstacles can inadvertently create unwanted traps for the oil return. As much as possible the refrigerant line should travel a direct and straight course between the evaporator and compressor. It should also be remembered that the entire system will be coated in oil to some extent. Oil viscosity changes with temperature. More oil stays in the system than was originally expected. Make sure the line is correctly sized.
	Oil pump out due to high cycling rate	A high cycling rate will pump oil into the system and lead to lubrication failure. Oil leaves the compressor at start-up and the short running time is insufficient to return the oil to the compressor via the suction side. Try to limit the number of cycles to maximum 10 per hour.
	Low gas velocity	System gas velocity changes depending on temperature and load (capacity control). In low load conditions gas velocity may not be high enough to return oil to the compressor.

Condition	Cause	Corrective action
Low discharge pressure	Low ambient temperature	Fit a fan cycling control system.
	Refrigerant undercharge	Check the system for leaks. Observe sight glass for bubbles. Add refrigerant until the sight glass is clear.
Low suction pressure	System design load too small	If the compressor is running in a tandem or in parallel, modulate the running process.
	Inadequate refrigerant going to the evaporator	Lower normal discharge pressure values can lead to insufficient refrigerant flow to the system. This can also be verified by checking the evaporator outlet superheat, if it is found unusually high. Check the selection of the expansion valve (likely undersized).
Noise during shut-off	Anti-reverse device	This does not have any effect on the durability of the compressor, no action is necessary.

8 Dismantling & disposal



Removing oil and refrigerant:

- **Do not disperse in the environment.**
- **Use the correct equipment and method of removal.**
- **Dispose of oil and refrigerant in accordance with national legislation and regulations.**

Dispose of compressor and drive in accordance with national legislation and regulations.

9 References

Please visit www.climate.emerson.com/en-gb for free download of Application Guidelines and Technical Information.

Additional technical information:

- C30.11/0419/E "NTC Mounting Recommendations"
- ED3 User Manual (June 2019 version)

Performance and technical data:

The latest version of Copeland Select software with performance data and technical data is available from the webpage www.climate.emerson.com/en-gb.

Spare parts and accessories:

An online version of the Emerson spare parts and accessories software is available from the webpage www.climate.emerson.com/en-gb/tools-resources.

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