

SECTION 23 23 00

REFRIGERANT PIPING  
10/07

PART 1 GENERAL

1.1 REFERENCES

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

JAPANESE STANDARDS ASSOCIATION (JSA)

JIS B 1180	(2014) Hexagon Head Bolts and Hexagon Screws
JIS B 2220	(2012) Steel Pipe Flanges
JIS B 2301	(2013) Screwed Type Malleable Cast Iron Pipe Fittings
JIS B 2312	(2015) Steel Butt-Welding Pipe Fittings
JIS B 2316	(2017) Steel Socket-Welding Pipe Fittings
JIS B 2404	(2018) Dimensions of Gaskets for Use with Pipe Flanges
JIS B 8225	(2012) Safety Valves-Measuring Methods for Coefficient of Discharge
JIS B 8471	(2004) Water Pipe Line-Solenoid Valves
JIS B 8605	(2002) Stop Valves for Refrigerants
JIS B 8619	(2018) Thermostatic Refrigerant Expansion Valves-Methods of Testing for Performance
JIS G 3302	(2022) Hot Dip Zinc Coated Steel Sheet and Strip
JIS G 3454	(2019) Carbon Steel Pipes for Pressure Service (Amendment 1)
JIS H 3300	(2018) Copper and Copper Alloy Seamless Pipes and Tubes
JIS H 3401	(2001) Pipe Fittings of Copper and Copper Alloys
JIS H 8641	(2021) Hot Dip Galvanized Coatings
JIS K 7137-2	(2001) Plastics-Polytetrafluoroethylene (PTFE) Semi-Finished Products-Part 2 : Preparation of Test Specimens and

Determination of Properties

JIS Z 2371	(2015) Methods of Salt Spray Testing
JIS Z 3197	(2012) Test Methods for Soldering Fluxes
JIS Z 3202	(2007) Copper and Copper Alloy Gas Welding Rods
JIS Z 3284-1	(2014) Solder Paste-Part 1: Kinds and Quality Classification
JIS Z 3801	(2018) Standard Qualification Test and Acceptance Requirements for Manual Welding Technique
JIS Z 3821	(2018) Standard Qualification Test and Acceptance Requirements for Welding Technique of Stainless Steel

THE JAPAN WELDING ENGINEERING SOCIETY (JWES)

JWES Japan Welding Engineering Society

MINISTRY OF LAND, INFRASTRUCTURE, TRANSPORT AND TOURISM (MLIT)

MLIT-M (2019) Public Building Construction Standard Specification

## 1.2 SUBMITTALS

Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are for [Contractor Quality Control approval.] Submit the following in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Refrigerant Piping System; G[, [\_\_\_\_\_]]

SD-06 Test Reports

Refrigerant Piping Tests

SD-10 Operation and Maintenance Data

Maintenance  
Operation and Maintenance Manuals

## 1.3 QUALITY ASSURANCE

### 1.3.1 Qualifications

Submit [\_\_\_\_\_] copies of qualified procedures, and list of names and identification symbols of qualified welders and welding operators, prior to non-factory welding operations.[ Piping shall be welded in accordance with the qualified procedures using performance qualified welders and welding operators. Procedures and welders shall be qualified in

accordance with JIS Z 3801. Notify the Contracting Officer 24 hours in advance of tests to be performed at the work site, if practical. The welder or welding operator shall apply the personally assigned symbol near each weld made, as a permanent record. Structural members shall be welded in accordance with Section [05 12 00 STRUCTURAL STEEL].] [ Welding and nondestructive testing procedures are specified in Section [40 05 13.96 WELDING PROCESS PIPING] .]

#### 1.3.2 Contract Drawings

Because of the small scale of the drawings, it is not possible to indicate all offsets, fittings, and accessories that may be required. Carefully investigate the plumbing, fire protection, electrical, structural and finish conditions that would affect the work to be performed and arrange such work accordingly, furnishing required offsets, fittings, and accessories to meet such conditions.

#### 1.4 DELIVERY, STORAGE, AND HANDLING

Protect stored items from the weather, humidity and temperature variations, dirt and dust, or other contaminants. Proper protection and care of all material both before and during installation is the Contractor's responsibility. Replace any materials found to be damaged at the Contractor's expense. During installation, cap piping and similar openings to keep out dirt and other foreign matter.

#### 1.5 MAINTENANCE

##### 1.5.1 General

Submit Data Package 2 plus operation and maintenance data complying with the requirements of Section 01 78 23 OPERATION AND MAINTENANCE DATA and as specified herein.

##### 1.5.2 Extra Materials

Submit spare parts data for each different item of equipment specified, after approval of detail drawings and not later than [\_\_\_\_\_] months prior to the date of beneficial occupancy. The data shall include a complete list of parts and supplies, with current unit prices and source of supply, a recommended spare parts list for 1 year of operation, and a list of the parts recommended by the manufacturer to be replaced on a routine basis.

### PART 2 PRODUCTS

#### 2.1 STANDARD COMMERCIAL PRODUCTS

- a. Provide materials and equipment which are standard products of a manufacturer regularly engaged in the manufacturing of such products, that are of a similar material, design and workmanship and that have been in satisfactory commercial or industrial use for 2 years prior to bid opening.
- b. The 2 year use shall include applications of equipment and materials under similar circumstances and of similar size. The 2 years experience shall be satisfactorily completed by a product which has been sold or is offered for sale on the commercial market through advertisements, manufacturer's catalogs, or brochures. Products having less than a 2 year field service record will be acceptable if a

certified record of satisfactory field operation, for not less than 6000 hours exclusive of the manufacturer's factory tests, can be shown.

- c. Products shall be supported by a service organization location in Japan. System components shall be environmentally suitable for the indicated locations. Submit a certified list of qualified permanent service organizations for support of the equipment which includes their addresses and qualifications. The service organizations shall be reasonably convenient to the equipment installation and be able to render satisfactory service to the equipment on a regular and emergency basis during the warranty period of the contract.
- d. Exposed equipment moving parts, parts that produce high operating temperature, parts which may be electrically energized, and parts that may be a hazard to operating personnel shall be insulated, fully enclosed, guarded, or fitted with other types of safety devices. Install safety devices so that proper operation of equipment is not impaired. Welding and cutting safety requirements shall be in accordance with MLIT-M and JIS Z 3801.
- e. Manufacturer's standard catalog data, at least [5 weeks] [\_\_\_\_\_] prior to the purchase or installation of a particular component, highlighted to show material, size, options, performance charts and curves, etc. in adequate detail to demonstrate compliance with contract requirements. Include in the data manufacturer's recommended installation instructions and procedures. Provide data for the following components as a minimum:
  - (1) Piping and Fittings
  - (2) Valves
  - (3) Piping Accessories
  - (4) Pipe Hangers, Inserts, and Supports

## 2.2 REFRIGERANT PIPING SYSTEM

Refrigerant piping, valves, fittings, and accessories shall be in accordance with Japanese Refrigeration Safety Regulations (Nihon-Reitou-Hoan-Kisoku) for Japanese Standard., except as specified herein. Refrigerant piping, valves, fittings, and accessories shall be compatible with the fluids used and capable of withstanding the pressures and temperatures of the service. Refrigerant piping, valves, and accessories used for refrigerant service shall be cleaned, dehydrated, and sealed (capped or plugged) prior to shipment from the manufacturer's plant. Submit drawings, at least [5] [\_\_\_\_\_] weeks prior to beginning construction, provided in adequate detail to demonstrate compliance with contract requirements. Drawings shall consist of:

- a. Piping layouts which identify all valves and fittings.
- b. Plans and elevations which identify clearances required for maintenance and operation.

## 2.3 PIPE, FITTINGS AND END CONNECTIONS (JOINTS)

### 2.3.1 Steel Pipe

Steel pipe for refrigerant service shall conform to JIS G 3454 & JIS B 2301, Schedule 40.

### 2.3.1.1 Welded Fittings and Connections

Butt-welded fittings shall conform to JIS B 2312. Socket-welded fittings shall conform to JIS B 2316. Welded fittings shall be identified with the appropriate grade and marking symbol. Welded valves and pipe connections (both butt-welds and socket-welds types) shall conform to JIS B 2312 or JIS B 2316.

### 2.3.1.2 Threaded Fittings and Connections

Threaded fitting shall conform to JIS B 2301. Threaded valves and pipe connections shall conform to JIS B 2301.

### 2.3.1.3 Flanged Fittings and Connections

Flanges shall conform to JIS B 2220. Gaskets shall be non asbestos compressed material in accordance with JIS B 2404, 1.59 mm thickness, full face or self-centering flat ring type. This gaskets shall contain aramid fibers bonded with styrene butadeine rubber (SBR) or nitrile butadeine rubber (NBR). Bolts, nuts, and bolt patterns shall conform to JIS B 2220. Bolts shall be high or intermediate strength material conforming to JIS B 1180.

### 2.3.2 Copper Tubing

Copper tubing shall conform to JIS H 3300 and JIS H 3401, annealed or hard drawn as required. Copper tubing shall be soft annealed where bending is required and hard drawn where no bending is required. Soft annealed copper tubing shall not be used in sizes larger than 35 mm. Joints shall be brazed except that joints on lines 22 mm and smaller may be flared. Cast copper alloy fittings for flared copper tube shall conform to JIS H 3401. Wrought copper and bronze solder-joint pressure fittings shall conform to JIS H 3401. Joints and fittings for brazed joint shall be wrought-copper or forged-brass sweat fittings. Cast sweat-type joints and fittings shall not be allowed for brazed joints. Brass or bronze adapters for brazed tubing may be used for connecting tubing to flanges and to threaded ends of valves and equipment.

### 2.3.3 Solder

Solder shall conform to JIS Z 3284-1, tin-antimony alloy for service pressures up to 1034 kPa. Solder flux shall be liquid or paste form, non-corrosive and conform to JIS Z 3197.

### 2.3.4 Brazing Filler Metal

Filler metal shall conform to JIS Z 3202.

## 2.4 VALVES

Valves shall be designed, manufactured, and tested specifically for refrigerant service. Valve bodies shall be of brass, bronze, steel, or ductile iron construction. Valves 25 mm and smaller shall have brazed or socket welded connections. Valves larger than 25 mm shall have [tongue-and-groove flanged] [butt welded] end connections. Threaded end connections shall not be used, except in pilot pressure or gauge lines where maintenance disassembly is required and welded flanges cannot be used. Internal parts shall be removable for inspection or replacement without applying heat or breaking pipe connections. Valve stems exposed

to the atmosphere shall be stainless steel or corrosion resistant metal plated carbon steel. Direction of flow shall be legibly and permanently indicated on the valve body. Control valve inlets shall be fitted with integral or adapted strainer or filter where recommended or required by the manufacturer. Purge, charge and receiver valves shall be of manufacturer's standard configuration.

#### 2.4.1 Refrigerant Stop Valves

Valve shall be the globe or full-port ball type with a back-seating stem especially packed for refrigerant service. Valve packing shall be replaceable under line pressure. Valve shall be provided with a [handwheel] [or] [wrench] operator and a seal cap. Valve shall be the straight or angle pattern design as indicated.

#### 2.4.2 Check Valves

Valve shall be the swing or lift type as required to provide positive shutoff at the differential pressure indicated. Valve shall be provided with resilient seat.

#### 2.4.3 Liquid Solenoid Valves

Valves shall comply with JIS B 8471 and be suitable for continuous duty with applied voltages 15 percent under and 5 percent over nominal rated voltage at maximum and minimum encountered pressure and temperature service conditions. Valves shall be direct-acting or pilot-operating type, packless, except that packed stem, seal capped, manual lifting provisions shall be furnished. Solenoid coils shall be moisture-proof, UL approved, totally encapsulated or encapsulated and metal jacketed as required. Valves shall have safe working pressure of 2760 kPa and a maximum operating pressure differential of at least 1375 kPa at 85 percent rated voltage. Valves shall have an operating pressure differential suitable for the refrigerant used.

#### 2.4.4 Expansion Valves

Valve shall conform to JIS B 8619. Valve shall be the diaphragm and spring-loaded type with internal or external equalizers, and bulb and capillary tubing. Valve shall be provided with an external superheat adjustment along with a seal cap. Internal equalizers may be utilized where flowing refrigerant pressure drop between outlet of the valve and inlet to the evaporator coil is negligible and pressure drop across the evaporator is less than the pressure difference corresponding to 1 degree C of saturated suction temperature at evaporator conditions. Bulb charge shall be determined by the manufacturer for the application and such that liquid will remain in the bulb at all operating conditions. Gas limited liquid charged valves and other valve devices for limiting evaporator pressure shall not be used without a distributor or discharge tube or effective means to prevent loss of control when bulb becomes warmer than valve body. Pilot-operated valves shall have a characterized plug to provide required modulating control. A de-energized solenoid valve may be used in the pilot line to close the main valve in lieu of a solenoid valve in the main liquid line. An isolatable pressure gauge shall be provided in the pilot line, at the main valve. Automatic pressure reducing or constant pressure regulating expansion valves may be used only where indicated or for constant evaporator loads.

#### 2.4.5 Safety Relief Valves

Valve shall be the two-way type, unless indicated otherwise. Valve shall conform to JIS B 8225. Valve capacity shall be certified by the National Board of Boiler and Pressure Vessel Inspectors or Japan Boiler Association. Valve shall be of an automatically reseating design after activation.

#### 2.4.6 Evaporator Pressure Regulators, Direct-Acting

Valve shall include a diaphragm/spring assembly, external pressure adjustment with seal cap, and pressure gauge port. Valve shall maintain a constant inlet pressure by balancing inlet pressure on diaphragm against an adjustable spring load. Pressure drop at system design load shall not exceed the pressure difference corresponding to a 1 degree C change in saturated refrigerant temperature at evaporator operating suction temperature. Spring shall be selected for indicated maximum allowable suction pressure range.

#### 2.4.7 Refrigerant Access Valves

Refrigerant access valves and hose connections shall be in accordance with JIS B 8605.

### 2.5 PIPING ACCESSORIES

#### 2.5.1 Filter Driers

Sizes 15 mm and larger shall be the full flow, replaceable core type. Sizes 13 mm and smaller shall be the sealed type. Cores shall be of suitable desiccant that will not plug, cake, dust, channel, or break down, and shall remove water, acid, and foreign material from the refrigerant. Filter driers shall be constructed so that none of the desiccant will pass into the refrigerant lines. Minimum bursting pressure shall be 10.3 MPa.

#### 2.5.2 Sight Glass and Liquid Level Indicator

##### 2.5.2.1 Assembly and Components

Assembly shall be pressure- and temperature-rated and constructed of materials suitable for the service. Glass shall be borosilicate type. Ferrous components subject to condensation shall be electro-galvanized.

##### 2.5.2.2 Gauge Glass

Gauge glass shall include top and bottom isolation valves fitted with automatic checks, and packing followers; red-line or green-line gauge glass; elastomer or polymer packing to suit the service; and gauge glass guard.

##### 2.5.2.3 Bull's-Eye and Inline Sight Glass Reflex Lens

Bull's-eye and inline sight glass reflex lens shall be provided for dead-end liquid service. For pipe line mounting, two plain lenses in one body suitable for backlit viewing shall be provided.

##### 2.5.2.4 Moisture Indicator

Indicator shall be a self-reversible action, moisture reactive, color

changing media. Indicator shall be furnished with full-color-printing tag containing color, moisture and temperature criteria. Unless otherwise indicated, the moisture indicator shall be an integral part of each corresponding sight glass.

#### 2.5.3 Vibration Dampeners

Dampeners shall be of the all-metallic bellows and woven-wire type.

#### 2.5.4 Flexible Pipe Connectors

Connector shall be a composite of interior corrugated phosphor bronze or stainless steel, as required for fluid service, with exterior reinforcement of bronze, stainless steel or monel wire braid. Assembly shall be constructed with a safety factor of not less than 4 at 150 degrees C. Unless otherwise indicated, the length of a flexible connector shall be as recommended by the manufacturer for the service intended.

#### 2.5.5 Strainers

Strainers used in refrigerant service shall have brass or cast iron body, Y-or angle-pattern, cleanable, not less than 60-mesh noncorroding screen of an area to provide net free area not less than ten times the pipe diameter with pressure rating compatible with the refrigerant service. Screens shall be stainless steel or monel and reinforced spring-loaded where necessary for bypass-proof construction.

#### 2.5.6 Pressure and Vacuum Gauges

Gauges shall conform to MLIT-M and shall be provided with throttling type needle valve or a pulsation dampener and shut-off valve. Gauge shall be a minimum of 85 mm in diameter with a range from 0 kPa to approximately 1.5 times the maximum system working pressure. Each gauge range shall be selected so that at normal operating pressure, the needle is within the middle-third of the range.

#### 2.5.7 Temperature Gauges

Temperature gauges shall be the industrial duty type and be provided for the required temperature range. Gauges shall have Celsius scale in 1 degree graduations scale (black numbers) on a white face. The pointer shall be adjustable. Rigid stem type temperature gauges shall be provided in thermal wells located within 1.5 m of the finished floor. Universal adjustable angle type or remote element type temperature gauges shall be provided in thermal wells located 1.5 to 2.1 m above the finished floor. Remote element type temperature gauges shall be provided in thermal wells located 2.1 m above the finished floor.

##### 2.5.7.1 Stem Cased-Glass

Stem cased-glass case shall be polished stainless steel or cast aluminum, 229 mm long, with clear acrylic lens, and non-mercury filled glass tube with indicating-fluid column.

##### 2.5.7.2 Bimetallic Dial

Bimetallic dial type case shall be not less than 89 mm, stainless steel, and shall be hermetically sealed with clear acrylic lens. Bimetallic element shall be silicone damped and unit fitted with external

calibrator adjustment. Accuracy shall be one percent of dial range.

#### 2.5.7.3 Liquid-, Solid-, and Vapor-Filled Dial

Liquid-, solid-, and vapor-filled dial type cases shall be not less than 89 mm, stainless steel or cast aluminum with clear acrylic lens. Fill shall be nonmercury, suitable for encountered cross-ambients, and connecting capillary tubing shall be double-braided bronze.

#### 2.5.7.4 Thermal Well

Thermal well shall be identical size, 13 or 19 mm NPT connection, brass or stainless steel. Where test wells are indicated, provide captive plug-fitted type 13 mm NPT connection suitable for use with either engraved stem or standard separable socket thermometer or thermostat. Mercury shall not be used in thermometers. Extended neck thermal wells shall be of sufficient length to clear insulation thickness by 25 mm.

#### 2.5.8 Pipe Hangers, Inserts, and Supports

Pipe hangers, inserts, guides, and supports shall conform to MLIT-M.

#### 2.5.9 Escutcheons

Escutcheons shall be chromium-plated iron or chromium-plated brass, either one piece or split pattern, held in place by internal spring tension or set screws.

### 2.6 FABRICATION

#### 2.6.1 Factory Coating

Unless otherwise specified, equipment and component items, when fabricated from ferrous metal, shall be factory finished with the manufacturer's standard finish, except that items located outside of buildings shall have weather resistant finishes that will withstand [125] [500] hours exposure to the salt spray test specified in JIS Z 2371 using a 5 percent sodium chloride solution. Immediately after completion of the test, the specimen shall show no signs of blistering, wrinkling, cracking, or loss of adhesion and no sign of rust creepage beyond 3 mm on either side of the scratch mark. Cut edges of galvanized surfaces where hot-dip galvanized sheet steel is used shall be coated with a zinc-rich coating conforming to JIS H 8641.

#### 2.6.2 Factory Applied Insulation

[Refrigerant suction lines between the cooler and each compressor [and cold gas inlet connections to gas cooled motors]] [Refrigerant pumps and exposed chilled water lines on absorption chillers] shall be insulated with not less than 19 mm thick unicellular plastic foam. Factory insulated items installed outdoors are not required to be fire-rated. .

### PART 3 EXECUTION

#### 3.1 EXAMINATION

After becoming familiar with all details of the work, perform a verification of dimensions in the field. Submit a letter, at least [2] [\_\_\_\_\_] weeks prior to beginning construction, including the date the site

was visited, conformation of existing conditions, and any discrepancies found before performing any work.

### 3.2 INSTALLATION

Pipe and fitting installation shall conform to the requirements of MLIT-M. Cut pipe accurately to measurements established at the jobsite, and work into place without springing or forcing, completely clearing all windows, doors, and other openings. Cutting or other weakening of the building structure to facilitate piping installation are not permitted without written approval. Cut pipe or tubing square, removed by reaming, and permit free expansion and contraction without causing damage to the building structure, pipe, joints, or hangers.

#### 3.2.1 Directional Changes

Make changes in direction with fittings, except that bending of pipe 100 mm and smaller is permitted, provided a pipe bender is used and wide weep bends are formed. Mitering or notching pipe or other similar construction to form elbows or tees is not permitted. The centerline radius of bends shall not be less than 6 diameters of the pipe. Bent pipe showing kinks, wrinkles, flattening, or other malformations will not be accepted.

#### 3.2.2 Functional Requirements

Piping shall be installed 4 mm/m of pipe in the direction of flow to ensure adequate oil drainage. Open ends of refrigerant lines or equipment shall be properly capped or plugged during installation to keep moisture, dirt, or other foreign material out of the system. Piping shall remain capped until installation. Equipment piping shall be in accordance with the equipment manufacturer's recommendations and the contract drawings. Equipment and piping arrangements shall fit into space allotted and allow adequate acceptable clearances for installation, replacement, entry, servicing, and maintenance.

#### 3.2.3 Fittings and End Connections

##### 3.2.3.1 Threaded Connections

Make threaded connections with tapered threads and make tight with tape complying with JIS K 7137-2 thread-joint compound applied to the male threads only.

##### 3.2.3.2 Brazed Connections

Perform brazing in accordance with MLIT-M, except as modified herein. During brazing, fill the pipe and fittings with a pressure regulated inert gas, such as nitrogen, to prevent the formation of scale. Before brazing copper joints, clean both the outside of the tube and the inside of the fitting with a wire fitting brush until the entire joint surface is bright and clean. Do not use brazing flux. Remove surplus brazing material at all joints. Make steel tubing joints in accordance with the manufacturer's recommendations. Paint joints in steel tubing with the same material as the baked-on coating within 8 hours after joints are made. Protect tubing against oxidation during brazing by continuous purging of the inside of the piping using nitrogen. Support piping prior to brazing and do not spring or force.

### 3.2.3.3 Welded Connections

Welded joints in steel refrigerant piping shall be fusion-welded. Branch connections shall be made with welding tees or forged welding branch outlets. Pipe shall be thoroughly cleaned of all scale and foreign matter before the piping is assembled. During welding the pipe and fittings shall be filled with an inert gas, such as nitrogen, to prevent the formation of scale. Beveling, alignment, heat treatment, and inspection of weld shall conform to JIS Z 3821. Weld defects shall be removed and rewelded at no additional cost to the Government. Electrodes shall be stored and dried in accordance with JWES-Welding Technology Education Sheet or as recommended by the manufacturer. Electrodes that have been wetted or that have lost any of their coating shall not be used.

### 3.2.3.4 Flared Connections

When flared connections are used, a suitable lubricant shall be used between the back of the flare and the nut in order to avoid tearing the flare while tightening the nut.

### 3.2.3.5 Flanged Connections

When steel refrigerant piping is used, union or flange joints shall be provided in each line immediately preceding the connection to each piece of equipment requiring maintenance, such as compressors, coils, chillers, control valves, and other similar items. Flanged joints shall be assembled square end tight with matched flanges, gaskets, and bolts. Gaskets shall be suitable for use with the refrigerants to be handled.

## 3.2.4 Valves

### 3.2.4.1 General

Refrigerant stop valves shall be installed on each side of each piece of equipment such as compressors condensers, evaporators, receivers, and other similar items in multiple-unit installation, to provide partial system isolation as required for maintenance or repair. Stop valves shall be installed with stems horizontal unless otherwise indicated. Ball valves shall be installed with stems positioned to facilitate operation and maintenance. Isolating valves for pressure gauges and switches shall be external to thermal insulation. Safety switches shall not be fitted with isolation valves. Filter dryers having access ports may be considered a point of isolation. Purge valves shall be provided at all points of systems where accumulated noncondensable gases would prevent proper system operation. Valves shall be furnished to match line size, unless otherwise indicated or approved.

### 3.2.4.2 Expansion Valves

Expansion valves shall be installed with the thermostatic expansion valve bulb located on top of the suction line when the suction line is less than 54 mm in diameter and at the 4 o'clock or 8 o'clock position on lines larger than 54 mm. The bulb shall be securely fastened with two clamps. The bulb shall be insulated. The bulb shall be installed in a horizontal portion of the suction line, if possible, with the pigtails on the bottom. If the bulb must be installed in a vertical line, the bulb tubing shall be facing up.

### 3.2.4.3 Valve Identification

Each system valve, including those which are part of a factory assembly, shall be tagged. Tags shall be in alphanumeric sequence, progressing in direction of fluid flow. Tags shall be embossed, engraved, or stamped plastic or nonferrous metal of various shapes, sized approximately 40 mm diameter, substantially attached to a component or immediately adjacent thereto. Tags shall be attached with nonferrous, heavy duty, bead or link chain, 14 gauge annealed wire, nylon cable bands or as approved. Tag numbers shall be referenced in Operation and Maintenance Manuals and system diagrams.

### 3.2.5 Vibration Dampers

Vibration damper shall be provided in the suction and discharge lines on spring mounted compressors. Vibration dampers shall be installed parallel with the shaft of the compressor and shall be anchored firmly at the upstream end on the suction line and the downstream end in the discharge line.

### 3.2.6 Strainers

Strainers shall be provided immediately ahead of solenoid valves and expansion devices. Strainers may be an integral part of an expansion valve.

### 3.2.7 Filter Dryer

A liquid line filter dryer shall be provided on each refrigerant circuit located such that all liquid refrigerant passes through a filter dryer. Dryers shall be sized in accordance with the manufacturer's recommendations for the system in which it is installed. Dryers shall be installed such that it can be isolated from the system, the isolated portion of the system evacuated, and the filter dryer replaced. Dryers shall be installed in the horizontal position except replaceable core filter dryers may be installed in the vertical position with the access flange on the bottom.

### 3.2.8 Sight Glass

A moisture indicating sight glass shall be installed in all refrigerant circuits down stream of all filter dryers and where indicated. Site glasses shall be full line size.

### 3.2.9 Discharge Line Oil Separator

Discharge line oil separator shall be provided in the discharge line from each compressor. Oil return line shall be connected to the compressor as recommended by the compressor manufacturer.

### 3.2.10 Accumulator

Accumulators shall be provided in the suction line to each compressor.

### 3.2.11 Flexible Pipe Connectors

Connectors shall be installed perpendicular to line of motion being isolated. Piping for equipment with bidirectional motion shall be fitted with two flexible connectors, in perpendicular planes. Reinforced

elastomer flexible connectors shall be installed in accordance with manufacturer's instructions. Piping guides and restraints related to flexible connectors shall be provided as required.

### 3.2.12 Temperature Gauges

Temperature gauges shall be located specifically on, but not limited to the following: [the sensing element of each automatic temperature control device where a thermometer is not an integral part thereof] [the liquid line leaving a receiver] [and] [the suction line at each evaporator or liquid cooler]. Thermal wells for insertion thermometers and thermostats shall extend beyond thermal insulation surface not less than 25 mm.

### 3.2.13 Pipe Hangers, Inserts, and Supports

Pipe hangers, inserts, and supports shall conform to MLIT-M, except as modified herein. Hangers used to support piping 50 mm and larger shall be fabricated to permit adequate adjustment after erection while still supporting the load. Piping subjected to vertical movement, when operating temperatures exceed ambient temperatures, shall be supported by variable spring hangers and supports or by constant support hangers.

#### 3.2.13.1 Horizontal Pipe Supports

Horizontal pipe supports shall be spaced as specified in MLIT-M and a support shall be installed not over 300 mm from the pipe fitting joint at each change in direction of the piping. Pipe supports shall be spaced not over 1.5 m apart at valves. [Pipe hanger loads suspended from steel joist with hanger loads between panel points in excess of 23 kg shall have the excess hanger loads suspended from panel points.]

#### 3.2.13.2 Vertical Pipe Supports

Vertical pipe shall be supported at each floor, except at slab-on-grade, and at intervals of not more than 4.5 m not more than 2.4 m from end of risers, and at vent terminations.

#### 3.2.13.3 Multiple Pipe Runs

In the support of multiple pipe runs on a common base member, a clip or clamp shall be used where each pipe crosses the base support member. Spacing of the base support members shall not exceed the hanger and support spacing required for an individual pipe in the multiple pipe run.

#### 3.2.13.4 Seismic Requirements

Piping and attached valves shall be supported and braced to resist seismic loads as specified under Building equipment seismic design & construction guidelines 2014 Edition.

#### 3.2.13.5 Structural Attachments

Attachment to building structure concrete and masonry shall be by cast-in concrete inserts, built-in anchors, or masonry anchor devices. Inserts and anchors shall be applied with a safety factor not less than 5. Supports shall not be attached to metal decking. Masonry anchors for overhead applications shall be constructed of ferrous materials only. Structural steel brackets required to support piping, headers, and equipment, but not shown, shall be provided under this section.

### 3.2.14 Pipe Alignment Guides

Pipe alignment guides shall be provided where indicated for expansion loops, offsets, and bends and as recommended by the manufacturer for expansion joints, not to exceed 1.5 m on each side of each expansion joint, and in lines 100 mm or smaller not more than 600 mm on each side of the joint.

### 3.2.15 Pipe Anchors

Anchors shall be provided wherever necessary or indicated to localize expansion or to prevent undue strain on piping. Anchors shall consist of heavy steel collars with lugs and bolts for clamping and attaching anchor braces, unless otherwise indicated. Anchor braces shall be installed in the most effective manner to secure the desired results using turnbuckles where required. Supports, anchors, or stays shall not be attached where they will injure the structure or adjacent construction during installation or by the weight of expansion of the pipeline. Where pipe and conduit penetrations of vapor barrier sealed surfaces occur, these items shall be anchored immediately adjacent to each penetrated surface, to provide essentially zero movement within penetration seal. Detailed drawings of pipe anchors shall be submitted for approval before installation.

### 3.2.16 Building Surface Penetrations

Sleeves shall not be installed in structural members except where indicated or approved. Sleeves in nonload bearing surfaces shall be galvanized sheet metal, conforming to JIS G 3302, 1.0 mm (20 gauge). Sleeves in load bearing surfaces shall be uncoated carbon steel pipe, conforming to JIS G 3454, [Schedule 30] [Schedule 20] [Standard weight]. Sealants shall be applied to moisture and oil-free surfaces and elastomers to not less than 13 mm depth. Sleeves shall not be installed in structural members.

#### 3.2.16.1 Refrigerated Space

Refrigerated space building surface penetrations shall be fitted with sleeves fabricated from hand-lay-up or helically wound, fibrous glass reinforced polyester or epoxy resin with a minimum thickness equal to equivalent size Schedule 40 steel pipe. Sleeves shall be constructed with integral collar or cold side shall be fitted with a bonded slip-on flange or extended collar. In the case of masonry penetrations where sleeve is not cast-in, voids shall be filled with latex mixed mortar cast to shape of sleeve and flange/external collar type sleeve shall be assembled with butyl elastomer vapor barrier sealant through penetration to cold side surface vapor barrier overlap and fastened to surface with masonry anchors. Integral cast-in collar type sleeve shall be flashed [with not less than 100 mm of cold side vapor barrier overlap of sleeve surface.] Normally noninsulated penetrating round surfaces shall be sealed to sleeve bore with mechanically expandable seals in vapor tight manner and remaining warm and cold side sleeve depth shall be insulated with not less than [100] [\_\_\_\_\_] mm of foamed-in-place rigid polyurethane or foamed-in-place silicone elastomer. Vapor barrier sealant shall be applied to finish warm side insulation surface. Warm side of penetrating surface shall be insulated beyond vapor barrier sealed sleeve insulation for a distance which prevents condensation. Wires in refrigerated space surface penetrating conduit shall be sealed with vapor barrier plugs or

compound to prevent moisture migration through conduit and condensation therein.

### 3.2.16.2 General Service Areas

Each sleeve shall extend through its respective wall, floor, or roof, and shall be cut flush with each surface. Pipes passing through concrete or masonry wall or concrete floors or roofs shall be provided with pipe sleeves fitted into place at the time of construction. Sleeves shall be of such size as to provide a minimum of 6 mm all-around clearance between bare pipe and sleeves or between jacketed-insulation and sleeves. Except in pipe chases or interior walls, the annular space between pipe and sleeve or between jacket over-insulation and sleeve shall be sealed in accordance with Section 07 92 00 JOINT SEALANTS.

### 3.2.16.3 Waterproof Penetrations

Pipes passing through roof or floor waterproofing membrane shall be installed through a 5.17 kg/sq. m copper sleeve, or a 0.81 mm thick aluminum sleeve, each within an integral skirt or flange. Flashing sleeve shall be suitably formed, and skirt or flange shall extend not less than 200 mm from the pipe and be set over the roof or floor membrane in a troweled coating of bituminous cement. The flashing sleeve shall extend up the pipe a minimum of 50 mm above the roof or floor penetration. The annular space between the flashing sleeve and the bare pipe or between the flashing sleeve and the metal-jacket-covered insulation shall be sealed as indicated. Penetrations shall be sealed by either one of the following methods.

#### 3.2.16.3.1 Waterproofing Clamping Flange

Pipes up to and including 250 mm in diameter passing through roof or floor waterproofing membrane may be installed through a cast iron sleeve with caulking recess, anchor lugs, flashing clamp device, and pressure ring with brass bolts. Waterproofing membrane shall be clamped into place and sealant shall be placed in the caulking recess.

#### 3.2.16.3.2 Modular Mechanical Type Sealing Assembly

In lieu of a waterproofing clamping flange and caulking and sealing of annular space between pipe and sleeve or conduit and sleeve, a modular mechanical type sealing assembly may be installed. Seals shall consist of interlocking synthetic rubber links shaped to continuously fill the annular space between the pipe/conduit and sleeve with corrosion protected carbon steel bolts, nuts, and pressure plates. Links shall be loosely assembled with bolts to form a continuous rubber belt around the pipe with a pressure plate under each bolt head and each nut. After the seal assembly is properly positioned in the sleeve, tightening of the bolt shall cause the rubber sealing elements to expand and provide a watertight seal rubber sealing elements to expand and provide a watertight seal between the pipe/conduit seal between the pipe/conduit and the sleeve. Each seal assembly shall be sized as recommended by the manufacturer to fit the pipe/conduit and sleeve involved. The Contractor electing to use the modular mechanical type seals shall provide sleeves of the proper diameters.

### 3.2.16.4 Fire-Rated Penetrations

Penetration of fire-rated walls, partitions, and floors shall be sealed as

specified in Section 07 84 00 FIRESTOPPING.

#### 3.2.16.5 Escutcheons

Finished surfaces where exposed piping, bare or insulated, pass through floors, walls, or ceilings, except in boiler, utility, or equipment rooms, shall be provided with escutcheons. Where sleeves project slightly from floors, special deep-type escutcheons shall be used. Escutcheon shall be secured to pipe or pipe covering.

#### 3.2.17 Access Panels

Access panels shall be provided for all concealed valves, vents, controls, and items requiring inspection or maintenance. Access panels shall be of sufficient size and located so that the concealed items may be serviced and maintained or completely removed and replaced. Access panels shall be as specified in Section 05 50 13 MISCELLANEOUS METAL FABRICATIONS.

#### 3.2.18 Field Applied Insulation

Field installed insulation shall be as specified in Section 23 07 00 THERMAL INSULATION FOR MECHANICAL SYSTEMS, except as defined differently herein.

#### 3.2.19 Field Painting

Painting required for surfaces not otherwise specified, and finish painting of items only primed at the factory are specified in Section 09 90 00 PAINTS AND COATINGS.

##### 3.2.19.1 Color Coding

Color coding for piping identification is specified in Section 09 90 00 PAINTS AND COATINGS.

##### 3.2.19.2 Color Coding Scheme

A color coding scheme for locating hidden piping shall be in accordance with [Section 22 00 00 PLUMBING, GENERAL PURPOSE][Section 22 00 70 PLUMBING, HEALTHCARE FACILITIES].

#### 3.2.20 Identification Tags

Provide identification tags made of brass, engraved laminated plastic or engraved anodized aluminum indicating service and item number on all valves and dampers. Tags shall be 35 mm minimum diameter and marking shall be stamped or engraved. Indentations shall be black for reading clarity. Tags shall be attached to valves with No. 12 AWG copper wire, chrome-plated beaded chain or plastic straps designed for that purpose.

### 3.3 CLEANING AND ADJUSTING

Clean uncontaminated system(s) by evacuation and purging procedures currently recommended by refrigerant and refrigerant equipment manufacturers, and as specified herein, to remove small amounts of air and moisture. Systems containing moderate amounts of air, moisture, contaminated refrigerant, or any foreign matter shall be considered contaminated systems. Restoring contaminated systems to clean condition including disassembly, component replacement, evacuation, flushing,

purging, and re-charging, shall be performed using currently approved refrigerant and refrigeration manufacturer's procedures. Restoring contaminated systems shall be at no additional cost to the Government as determined by the Contracting Officer. Water shall not be used in any procedure or test.

### 3.4 REFRIGERANT PIPING TESTS

After all components of the refrigerant system have been installed and connected, subject the entire refrigeration system to pneumatic, evacuation, and startup tests as described herein. Submit a schedule, at least [2] [\_\_\_\_\_] weeks prior to the start of related testing, for each test. Identify the proposed date, time, and location for each test. Conduct tests in the presence of the Contracting Officer. Water and electricity required for the tests will be furnished by the Government. Provide all material, equipment, instruments, and personnel required for the test. Provide the services of a qualified technician, as required, to perform all tests and procedures indicated herein. Field tests shall be coordinated with Section 23 05 93 TESTING, ADJUSTING, AND BALANCING OF HVAC SYSTEMS. Submit [6] [\_\_\_\_\_] copies of the tests report in bound 216 by 279 mm booklets documenting all phases of the tests performed. The report shall include initial test summaries, all repairs/adjustments made, and the final test results.

#### 3.4.1 Preliminary Procedures

Prior to pneumatic testing, equipment which has been factory tested and refrigerant charged as well as equipment which could be damaged or cause personnel injury by imposed test pressure, positive or negative, shall be isolated from the test pressure or removed from the system. Safety relief valves and rupture discs, where not part of factory sealed systems, shall be removed and openings capped or plugged.

#### 3.4.2 Pneumatic Test

Pressure control and excess pressure protection shall be provided at the source of test pressure. Valves shall be wide open, except those leading to the atmosphere. Test gas shall be dry nitrogen, with minus 55 degrees C dewpoint and less than 5 ppm oil. Test pressure shall be applied in two stages before any refrigerant pipe is insulated or covered. First stage test shall be at 69 kPa with every joint being tested with a thick soap or color indicating solution. Second stage tests shall raise the system to the minimum refrigerant leakage test pressure, with a maximum test pressure 25 percent greater. Pressure above 690 KPa shall be raised in 10 percent increments with a pressure acclimatizing period between increments. The initial test pressure shall be recorded along with the ambient temperature to which the system is exposed. Final test pressures of the second stage shall be maintained on the system for a minimum of 24 hours. At the end of the 24 hour period, the system pressure will be recorded along with the ambient temperature to which the system is exposed. A correction factor of 2 kPa will be allowed for each degree C change between test space initial and final ambient temperature, plus for increase and minus for a decrease. If the corrected system pressure is not exactly equal to the initial system test pressure, then the system shall be investigated for leaking joints. To repair leaks, the joint shall be taken apart, thoroughly cleaned, and reconstructed as a new joint. Joints repaired by caulking, remelting, or back-welding/brazing shall not be acceptable. Following repair, the entire system shall be retested using the pneumatic tests described above. The entire system

shall be reassembled once the pneumatic tests are satisfactorily completed.

#### 3.4.3 Evacuation Test

Following satisfactory completion of the pneumatic tests, the pressure shall be relieved and the entire system shall be evacuated to an absolute pressure of 300 micrometers. During evacuation of the system, the ambient temperature shall be higher than 2 degrees C. No more than one system shall be evacuated at one time by one vacuum pump. Once the desired vacuum has been reached, the vacuum line shall be closed and the system shall stand for 1 hour. If the pressure rises over 500 micrometers after the 1 hour period, then the system shall be evacuated again down to 300 micrometers and let set for another 1 hour period. The system shall not be charged until a vacuum of at least 500 micrometers is maintained for a period of 1 hour without the assistance of a vacuum line. If during the testing the pressure continues to rise, check the system for leaks, repair as required, and repeat the evacuation procedure. During evacuation, pressures shall be recorded by a thermocouple-type, electronic-type, or a calibrated-micrometer type gauge.

#### 3.4.4 System Charging and Startup Test

Following satisfactory completion of the evacuation tests, the system shall be charged with the required amount of refrigerant by raising pressure to normal operating pressure and in accordance with manufacturer's procedures. Following charging, the system shall operate with high-side and low-side pressures and corresponding refrigerant temperatures, at design or improved values. The entire system shall be tested for leaks. Fluorocarbon systems shall be tested with halide torch or electronic leak detectors.

#### 3.4.5 Refrigerant Leakage

If a refrigerant leak is discovered after the system has been charged, the leaking portion of the system shall immediately be isolated from the remainder of the system and the refrigerant pumped into the system receiver or other suitable container. Under no circumstances shall the refrigerant be discharged into the atmosphere.

#### 3.4.6 Contractor's Responsibility

At all times during the installation and testing of the refrigeration system, take steps to prevent the release of refrigerants into the atmosphere. The steps shall include, but not be limited to, procedures which will minimize the release of refrigerants to the atmosphere and the use of refrigerant recovery devices to remove refrigerant from the system and store the refrigerant for reuse or reclaim. At no time shall more than 85 g of refrigerant be released to the atmosphere in any one occurrence. Any system leaks within the first year shall be repaired in accordance with the requirements herein at no cost to the Government including material, labor, and refrigerant if the leak is the result of defective equipment, material, or installation.

-- End of Section --