

No Heat! No Flame
Never Burn a Valve Again

TXV &

**SOLDERLESS
BONDING**

REVERSING VALVE

INSTALLATION KIT

LIFETIME PERMANENT BOND FOR • COPPER • BRASS • ALUMINUM



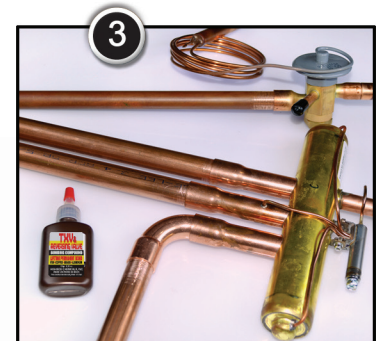
TXV & Reversing Valve Installation Kit™ is a chemical weld that permanently bonds Copper, Brass, or Aluminum in any combination through an anaerobic chemical reaction. The bond between the metals is very strong and will withstand 450 lbs./ft. of twisting torque and hold up to 1200 psi of pressure and 350 degrees Fahrenheit .

The TXV & Reversing Valve Installation Kit™ - eliminates the risk of burning up the TXV Valve or the Reversing Valve during installation by removing the need for fire or heat.

There is no need for a fire permit or fire prevention materials. This also avoids damage to sensors or electronic circuits like the TXV's service modules. With a twenty minute cure time this creates a permanent bond that will last the lifetime of the equipment.

TXV & Reversing Valve Bonding Compound™

is an innovative, single-part, braze-less, solderless bonding product that is easy to use. Specifically formulated for copper, brass and aluminum fittings used in HVAC systems.

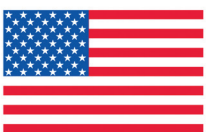


Easy as 1 - 2 - 3

1. Clean the pipe and connector with 60 grit emery cloth
2. Apply TXV & Reversing Valve Bonding Compound™ to both male and female surfaces.
3. Insert pipe into fitting and hold for 10 seconds



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10g .35 oz

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Highside Chemical Products are available through local wholesalers and distributors worldwide.

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TXV and Reversing Valve Installation Kit™ Bonding Compound is not sticky and is not activated until installation. You can prepare your male and female unions individually and assemble in any order as required by site requirements. However, you can also prepare all of your male and female unions and install all of them at the same time. This makes installation easier and faster. For more amazing products like HVAC Super Pro™ and Leak Lock® go to Highsidechem.com.

STEP 1: Verify that pipe and valve are round and that the connector I.D. is a minimum of 0.010 larger than the tubing O.D.

STEPS 2: Sand the inside of connector and outside of pipe using 60 grit emery cloth. **Do not use Scotchbrite or other metal abrasives including a wire brush.** To sand the inside of a connector, roll the sanding cloth and insert into the connector and rotate. **(NOTE: DO NOT WIPE THE SANDED AREA OR CLEAN IT WITH A CLOTH OR SOLVENT – LEAVE THE SANDING DUST ON THE PIPE AND CONNECTOR.)**

STEP 3: Cut the tip from the TXV & Reversing Valve™ Bonding Compound bottle. (Note: The orifice should be small.) Shake the bottle and squeeze a small amount (one or two drops) out and discard (this is the product that is in the tip of the tube and does not get mixed well.)

STEPS 4: Apply a small bead of TXV & Reversing Valve™ Bonding Compound around the inner circumference of the connector, and the outer circumference of the pipe. If you cannot correctly apply TXV & Reversing Valve™ Bonding Compound from the bottle into the inside of a connector or underneath a pipe, use a tooth pick to spread the TXV & Reversing Valve™ Bonding Compound around the inside of the connector and underneath the pipe. **(NOTE: NEVER USE A Q-TIP AS THE COTTON PORTION OF A Q-TIP ABSORBS THE TXV & Reversing Valve™ Bonding Compound AND LEAVES DRY AREAS THAT WILL RESULT IN LEAKS.)** You may use a non-metallic tool to spread TXV & Reversing Valve™ Bonding Compound. Spread the TXV & Reversing Valve™ Bonding Compound around the entire bonding area on the pipe – making sure that no area is wiped dry. Be sure to leave a complete coat of TXV & Reversing Valve Bonding Compound™.

STEPS 5: Insert pipe into connector and hold for 10 seconds. Let the bond sit undisturbed for 3 minutes. After 3 minutes the bond is insufficient to continue working or handling. (For aluminum, allow bond to set for 5 minutes undisturbed.)

NOTE: After 12 minutes on copper or brass (20 minutes on aluminum), the bond is ready for a vacuum or pressure test and will withstand a minimum of 1200 psi.

WARNING! CAUTIONS: TXV & Reversing Valve Bonding Compound™ is NON-Toxic. Do not induce vomiting. Contact physician. **IF ON SKIN:** Wash with soap and water. **IF IN EYES:** Flush with water for 15 minutes and contact physician. This bottle intentionally filled 1/3 full.

Part Number: **32100**

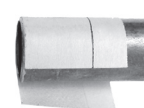
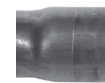


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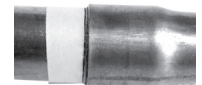
IMPORTANT SPACING

Make sure the tubing fits properly inside the connector. The tubing must have a minimum of five thousandths of an inch clearance completely around the connector. A good way to check the minimum clearance is



to wrap a sheet of paper, like a sticky

note, around the tubing. The tubing, with the paper wrapped around it, should be able to be inserted into the connector without damaging the paper. If the clearance is too tight, use a swaging tool



to enlarge the connector; otherwise, the TXV & Reversing Valve™ Bonding Compound™ will be wiped from the bonding area as the tube is inserted into the connector and the bond will not hold. The maximum clearance allowed between the tubing and the connector is 20 thousandths of an inch.