



**JB INDUSTRIES**

In Exclusive Partnership with *FastTest*

**CoreMax**<sup>®</sup>

**CoreMax<sup>®</sup> Integrated System for Rapid Evacuation and Refrigerant Charging**

# Seat Installation

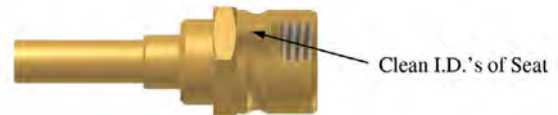
## Stub Tube, Saddle Mount and NPT Seat Installation

**Description:** Installation instructions between Core and Seat. Please thoroughly read the following steps on properly installing Core to Seat.



**Steps 3 - 4 apply to all style seats.**

**3.** Make sure there is no contamination in the I.D. of the Seat, especially the o-ring groove.



**4.** Make sure the o-ring on the Core is free of contamination and foreign particulates. Lightly lubricate with compatible refrigerant oil.



**INSTALLATION PROCEDURE FOR ALL SEATS AND CORES:**

**1.** CoreMax Cores should remain in protective packaging until assembly is required to ensure cleanliness and eliminate damage. Just prior to assembly remove the CoreMax Core from packaging tray.

**5.** Thread Core into Seat and torque clockwise to 8 ft-lb's.

**2.** Braze SEAT ONLY onto tube or valve block before installing/threading Core into Seat.





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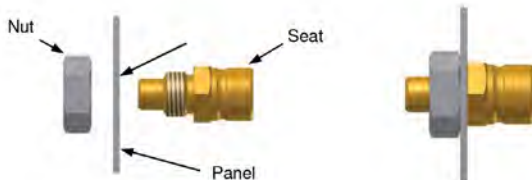
### Access Valve Installation

**Description:** Installation instructions of the Nut and Clip Style Seat Panel Mounts.

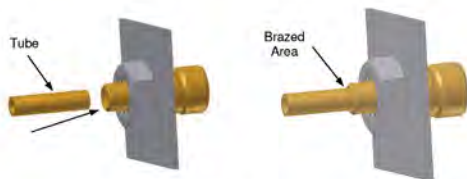
#### Nut Style Panel Mount

1. CoreMax Cores should remain in protective packaging until assembly is required to ensure cleanliness and eliminate damage. Just prior to assembly remove the CoreMax Core from packaging tray.

2. Insert seat thru hole in panel and thread nut onto seat.

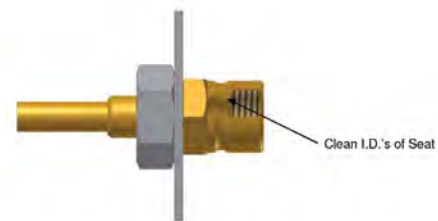


3. Braze SEAT ONLY onto tube or valve block before installing/threading Core into seat.



Example: Tube brazed to Seat

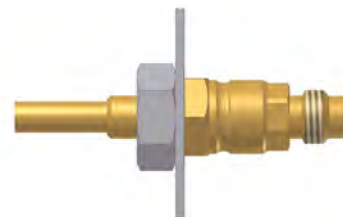
4. Make sure there is no contamination in the I.D. of seat, especially the o-ring groove.



5. Inspect the Core to ensure the o-ring is free of contamination and foreign particulates. Lightly lubricate with compatible refrigerant oil.



6. Thread Core into Seat and torque clockwise to 8 ft-lb's.



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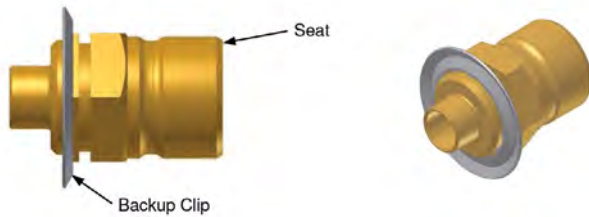
### Access Valve Installation

**Description:** Installation instructions of the Nut and Clip Style Seat Panel Mounts.

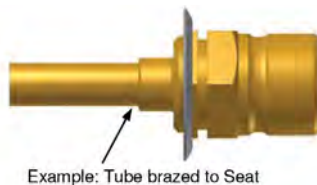
#### Clip Style Panel Mount

1. Cores should remain in protective packaging until assembly is required to ensure cleanliness and eliminate damage. Just prior to assembly remove the CoreMax Core from packaging tray.

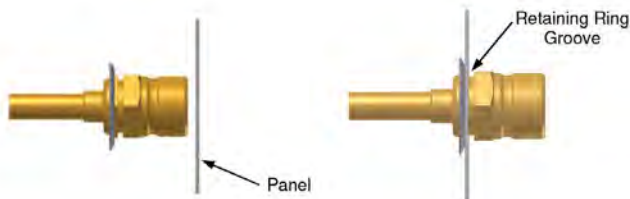
2. Push the self-locking retaining ring (Backup Clip) onto seat as shown.



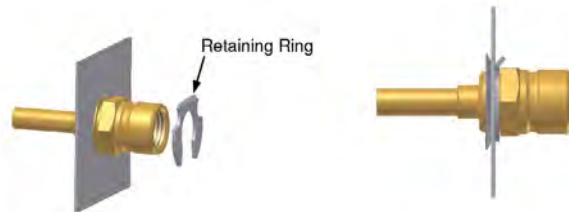
3. Braze SEAT ONLY onto tube or valve block before installing/threading Core into seat.



4. Install seat thru hole in panel up to the Backup Clip. Hole in panel must be larger than the hex corners.



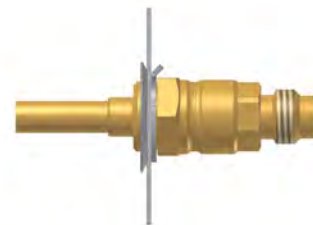
5. Install retaining ring into groove on the seat.



6. Make sure the I.D. of seat is clean, and then inspect the Core to ensure the o-rings is free of contamination and foreign particulates. Lightly lubricate with compatible refrigerant oil.



7. Thread Core into seat and torque clockwise to 8 ft-lb's.



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