

Installation guide

# Filter drier, shell

## Type DCR for CO<sub>2</sub> Application



023R9548

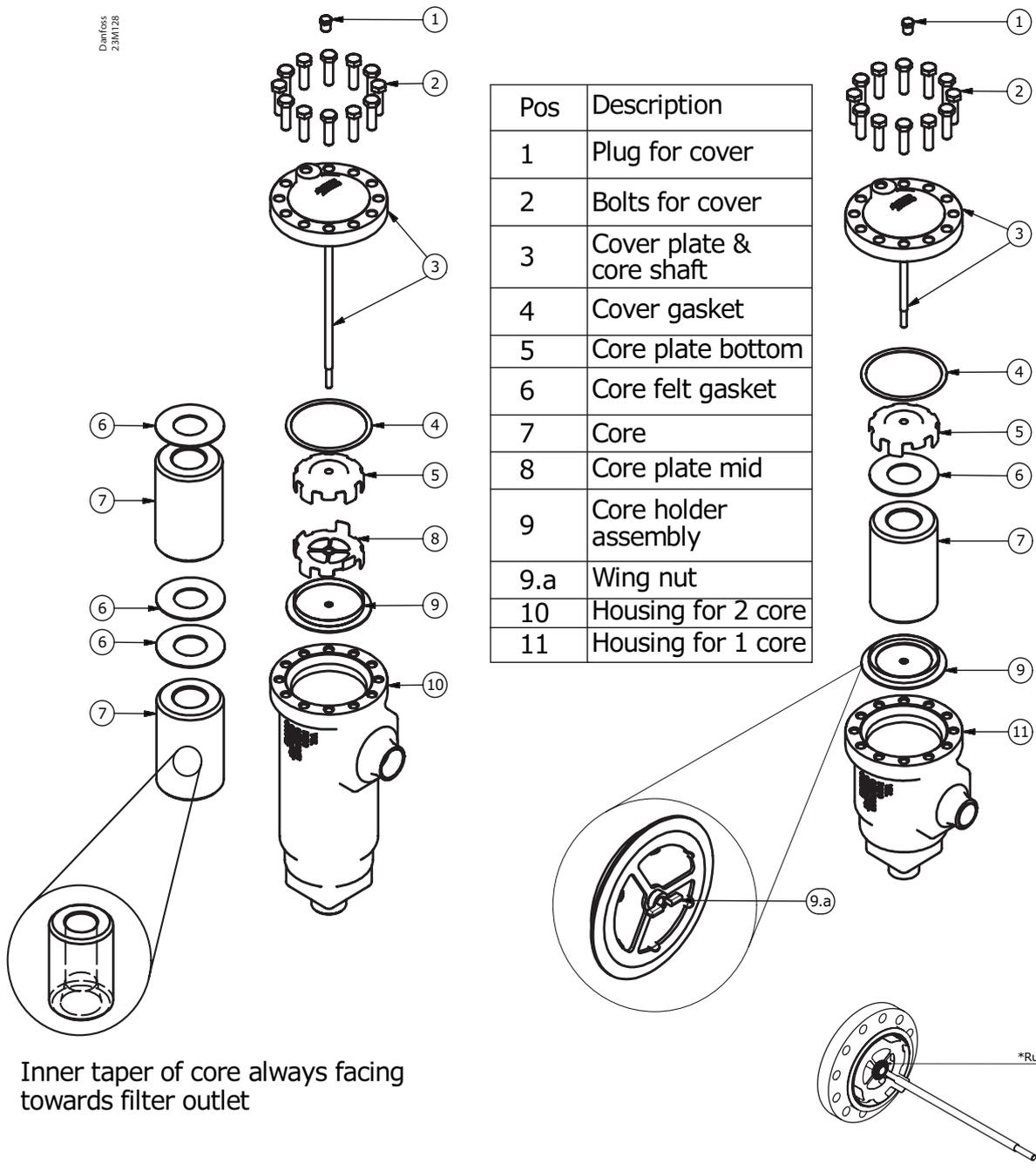
023R9548

**Refrigerants:**

CO<sub>2</sub> (sub critical and trans critical system)

Media Temperature: -55 to 100 °C / -67 to 212 °F  
Maximum working pressure (PS/MWP): 90bar / 1305 psig

**Design**



Pos	Description
1	Plug for cover
2	Bolts for cover
3	Cover plate & core shaft
4	Cover gasket
5	Core plate bottom
6	Core felt gasket
7	Core
8	Core plate mid
9	Core holder assembly
9.a	Wing nut
10	Housing for 2 core
11	Housing for 1 core

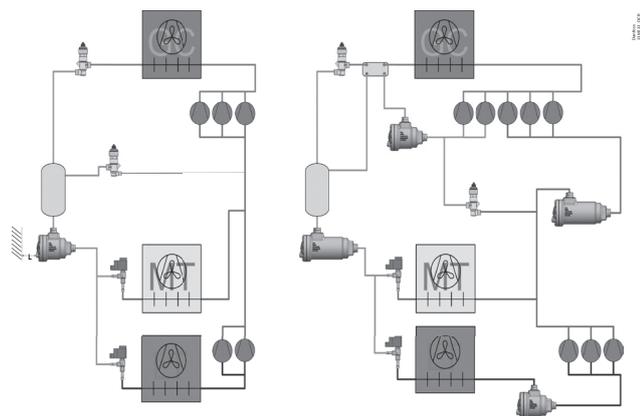
Inner taper of core always facing towards filter outlet

\*Remove the rubber bush while making assembly.

Імпортер: ТОВ з іі "Данфосс ТОВ" 04080, Київ 80, п/с 168, Україна

Info for UK customers only: Danfoss Ltd., 22 Wycombe End, HP9 1NB, GB

## Installation



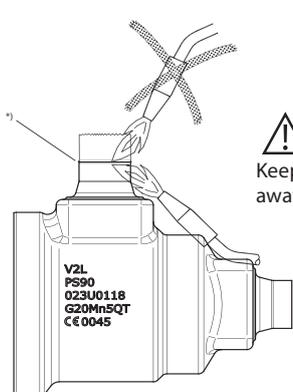
Type	L minimum	
	[mm]	[in]
DCR 048	250	9.8
DCR 096	400	15.8



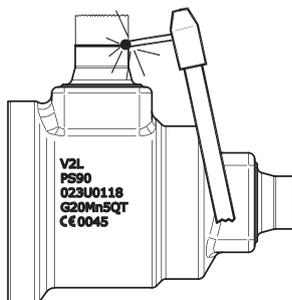
Be careful of liquid refrigerant trap in the system as may result in very high internal pressures while heated up. Ensure proper pump down before removing the DCR cover. Also drain out residual refrigerant before removing cover bolts.

## Brazing

## Welding



Keep flames away from body



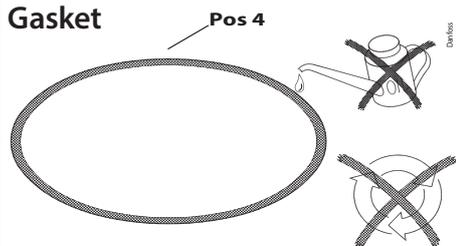
Connector type *	Brazing material
Steel	Silver-flo 55 + Easy-flow flux

Danfoss 310821

Customer best practice will still be needed:

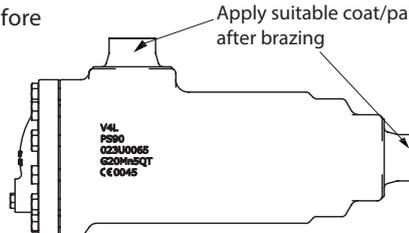
- Remove cover assembly before brazing/welding.
- Do not remove core shaft from the cover.
- Brazing/Welding of the joints to be done by certified welder.
- Let them cool down.
- Clean the brazing /welding area after the installation (remove remaining flux with a brush).
- This is an important operation and needs to be done with great care to remove all remaining flux.
- The external surface has TLP(Zink) coating to protect corrosion, however we recommend painting the DCR after installation for maximum corrosion protection.
- After brazing/welding use suitable coating on the connector surface to avoid any rust in the field.

## Gasket



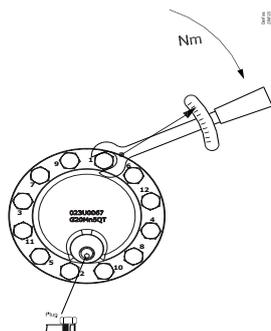
Do not install DCR insert before Brazing / welding

Apply suitable coat/paint after brazing



Note: Confirm correct top cover gasket is selected for DCR  
Do not reuse the gasket  
Do not use Oil/Grease on Gasket

## How to tighten the bolts



### DCR Bolts M12\*1.75

Step 1	Finger tight all the bolts
Step 2	10 N.m/7.4 lbf.ft
Step 3	20 N.m/15 lbf.ft
Step 4	40 N.m/30 lbf.ft
Step 5	80 N.m /59 lbf.ft

\* Repeat until complete tightness has been reached.

Component	Size	Torque (N.m/ lbf.ft)
Cover bolts	M12*1.75	80/59
Plug**	1/4" NPT	50/37
Plug**	1/2" G	50/37
Core Shaft	M10	30/22
Wing nut	M8	1.5 /1.10 (Hand tight)



Note:

\*\* Replace the plug for example with schrader/ Needle valve etc..