

CATALOG No. **STF-2505G3**
 MANUFACTURING No. **7228**
 MAX. WORKING PRESSURE **PS 45.0bar**
 FLUID TEMPERATURE **TS -30/140°C**

MFG NO. EXAMPLE
 7 22 8
 YEAR
 DAY
 MONTH

1~9: JAN. ~SEP.
 X: OCTOBER
 Y: NOVEMBER
 Z: DECEMBER

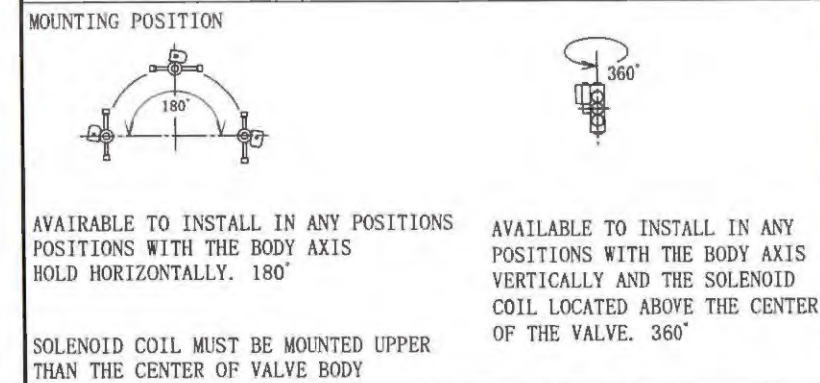
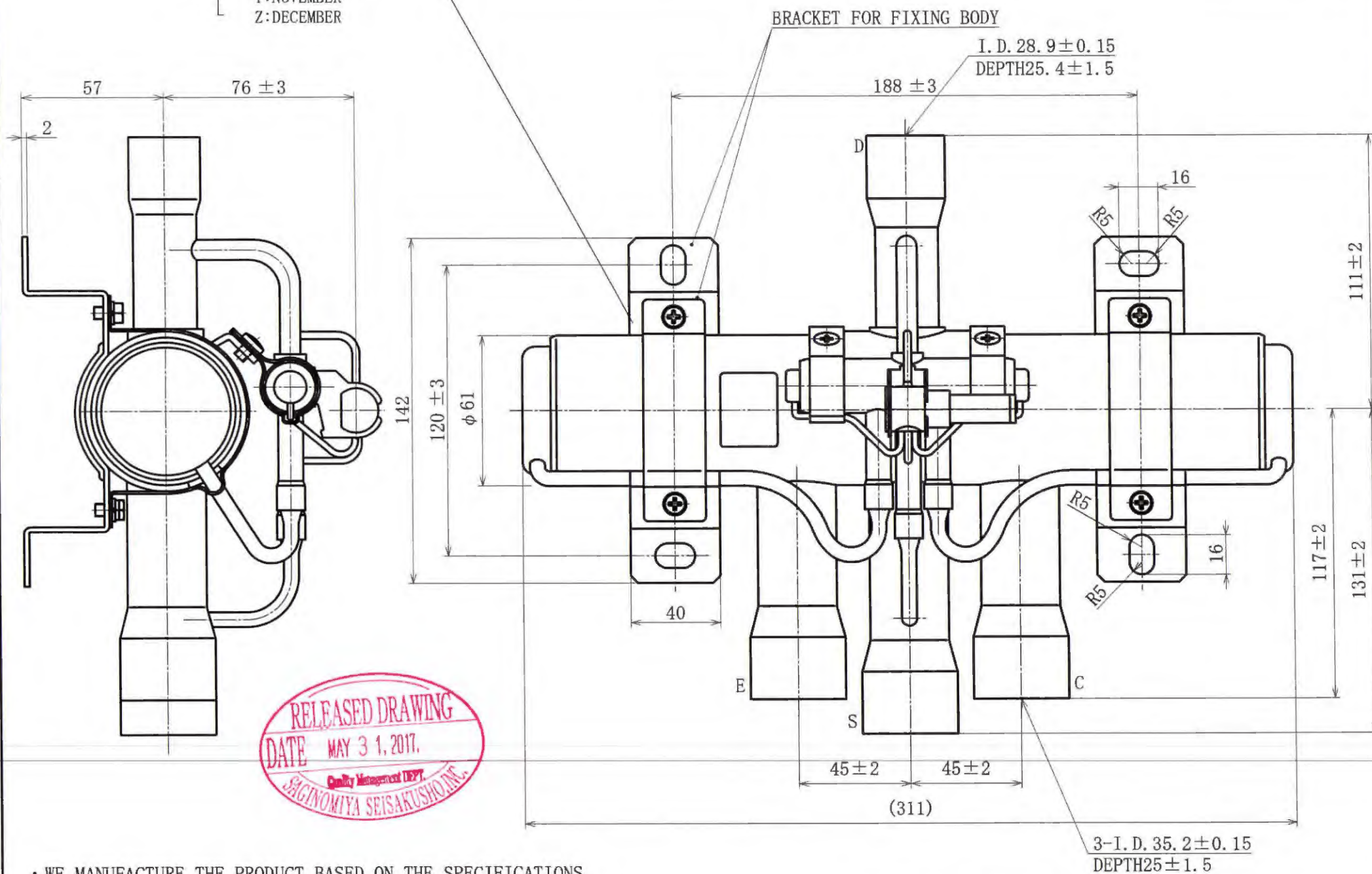
DRAGAGE
STF-2505G3
7228
PS 45.0bar
TS -30/140°C
EAC
CE
 FOSHAN HUALU
 AUTOMATIC CONTROLS LTD.
 MADE IN CHINA

HANDLING NOTICE

- When use the 4-Way Reversing Valves, please check products' adaptability to whole system. If the products could not adapt the whole system, malfunction such as abnormal pressure increase at High Pressure Side and / or incapability of change over, etc will take a place.
- In order to keep temperature of the valve body under 130°C, cooling the valve body with water or wet waste during brazing the joints. (Be sure not to wet the products inside.) If not cool enough, it may cause of melting of inside resin. Besides foreign matter such as oxidation scale may cause of valve leakage and malfunction.
- When mounting the solenoid coil, the fixing screw must be tightened with 1.47~1.96 N·m torque.
- External force by impact, etc to the valve body will be cause of deformation and malfunction.

SPECIFICATIONS

WATER TEST PRESSURE	WITH WATER PRESSURE 6.44 MPa { 64.4 bar }
AIRTIGHT TEST PRESSURE	WITH AIR PRESSURE 4.5 MPa { 45.0 bar }
MAX. WORKING PRESSURE	4.5 MPa { 45.0 bar }
CONNECTION	ILLUSTRATE
FLUID	R410A
PORT SIZE	28 mm
VALVE OPERATION	PILOT OPERATED 4-WAY REVERSING VALVE
DURABILITY	10000 TIMES TESTED BY AIR PRESSURE UNDER DISCHARGE PRESSURE 2.5 MPa, {25 bar} SUCTION TUBE OPEN TO ATMOSPHERE AND BODY TEMP. NORMAL TEMPERATURE (LUB. OIL APPLIED DURING THE TEST)
MAX. OPERATING PRESS. DIFFERENTIAL	3.1 MPa {31 bar}
MIN. OPERATING PRESS. DIFFERENTIAL	0.3 MPa {3 bar}
VALVE LEAKAGE	10000 cm ³ /min. OR LESS WITH AIR UNDER O. P. D. 1 MPa {10 bar} AND BODY TEMP. NORMAL TEMPERATURE BUT 15000 cm ³ /min. OR LESS AFTER THE DURABILITY TEST.
CAPACITY	52 ~ 94 kW
MIN. OPERATING VOLTAGE	*1 85% OR LESS OF RATED VOLTAGE AT ΔP 2.5 MPa {25 bar}
AMBIENT TEMPERATURE	*2 -20 ~ +55 °C
ALLOWABLE FLUID TEMPERATURE	*3 -30 ~ +140 °C
MAX. ALLOWABLE TEMPERATURE	130 °C



- *1 BE SURE TO CHANGE OVER 4-WAY VALVE WITHIN THE RANGE OF CAPACITY DESCRIBED IN THE DRAWING. DISCHARGE PRESSURE RISE OR STOP OF THE INTERNAL VALVE AT AN INTERMEDIATE POSITION MAY OCCUR IF IT IS CHANGED OVER OUTSIDE THE CAPACITY RANGE.
- *2 WHEN THERE IS A DIFFERENCE IN THE MIN. OPERATING VOLTAGE AND THE ALLOWABLE VOLTAGE VARIATION IN THE COIL DRAWING, A COIL DRAWING IS GIVEN PRIORITY TO.
- *3 PLEASE USE THIS PRODUCT SO THAT THE DISCHARGE SIDE FLUID TEMPERATURE IS CONTINUOUS AND DOES NOT EXCEED 130°C FOR A LONG TIME.

• WE MANUFACTURE THE PRODUCT BASED ON THE SPECIFICATIONS DESCRIBED IN THIS DRAWING. PLEASE CHECK THE SAFETY AND VALIDITY IN THE PRODUCT DESIGN IN CONSIDERATION THAT THE PRODUCT IS CONFORMED TO THE SYSTEM OR NOT WHEN USING.

• PLEASE USE THIS PRODUCT SO THAT FLUID ALWAYS FLOW TO THE DISCHARGE SIDE AND SUCTION SIDE DURING COMPRESSOR OPERATION.

CONNECTIONS INDICATED BELOW SHOW AT COOLING MODE (WHEN COIL IS DE-ENERGIZED)
 D CONNECTION : DISCHARGE S CONNECTION : SUCTION
 C CONNECTION : CONDENSER E CONNECTION : EVAPORATOR

C APR 18. 2017 REVISED(CHANGE AND ADD ANNOTATIONS) OKADA
 - MAR 7. 2017 CORRECTION OF ERROR (FLUID TEMPERATURE ON THE LABEL) MITOME
 B NOV 23. 2016 REVISED(CHANGE ALLOWBLE FLUID TEMPERATURE AND ADD EXPLANATORY NOTE) MITOME
 A JUL 2. 2016 REVISED(CHANGE LABEL etc.) MITOME

RELEASED DRAWING
 DATE MAY 31, 2017.
 Quality Management DEPT.
 SAGINOMIYA SEISAKUSHO, INC.

Approved by A. Furukawa	Date JUL 22 2008	Name 4-WAY REVERSING VALVE BODY	
Designed by S. Sekita	Scale —	Catalog Number STF-2505G3	Drawing Number N-HV-26003-C
Drawn by R. Mitome	SAGINOMIYA SEISAKUSHO, INC.		