

# Standard Installation Manual

## Split-Core Coil – Gasket Install



Please consult your local representative or the factory for warranty issues.

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**WARNING:**

Read all instructions carefully before installing. Improper installation, maintenance, or operation may result in a voided warranty

**WARNING:**

Fins are susceptible to damage. Do not apply any load to fins either by placing objects on fins when coil is horizontal or by applying force to the fins while moving/handling the coil. Leading edges of fins that have minor bending can normally be straightened out using a fin comb.

**WARNING:**

Coil sections are heavy. Use approved lifting devices for moving coil sections. Apply forces to coil frame only. Do not apply force to the headers, connections, fins or any exposed copper tubing.

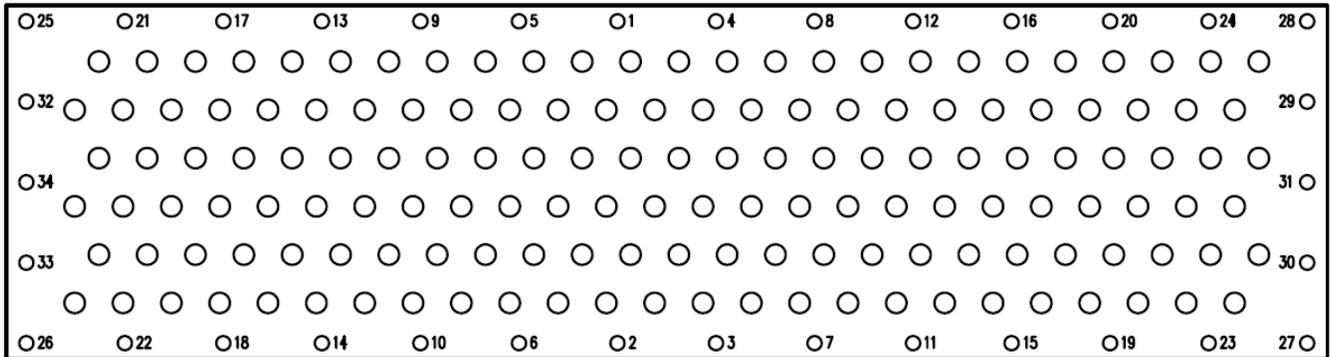
The following instructions should be followed to seal the coil core sections during installation. Failure to follow these instructions may lead to coil leaks and/or reduced performance.

Refer to Coil Assembly Drawing for proper orientation of Split-Cores

1. Use only the hardware and gasket shipped with the coil.
2. Coil core sections should be inspected to ensure the mating surfaces are completely flat and smooth, with no visible signs of debris or material burs, which may impede sealing.
3. Position the tube plate of the return bend section of the coil adjacent to the tube plate of the header section of the coil. Verify tops and bottoms of coil core sections are aligned and tube holes line up on mating surfaces. The tube plates should be approximately 12 inches apart.
4. Clean the mating surfaces with Toluene or other quickly evaporating solvent prior to installing gasket.
5. Push bolts into the top row of bolt holes of one of the tube plates.
6. Place gasket up against this tube plate checking that the holes in the gasket align with the tube holes in the plate.
7. Use the top row of bolts to hold the gasket in position.
8. Push the two coil sections together.
9. Insert bolts through plates and lubricate threads with high pressure grease.
10. Install split washers and nuts and tighten to finger tight.
11. Torque the bolts in an alternating pattern typically as shown in Figure 2.
12. Bolts will be tightened in three stages to the torque values listed on Figure 1.

Step/Stage	Torque Value (ft lb)
1	20
2	35
3	50

**Figure 1 - Bolt Torque per Tightening Stage**



**Figure 2 - Typical Bolt Sequence**

