FLUID COIL SPECIFICATION

1.0 CERTIFICATION

Acceptable coils are to have ARI Standard 410 certification and bear the ARI symbol. Coils exceeding the scope of the manufacturer's certification and/or the range of ARI's standard rating conditions will be considered provided the manufacturer is a current member of the ARI Air-Cooling and Air-Heating Coils certification program and the coils have been rated in accordance to ARI Standard 410. Manufacturer must be ISO 9002 certified.

1.1 FLUID COIL DESIGN PRESSURES AND TEMPERATURES

Coils shall be designed to withstand 250 psi maximum operating pressures and a maximum fluid temperature of 300°F for standard duty copper tube coils. Optional high pressure construction will include cupronickel tubes and headers to increase maximum operating pressure to 350 psi and maximum operating temperature to 450°F. For cleanable coils with removable heads, coils shall be designed to withstand 100 psi maximum operating pressures and a maximum fluid temperature of 150°F. Higher limits are available, depending on coil construction and/or materials used.

For High Pressure/Normal temperature fluid coils, the following Schedule should be used:

0-150 psi	Standard Construction-5/8” x 0.020” copper tubing, 0.065” wall copper headers, copper end caps, vent and drain located as required, coil tubes extended into the header.
150-300 psi	5/8” x 0.025 copper tubing, 0.095” copper headers, Monel end caps, vent and drain located on the face (locating on end caps is not allowed), 5/8” x 0.049” adapter tube construction.
300-400 psi	5/8” x 0.035” copper tubing, 0.187” wall brass pipe headers, Monel end caps, vent and drain located on the face (located on end caps not allowed), 5/8” x 0.049” adapter tube construction.

1.2 FACTORY TESTING REQUIREMENTS

Coils shall be submerged in water and tested with a minimum of 315 psi air pressure for standard copper tube coils and 125 psi for cleanable coils with removable heads. A 500 psig hydrostatic and shock test is required for high pressure cupronickel construction. Coils must display a tag with the inspector's identification as proof of testing.

1.3 FINS

Coils shall be of plate fin type construction providing uniform support for all coil tubes. Stainless steel fins shall be constructed of 304 stainless. Coils are to be manufactured with die-formed aluminum, copper, or stainless steel fins with self-spacing collars which completely cover the entire tube surface. The fin thickness shall be 0.0075 +/- 5% unless otherwise specified. Manufacturer must be capable of providing self-spacing die-formed fins 4 through 14 fins/inch with a tolerance of +/- 4%.

1.4 TUBING

Tubing and return bends shall be constructed from UNS 12200 seamless copper conforming to ASTM B75 and ASTM B251 for standard pressure applications. High pressure construction shall use seamless 90/10 Cupronickel alloy C70600 per ASTM B111. Stainless steel tubes shall be ASTM A249. Copper tube temper shall be light annealed with a maximum grain size of 0.040 mm and a maximum hardness of Rockwell 65 on the 15T scale.

Design permits in-tube water velocities up to 6 ft/s for the standard seamless copper tubing, and up to 8 ft/s for optional seamless alloy C70600 cupronickel tubing.

Tubes are to be mechanically expanded to form an interference fit with the fin collars. Coil tube size and wall thickness' are 5/8"x0.020 and 1/2"x0.016 and 1"x.035 standard for copper, with other options available. Steel tubes are offered as 5/8"x0.035 or 0.049.

1.5 HEADERS

Headers shall be constructed from UNS 12200 seamless copper conforming to ASTM B75 and ASTM B251 for standard pressure applications. High-pressure construction is to incorporate seamless 90/10 Cupronickel alloy C70600 per ASTM B111. Stainless steel will be constructed of 304L (ASTM-A240) Sch-5 or Sch-10. Carbon steel headers shall be constructed of Sch-10 (ASTM-A135A) or Sch-40 (ASTM A53A) pipe.

Coil return headers are to be equipped with factory-installed 1/2” fpt air vent connection placed at the highest point available on face of the header.

Tube-to-header holes are to be intruded inward such that the landed surface area is three times the core tube thickness to provide enhanced header to tube joint integrity. all core tubes shall evenly extend within the inside diameter of the header no more than 0.12 inch.

End caps shall be die-formed and installed on the inside diameter of the header such that the landed surface area is three times the header wall thickness.

1.6 CONNECTIONS

Standard construction fluid connections are male pipe thread (MPT) and constructed from red brass conforming to ASTM B43 or Schedule 40 steel pipe as a minimum. Stainless steel will be 304L (ASTM-A240) Sch-40 or Sch 80. Carbon steel will be A53A Sch-40, A106A Sch-40 or Sch-80 or A53B Sch-80 pipe.

1.7 CLEANING

All residual manufacturing oils and solid contaminants are removed internally and externally by completely submersing the coil in an environmentally and safety approved type degreasing solution, which is also chemically compatible with the coil material. This may vary for steel tube coils, depending on the application and/or customer specifications.

1.8 BRAZING

Oxyfuel gas brazing, using fillet rod material of minimum 5% silver, is used for all non-ferrous tube joints to headers and connections. Depending on the application, ferrous to non-ferrous brazing material may contain upwards of 35% silver, or may be Tobin bronze.

1.8.1 WELDING

Gas shielded arc welding is used for welded vessels constructed of stainless steel. Gas welding is used for welded vessels constructed of carbon steel.

1.9 CASING

Coil casing and endplate shall be fabricated from Galvanized steel, as a standard construction, meeting ASTM and UL G90U requirements, Aluminum, 0.080” thick, optional, Copper, 0.063 “ thick, optional,16- stainless steel, optional. double-flange casing shall be provided when coils are specified as vertical stacking.

Standard coil intermediate tube sheets (center tube supports) shall be fabricated from the same gauge sheet stock and material as the end plates, and to the following schedule:

Finned Length (inches)	Number of Tube Sheets
6.00 – 48.00	0
48.01 – 96.00	1
96.01 – 144.00	2
144.01 and greater	4

1.10 CERTIFICATION

Performance certified coils that are ARI Standard 410 listed bear the ARI symbol. Coils exceeding the scope of the certification and/or the range of standard rating conditions are also rated to the extent possible by the ARI Std. 410 method. Heatcraft continues as a current and active member of the ARI Air-Cooling and Air-Heating Coils certification program, with original coil line certification and computerized selections dating back to 1969.

1.11 AGENCY APPROVAL

Luvata Grenada LLC was facility registered by UL in 1994 to ISO 9002 (ANSI/ASQC Q92). Applicable commercial coil models are UL Standard 207 registered as Refrigerant Containing Components and Accessories; non-electrical. CRN, category H.

Note: Modine Grenada LLC can provide ASME code stamped vessels.

1.13 INSTALLATION

Coils to be installed in accordance with manufacturer’s instructions and any applicable piping codes.

1.14 LEAD TIME

Standard lead-time for custom made retrofit fluid coils of standard construction with OEM circuiting shall be 11-15 working days, with reduced lead-time emergency shipment options of 10 working days and 5 working days from order placement date and based upon production approval.

Standard lead-time for custom made fluid coils of manufacturer’s own standard design and circuiting shall be 10 working days, with reduced lead-time emergency shipment options for 5 working days, 48-hours and 24-hours from order placement date.

All coils shall be quoted and offered as FOB Factory, Full Freight Allowed to any and all destinations within the Continental United States.