

**ECONOMIZER KIT IS SHIPPED LOOSE**

SAB1933	SG61913	DN40
SAB1934	SG61918	DN40
SAB2333	SGC2333	DN50
SAB2334	SGC2337	DN50
SAB2335	SGC2341	DN50
SAB2336	SGC2345	DN50
SAB2337	SGC2349	DN50
SAB2338	SGC2353	DN50
SAB2339	SGC2357	DN50
SAB2340	SGC2361	DN50
SAB2341	SGC2365	DN50
SAB2342	SGC2369	DN50
SAB2343	SGC2373	DN50
SAB2344	SGC2377	DN50
SAB2345	SGC2381	DN50
SAB2346	SGC2385	DN50
SAB2347	SGC2389	DN50
SAB2348	SGC2393	DN50
SAB2349	SGC2397	DN50
SAB2350	SGC2401	DN50
SAB2351	SGC2405	DN50
SAB2352	SGC2409	DN50
SAB2353	SGC2413	DN50
SAB2354	SGC2417	DN50
SAB2355	SGC2421	DN50
SAB2356	SGC2425	DN50
SAB2357	SGC2429	DN50
SAB2358	SGC2433	DN50
SAB2359	SGC2437	DN50
SAB2360	SGC2441	DN50
SAB2361	SGC2445	DN50
SAB2362	SGC2449	DN50
SAB2363	SGC2453	DN50
SAB2364	SGC2457	DN50
SAB2365	SGC2461	DN50
SAB2366	SGC2465	DN50
SAB2367	SGC2469	DN50
SAB2368	SGC2473	DN50
SAB2369	SGC2477	DN50
SAB2370	SGC2481	DN50
SAB2371	SGC2485	DN50
SAB2372	SGC2489	DN50
SAB2373	SGC2493	DN50
SAB2374	SGC2497	DN50
SAB2375	SGC2501	DN50
SAB2376	SGC2505	DN50
SAB2377	SGC2509	DN50
SAB2378	SGC2513	DN50
SAB2379	SGC2517	DN50
SAB2380	SGC2521	DN50
SAB2381	SGC2525	DN50
SAB2382	SGC2529	DN50
SAB2383	SGC2533	DN50
SAB2384	SGC2537	DN50
SAB2385	SGC2541	DN50
SAB2386	SGC2545	DN50
SAB2387	SGC2549	DN50
SAB2388	SGC2553	DN50
SAB2389	SGC2557	DN50
SAB2390	SGC2561	DN50
SAB2391	SGC2565	DN50
SAB2392	SGC2569	DN50
SAB2393	SGC2573	DN50
SAB2394	SGC2577	DN50
SAB2395	SGC2581	DN50
SAB2396	SGC2585	DN50
SAB2397	SGC2589	DN50
SAB2398	SGC2593	DN50
SAB2399	SGC2597	DN50
SAB2400	SGC2601	DN50

**PORT CONNECTIONS FOR DIRECTION CONTROL VALVES**

CONNECTION DESIGNATION	SIZE	DESCRIPTION
P	SAE #6	PRESSURE SUPPLY
T	SAE #6	RELIEF TO TANK
SC-1	5/16	SCREW IN FLOW REGULATING NEEDLE VALVE
SC-2	5/16	SCREW IN FLOW REGULATING NEEDLE VALVE
SC-3	5/16	SCREW IN FLOW REGULATING NEEDLE VALVE
SC-4	5/16	SCREW IN FLOW REGULATING NEEDLE VALVE

**LEGEND**

AS	AIR SUPPLY
C	COMPRESSOR
CV	CHECK VALVE
DP	DISCHARGE PRESSURE
FP	FILTER OR FILTER DRIER
FG	FLOW GLASS
HV	HAND VALVE
HTR	HEATER
LG	LEVEL GLASS
LSL	LOW OIL LEVEL SWITCH
LSL	SEPARATOR LOW OIL LEVEL SHUTDOWN
M	MOTOR
MTC	MOTOR CONTROL CENTER
MTC	MOTOR CONTROL CENTER
OP	OIL PRESSURE
P	PUMP
PAH	HIGH DISCHARGE PRESSURE ALARM
PAHH	HIGH DISCHARGE PRESSURE SHUTDOWN
PALL	LOW PRESSURE SHUTDOWN
PCV	PRESSURE CONTROL VALVE
PDSSL	COMPRESSOR LOW DIFFERENTIAL PRESSURE CUTOFF
PE	PRESSURE TRANSDUCER
PI	PRESSURE INDICATOR
PIE	PRESSURE INDICATION CONTROLLER
PM	PUMP MOTOR
PS	PRESSURE SWITCH CONTROL
PS	AUTO CYCLE
PSV	HIGH PRESS SAFETY VALVE
RTD	RESISTANCE TEMP DETECTOR
SP	SUCTION PRESSURE
STR	STRAINER
TAH	HIGH TEMPERATURE ALARM
TAHH	HIGH TEMPERATURE SHUTDOWN
TAL	LOW OIL TEMPERATURE ALARM
TALL	LOW OIL TEMPERATURE SHUTDOWN
TCV	THERMAL CONTROL VALVE
TE	TEMPERATURE ELEMENT
TI	TEMPERATURE INDICATOR
TS	TEMPERATURE SWITCH
TSH	TEMPERATURE SWITCH HIGH ALARM
TW	TEMPERATURE TRANSMITTER
TV	SOLENOID VALVE
V	V. CONTROL
WS	WATER SUPPLY
XE	VIBRATION ELEMENT
XH	VIBRATION TRANSMITTER
XAH	VIBRATION HIGH ALARM
XAHH	VIBRATION HIGH SHUTDOWN

CONNECTION DESIGNATION	SIZE	DESCRIPTION
SP-3	1 1/16-1/2UN-2B	COMPRESSOR OIL SUPPLY, STR THD O-RING
	3/8 - 18 NPT	SLIDE VALVE - UNLOAD
	3/8 - 18 NPT	SLIDE VALVE - LOAD
	3/8 - 18 NPT	MOVABLE SLIDE STOP
	3/8 - 18 NPT	MOVABLE SLIDE STOP
SC-5	9/16-18UNF-2B	INLET PRESSURE, STR THD O-RING
SC-6	9/16-18UNF-2B	DISCHARGE PRESSURE, STR THD O-RING
SC-7	1/8 - 27 NPT	SEAL WEAPACE
SC-8	1 1/16-1/2UN-2B	CLOSED THREAD DRAIN, STR THD O-RING
SC-9	9/16-18UNF-2B	OIL DRAIN CYLINDER, STR THD O-RING
SC-13	1 5/16-1/2UN-2B	MAIN OIL INJECTION, STR THD O-RING
SM-1	2 SQ. FLG.	VAPOR INJECTION TONGUE & GROOVE
SE-1	1/2 - 14 NPT	ELECTRICAL CONNECTOR
SD-1	1 1/16-1/2UN-2B	COALESCE BLEED, STR THD O-RING PORT
SL-1	9/16-18UNF-2B	LOW V. LIQUID INJECTION
SL-2	1 1/16-1/2UN-2B	HIGH V. LIQUID INJECTION
SE-2	1/2-14 NPT	ELECTRICAL CONNECTOR
TE-1	3/4-14 NPT	SUCTION GAS TEMPERATURE ELEMENT

**MICROPROCESSOR NOTES:**

- PRESSURE TRANSDUCERS INDICATE:
  - PE-1 OIL PRESSURE (MANIFOLD)
  - PE-2 OIL PRESSURE BEFORE FILTER
  - PE-3 DISCHARGE PRESSURE
  - PE-4 SUCTION PRESSURE
- TEMPERATURE PROBES INDICATE:
  - TE-1 SUCTION GAS TEMPERATURE
  - TE-2 DISCHARGE GAS TEMPERATURE
  - TE-3 LIQE OIL TEMPERATURE
  - TE-4 SEPARATOR OIL TEMPERATURE

NOTES:  
 1. REFERENCE P&I SYMBOLS (DRAWING 66000000) FOR ADEPT DESCRIPTIONS OF SYMBOLS AND ABBREVIATIONS.  
 2. UNIT MUST BE PRESSURE TESTED TO THE DESIGN WORKING PRESSURE OF THE HIGH SIDE.

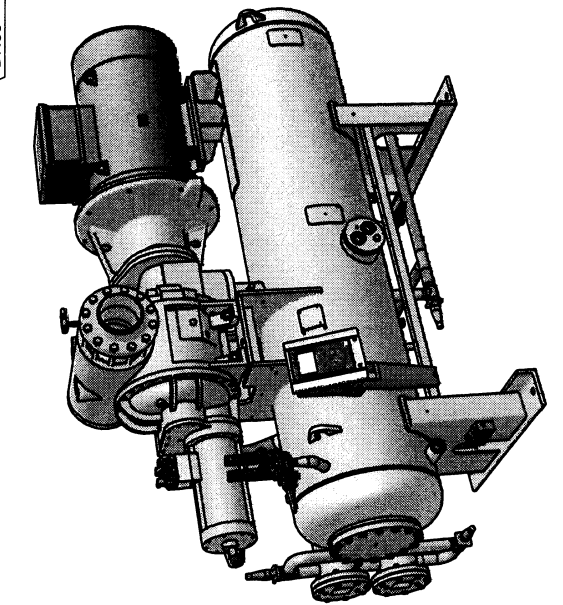
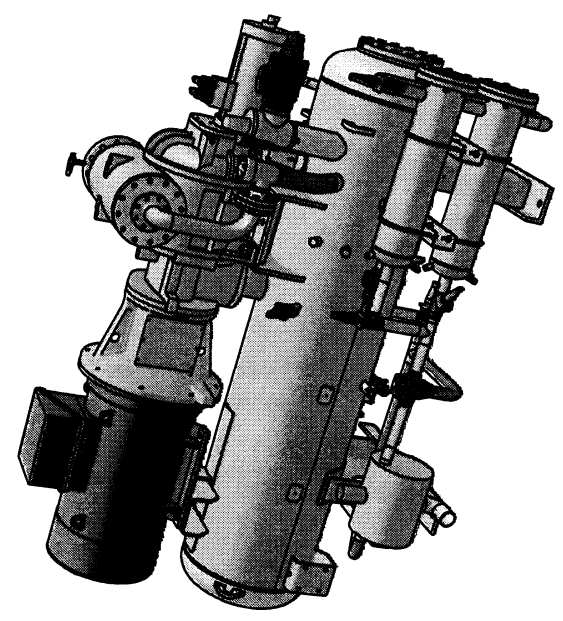
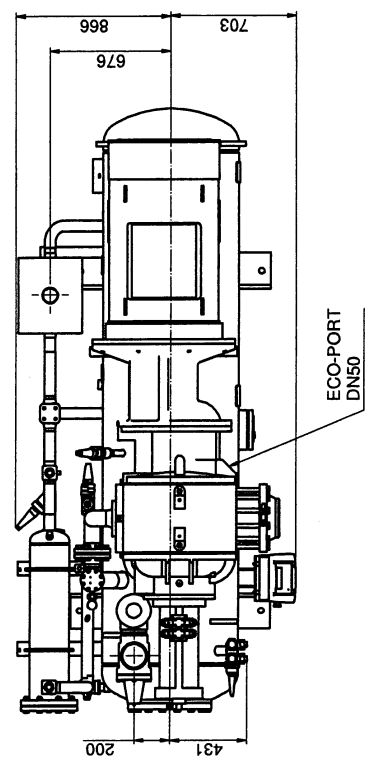
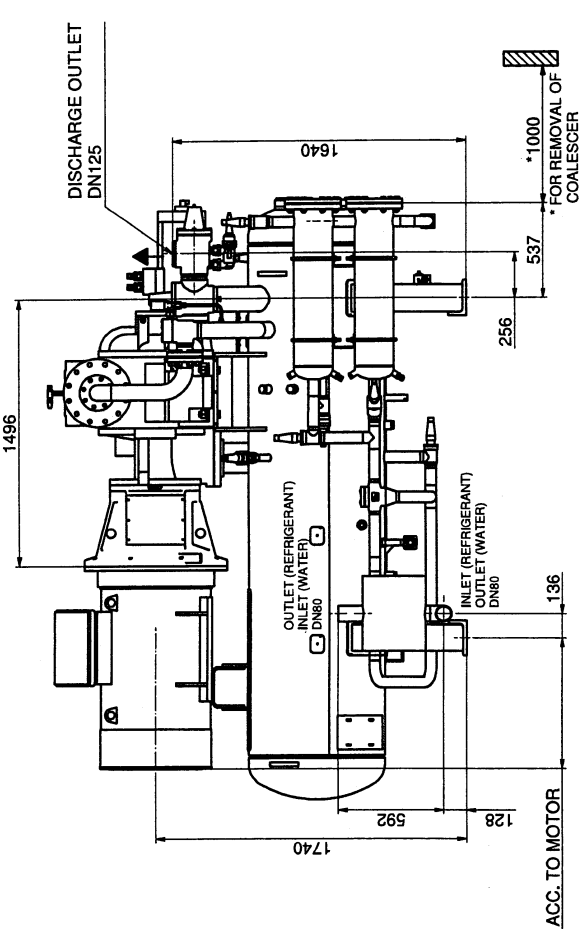
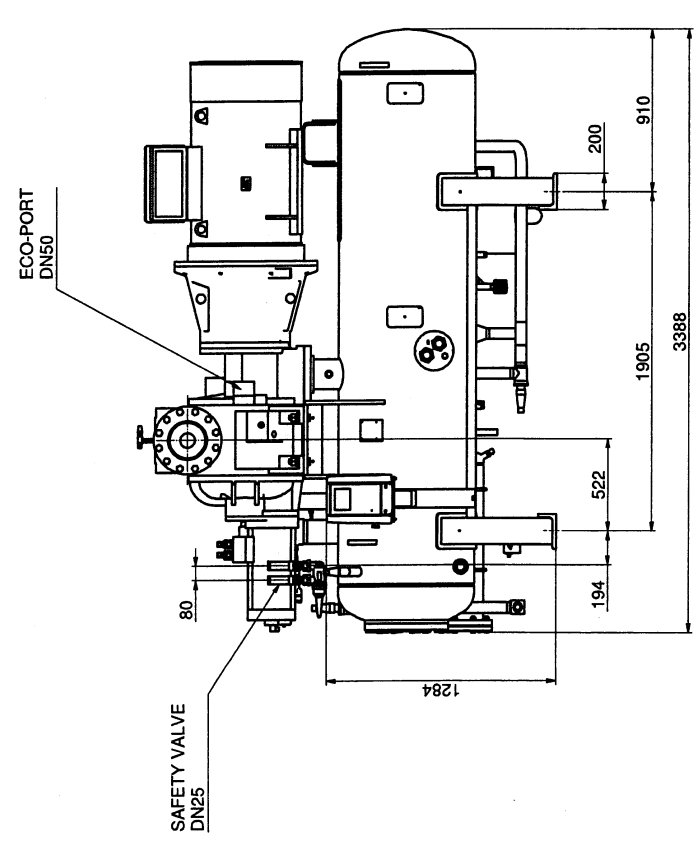
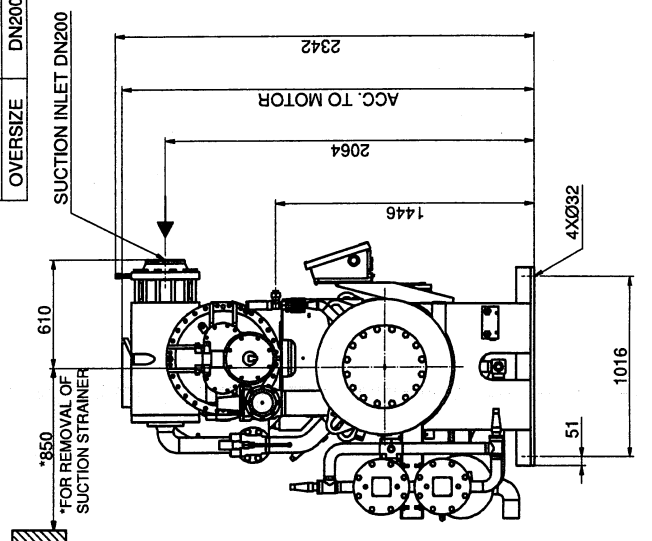
**Conversion table**

00	inch	00	mm
1	1/16	1	1.5875
2	1/8	2	3.1750
3	3/16	3	4.7625
4	1/4	4	6.3500
5	5/16	5	7.9375
6	3/8	6	9.5250
7	7/16	7	11.1125
8	1/2	8	12.7000
9	9/16	9	14.2875
10	5/8	10	15.8750
11	11/16	11	17.4625
12	3/4	12	19.0500
13	7/8	13	20.6375
14	1	14	22.2250
15	1 1/8	15	23.8125
16	1 1/4	16	25.4000
17	1 3/8	17	26.9875
18	1 1/2	18	28.5750
19	1 5/8	19	30.1625
20	1 3/4	20	31.7500
21	1 7/8	21	33.3375
22	2	22	34.9250
23	2 1/8	23	36.5125
24	2 1/4	24	38.1000
25	2 3/8	25	39.6875
26	2 1/2	26	41.2750
27	2 5/8	27	42.8625
28	2 3/4	28	44.4500
29	2 7/8	29	46.0375
30	3	30	47.6250
31	3 1/8	31	49.2125
32	3 1/4	32	50.8000
33	3 3/8	33	52.3875
34	3 1/2	34	53.9750
35	3 5/8	35	55.5625
36	3 3/4	36	57.1500
37	3 7/8	37	58.7375
38	4	38	60.3250
39	4 1/8	39	61.9125
40	4 1/4	40	63.5000
41	4 3/8	41	65.0875
42	4 1/2	42	66.6750
43	4 5/8	43	68.2625
44	4 3/4	44	69.8500
45	4 7/8	45	71.4375
46	5	46	73.0250
47	5 1/8	47	74.6125
48	5 1/4	48	76.2000
49	5 3/8	49	77.7875
50	5 1/2	50	79.3750
51	5 5/8	51	80.9625
52	5 3/4	52	82.5500
53	5 7/8	53	84.1375
54	6	54	85.7250
55	6 1/8	55	87.3125
56	6 1/4	56	88.9000
57	6 3/8	57	90.4875
58	6 1/2	58	92.0750
59	6 5/8	59	93.6625
60	6 3/4	60	95.2500
61	6 7/8	61	96.8375
62	7	62	98.4250
63	7 1/8	63	100.0125
64	7 1/4	64	101.6000
65	7 3/8	65	103.1875
66	7 1/2	66	104.7750
67	7 5/8	67	106.3625
68	7 3/4	68	107.9500
69	7 7/8	69	109.5375
70	8	70	111.1250
71	8 1/8	71	112.7125
72	8 1/4	72	114.3000
73	8 3/8	73	115.8875
74	8 1/2	74	117.4750
75	8 5/8	75	119.0625
76	8 3/4	76	120.6500
77	8 7/8	77	122.2375
78	9	78	123.8250
79	9 1/8	79	125.4125
80	9 1/4	80	127.0000
81	9 3/8	81	128.5875
82	9 1/2	82	130.1750
83	9 5/8	83	131.7625
84	9 3/4	84	133.3500
85	9 7/8	85	134.9375
86	10	86	136.5250
87	10 1/8	87	138.1125
88	10 1/4	88	139.7000
89	10 3/8	89	141.2875
90	10 1/2	90	142.8750
91	10 5/8	91	144.4625
92	10 3/4	92	146.0500
93	10 7/8	93	147.6375
94	11	94	149.2250
95	11 1/8	95	150.8125
96	11 1/4	96	152.4000
97	11 3/8	97	153.9875
98	11 1/2	98	155.5750
99	11 5/8	99	157.1625
100	11 3/4	100	158.7500
101	11 7/8	101	160.3375
102	12	102	161.9250
103	12 1/8	103	163.5125
104	12 1/4	104	165.1000
105	12 3/8	105	166.6875
106	12 1/2	106	168.2750
107	12 5/8	107	169.8625
108	12 3/4	108	171.4500
109	12 7/8	109	173.0375
110	13	110	174.6250
111	13 1/8	111	176.2125
112	13 1/4	112	177.8000
113	13 3/8	113	179.3875
114	13 1/2	114	180.9750
115	13 5/8	115	182.5625
116	13 3/4	116	184.1500
117	13 7/8	117	185.7375
118	14	118	187.3250
119	14 1/8	119	188.9125
120	14 1/4	120	190.5000
121	14 3/8	121	192.0875
122	14 1/2	122	193.6750
123	14 5/8	123	195.2625
124	14 3/4	124	196.8500
125	14 7/8	125	198.4375
126	15	126	200.0250
127	15 1/8	127	201.6125
128	15 1/4	128	203.2000
129	15 3/8	129	204.7875
130	15 1/2	130	206.3750
131	15 5/8	131	207.9625
132	15 3/4	132	209.5500
133	15 7/8	133	211.1375
134	16	134	212.7250
135	16 1/8	135	214.3125
136	16 1/4	136	215.9000
137	16 3/8	137	217.4875
138	16 1/2	138	219.0750
139	16 5/8	139	220.6625
140	16 3/4	140	222.2500
141	16 7/8	141	223.8375
142	17	142	225.4250
143	17 1/8	143	227.0125
144	17 1/4	144	228.6000
145	17 3/8	145	230.1875
146	17 1/2	146	231.7750
147	17 5/8	147	233.3625
148	17 3/4	148	234.9500
149	17 7/8	149	236.5375
150	18	150	238.1250
151	18 1/8	151	239.7125
152	18 1/4	152	241.3000
153	18 3/8	153	242.8875
154	18 1/2	154	244.4750
155	18 5/8	155	246.0625
156	18 3/4	156	247.6500
157	18 7/8	157	249.2375
158	19	158	250.8250
159	19 1/8	159	252.4125
160	19 1/4	160	254.0000
161	19 3/8	161	255.5875
162	19 1/2	162	257.1750
163	19 5/8	163	258.7625
164	19 3/4	164	260.3500
165	19 7/8	165	261.9375
166	20	166	263.5250
167	20 1/8	167	265.1125
168	20 1/4	168	266.7000
169	20 3/8	169	268.2875
170	20 1/2	170	269.8750
171	20 5/8	171	271.4625
172	20 3/4	17	

Material	Material	Material	Material
Steel	Steel	Steel	Steel
Aluminum	Aluminum	Aluminum	Aluminum
Copper	Copper	Copper	Copper
Brass	Brass	Brass	Brass
Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel
Cast Iron	Cast Iron	Cast Iron	Cast Iron
Cast Steel	Cast Steel	Cast Steel	Cast Steel
Aluminum Alloy	Aluminum Alloy	Aluminum Alloy	Aluminum Alloy
Steel Alloy	Steel Alloy	Steel Alloy	Steel Alloy
Brass Alloy	Brass Alloy	Brass Alloy	Brass Alloy
Copper Alloy	Copper Alloy	Copper Alloy	Copper Alloy
Stainless Steel Alloy	Stainless Steel Alloy	Stainless Steel Alloy	Stainless Steel Alloy
Cast Iron Alloy	Cast Iron Alloy	Cast Iron Alloy	Cast Iron Alloy
Cast Steel Alloy	Cast Steel Alloy	Cast Steel Alloy	Cast Steel Alloy
Aluminum Alloy	Aluminum Alloy	Aluminum Alloy	Aluminum Alloy
Steel Alloy	Steel Alloy	Steel Alloy	Steel Alloy
Brass Alloy	Brass Alloy	Brass Alloy	Brass Alloy
Copper Alloy	Copper Alloy	Copper Alloy	Copper Alloy
Stainless Steel Alloy	Stainless Steel Alloy	Stainless Steel Alloy	Stainless Steel Alloy
Cast Iron Alloy	Cast Iron Alloy	Cast Iron Alloy	Cast Iron Alloy
Cast Steel Alloy	Cast Steel Alloy	Cast Steel Alloy	Cast Steel Alloy

SUCTION STOPVALVE  
(SUPPLIED LOOSE)

R717	OTHER
DN150	DN200
DN200	DN250



**CUSTOMER NOTES:**

- NOTICE TO INSTALLER TO ALLOW ADJUSTMENT IN EACH PLANE FOR EXTERNALLY PREFABRICATED PIPING.
- THIS COMPRESSOR PACKAGE MUST BE ANCHORED, SHIMMED AND GROUTED TO A SUITABLE FOUNDATION IN ACCORDANCE WITH FRICK DOCUMENT S70-2101B, SCREW COMPRESSOR FOUNDATIONS, SPECIFIC VIBRATION DAMPED.
- MUST LEAVE HAND THROTTLING VALVE, ON MAIN OIL INJECTION LINE, FULLY OPEN AT INSTALLATION AND START UP.
- ASSEMBLY SHOWN WITH COMPRESSOR SIZE - SGC2317 AN MOTOR FRAME SIZE - IEC315
- UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE CONSIDERED REFERENCE.
- DIMENSION: mm

**MANUFACTURING NOTES:**

- PRODUCT DOCUMENTATION INCLUDING DRAWINGS ARE NOT INTENDED TO SUPERCEDE SAFE MANUFACTURING PRACTICE. ANY DOCUMENT THAT IMPLIES AN UNSAFE CONDITION MUST BE BROUGHT TO THE ATTENTION OF ENGINEERING FOR IMMEDIATE RESOLUTION.
- FOLLOW FRICK STANDARD PROCEDURES FOR ASSEMBLY, PRESSURE TESTING, EVACUATION AND SHIPMENT.
- SEE DRAWING 72000034 FOR MOTOR MOUNTING PROCEDURE REFERENCE.

WEIGHT EXCL. MOTOR, OIL, WATER AND REFRIGERANT:  
APPROX: 3447 kg

APPROVED FOR MANUFACTURE  
(SIGNATURE)

Rev.	ECN	ECN Description	Production Date	Quality Date
3	1742	ECN 1742		
2	1741	ECN 1741		
1	1740	ECN 1740		

Engineering	Production	Quality
TPH	TPH	TPH
LOD	LOD	LOD
LNM	LNM	LNM

Order No.	Part No.	Rev.	Quantity	Unit
4840-616		1	1	1