
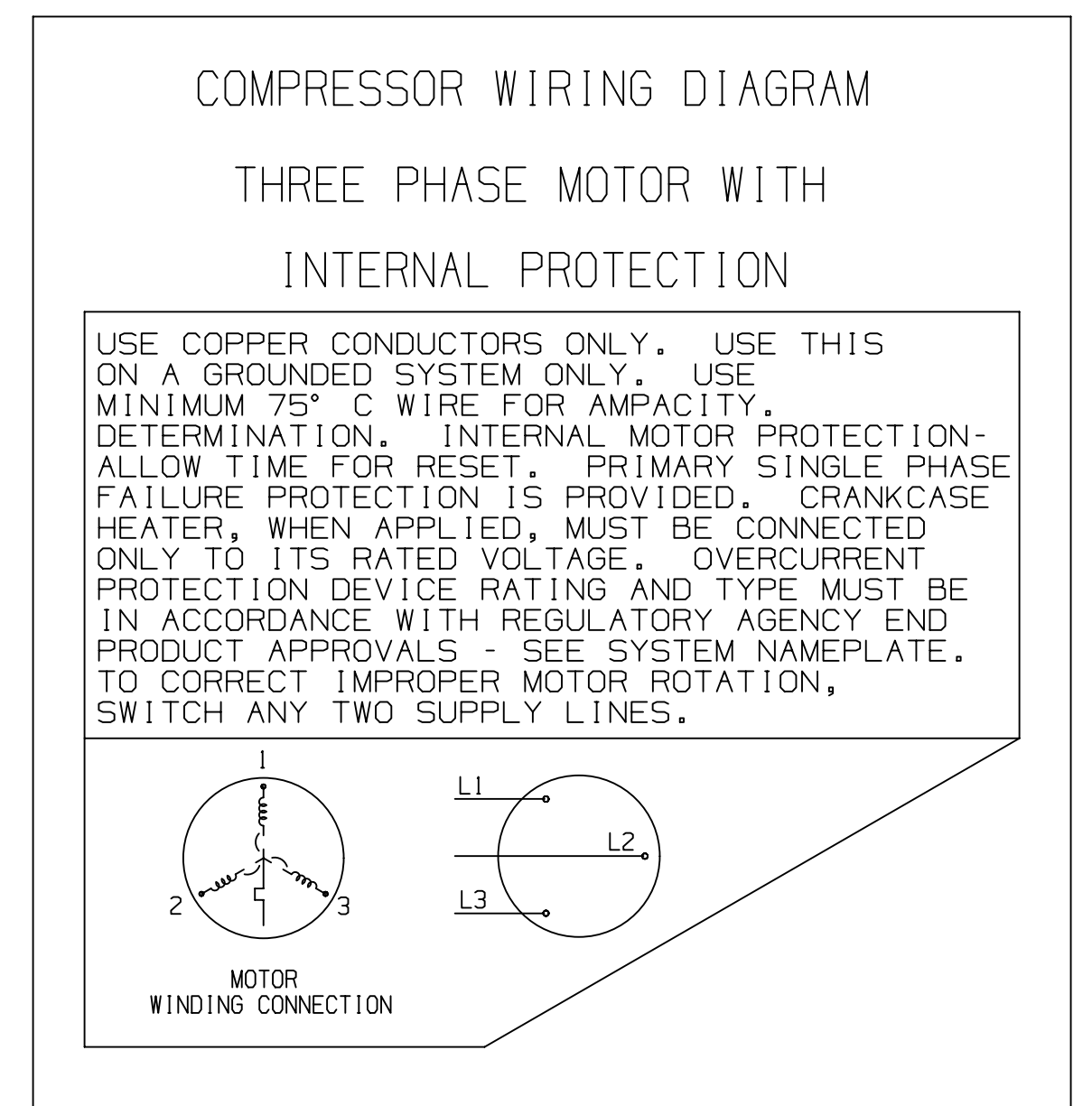




PART NUMBER	MODEL NUMBER	CUSTOMER CONNECTIONS	A	B	C	D	E	F	G	◆ H	MOUNTING KIT 	SPECIFICATIONS	
												ES NO.	DESCRIPTION
												ES92-155	CONVERSION-METRIC
497-1675-00	ZR84KC/KCE ZR94KC/KCE ZP90KCE ZH40KCE	BRAZED WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	476.3 [18.75]	444.3 [17.49]	93.6 [3.69]	201.5 [7.93]	19.1 [0.75]	-	-	28.49-28.67 [1.122-1.129]	527-0116-00		
497-1675-01	ZR84KC/KCE ZR94KC/KCE ZP90KCE ZH40KCE	ROTALOCK WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	476.3 [18.75]	444.3 [17.49]	93.6 [3.69]	201.5 [7.93]	19.1 [0.75]	-	-	-	527-0116-00		
497-1675-02	ZR108KC/KCE/KF/KFE ZR125KC/KCE ZR144KC/KCE ZP103KCE ZP120KCE ZP137KCE ZP144KCE/KFE ZH45KCE ZH50KCE	BRAZED WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	533.2 [20.99]	501.1 [19.73]	122.1 [4.81]	242.8 [9.56]	19.1 [0.75]	-	-	34.84-35.02 [1.372-1.379]	527-0116-00	⑦	
497-1675-03	ZR108KC/KCE/KF/KFE ZR125KC/KCE ZR144KC/KCE ZP103KCE ZP120KCE ZP137KCE ZP144KCE/KFE ZH45KCE ZH50KCE	ROTALOCK WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	533.2 [20.99]	501.1 [19.73]	122.1 [4.81]	242.8 [9.56]	19.1 [0.75]	-	-	-	527-0116-00	⑦	
497-1675-04	ZR160KC/KCE ZR190KC/KCE ZP154KCE/KFE ZH64KCE ZH75KCE	BRAZED WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	551.4 [21.71]	519.3 [20.45]	140.3 [5.52]	261.0 [10.28]	33.3 [1.31]	-	-	34.84-35.02 [1.372-1.379]	527-0210-00	⑦ ⑧	
497-1675-05	ZR160KC/KCE ZR190KC/KCE ZP154KCE/KFE ZH64KCE ZH75KCE	ROTALOCK WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	551.4 [21.71]	519.3 [20.45]	140.3 [5.52]	261.0 [10.28]	33.3 [1.31]	-	-	-	527-0210-00	⑦ ⑧	
497-1675-06	ZR84KC/KCE ZR94KC/KCE ZP90KCE ZH40KCE	BRAZED WITH SIGHTGLASS WITH OIL ADJUSTMENT	476.3 [18.75]	444.3 [17.49]	93.6 [3.69]	201.5 [7.93]	19.1 [0.75]	67.6 [2.66]	74.3 [2.93]	28.49-28.67 [1.122-1.129]	527-0116-00		
497-1675-07	ZR84KC/KCE ZR94KC/KCE ZP90KCE ZH40KCE	ROTALOCK WITH SIGHTGLASS WITH OIL ADJUSTMENT	476.3 [18.75]	444.3 [17.49]	93.6 [3.69]	201.5 [7.93]	19.1 [0.75]	67.6 [2.66]	74.3 [2.93]	-	527-0116-00		
497-1675-08	ZR108KC/KCE/KF/KFE ZR125KC/KCE ZR144KC/KCE ZP103KCE ZP120KCE ZP137KCE ZP144KCE ZH45KCE ZH50KCE	BRAZED WITH SIGHTGLASS WITH OIL ADJUSTMENT	533.2 [20.99]	501.1 [19.73]	122.1 [4.81]	242.8 [9.56]	19.1 [0.75]	92.3 [3.63]	92.3 [3.63]	34.84-35.02 [1.372-1.379]	527-0116-00 527-0182-01	⑥ ⑦	

- NOTES:
- ① ALL TOLERANCES ± 1.5 [0.06] UNLESS OTHERWISE SPECIFIED. DUE TO ACCUMULATED ASSEMBLY TOLERANCES THE LISTED COMPONENTS MAY VARY FROM THE MOUNTING HOLES AS TABULATED.
 - ◆ SUCTION FITTING ± 3.0 [0.12]
 - ◆ DISCHARGE FITTING ± 3.0 [0.12]
 - ② MOUNTING KIT
 - 3. TUBE ENDS MUST BE PLUGGED.
 - ④ GROUNDING SCREW AND WASHER PER BOM.





ENG NOTICE NO.	REV.NO.	REVISIONS	DATE	BY	CHKD	APPR
ECN100001	8	ADD ZP154KFE	10-26-16	AZ	LG	AW
ECN201120	7	CHANGED DIMENSIONS	08-15-16	JLS	LLB	KJR
ECN102816	6	REDRAWN & ADDED 527-0182-01 IN MOUNTING KIT COLUMN	12-30-15	PLS	KRB	KJR
ECN008643	0	RELEASED	06-26-14	VPV	LLB	KJR

INTERPRET PER ASME Y14.5M-1994 AND EMERSON CLIMATE TECHNOLOGIES, INC. DESIGN STANDARDS DS2002

DO NOT SCALE DRAWING

CRITICAL PRODUCT CHARACTERISTICS 

THIRD ANGLE PROJECTION 

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE MILLIMETER OR (INCH)

1-PLACE ± 0.13 [0.005]

2-PLACE ± 0.25 [0.010]

ANGULAR ± 0.5 [0.020]

15

CONFIDENTIALITY NOTICE

THIS DRAWING AND INFORMATION CONTAINED HEREIN ARE THE EXCLUSIVE PROPERTY OF EMERSON CLIMATE TECHNOLOGIES, INC. AND SHALL BE RETURNED UPON DEMAND AND SHALL NOT BE REPRODUCED, IN WHOLE OR IN PART, DISCLOSED TO ANYONE ELSE OR USED, WITHOUT THE WRITTEN CONSENT OF EMERSON CLIMATE TECHNOLOGIES, INC.

MATERIAL SPECIFICATION: N/A

DRAWN BY: PLS

DATE: 12-30-15

SUPERSEDES DWG. NO. / REV. NO.: 497-1675-00 / 005

SCALE: 1:1

DATE FORMAT: MM-DD-YY

TITLE: REF DWG-WELD COMP ASSM

DRAWING NUMBER: 497-1675-00

SHEET 1 OF 3 DWG

SIZE: 4

EMERSON CLIMATE TECHNOLOGIES, INC. - CONFIDENTIAL

PART NUMBER	MODEL NUMBER	CUSTOMER CONNECTIONS	A	B	C	D	E	F	G	◆	H	MOUNTING KIT △ 2	
497-1675-09	ZR108KC/KCE/KF/KFE ZR125KC/KCE ZR144KC/KCE ZP103KCE ZP120KCE ZP137KCE ZP144KFE ZH45KCE ZH50KCE	ROTALOCK WITH SIGHTGLASS WITH OIL ADJUSTMENT	533.2 (20.99)	501.1 (19.73)	122.1 (4.81)	242.8 (9.56)	19.1 (0.75)	92.3 (3.63)	92.3 (3.63)	-	-	527-0116-00	⑦
497-1675-10	ZR160KC/KCE ZR190KC/KCE ZP154KCE/KFE ZP182KCE ZH64KCE ZH75KCE	BRAZED WITH SIGHTGLASS WITH OIL ADJUSTMENT	551.4 (21.71)	519.3 (20.45)	140.3 (5.52)	261.0 (10.28)	33.3 (1.31)	92.4 (3.64)	92.4 (3.64)	34.84-35.02 (1.372-1.379)	-	527-0210-00 527-0182-01	⑥⑦⑧
497-1675-11	ZR160KC/KCE ZR190KC/KCE ZP154KCE/KFE ZP182KCE ZH64KCE ZH75KCE	ROTALOCK WITH SIGHTGLASS WITH OIL ADJUSTMENT	551.4 (21.71)	519.3 (20.45)	140.3 (5.52)	261.0 (10.28)	33.3 (1.31)	92.4 (3.64)	92.4 (3.64)	-	-	527-0210-00	⑦⑧
497-1675-12	ZR84KC/KCE ZR94KC/KCE ZP90KCE	BRAZED WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	476.3 (18.75)	444.3 (17.49)	93.6 (3.69)	201.5 (7.93)	19.1 (0.75)	67.6 (2.66)	-	28.49-28.67 (1.122-1.129)	-	527-0182-01	⑥
497-1675-13	ZR108KC/KCE/KF/KFE ZR125KC/KCE ZR144KC/KCE ZP103KCE ZP120KCE ZP137KCE ZP144KCE/KFE	BRAZED WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	533.2 (20.99)	501.1 (19.73)	122.1 (4.81)	242.8 (9.56)	19.1 (0.75)	92.3 (3.63)	-	34.84-35.02 (1.372-1.379)	-	527-0182-01	⑥⑦
497-1675-14	ZR160KC/KCE ZR190KC/KCE ZP154KCE/KFE ZP182KCE	BRAZED WITHOUT SIGHTGLASS WITHOUT OIL ADJUSTMENT	551.4 (21.71)	519.3 (20.45)	140.3 (5.52)	261.0 (10.28)	33.3 (1.31)	92.4 (3.64)	-	34.84-35.02 (1.372-1.379)	-	527-0182-01	⑥⑦⑧
497-1675-15	ZR144KC/KCE	BRAZED WITHOUT SIGHTGLASS WITH OIL FITTING	533.2 (20.99)	501.1 (19.73)	122.1 (4.81)	242.8 (9.56)	19.1 (0.75)	92.3 (3.63)	-	34.84-35.02 (1.372-1.379)	-	527-0182-01	⑥⑦
497-1675-16	ZR160KC/KCE ZR190KC/KCE ZP154KCE ZP182KCE	BRAZED WITHOUT SIGHTGLASS WITH OIL FITTING	551.4 (21.71)	519.3 (20.45)	140.3 (5.52)	261.0 (10.28)	33.3 (1.31)	92.4 (3.64)	-	34.84-35.02 (1.372-1.379)	-	527-0182-01	⑥⑦

ECN100001	8	ADD ZP154KFE	10-26-16	AZ	LG	AW
ECN201120	7	CHANGED DIMENSIONS	08-15-16	JLS	LLB	KJR
ECN102816	6	REDRAWN & RELEASED -15 & -16	12-30-15	PLS	KRB	KJR
ECN008643	0	RELEASED	06-26-14	VPV	LLB	KJR
ENG NOTICE NO.	REV.NO.	REVISIONS	DATE	BY	CHKD	APPR

CONFIDENTIALITY NOTICE						
15	THIS DRAWING AND INFORMATION CONTAINED HEREIN ARE THE EXCLUSIVE PROPERTY OF EMERSON CLIMATE TECHNOLOGIES, INC. AND SHALL BE RETURNED UPON DEMAND AND SHALL NOT BE REPRODUCED IN WHOLE OR IN PART DISCLOSED TO ANYONE ELSE OR USED, WITHOUT THE WRITTEN CONSENT OF EMERSON CLIMATE TECHNOLOGIES, INC.					
MATERIAL SPECIFICATION	DRAWN BY	SUPERSEDES DWG. NO. / REV. NO.				
N/A	PLS	497-1675-00 / 005				
	DATE	SCALE	DATE FORMAT:			
	12-30-15	1:1	MM-DD-YY			
TITLE	DRAWING NUMBER	SHEET 2 OF 3			DWG	
REF DWG-WELD COMP ASSM	497-1675-00				4	
SIZE						

INTERPRET PER ASME Y14.5M-1994 AND EMERSON CLIMATE TECHNOLOGIES, INC. DESIGN STANDARDS DS2002





DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION

CRITICAL PRODUCT CHARACTERISTICS

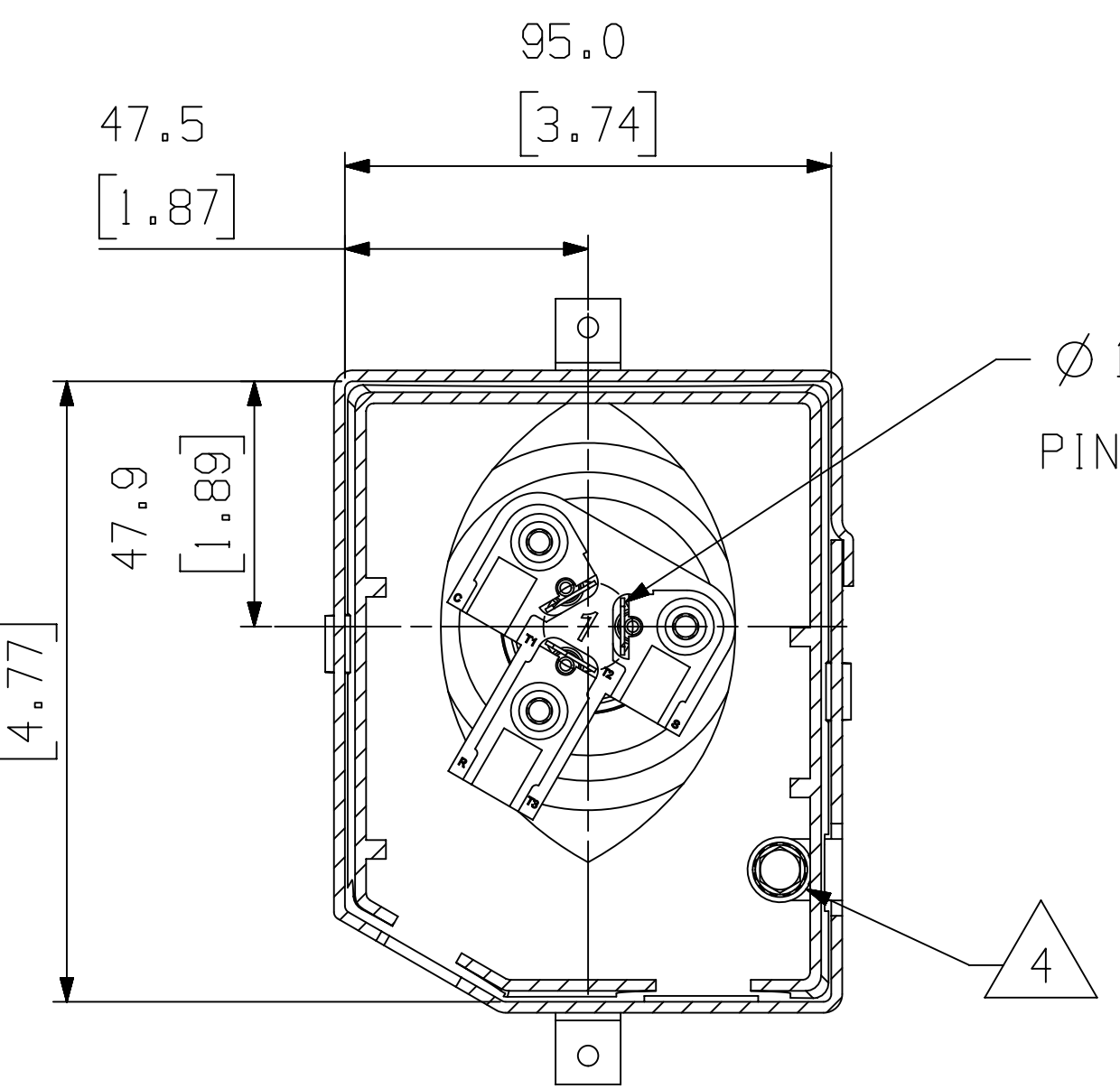
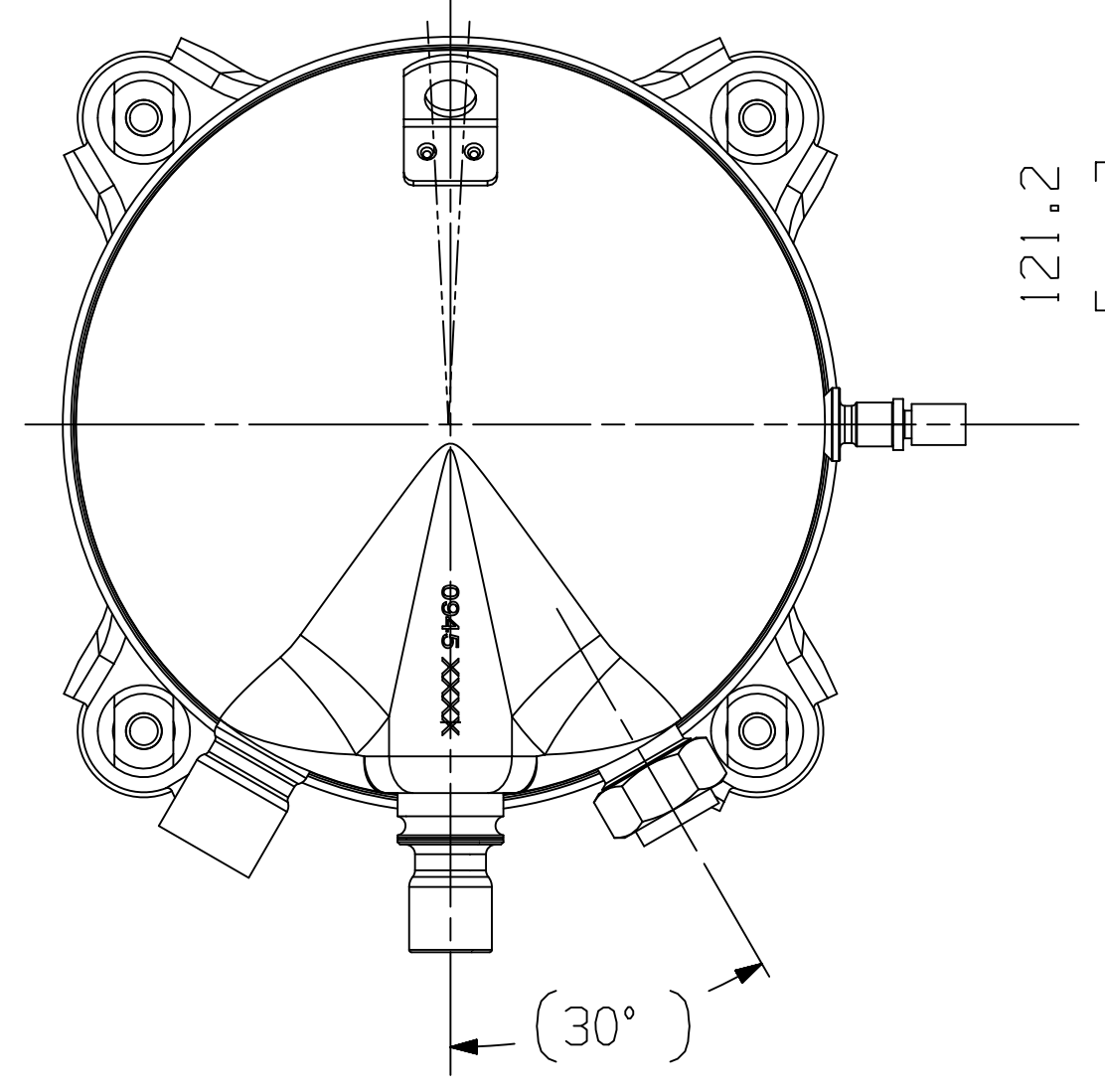
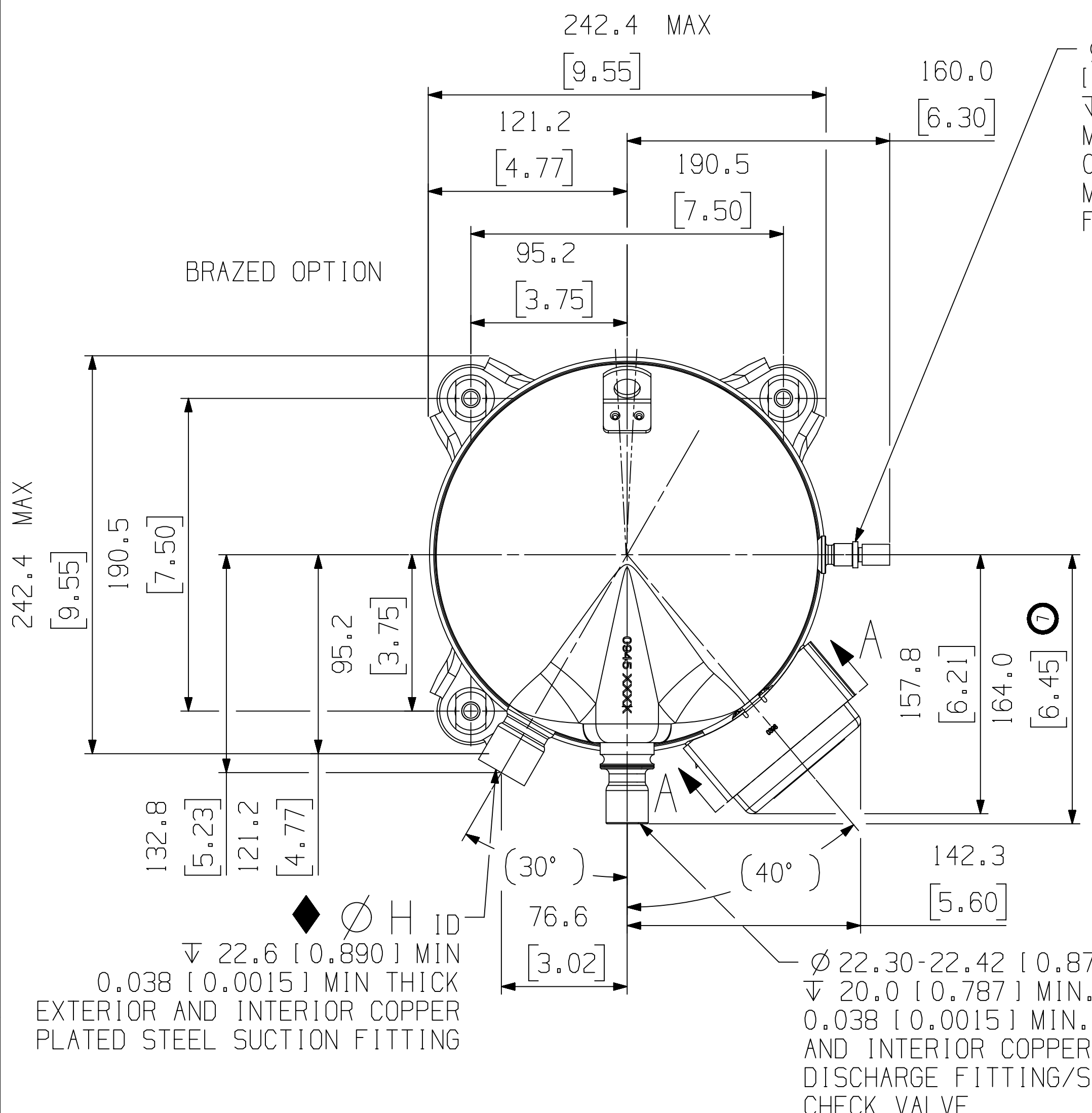
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE MILLIMETER OR (1 INCH)

1-PLACE ±
2-PLACE ±
ANGULAR ±

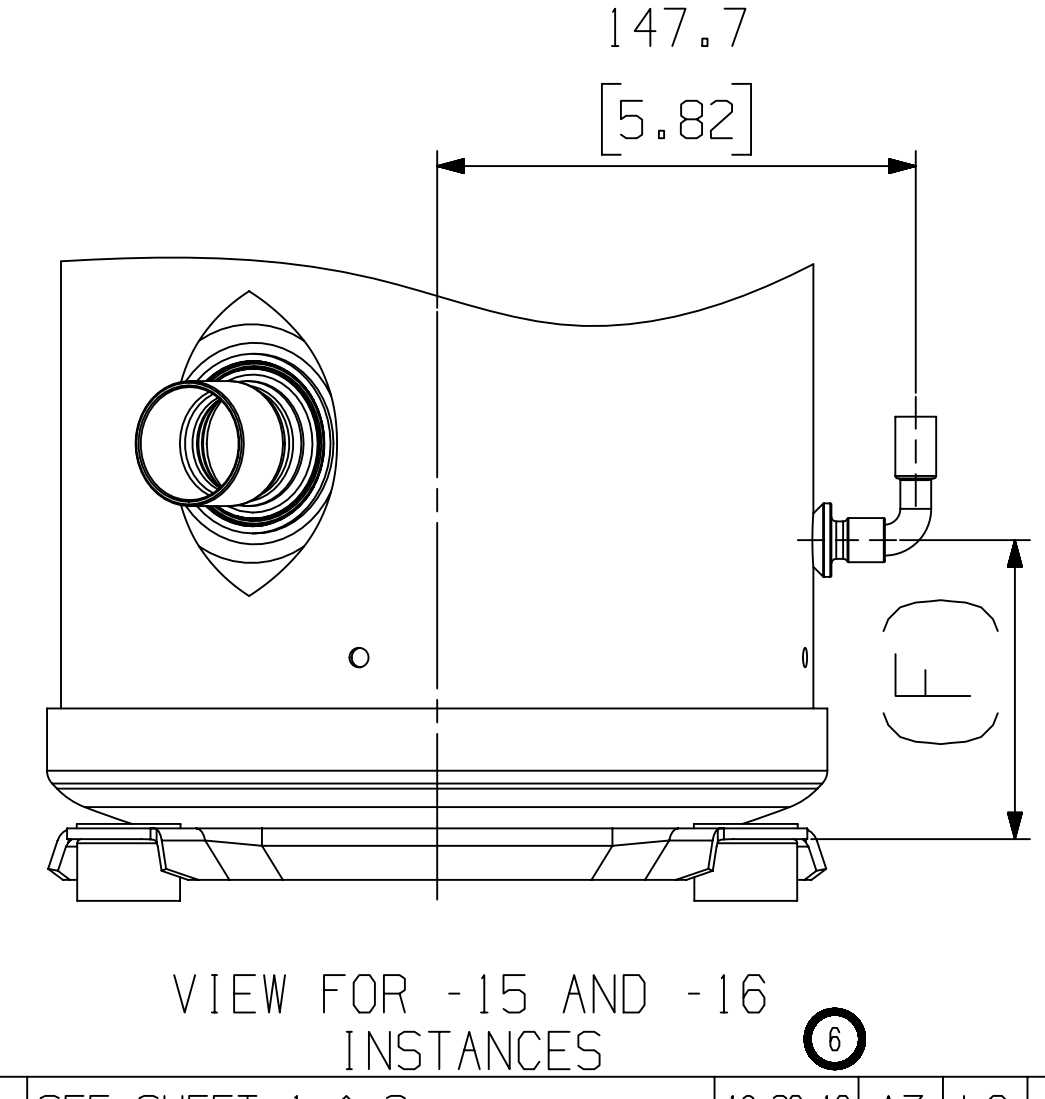
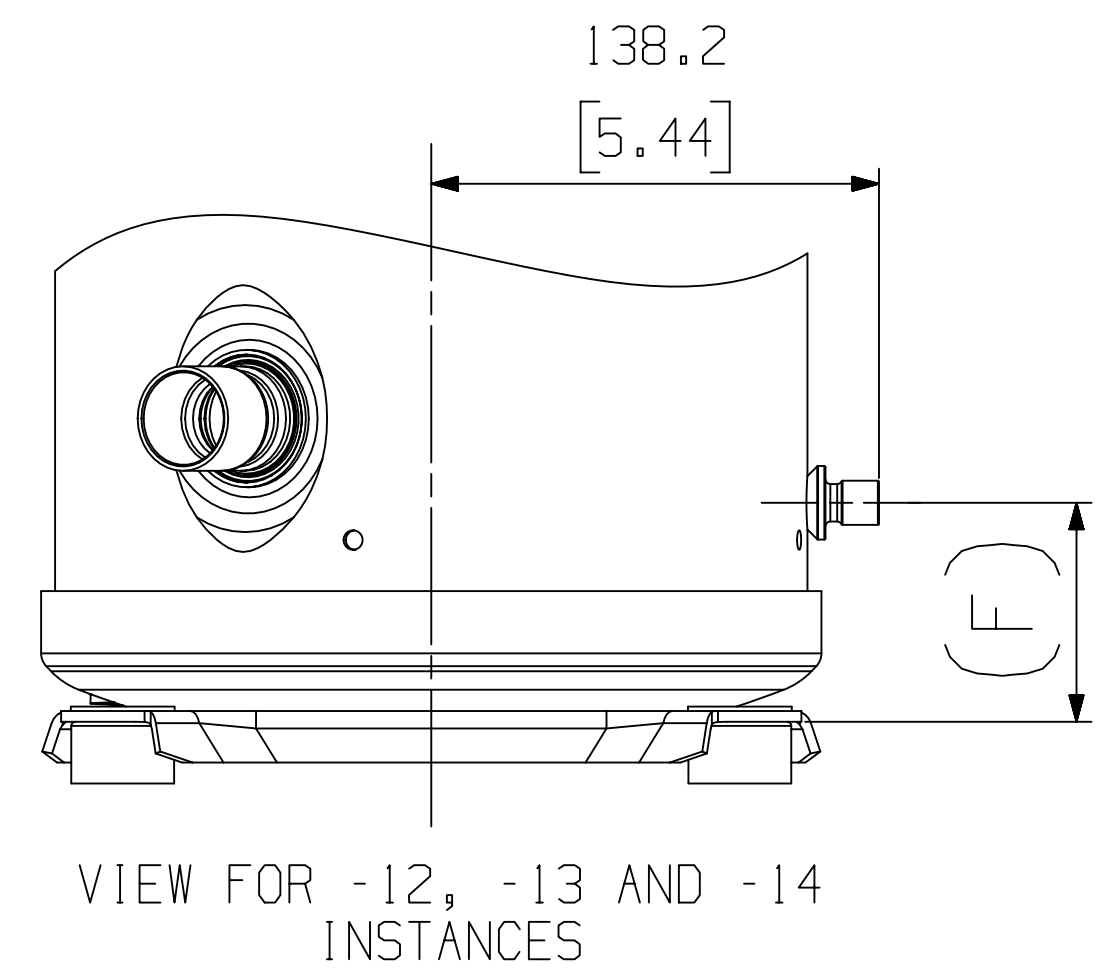
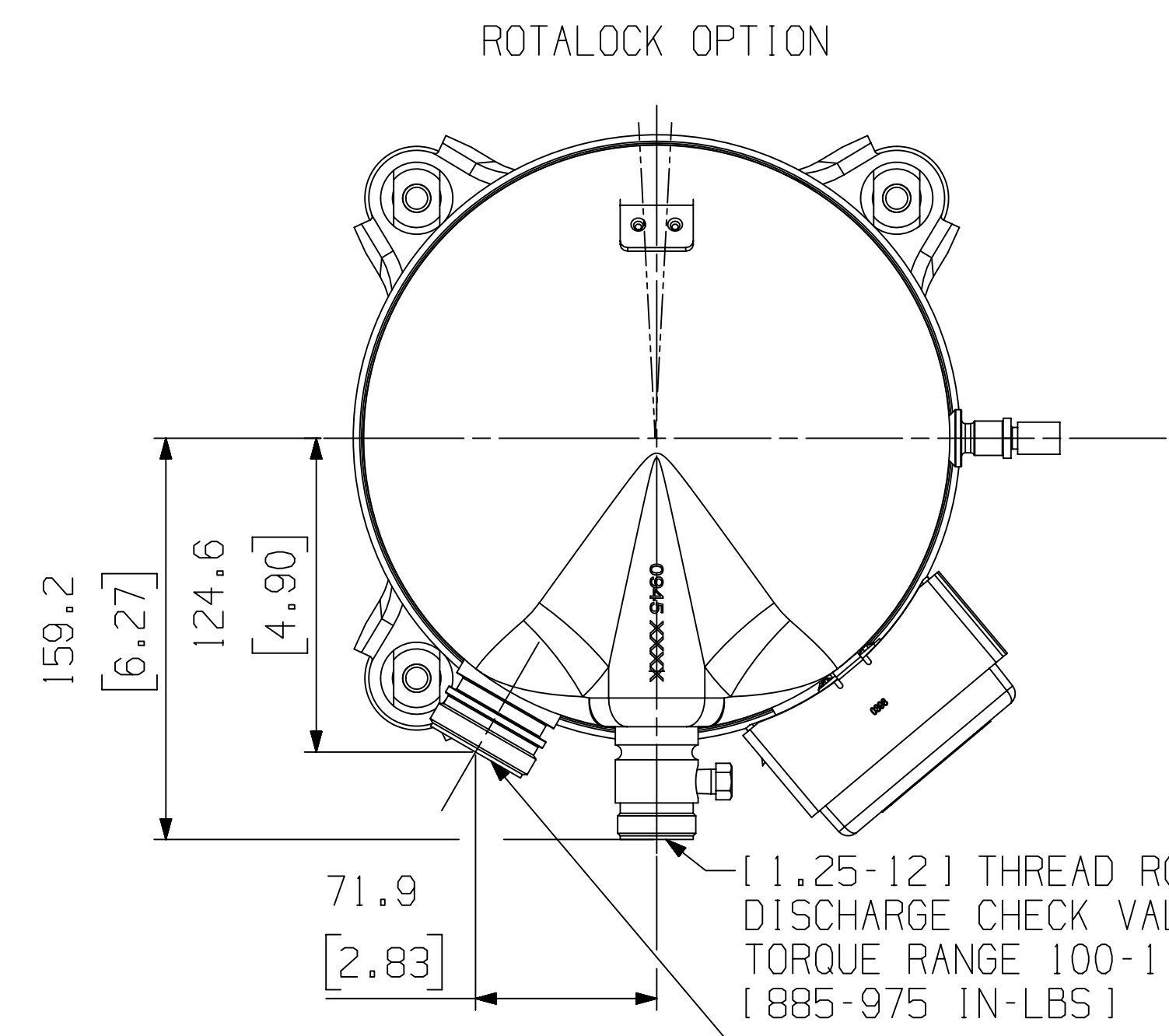
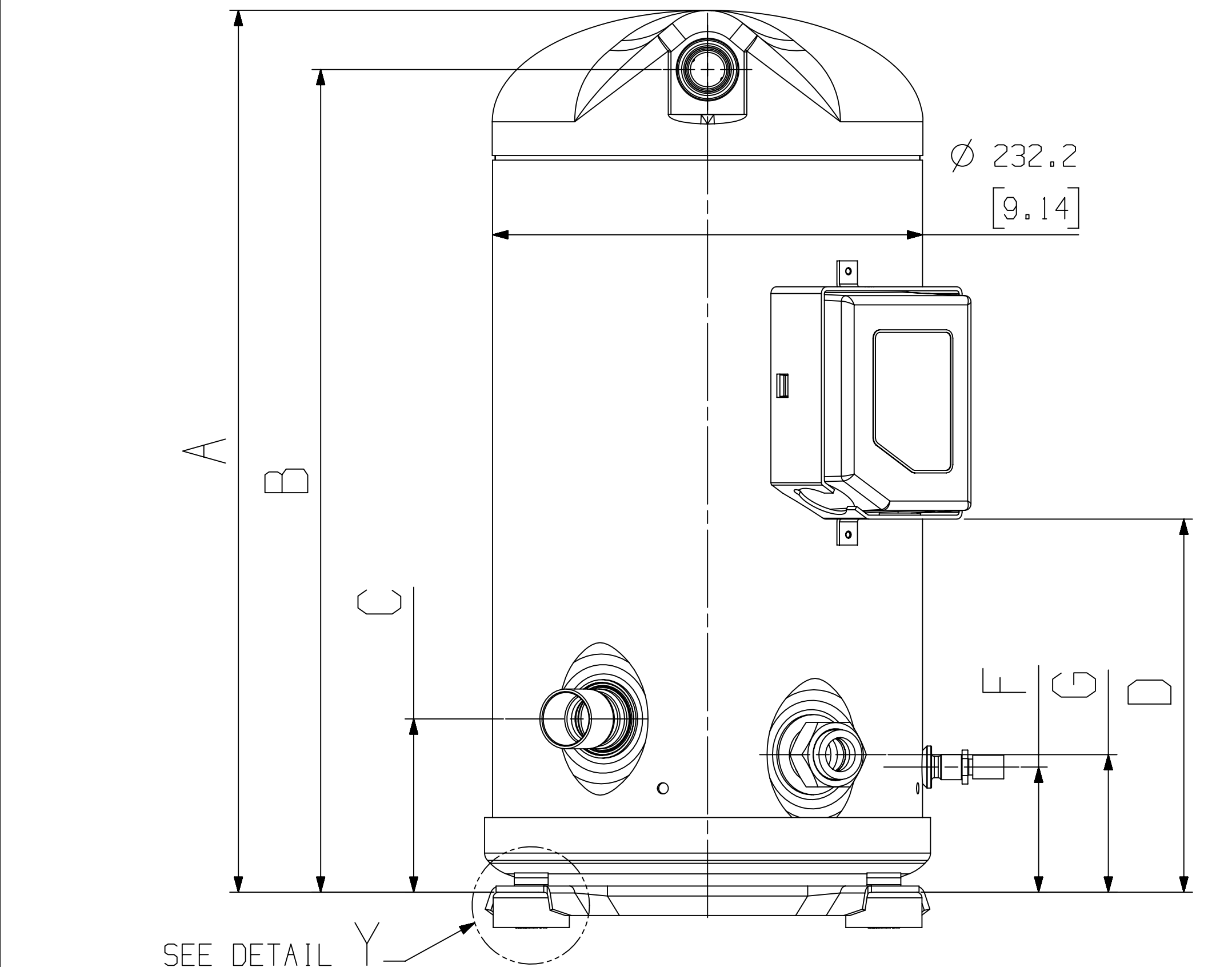
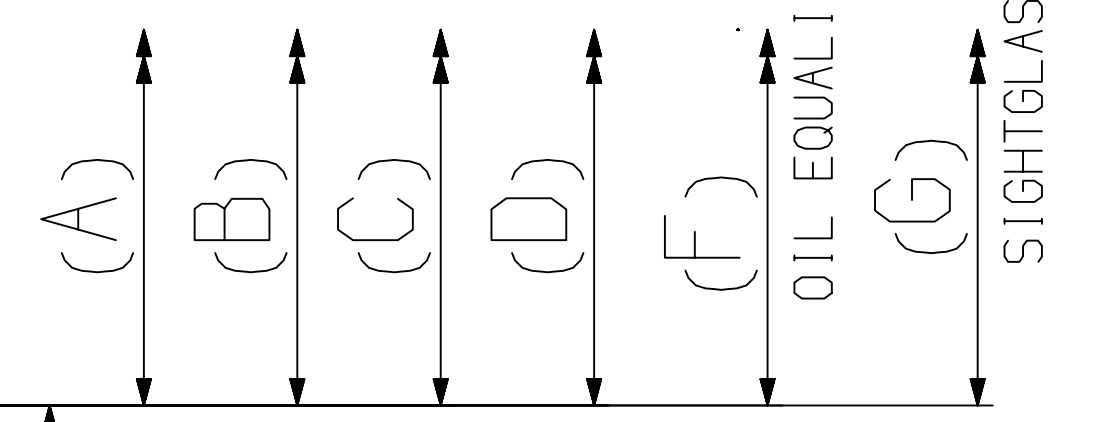
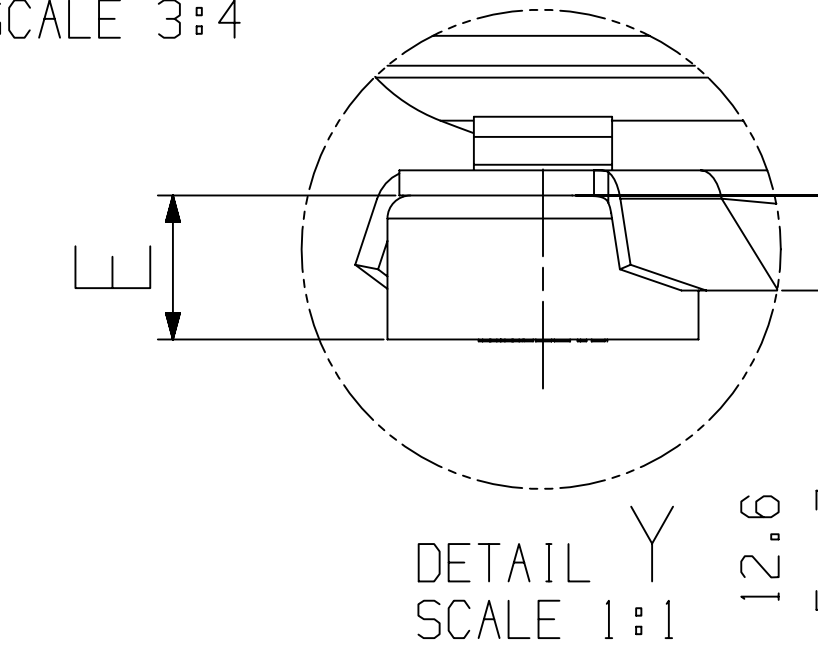





UNCONTROLLED - DO NOT MODIFY

EMERSON CLIMATE TECHNOLOGIES, INC. - CONFIDENTIAL



SECTION A-A
SCALE 3:4



◆ [1.75-12] THREAD ROTALOCK SPUD
SUCTION FITTING
TORQUE RANGE 170-180 NEWTON-METERS [1500-1590 IN-LBS]



INTERPRET PER ASME Y14.5M-1994 AND EMERSON CLIMATE TECHNOLOGIES, INC. DESIGN STANDARDS DS2002

DO NOT SCALE DRAWING

THIRD ANGLE PROJECTION

CRITICAL PRODUCT CHARACTERISTICS

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE MILLIMETER OR (1 INCH)

TOLERANCES:
1-PLACE ±
2-PLACE ±
ANGULAR ±

ECN100001	8	SEE SHEET 1 & 2	10-26-16	AZ	LG	AW
ECN201120	7	CHANGED DIMENSION	08-15-16	JLS	LLB	KJR
ECN102816	6	REDRAWN & ADDED VIEW FOR -15 & -16	12-30-15	PLS	KRB	KJR
ECN008643	0	RELEASED	06-26-14	VPV	LLB	KJR
ENG NOTICE NO.	REV. NO.	REVISIONS	DATE	BY	CHKD	APPR
CONFIDENTIALITY NOTICE						
15	THIS DRAWING AND INFORMATION CONTAINED HEREIN ARE THE EXCLUSIVE PROPERTY OF EMERSON CLIMATE TECHNOLOGIES, INC. AND SHALL BE RETURNED UPON DEMAND AND SHALL NOT BE REPRODUCED, IN WHOLE OR IN PART, DISCLOSED TO ANYONE ELSE OR USED, WITHOUT THE WRITTEN CONSENT OF EMERSON CLIMATE TECHNOLOGIES, INC.					
MATERIAL SPECIFICATION		DRAWN BY	SUPERSEDES DWG. NO. / REV. NO.			
N/A		PLS	497-1675-00 / 005			
		DATE	SCALE	DATE FORMAT:		
		12-30-15	3:7	MM-DD-YY		
TITLE		DRAWING NUMBER	SHEET 3 OF 3		DWG	
REF DWG-WELD COMP ASSM		497-1675-00			4	
						SIZE

UNCONTROLLED - DO NOT MODIFY

COPYRIGHT EMERSON CLIMATE TECHNOLOGIES, INC. - CONFIDENTIAL