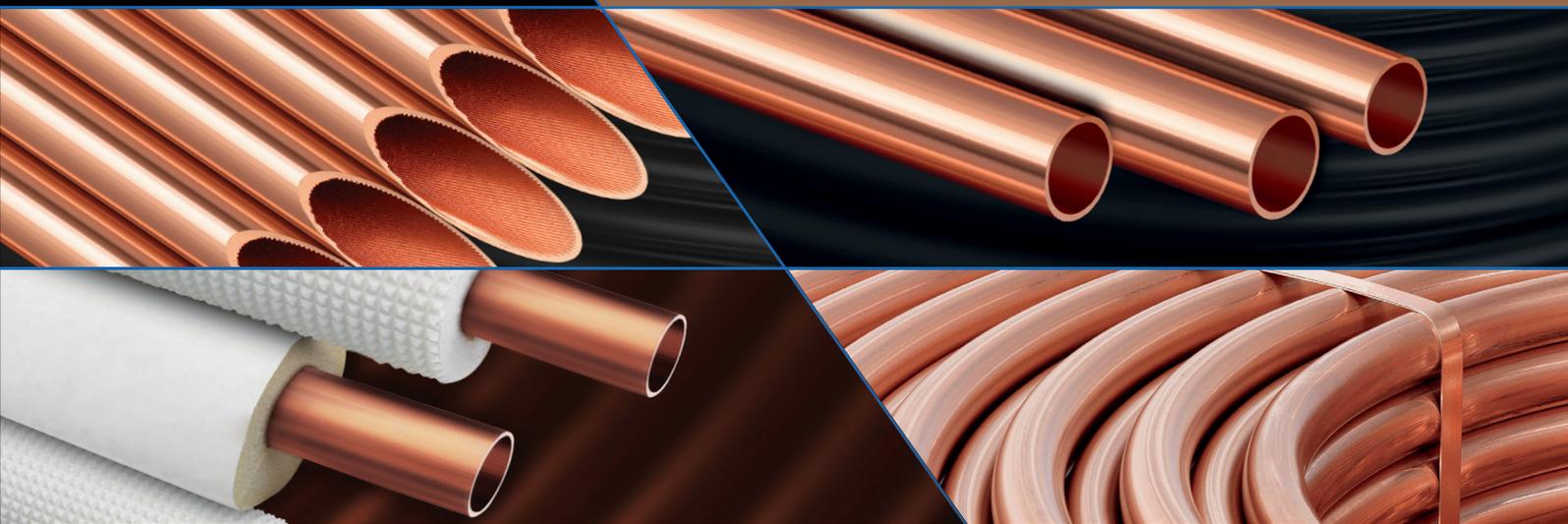
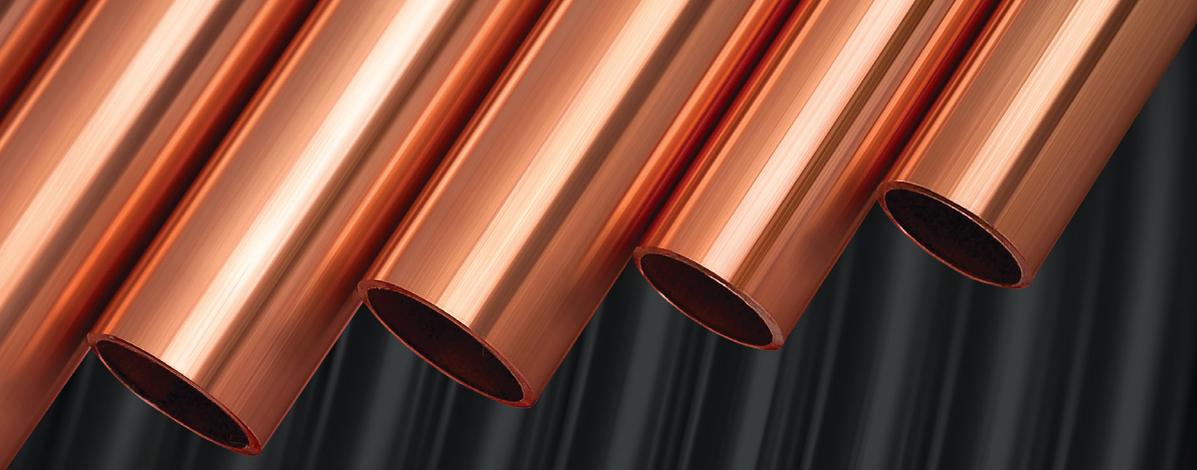


**HALCOR**

---

AIR CONDITIONING & REFRIGERATION





# **HALCOR**

Member of **Copper Alliance**

Halcor is the copper tubes division of ElvalHalcor S.A. and together with four more companies form the copper segment of ElvalHalcor S.A. that specializes in the production, processing and marketing of copper and copper alloys products with dynamic commercial presence in the European and global markets. For more than 80 years, Halcor has been offering innovative and added-value solutions that meet contemporary client demands in fields, such as plumbing, HVAC&R, renewable energy, architecture, engineering and industrial production.

The copper segment of ElvalHalcor is composed of four subsidiaries and two associates/joint ventures, based in Greece, Belgium, Bulgaria, Romania and Turkey, while it operates a total of eight production plants in Greece, Bulgaria and Turkey. The copper segment of ElvalHalcor S.A. develops and distributes a wide range of products, including copper and copper-alloy rolled and extruded products with Halcor being the sole producer of copper tubes in Greece.

High quality in production is achieved through strict controls applied throughout the production process. With a consistent quality focus, Halcor implements an ISO 9001:2015 Certified Quality Management System and leverages high technologies and expert staff.

As a result of the strategic investments in research & development, Halcor is recognized as one of the leading copper producers globally, setting new standards in copper processing. Halcor maintains a consistent focus on quality and environmental protection and a strong commitment to the principles of sustainable development. In this context, all production facilities leverage advanced technologies to bring in the market innovative products that are energy efficient and environmentally friendly.



# INDEX

page  
**04**  
TALOS® ACR

page  
**08**  
TALOS® ACR  
INNER GROOVED

page  
**12**  
TALOS® ACR  
ECUTHERM

page  
**16**  
TALOS® ACR  
ECUTHERM 2

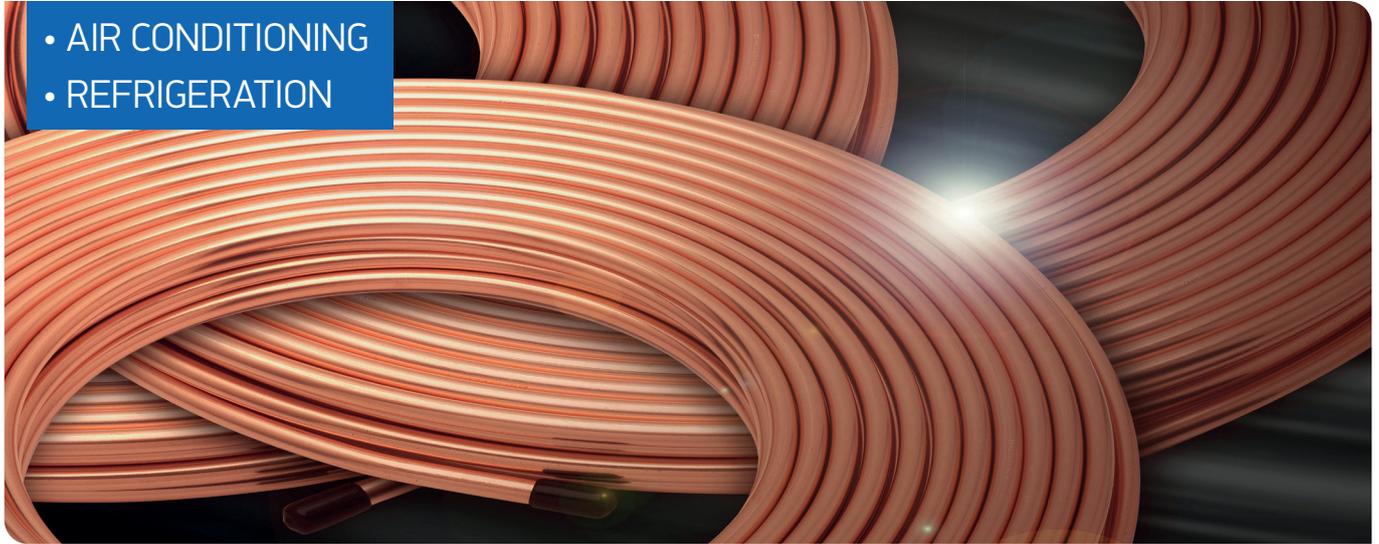
page  
**18**  
TALOS® ACR  
LINESETS

page  
**20**  
TALOS® XS

page  
**22**  
TALOS® S80

page  
**24**  
TALOS® S60

- AIR CONDITIONING
- REFRIGERATION



### Advantages of TALOS® ACR Copper Tubes

The unique properties of high purity copper, make TALOS® ACR copper tubes, indispensable for air conditioning and refrigeration applications:

- High thermal conductivity
- Stable mechanical properties covering an extensive temperature range
- Chemically “inert” against HFCs, HFOs and natural refrigerants (e.g. R-410A, R-32, R-134A, R-407C, R-1234yf, R-1234ze, R-600, R-744, etc.)
- High purity of internal surface
- Smooth internal surface enhancing flow rate
- Excellent weldability
- Excellent “cold formability”

### Mechanical Properties EN12735-1

Material Condition Designation (Temper)	Min. Tensile Strength, R <sub>m</sub> (MPa)	Min. Elongation, A (%)
Annealed (R220)	220	40
Half-Hard (R250)*	250	30
Hard (R290)*	290	3

\* Straight Lengths only

### Mechanical Properties EN12735-2

Material Condition Designation (Temper)	Min. Tensile Strength, R <sub>m</sub> (MPa)	Yield Strength, R <sub>p0.2</sub> (MPa)	Min. Elongation, A (%)
Soft Annealed (Y035)	210	35-80	40
Light Annealed (Y040)	220	40-90	40
Half-Hard (R250)	250	-	30
Hard (R290)	290	-	3

### Material

Copper phosphorus deoxidised (minimum copper content 99,90%, phosphorus concentration P=0,015% - 0,04%, classified as CW024A, or Cu-DHP, according to the European alloy coding system.

### Specifications

EN 12735 parts 1 & 2, ASTM B280/B68/B743, JIS H3300 All TALOS® ACR copper tubes produced according to EN 12735 parts 1 & 2 are certified according to the requirements of the Pressure Equipment Directive (PED) 2014/68/EU, as well as, the German regulation AD2000/W6 for pressure vessels.

### Quality Marks

AENOR, TÜV, GL, VIK

### Standard Dimensions according to European Standards (EN 12735-1)

PANCAKES (SOFT)									
Copper tube external diameter	mm	4,76	6,35	7,94	9,52	12,70	15,87	19,05	22,22
Copper tube wall thickness	mm	0,80	0,80	0,80	0,80	0,80	1,00	1,00	1,00
Weight	Kg/m	0,089	0,124	0,160	0,195	0,266	0,416	0,505	0,594
Maximum Allowable Pressure	bar	238	171	133	109	80	77	62	53

STRAIGHT LENGTHS (5 METERS)														
Copper tube external diameter	mm	9,52	12,70	15,87	19,05	22,22	28,57	34,92	41,27	53,97	66,67	79,37	92,08	104,77
Copper tube wall thickness	Kg/m	0,75	0,80	0,80	0,80	1,00	1,00	1,25	1,25	1,65	2,00	2,30	2,50	2,85
Weight	Kg/m	0,184	0,266	0,337	0,408	0,594	0,771	1,177	1,399	2,414	3,617	4,957	6,262	8,122
Maximum Allowable Pressure	bar	102	80	63	52	53	41	42	35	36	35	34	31	32

### Standard Dimensions according to US Standards (ASTM B-280)

PANCAKES (SOFT TEMPER)									
Copper tube external diameter	Inch	3/16	1/4	5/16	3/8	1/2	5/8	3/4	7/8
	mm	4,76	6,35	7,94	9,52	12,70	15,87	19,05	22,22
Copper tube wall thickness	Inch	0,030	0,030	0,032	0,032	0,032	0,035	0,035	0,045
	mm	0,76	0,76	0,81	0,81	0,81	0,89	0,89	1,14
Weight	Kg/m	0,085	0,119	0,162	0,198	0,270	0,372	0,451	0,672
Maximum Allowable Pressure	bar	224	161	135	111	81	71	59	61

STRAIGHT LENGTHS (HARD TEMPER, 4 OR 5 METERS)														
Copper tube external diameter	Inch	3/8	1/2	5/8	3/4	7/8	1 1/8	1 3/8	1 5/8	2 1/8	2 5/8	3 1/8	3 5/8	4 1/8
	mm	9,52	12,70	15,87	19,05	22,22	28,57	34,92	41,27	53,97	66,67	79,37	92,07	104,77
Copper tube wall thickness	Inch	0,030	0,035	0,040	0,042	0,045	0,050	0,055	0,060	0,070	0,080	0,090	0,100	0,110
	mm	0,76	0,89	1,02	1,07	1,14	1,27	1,40	1,52	1,78	2,03	2,29	2,54	2,79
Weight	Kg/m	0,187	0,294	0,424	0,538	0,672	0,970	1,312	1,690	2,598	3,669	4,936	6,359	7,956
Maximum Allowable Pressure	bar	103	90	79	67	61	52	47	43	38	35	34	32	31

Customized dimensions are manufactured upon request.

Maximum Allowable Pressure calculation according to EN 14276:2020 Standard which complies with the European Directive PED 2014/68/EU (Pressure Equipment Directive). The values of the maximum allowable pressure refer to the material condition R200. A safety factor of 3.0 is used. The minus tolerance of the wall thickness is considered. No further processing is taken into account. For temperature up to 100°C.

### Form of supply

Straight lengths, in bundles (hard copper tubes) and in wooden boxes (soft copper tubes) Pancakes-PNC in shrink-wrapped individual plastic bags. Depending on market requirements, products can be placed in cardboard boxes and pallets.

TALOS<sup>®</sup> ACR copper tubes for heat exchanger units are available in the following forms:

#### Spools (LWC)

TALOS<sup>®</sup> ACR copper tubes are available in spools (LWC) with or without central support (hard carton). Spool sides may be delivered protected by "flanges" of reinforced cardboard.

#### "CD" coils: Spools with a "central" decoiling

Spools with a "central" decoiling are especially prepared so that unwinding from the center of the coil is possible. They provide significant advantages to the user, such as reduction in packaging materials, unwinding directly from the pallet and greater weights per spool. "CD" coils of TALOS<sup>®</sup> ACR copper tubes do not require special unwinding equipment; they have lower handling costs, reducing machine downtime and increasing production efficiency.

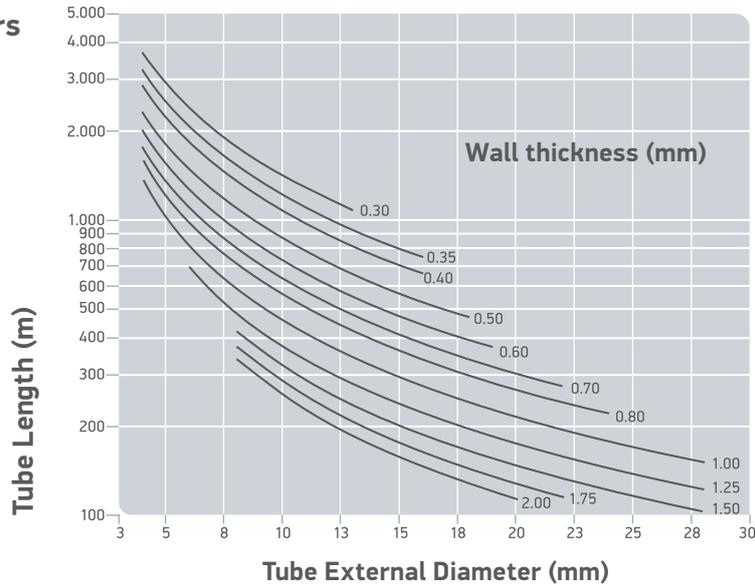


**Available Dimensions**

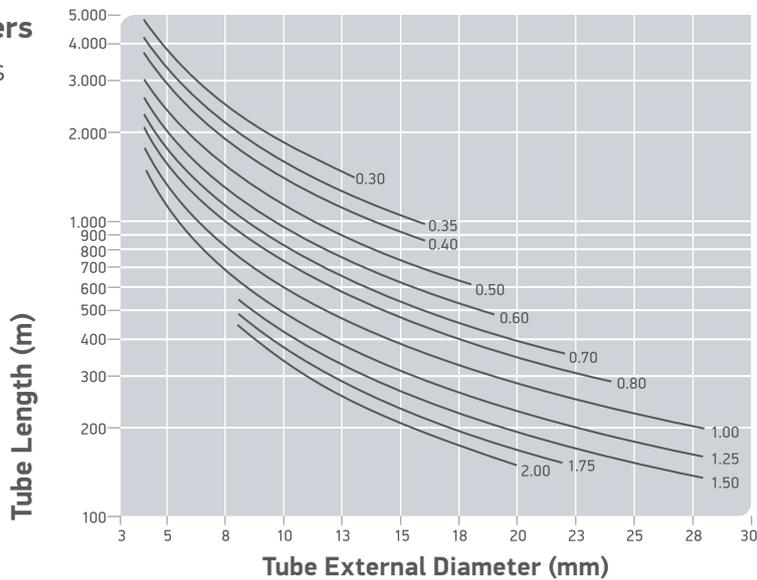
External diameter		Thickness (Inch) (mm)							
(inch)	(mm)	0,011 0,28	0,012 0,30	0,014 0,35	0,016 0,41	0,018 0,45	0,020 0,51	0,025 0,635	0,028 0,71
5/16	7,94								
3/8	9,52								
1/2	12,70								
5/8	15,87								

Recommended dimensions for LWC spools

**Tube Length in meters for 115kg LWC spools**



**Tube Length in meters for 150kg LWC spools**

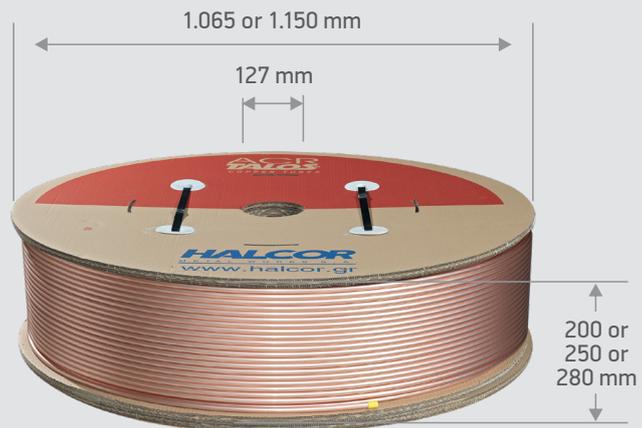


### Spool (LWC) Dimensions

SPOOL WEIGHT (kg)	FORM OF SUPPLY
75	With carton spool
85	
115	
150	
200	
290	Without carton spool
460	
580	



Without carton spool.  
 Maximum Coil Weight 580 kg



With carton spool.  
 Spool weight: 75 to 200 kg  
 (Spools of greater weight are available upon request)





• HEAT EXCHANGERS



### Inner Grooved Tubes

TALOS<sup>®</sup> IGT copper tubes feature inner grooves that enhance the heat transferred by the refrigerant and as a result increase the energy efficiency of the HVAC&R units. Applications of TALOS<sup>®</sup> IGT include heat exchangers for condensation and /or evaporation in A/C and refrigeration systems, as well as, heat pumps.

HALCOR's production technology for TALOS<sup>®</sup> IGT copper tubes enables the manufacture of advanced inner groove designs for a complete range of sizes, starting from 16mm outside diameter down to the new generation microgroove<sup>™</sup> tubes with an outside diameter of 5mm or less, being one of the few manufacturers worldwide to have this capability.

The ability of HALCOR to provide complete solutions to its clients was reinforced by the establishment of a Tube Heat Transfer Laboratory. The equipment of the Tube Heat Transfer Laboratory was specially designed to enable measurements of the heat transfer performance of ACR tubes under fully controlled test conditions. Critical features, such as, the heat transfer coefficient and the pressure drop, are measured using a sophisticated system for condensation and evaporation of HFC and HFO refrigerants. The flow and ther-

mal parameters are programmed to simulate specific operating conditions, such as, refrigerant flow rate, saturation temperature, vapor quality, thermal capacity, etc., and thus allow HALCOR's engineers to study the influence of the inner-groove design.

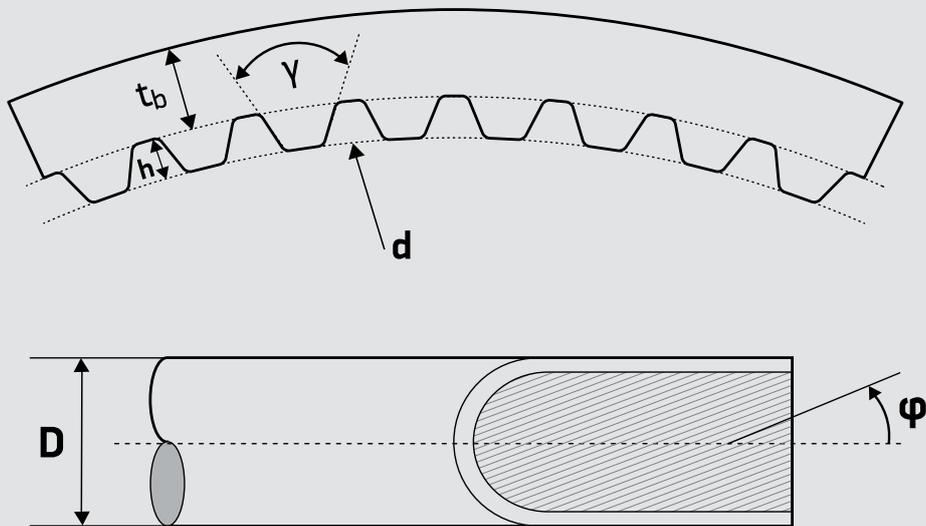
The Tube Heat Transfer Laboratory gives HALCOR the capability to incorporate the test results in a complete framework of technical support to manufacturers of heat exchangers, with the purpose of optimizing their heat-exchanger design for any of the following:

- Improved efficiency
- Higher capacity
- Reduction of raw material
- Compact heat-exchanger size
- Reduction of refrigerant charge

The Tube Heat Transfer Laboratory offers a superior advantage to HALCOR's clients by giving them the opportunity to establish a mutually beneficial co-operation within an integrated support and product development framework.

Other configurations and sizes are available upon request.

Outer Diameter D (mm)	Bottom Wall Thickness $t_b$ (mm)	Groove Depth h (mm)	Top Apex Angle $\gamma$ (deg)	Lead Helix Angle $\phi$ (deg)	Number of Grooves n	Weight /Meter (gr/m)
5,00	0,20-0,23	0,12-0,15	11-40	18-40	40-58	32-35
6,35	0,23-0,27	0,15-0,16	12-40	18-28	45-54	46-53
7,00	0,21 - 0,27	0,10-0,24	10-53	15-40	50-70	46-60
7.94 - 8.00	0,23 - 0,41	0,12-0,22	12-42	18-43	50-80	57-69
9,52	0,27 - 0,45	0,15-0,25	20-90	15-30	55-85	80-128
11,90 - 12,00	0,32 - 0,40	0,17-0,25	15-55	16-30	70-98	120-145
12,70	0,32 - 0,41	0,23-0,25	30-58	18-30	70-75	135-170
15,00 - 15,90	0,35 - 0,50	0,25-0,35	30-53	18-30	30-75	188-259



**D:** Outside Diameter    **d:** Inside Diameter     **$t_b$ :** Bottom Wall Thickness    **h:** Groove Depth     **$\phi$ :** Lead Angle     **$\gamma$ :** Top Angle

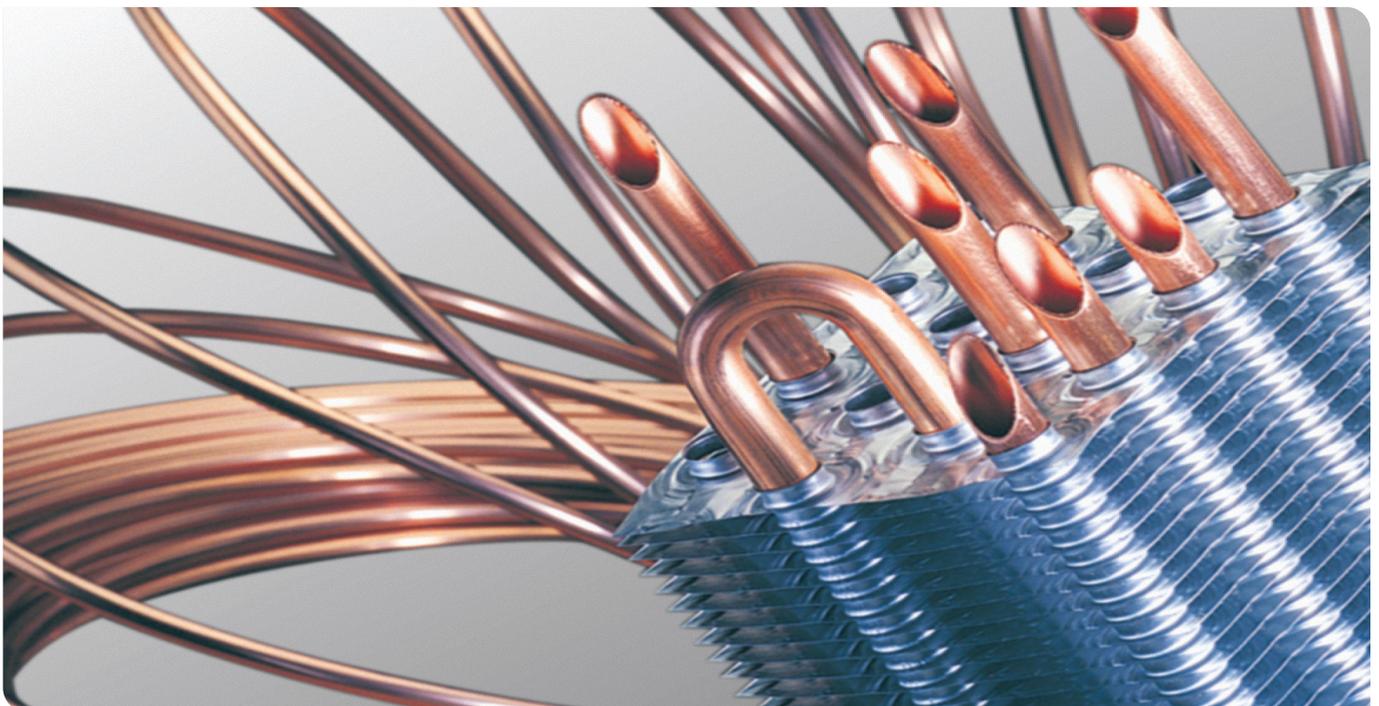
COPPER TUBES  
**TALOS**<sup>®</sup>  
ACR INNER GROOVED



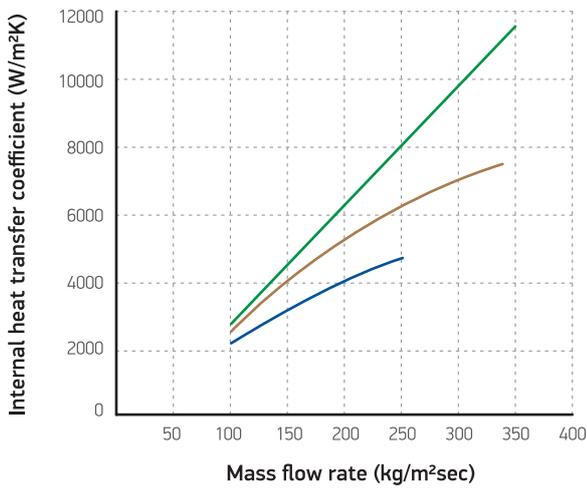
TUBE HEAT TRANSFER LABORATORY



- Performance measurement and R&D on plain and inner grooved tubes
- Test data derived from the laboratory enable HALCOR to offer specialized technical support to manufacturers of heat-exchangers with the aim of optimizing their heat exchanger design and achieving higher efficiency



Tube Heat Transfer Performance: **EVAPORATION**



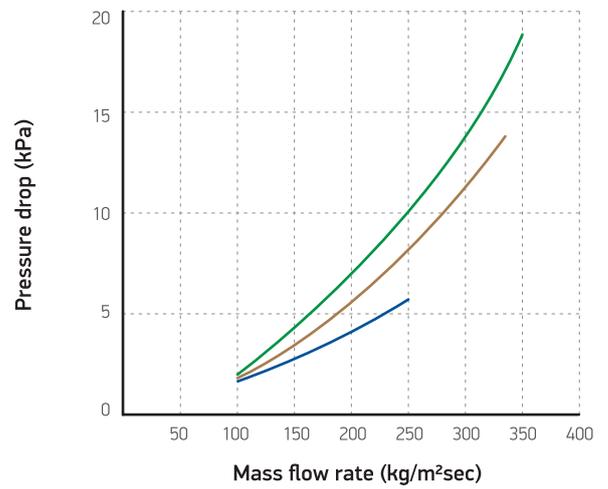
**Performance mode:**  
Evaporation

**Test conditions:**  
 Dew point: 0°C  
 Inlet vapor quality: x=20%  
 Outlet superheat: 5K  
 Tube length: 2m

**PLAIN TUBE**  
**HALCOR IGT ENHANCED TYPE**  
**HALCOR IGT STANDARD TYPE**

**Refrigerant:**  
R404A - no oil

Tube Heat Transfer Performance: **EVAPORATION**



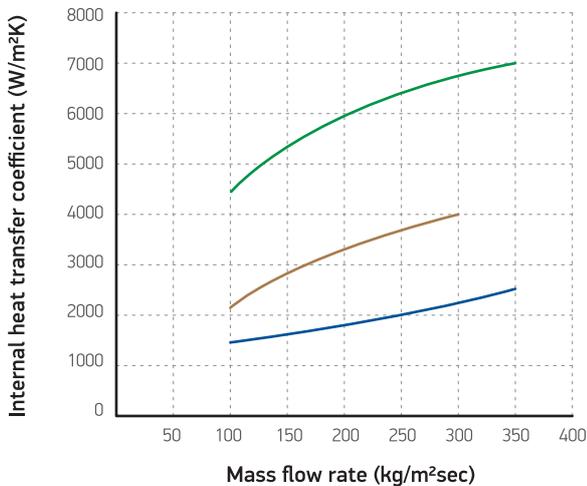
**Performance mode:**  
Evaporation

**Test conditions:**  
 Dew point: 0°C  
 Inlet vapor quality: x=20%  
 Outlet superheat: 5K  
 Tube length: 2m

**PLAIN TUBE**  
**HALCOR IGT ENHANCED TYPE**  
**HALCOR IGT STANDARD TYPE**

**Refrigerant:**  
R404A - no oil

Tube Heat Transfer Performance: **CONDENSATION**



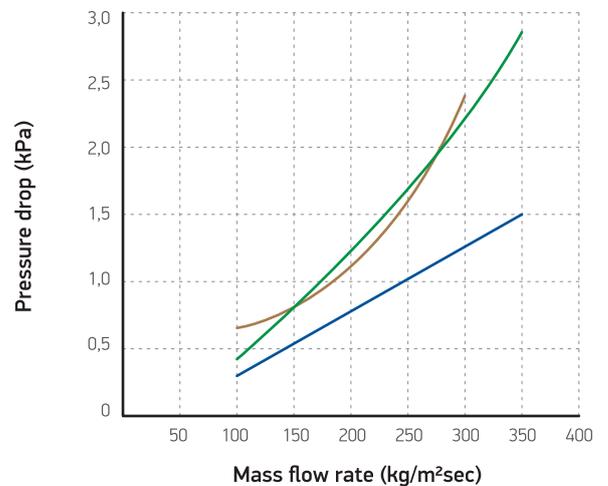
**Performance mode:**  
Condensation

**Test conditions:**  
 Dew point: 35°C  
 Inlet superheat: 5K  
 Outlet subcooling: 2K  
 Tube length: 2m

**PLAIN TUBE**  
**HALCOR IGT ENHANCED TYPE**  
**HALCOR IGT STANDARD TYPE**

**Refrigerant:**  
R404A - no oil

Tube Heat Transfer Performance: **CONDENSATION**



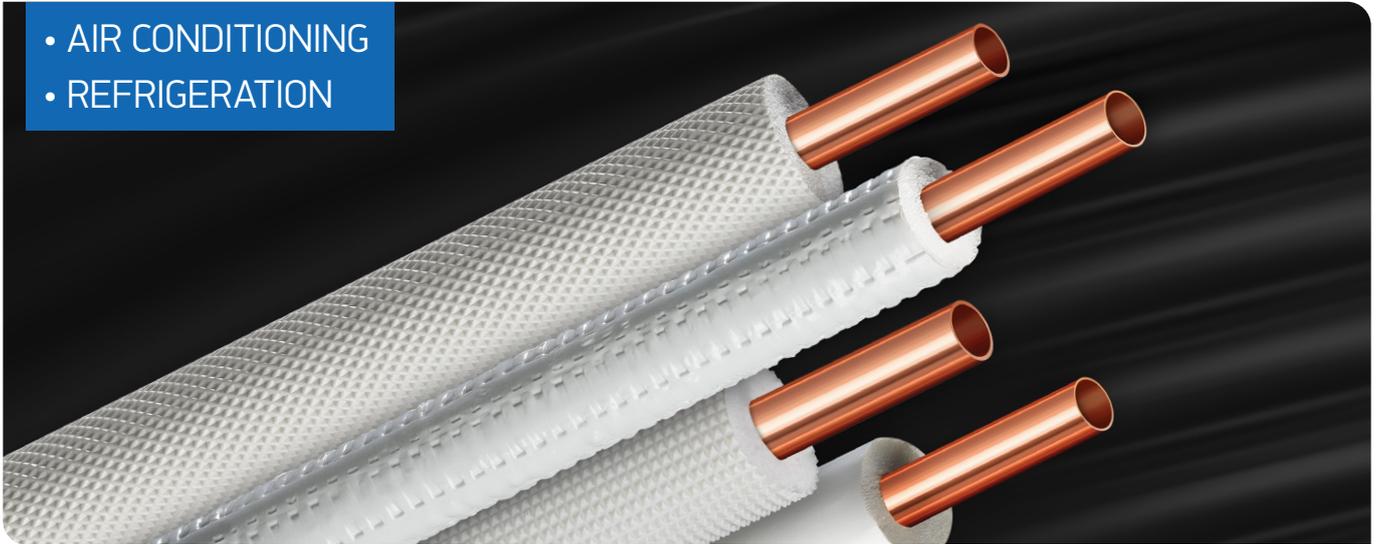
**Performance mode:**  
Condensation

**Test conditions:**  
 Dew point: 35°C  
 Inlet superheat: 5K  
 Outlet subcooling: 2K  
 Tube length: 2m

**PLAIN TUBE**  
**HALCOR IGT ENHANCED TYPE**  
**HALCOR IGT STANDARD TYPE**

**Refrigerant:**  
R404A - no oil

- AIR CONDITIONING
- REFRIGERATION



### Advanced Technology that saves Energy and protects the Environment.

TALOS<sup>®</sup> ACR ECUTHERM pre-insulated copper tubes are advanced technological products of high added value and significantly superior in effectiveness compared to conventional insulation methods.

- Significant and continuous energy savings
- Safe network operation
- Reduction of installation time
- High resistance to mechanical stress
- Ease of forming
- External or embedded installations
- Resistance to extreme atmospheric conditions

The unique advantages offered by the TALOS<sup>®</sup> ACR ECUTHERM copper tubes, such as copper resistance and durability, coupled with high performance pre-insulation (Engineering Foams), result in significant energy savings. With a competitive market price and low installation cost, TALOS<sup>®</sup> ACR ECUTHERM copper tubes are the ideal choice for every modern application.

### High Performance Technological Product

The insulating material used in the manufacturing of TALOS<sup>®</sup> ACR ECUTHERM copper tubes is an extruded high quality cross-linked polyethylene (PE-X) suitably expanded to form a foam with closed microcells, free of FCFC and fibrous substances. A layer of thin polyethylene coating is adhered to the foamy crosslinked substrate, providing a skin of improved operational features and esthetic appearance.

The closed microcells of the insulating material, combined with the protective outer polyethylene skin, form an integral barrier to aggressive environments, rendering the tube suitable for a variety of applications, such as heating, cooling, and air-conditioning installations.

The TALOS<sup>®</sup> ACR ECUTHERM (PE-X) copper tubes are produced in compliance to the requirements of standards that apply in most of the European Union countries, as regards insulation properties, chemical characteristics and resistance to fire. They exhibit low  $\lambda$  coefficient, determining its heat conductivity properties and very good  $\mu$  coefficient which determines its resistance to penetration of moisture.

The TALOS<sup>®</sup> ACR ECUTHERM (PE-X) copper tubes are available in coils of 25 & 50 meter lengths and insulation thickness of 6, 9, 10 and 13mm, suiting a variety of insulation needs.

## Reliability that only TALOS<sup>®</sup> Copper Tubes can provide

TALOS<sup>®</sup> ACR copper tubes are manufactured according to the European Standard EN 12735-1 for use in air conditioning and refrigeration installations, and have been awarded most major international quality marks. TALOS<sup>®</sup> ACR copper tubes meet the requirements imposed by new generations of refrigerants (HFCs, HFOs) which are adopted by major refrigeration and air conditioning unit manufacturers. TALOS<sup>®</sup> copper tubes, with their high quality of manufacture, provide:

- Long lifetime
- Resistance to pressure, temperature variations and fire
- Complete network impermeability
- Quality and reliability of installation
- Versatile applications
- Comprehensive range of sizes

## Copper Tube Material

Copper phosphorus deoxidised (minimum copper content 99,90%, phosphorus concentration P=0,015% - 0,04%, classified as CW024A, or Cu-DHP, according to the Euroalloy coding system.

## Specifications

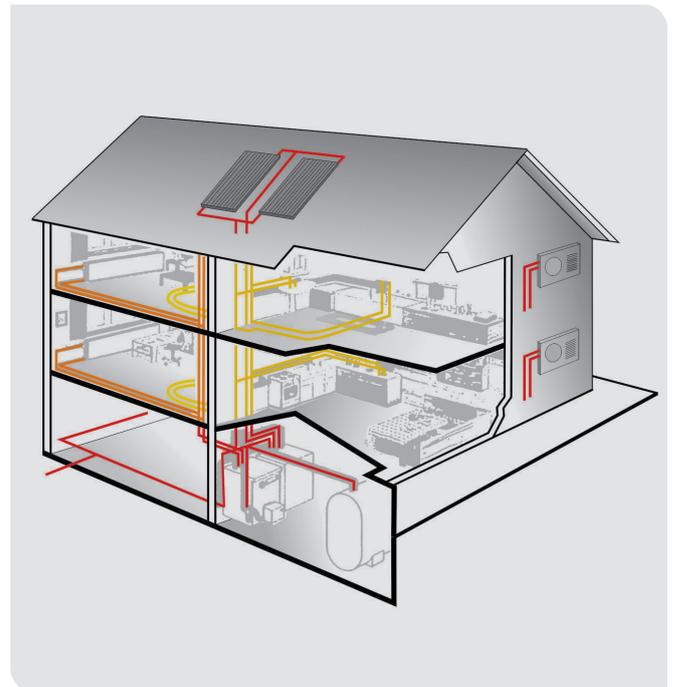
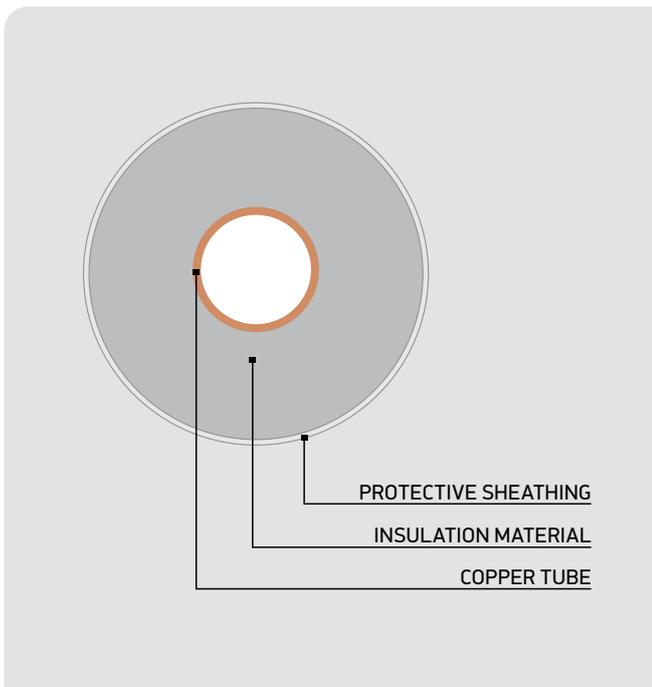
EN 12735-1

## Quality Marks

AENOR, TÜV, GL, VIK

## Mechanical Properties

Temper	EN 12735 Designation	Min. Tensile Strength, R <sub>m</sub> (MPa)	Min. Elongation, A (%)
Soft	R-220	220	40





## Insulation Technical Properties



Cross-linked Polyethylene



RESISTANCE

MATERIAL	PE-X foam
DENSITY ACCORDING TO DIN 53420 ASTM D 1667	30-33 Kg/m <sup>3</sup>
THERMAL CONDUCTIVITY COEFFICIENT ( $\bar{\lambda}$ ) ACCORDING TO EN ISO 8497	0.0357 W/mK (0°C) 0.0389 W/mK (40°C)
VAPOUR-WATER DIFFUSION RESISTANCE COEFFICIENT ( $\mu$ ) ACCORDING TO EN 13469	12,500
WORKING TEMPERATURE	-80°C to +110°C
REACTION TO FIRE	EN 13501-1 Class B or Class E, DIN 4102, B2, BS 476, NF P 92 501-M1
RESISTANCE TO CHEMICAL AGENTS ACC. TO ASTM 543-56 T	Very good
DIMENSIONAL STABILITY ACCORDING TO ISO 2796 FOR TEMPERATURES UP TO 100°C	<5%

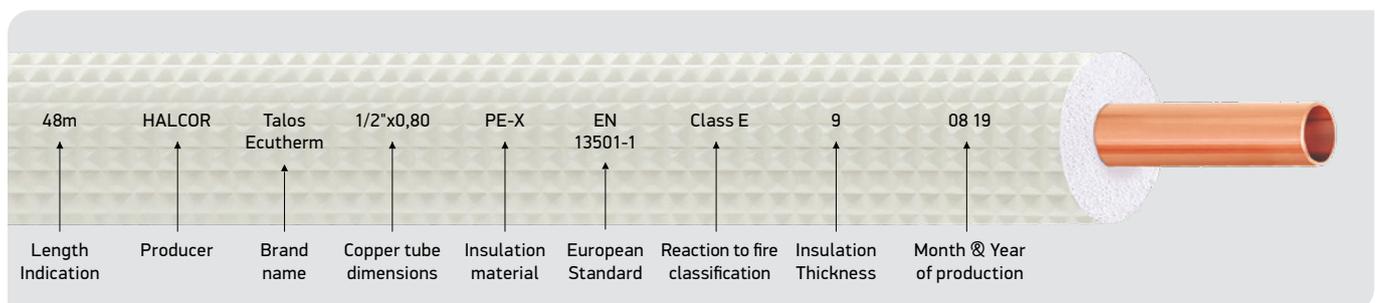
Values are listed, as obtained under standard laboratory conditions and may be amended, without prior notice.

## Standard Dimensions according to EN 12735-1

Copper tube external diameter	Inch	3/16	1/4	5/6	3/8	1/2	5/8	3/4	7/8
	mm	4,76	6,35	7,94	9,52	12,70	15,87	19,05	22,22
Copper tube wall thickness	mm	0,80	0,80	0,80	0,80	0,80	1,00	1,00	1,00
Overall external diameter with 9mm thick insulation	mm	22,76	24,35	25,94	27,52	30,70	33,87	37,05	40,23
Maximum Allowable Pressure	bar	238	171	146	109	80	77	62	53

Maximum Working Pressure calculation according to EN 14276:2020 which complies with the European Directive PED 2014/68/EU (Pressure Equipment Directive)

## Marking



**TALOS® ECUTHERM 1/2" & 5/8"**  
**Indicative Calculation Of Insulation Thickness**

Air conditioning and refrigeration units, operate in temperatures lower than ambient temperature; This temperature difference may lead to unwanted vapour condensation on the insulation outer surface; therefore it must be compensated by the insulation thickness. The thickness of the insulation (with reference to Mollier's diagram), is calculated taking into consideration the temperature of the fluid (or gas) inside the pipes, ambient temperature and the relative humidity of the air.



TEMPERATURE INSIDE THE TUBE (°C)	INSULATION THICKNESS (mm)											
	AMBIENT TEMPERATURE (°C) AND RELATIVE HUMIDITY (%)											
	25°C			30°C			35°C			40°C		
	50%	60%	70%	50%	60%	70%	50%	60%	70%	50%	60%	70%
+15		6	6	6	6	6	6	6	9	6	6	9
+10	6	6	6	6	6	9	6	6	9	6	6	9
+5	6	6	9	6	6	9	6	6	9	6	9	9
0	6	6	9	6	6	9	6	9	9	6	9	13
-5	6	6	9	6	9	9	6	9	13	6	9	13
-10	6	9	9	6	9	13	6	9	13	9	9	13
-20	6	9	13	9	9	13	9	9	13	9	13	13

1/2 inch - 12,7 mm

5/8 inch - 15,88 mm



- AIR CONDITIONING
- REFRIGERATION



### Clear Advantage in Refrigeration and Air Conditioning

TALOS<sup>®</sup> ACR ECUTHERM 2 pre-insulated copper tubes, manufactured by HALCOR are an innovation that ensures significant advantages for refrigeration and air conditioning installers.

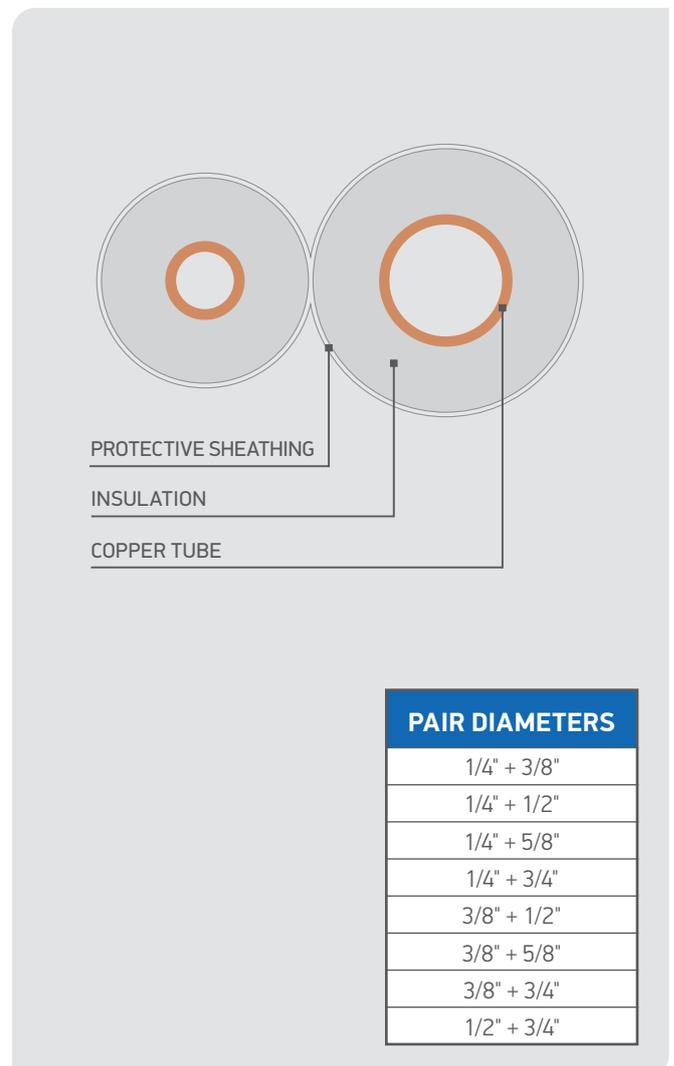
- Simplified installation process and reduction of installation time
- Reduction of overall network installation cost
- Reliable operation of installations and significant energy savings
- Aesthetic result and space saving

### Pair Combinations for any Application

TALOS<sup>®</sup> ACR ECUTHERM 2 copper tubes are manufactured in pairs, firmly connected along their entire length, and in eight standard size combinations which cover sufficiently the usual connectivity requirements of any refrigeration or air conditioning unit. TALOS<sup>®</sup> ACR ECUTHERM 2 copper tube pairs, form a single unit which is installed easily and fast, ensuring professional results.

### Certified Quality

TALOS<sup>®</sup> ACR ECUTHERM 2 pre-insulated copper tubes, have been certified by the German quality assurance organization RWTUV, with regard to trials and manufacturing tests. The quality and reliability of such products, is ensured through the implementation of a Quality Assurance System, according to standard ISO 9001:2015, certified by TÜV Hellas.



## Appropriate also for the New Green Refrigeration Units

According to the European Standard EN12735-1:2010, as well as current market requirements, laid down by the use of new generation of refrigerants, including HFCs and HFOs, adopted by all major manufacturers of refrigeration and air conditioning units the following standardisation is applied to TALOS® ACR ECUTHERM 2 copper tubes:

- For an external diameter of 1/4" to 1/2", the wall thickness is standardised at 0,80 mm
- For an external diameter of 5/8" to 3/4", the wall thickness is standardised at 1,00 mm

## Copper Tube Material

Copper phosphorus deoxidised (minimum copper content 99,90%, phosphorus concentration P=0,015% - 0,04%, classified as CW024A, or Cu-DHP, according to the Euroalloy coding system.

## Quality Marks

AENOR, TÜV, GL, VIK

## Mechanical Properties

Temper	EN 12735 Designation	Min. Tensile Strength, R <sub>m</sub> (MPa)	Min. Elongation, A (%)
Soft	R-220	220	40

## Insulation Technical Properties



Cross-linked Polyethylene



RESISTANCE

MATERIAL	PE-X foam
DENSITY ACCORDING TO DIN 53420 ASTM D 1667	30-33 Kg/m <sup>3</sup>
THERMAL CONDUCTIVITY COEFFICIENT (λ) ACCORDING TO EN ISO 8497	0.0357 W/mK (0°C) 0.0389 W/mK (40°C)
VAPOUR-WATER DIFFUSION RESISTANCE COEFFICIENT (μ) ACCORDING TO EN 13469	12,500
WORKING TEMPERATURE	-80°C to +110°C
REACTION TO FIRE	EN 13501-1 Class B or Class E, DIN 4102, B2, BS 476, NF P 92 501-M1
RESISTANCE TO CHEMICAL AGENTS ACC. TO ASTM 543-56 T	Very good
DIMENSIONAL STABILITY ACCORDING TO ISO 2796 FOR TEMPERATURES UP TO 100°C	<5%

Values are listed, as obtained under standard laboratory conditions and may be amended, without prior notice.

## Standard Pair Dimensions (Coils 15m, 25m, 30m Long)

Maximum Allowable Pressure calculation according to EN 14276:2020 which complies with the European Directive PED 2014/68/EU (Pressure Equipment Directive)

Copper tube external diameter	Inch	1/4-3/8	1/4-1/2	1/4-5/8	1/4-3/4	3/8-1/2	3/8-5/8	3/8-3/4	1/2-3/4
	mm	6,35-9,52	6,35-12,7	6,35-15,87	6,35-19,05	9,52-12,7	9,52-15,87	9,52-19,05	12,7-19,05
Copper tube wall thickness	mm	0,80-0,80	0,80-0,80	0,80-1,00	0,80-1,00	0,80-0,80	0,80-1,00	0,80-1,00	0,80-1,00
Overall external diameter with 9mm thick insulation	mm	24,4-27,5	24,4-30,7	24,4-33,9	24,4-37,10	27,5-30,7	27,5-33,9	27,5-37,1	30,7-37,1
Maximum Allowable Pressure	bar	171-109	171-80	171-77	171-62	109-80	109-77	109-62	80-62

Other sizes and special packaging in pallets or cardboard boxes are available upon request.



- AIR CONDITIONING
- HEAT PUMP SYSTEMS



TALOS® ACR Linesets are designed especially for the split Air Conditioning and Heat Pump Systems products requiring installation with flared connections. The unique advantages offered by TALOS® ACR Linesets, including, copper resistance and durability, high performance foam insulation and pre-flared ends with mounted flare nuts, result in significant energy savings and in quick, cost effective field installations.

#### Advantages of TALOS® ACR Linesets:

- Significant and continuous energy savings
- Quick, Safe and Cost effective installations
- Comprehensive range of sizes

TALOS® ACR Linesets comprise pre-insulated TALOS® copper tubes manufactured according to the European Standard EN 12735-1 for use in air conditioning and refrigeration installations. TALOS® ACR Linesets meet the current requirements imposed by the new green refrigerants (R -410A, etc.), adopted by major refrigeration and air conditioning unit manufacturers.

The insulating material used in the manufacturing of TALOS® ACR Linesets is an extruded high quality crosslinked polyethylene (PE-X) foam with closed microcells. The closed microcells of the insulating material, combined with an external protective skin layer of thin polyethylene coating, form an integral barrier to aggressive environments. The continuous factory-applied insulation avoids seams or openings that can cause dripping and decrease efficiency.

The ends of TALOS® ACR Linesets are conveniently pre-flared and mounted with forged brass flare nuts manufactured according to the SAE J513 international standard for use with

standardized 45° flare joints. The flare nuts are capped with protective plastic plugs for shipment.

TALOS® ACR Linesets are supplied either in single or “twin tube” configurations with a variety of foam thicknesses to meet every insulation requirement. The comprehensive range of sizes reduces waste and time.

#### Copper Tube Material

Copper phosphorus deoxidised (minimum copper content 99,90%, phosphorus concentration P=0,015% - 0,04%, classified as CW024A, or Cu-DHP, according to the Euroalloy coding system.

#### Specifications

COPPER TUBES: EN 12735-1

FOAM INSULATION: EN 13501-1

FLARE FITTINGS: SAE J513

#### Quality Marks

COPPER TUBES: AENOR, TÜV, GL

#### Instructions

Follow the equipment manufacturer’s installation instructions regarding refrigerant tubing, system evacuation and testing for leaks.

- Remove protective shipping plugs
- Properly connect and tighten the flare nut to the approved level of torque
- Take precautions not to crimp tube when bending
- Take precautions not to tear the insulation
- Do not allow contaminants to be introduced inside the network

## Mechanical Properties

Material Condition Designation (Temper)	Min. Tensile Strength, R <sub>m</sub> (MPa)	Min. Elongation, A(%)
Soft (R220)	220	40

## Standard Dimensions according to EN 12735-1

Copper tube external diameter	Inch	3/16	1/4	5/8	3/8	1/2	5/8	3/4	7/8
	mm	4,76	6,35	7,94	9,52	12,70	15,87	19,05	22,22
Copper tube wall thickness	mm	0,80	0,80	0,80	0,80	0,80	1,00	1,00	1,00
Overall external diameter with 9mm thick insulation	mm	22,76	24,35	25,94	27,52	30,70	33,87	37,05	40,23
Maximum Allowable Pressure	bar	238	171	133	109	80	77	62	53

## Standard Pair Dimensions (coils 2m-15m)

Copper tube external diameter	Inch	1/4-3/8	1/4-1/2	1/4-5/8	1/4-3/4	3/8-1/2	3/8-5/8	3/8-3/4	1/2-3/4
	mm	6,35-9,52	6,35-12,7	6,35-15,87	6,35-19,05	9,52-12,7	9,52-15,87	9,52-19,05	12,7-19,05
Copper tube wall thickness	mm	0,80-0,80	0,80-0,80	0,80-1,00	0,80-1,00	0,80-0,80	0,80-1,00	0,80-1,00	0,80-1,00
Overall external diameter with 9mm thick insulation	mm	24,4-27,5	24,4-30,7	24,4-33,9	24,4-37,10	27,5-30,7	27,5-33,9	27,5-37,1	30,7-37,1
Maximum Allowable Pressure	bar	171-109	171-80	171-77	171-62	109-80	109-77	109-62	80-62

Other sizes and special packaging in pallets or cardboard boxes are available upon request.

Maximum Allowable Pressure calculation according to EN 14276:2020 which complies with the European Directive PED 2014/68/EU (Pressure Equipment Directive)

## Insulation Technical Properties



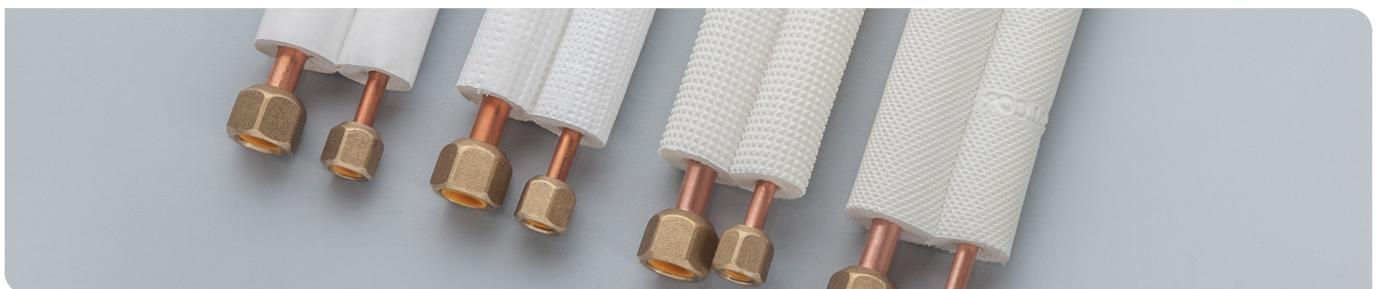
Cross-linked Polyethylene

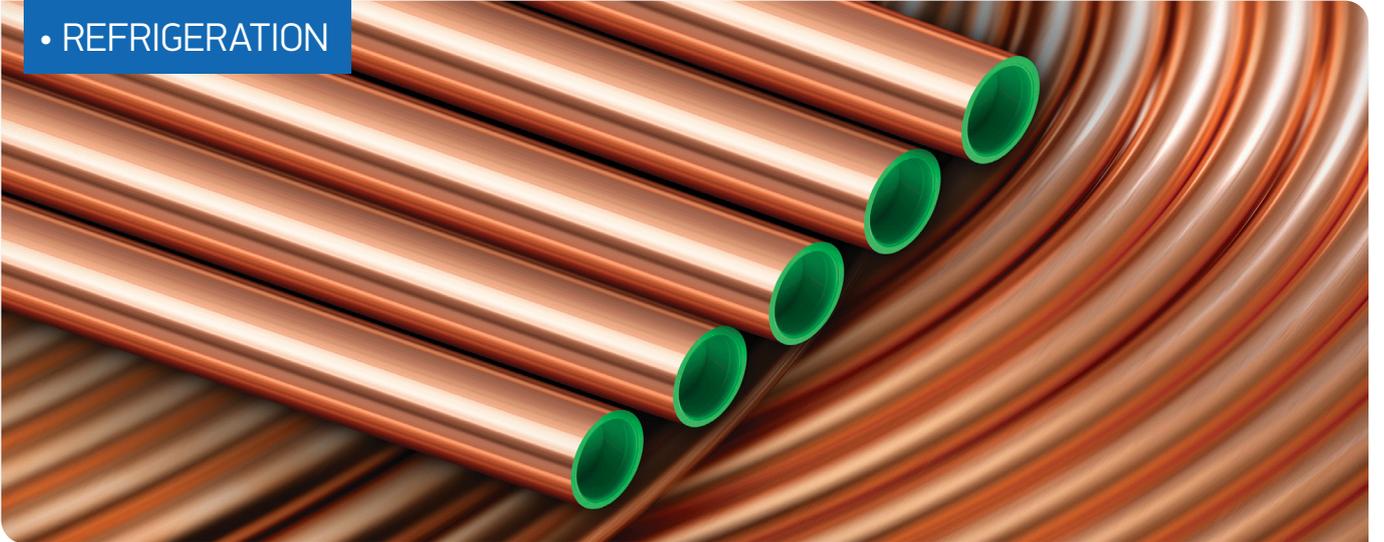


RESISTANCE

MATERIAL	PE-X foam
DENSITY ACCORDING TO DIN 53420 ASTM D 1667	30-33 Kg/m <sup>3</sup>
THERMAL CONDUCTIVITY COEFFICIENT (λ) ACCORDING TO EN ISO 8497	0.0357 W/mK (0°C) 0.0389 W/mK (40°C)
VAPOUR-WATER DIFFUSION RESISTANCE COEFFICIENT (μ) ACCORDING TO EN 13469	12,500
WORKING TEMPERATURE	-80°C to +110°C
REACTION TO FIRE	EN 13501-1 Class B or Class E, DIN 4102, B2, BS 476, NF P 92 501-M1
RESISTANCE TO CHEMICAL AGENTS ACC. TO ASTM 543-56 T	Very good
DIMENSIONAL STABILITY ACCORDING TO ISO 2796 FOR TEMPERATURES UP TO 100°C	<5%

Values are listed, as obtained under standard laboratory conditions and may be amended, without prior notice.




 • REFRIGERATION

### Green Refrigeration

The increasing concern of the environmental impact of hydro-fluorocarbon (HFC) refrigerants, as well as the more stringent environmental regulations, have prompted a re-emergence of carbon dioxide (CO<sub>2</sub>) based refrigeration systems. CO<sub>2</sub> refrigerant is used as a working fluid in many climate control systems, in applications such as commercial refrigeration, residential air conditioning, hot water pumps, vending machines, etc. The supermarket industry in particular, implemented an ecological and efficient store concept by successfully embracing advanced CO<sub>2</sub> refrigeration technologies developed by refrigeration system manufacturers.

### CO<sub>2</sub> as a refrigerant

CO<sub>2</sub> (R-744) refrigerant is termed a “natural” refrigerant because it exists in the natural environment. Released from refrigeration systems into the atmosphere has a negligible effect to global warming, thus CO<sub>2</sub> has no regulatory liability, as is the case of CFC, HCFC and HFC refrigerants. In addition to its environmental-friendly character, CO<sub>2</sub> is currently viewed as a viable solution for low-temperature refrigeration applications because it is non-ozone depleting, non-toxic, non-flammable and has a high volumetric cooling capacity. However due to its physical properties, CO<sub>2</sub> based refrigeration systems request much higher pressure, compared to conventional systems. The operating pressure of such systems can reach up to 120/130 bar in the transcritical cycle. CO<sub>2</sub> meets the demand for a low-global warming potential (GWP) refrigerant but presents challenges in both its application and handling. The higher operating pressure and broad temperature fluctuations require that all the system components, including piping, should be designed accordingly.

### Extra-Strong TALOS® XS tubes for high-pressure systems

TALOS® XS tubes were specifically developed from a high strength copper-alloy (CuFe2P) to satisfy the demands of today’s high-pressure CO<sub>2</sub> systems in refrigeration, as well as, other high-pressure HVAC&R applications. TALOS® XS tubes possess the extra strength to withstand operating pressures of up to 130bar. At the same time, TALOS® XS tubes are manufactured with comparatively thinner walls and thus achieve an economical advantage that meets the pressure equipment design. The well-known installation practices of refrigeration copper tubes are followed also for the installation of TALOS® XS tubes in systems and in the field (see also EN378 for guidelines). Since the processing methodology remains essentially the same, existing tooling and handling equipment is made of use. This includes brazing with standardized silver braze alloy (min. silver content of 2%), bending with traditional tools and joining with standardized fittings made from copper or copper-alloy (CuFe2P).





### TALOS® XS Product Features

- Ideally suited for CO<sub>2</sub> refrigeration applications
- Made from Extra-Strong copper-iron (CuFe2P) alloy
- Cost-effective and lightweight, manufactured with comparatively thinner walls
- Traditional processing techniques and equipment
- Compatible with existing fittings made of the same alloy
- Clearly marked and easily identified

### Material

Copper-iron alloy (CuFe2P), with chemical composition according to EN 12735-1 (CW107C) and UNS C19400

### Specifications

**Dimensional Tolerances:** Internal production specifications, EN 12735-1

**Internal Cleanliness:** EN 12735-1

**Mechanical Properties:** R300 acc. to EN 12735-1 and VdTÜV WB567, R420 acc. to EN12735-1 upon request

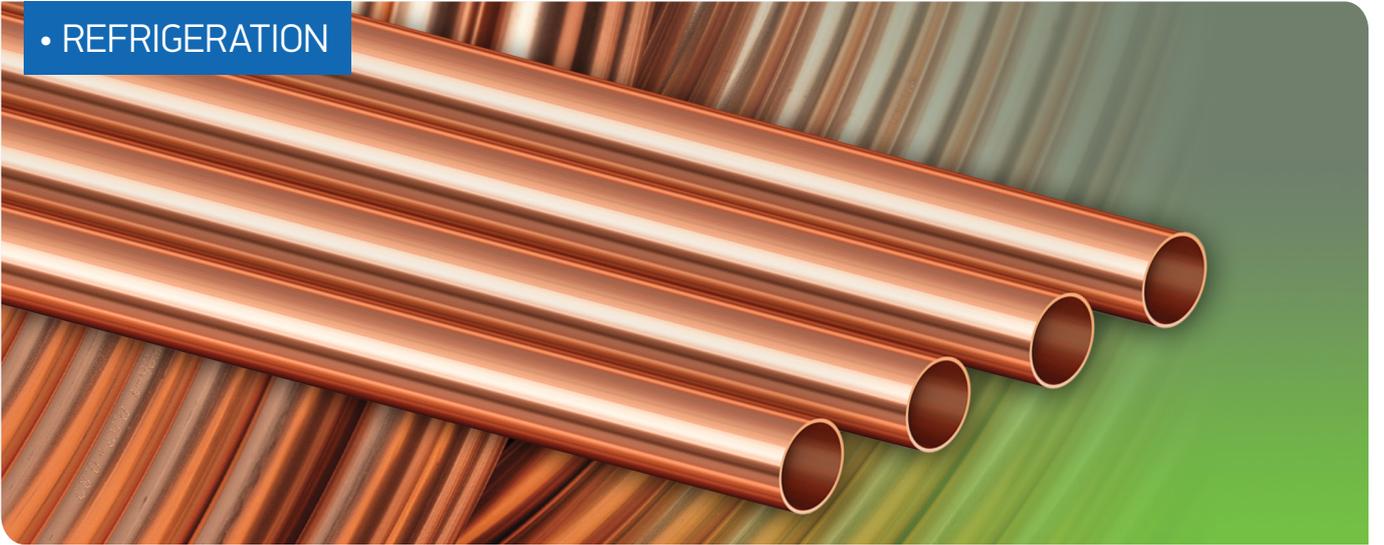
**Form of supply:** Straight lengths with end-caps, in bundles or wooden cases

**Marking:** e.g. HALCOR TALOS-XS 9.52x0.65 CuFe2P R300 130bar/1885psi EN 12735-1

TALOS® XS for 130 bar								
Outside Diameter		Wall Thickness				Temper	Length <sup>2</sup>	
		120bar <sup>1</sup>		130bar <sup>1</sup>				
(mm)	(inch)	(mm)	(inch)	(mm)	(inch)		(meters)	(feet)
9,52	3/8	0,56	0,022	0,65	0,026	R300	5	16,4
12,70	1/2	0,75	0,030	0,85	0,033	R300	5	16,4
15,87	5/8	0,93	0,037	1,05	0,041	R300	5	16,4
19,05	3/4	1,19	0,046	1,30	0,051	R300	5	16,4
22,23	7/8	1,38	0,054	1,50	0,059	R300	5	16,4
28,57	1 1/8	1,78	0,070	1,90	0,075	R300	5	16,4
34,92	1 3/8	2,17	0,085	2,30	0,091	R300	5	16,4
41,27	1 5/8	2,56	0,100	2,70	0,106	R300	5	16,4
53,97	2 1/8	3,35	0,131	3,55	0,140	R300	5	16,4
66,67	2 5/8	4,14	0,163	4,45	0,175	R300	5	16,4

<sup>1</sup> Maximum Allowable Pressure of 120bar (1740psi) and 130bar (1885psi) up to 150°C (302°F) and down to -196°C (-320°F) calculated acc. to EN14276:2020.

<sup>2</sup> Additional lengths are available upon request.


 • REFRIGERATION

### CO<sub>2</sub> Subcritical Systems

Carbon dioxide (CO<sub>2</sub>) is a naturally occurring substance in the atmosphere and it has been used as refrigerant since the early days of refrigeration. CO<sub>2</sub> has zero ODP and a GWP of 1, making it one of the best choices from an environmental perspective. Due to thermodynamic properties, CO<sub>2</sub> systems require high operating pressures in order to operate efficiently. CO<sub>2</sub> has a low critical temperature and high pressure 31°C and 73.8bar respectively.

CO<sub>2</sub> refrigeration cycles can be transcritical as well as subcritical. Transcritical and subcritical refers to the high-pressure side of the systems, as it operates above or below the critical point, respectively. Transcritical refers to the state of the refrigerant above the critical point.

The design pressure of CO<sub>2</sub> systems depends on the corresponding component refrigerant state. A design pressure of 80bar is sufficient for components in contact with non-transcritical CO<sub>2</sub> at working and standstill conditions.

### TALOS® S80

TALOS® S80 tubes are specifically designed for an operation pressure of up to 80bar. In order to meet the high-pressure CO<sub>2</sub> requirements TALOS® S80 tubes are manufactured with reinforced wall thicknesses in comparison with TALOS® ACR.

TALOS® S80 can be used where the system's design pressure does not exceed 80bar, i.e. where the CO<sub>2</sub> is not supercritical. In practice, this occurs at both high and low pressure sides in subcritical cycles and at the low pressure side of transcritical cycles.

The well-known installation practices of refrigeration copper tubes apply both in systems and in the field (see relative EN378 standard for guidelines).

### TALOS® S80 Product Features

- Tailored to meet subcritical CO<sub>2</sub> systems requirements
- Suitable for ACR systems with a design pressure up to 80bar
- Traditional processing techniques and equipment
- Excellent “cold formability”
- Smooth internal surface enhancing flow rate
- High purity of internal surface
- Stable mechanical properties covering an extensive temperature range
- Excellent brazing ability
- Compatible with standardized ACR fittings



## Specifications

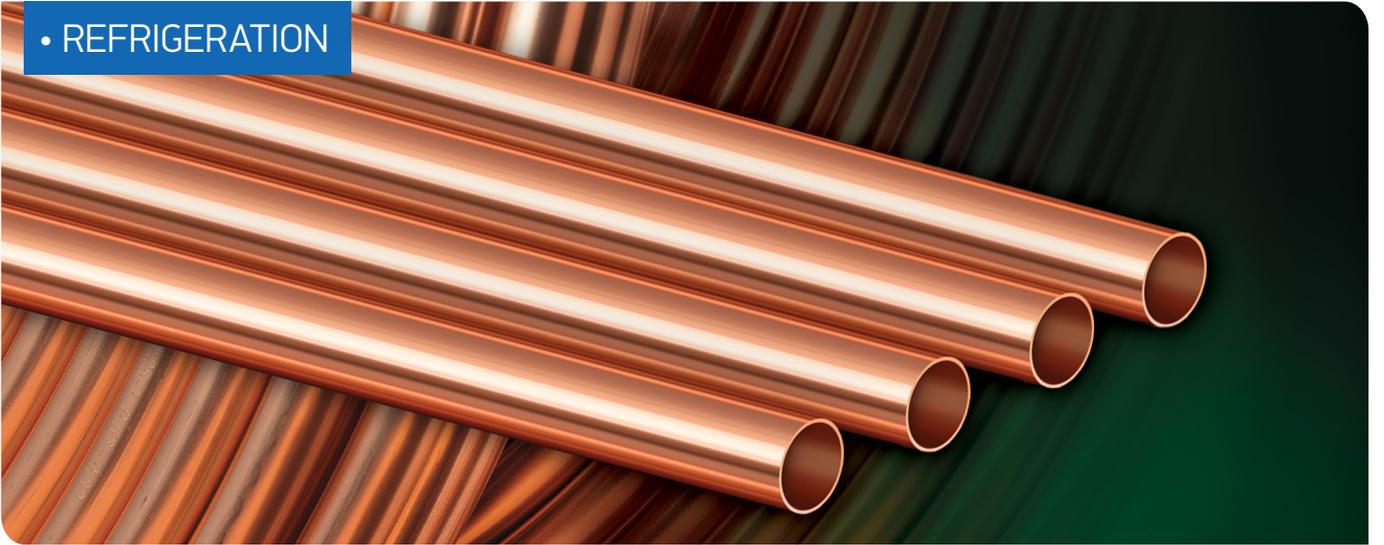
TALOS®S80 tubes are made from Copper-DHP (CW024A, UNS 12200). They are produced according to EN 12735-1 and internal production specifications and are approved according to the European Pressure Equipment Directive (PED) 2014/68/EU.

## Form of supply

- Straight lengths, in bundles (hard copper tubes) and in wooden boxes (soft copper tubes).
- Pancakes-PNC in shrink-wrapped individual plastic bags. Depending on market requirements, products can be placed in cardboard boxes and pallets.

TALOS® S80 for 80bar <sup>1</sup>			
Outer Diameter		Wall Thickness	
(inch)	(mm)	(mm)	(inch)
5/16"	7,94	0,70	0,028
3/8"	9,53	0,80	0,031
1/2"	12,70	0,90	0,035
5/8"	15,88	1,05	0,041
3/4"	19,05	1,30	0,051
7/8"	22,23	1,50	0,059
1 1/8"	28,58	1,90	0,075
1 3/8"	34,93	2,30	0,091
1 5/8"	41,28	2,70	0,106
2 1/8"	53,98	3,60	0,142
2 5/8"	66,68	4,50	0,177

<sup>1</sup> Maximum Allowable Pressure calculation acc. to EN 14276:2020. For service temperatures from -196°C up to 100°C.


 • REFRIGERATION

### CO<sub>2</sub> Systems Technology

The rising demand of the international community for a green and safe environment has put pressure on the use of HFC refrigerants for HVAC&R applications. At the same time, the use of Carbon Dioxide (CO<sub>2</sub>) as a refrigerant thrives and installations of CO<sub>2</sub> (R-744) refrigeration systems are increasing at a high rate around the world.

CO<sub>2</sub> is a natural refrigerant with zero ODP and a GWP of 1, being one of the best choices from an environmental perspective. CO<sub>2</sub> refrigeration cycles, require high operating pressures in order to operate efficiently. Several technologies that improve the efficiency of CO<sub>2</sub> systems have been established and are under development and optimization (e.g. ejectors, parallel compression, adiabatic cooling, etc.). New technologies lead to new and specialized design conditions that result in different levels of operating and design pressure and temperature.

### TALOS® S60

TALOS®S60 tubes are specifically designed for a maximum allowable pressure of 60bar and feature a reinforced wall thickness in comparison with the standardized TALOS®ACR tube range.

Combined with TALOS®XS for 120/130bar and TALOS®S80 for 80bar, TALOS®S60 for 60bar completes HALCOR's copper tube portfolio for CO<sub>2</sub> applications and provides the HVAC&R designer a full range of choices corresponding to the unique design conditions.

The well-known installation practices of refrigeration copper tubes apply both in systems and in the field (see relevant EN378 standard for guidelines).

### TALOS® S60 Features

- Suitable for ACR systems with a design pressure up to 60bar
- Traditional processing techniques and equipment
- Excellent “cold formability”
- Smooth internal surface enhancing flow rate
- High purity of internal surface
- Stable mechanical properties covering an extensive temperature range
- Excellent brazing ability
- Compatible with standardized ACR fittings



## Specifications

TALOS®S60 tubes are made from Copper-DHP (CW024A, UNS 12200). They are produced according to EN 12735-1 and internal company specifications and comply with the European Pressure Equipment Directive (PED) 2014/68/EU.

## Form of supply

- Straight lengths, in bundles (hard copper tubes) and in wooden boxes (soft copper tubes).
- Pancakes-PNC in shrink-wrapped individual plastic bags. Depending on market requirements, products can be placed in cardboard boxes and pallets.

TALOS® S60 for 60bar <sup>1</sup>			
Outer Diameter		Wall Thickness	
(inch)	(mm)	(mm)	(inch)
5/16"	7,94	0,70	0,028
3/8"	9,53	0,70	0,028
1/2"	12,7	0,70	0,028
5/8"	15,88	0,80	0,031
3/4"	19,05	0,91	0,036
7/8"	22,23	1,10	0,043
1 1/8"	28,58	1,42	0,056
1 3/8"	34,93	1,73	0,068
1 5/8"	41,28	2,05	0,081
2 1/8"	53,98	2,67	0,105
2 5/8"	66,68	3,30	0,130

<sup>1</sup> Maximum Allowable Pressure calculation acc. to EN 14276:2020. For service temperatures from -196°C up to 100°C.

# HALCOR

COPPER TUBES DIVISION of:



62nd km Athens-Lamia National Road,  
320 11 Oinofyta Viotia, Greece  
T: +30 22620 48 111 F: +30 22620 48799  
E: info@halcor.com www.halcor.com

Member of **Copper Alliance**

#### Alurame S.r.l.

Via Antonio Stradivari 10  
20131 Milano Italy  
T: +39 02 971781 F: +39 02 97178115  
E: info.alurame@viohalco.com

#### BASE METAL TİCARET VE SANAYİ A.Ş.

Barbaros Mah. Mustafa Pehlivan Sok. 21/1 34662 Üsküdar,  
İstanbul Turkey  
T: +90 216 688 76 44  
E: info@base-metal.com.tr www.base-metal.com.tr

#### METAL AGENCIES LIMITED

Suite 4, Cobb House, 2-4 Oyster Lane, Byfleet,  
Surrey KT14 7DU United Kingdom  
T: +44 1932 33 11 11 F: +44 1932 33 11 90  
E: sales@metalagencies.com http://www.metalagencies.com

#### REYNOLDS CUIVRE S.A.s.

1 rue François Jacob, CS 60099, 92508  
Rueil Malmaison CEDEX, France  
T: +33 1 55 47 24 60  
E: tubecuire@reynolds-cuivre.fr http://reynolds-cuivre.fr/

#### SOFIA MED

4 Dimitar Peshev str., Gara Iskar  
1528 Sofia Bulgaria  
T: + 359 2 960 6209, + 359 2 960 6350 F: + 359 2 960 6393  
E: info@sofiamed.bg www.sofiamed.bg

#### STEELMET ROMANIA S.A.

Str. Drumul intre Tarlale nr.42, Sector 3, CP 032982  
73644 Bucharest, Romania  
T: + 40 21 209 0570 F: + 40 21 256 1464  
E: office@steelmet.ro www.steelmet.ro

#### TeProMKC GmbH

Ursulastraße 33 – 41  
DE - 50354 Hürth Germany  
T: +49 (0) 2233 - 3962 – 324  
E: info@tepromkc.com www.tepromkc.com