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B U L L E T I N

NO:	MB2019CC-17
DATE:	**12/13/2019**
TO:	**Air Conditioning & Refrigeration Original Equipment Manufacturers & End Users**
FROM:	Emerson
SUBJECT:	**Copeland Scroll™ Manufacturing Location Change – Group 1**
ACTION REQUIRED:	Review transition timeline and minor compressor design changes
TIME PERIOD:	Group 1 transition period: Q1 – Q3 CY2020

Emerson is moving the manufacturing location of **Copeland Scroll™ Compressors (ZP/R/H 6-40Ton and ZB/F 7-17HP)** from Sidney, OH, to Lebanon, MO.

Copeland Scroll compressors have been at the heart of the HVAC and Refrigeration systems, supporting homeowners, businesses, and industries for over 30 years. Every product is engineered, manufactured, and tested for efficient, sustainable, ultra-reliable, and quiet operation, and we are continually improving the technology to meet customers' needs in the ever-changing HVACR market.

As a result, Emerson has invested in a new, state of the art assembly line in the Lebanon plant (Figure 1) to improve manufacturing processes, increase operations flexibility, enhance product quality, and prepare for future regulatory requirements. Lebanon's geographic location also enables Emerson to streamline its supply chain to serve customers better.

Figure 1: Emerson Plant in Lebanon, Missouri

The transition includes five different product groups (Figure 2) that will move from Sidney to Lebanon starting in 2020.

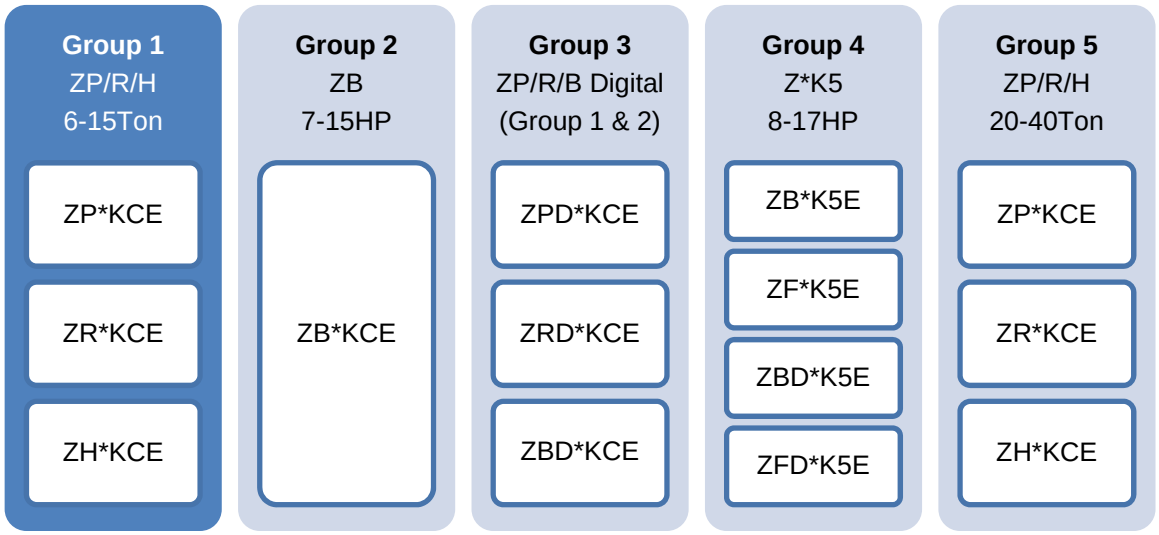

Figure 2: Product Transition Groups

The standard lead-times will remain the same, and new serial numbers will indicate Lebanon as the building plant (the new number ends in “L”) versus Sidney (the previous number ends in “D”).

The manufacturing location of other products currently made in Sidney – Copeland Scroll Compressors (2-8Ton / 2-8HP), Tandem Units, and Copeland Condensing Units for Refrigeration – will not change.

This bulletin details **Group 1 – ZP/R/H 6-15Ton** for which customers should:

1. REVIEW TRANSITION TIMELINE

Timeline for ZP*KCE:

- Orders accepted by Lebanon: **Starting between ~~January and March 2020~~** March and August 2020
- Estimated end of production of ZP*KCE in Sidney: **~~April 2020~~** September 2020

Timeline for ZR*KCE and ZH*KCE:

- Orders accepted by Lebanon: **Starting between April and June 2020**
- Estimated end of production of ZR*KCE and ZH*KCE in Sidney: **July 2020**

Customer Service Representatives and Sales personnel will work with customers individually on specific dates for orders and deliveries from the Lebanon plant.

2. REVIEW MINOR COMPRESSOR DESIGN CHANGES

Products will have no functional or performance alterations due to the move, but design adjustments are necessary for manufacturability and quality enhancement. Consequently, customers should prepare for minor changes to fit and form as described below.

Change in the Suction Braze Fittings of ZP*KCE, ZR*KCE, ZH*KCE 6-15Ton models

- The suction fitting location from the center (Figure 3) will move outward radially by 3.8mm, from 153.5mm to 157.3mm.

Figure 3: ZP*KCE, ZR*KCE, ZH*KCE Suction Braze Fitting Location

- The new fitting size (Figure 4) will be optimized for ASTM Brazing Standard:
  - From Ø28.49-28.67 to Ø28.65-28.80. Nominal Ø28.58 to Ø28.73. Delta 0.15 mm.
  - From Ø34.84-35.02 to Ø35.03-35.20. Nominal Ø34.93 to Ø35.12. Delta 0.19 mm.

Figure 4: ZP*KCE, ZR*KCE, ZH*KCE Suction Braze Fitting Size

- The braze discharge fitting of Z*KCE will not change.
- The suction and discharge rotalock fitting connections of Z*KCE will not change.

Change in the Terminal Cover of Z*KCE-TF* 6-15Ton models

- The end of the terminal box location (Figure 5) will move out 4.2mm (y) and 3.8mm (x).

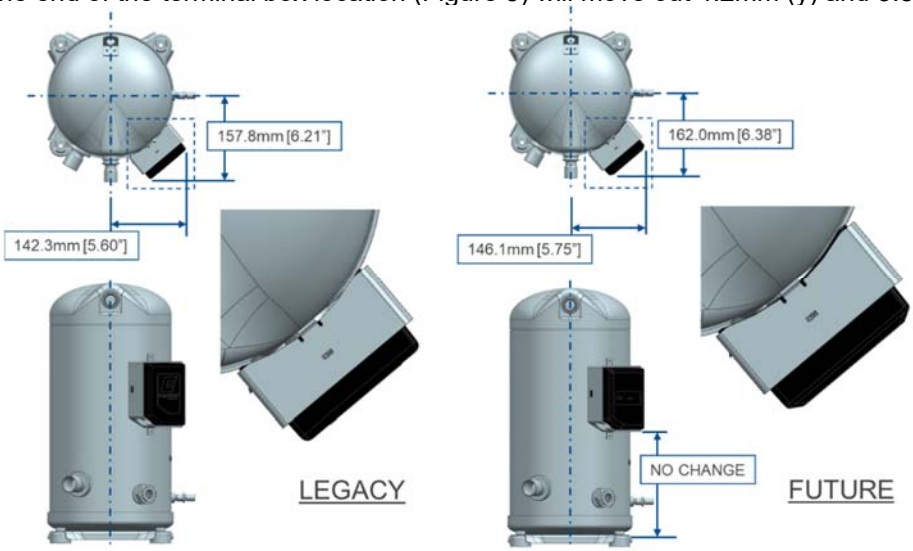

Figure 5: Z*KCE-TF* Terminal Cover Location

- There is no change to the terminal cover on the -TE* models.

Emerson will continue to communicate with customers through Bulletins, Sales personnel, and responding to individual customer requests.

Future Marketing Bulletins with details about Groups 2, 3, 4 and 5 will be released soon.

Customers are welcome to contact their respective Sales or Application Engineering personnel for more information.