

SEC HEAT EXCHANGERS

**Plate and Frame
Service Manual rev.1**

Table of Contents

Page 3		Name Plate Insert
4		Basic Unit Information Insert
5	1.0	Principles of the Plate Heat Exchanger
	1.1	Principles
	1.2	Features of PHE
6-7	1.3	Applications
8	2.0	Construction of the PHE
9	2.1	Plate Characteristics
10	2.2	Frame Components
11	2.3	Typical Fluid Flow
12	2.4	Construction of the Gasket
	2.5	Construction and Application of the Frame
13	2.6	Fluid Flow Arrangement “A” to “B” Configuration
14	2.7	Typical Plate Arrangements Single Pass
15	2.7.1	Typical Plate Arrangements Multi Pass
16	2.7.2	Separator (Connection Plate)
17	3.0	Dis-Assembling a Unit
18	3.1	Re-Assembling a Unit
19	3.2	Cleaning
	3.3	Cleaning in Place (CIP)
20	3.4	Cleaning of Edible Oil
21	4.0	Tightening Devices
22	5.0	Transportation and Installation of the PHE
23	6.0	Installation and Minimum Clearance
24	7.0	Piping and Fitting on Multi Pass Units
25	8.0	Flushing a Unit before Start up
	9.0	General Operating Instructions
	10.0	Re-Gasketing
	10.1	General Instructions for Glued Gaskets
26	10.2	Long Term Storage
	11.0	Spare Parts Numbering System
27	11.1	Gasket Code System
	11.2	Plates with Gasket Code System
	11.3	Frame Component Code System
28	12.0	Pipe Loading
	13.0	Assistance and Field Service
29	14.0	Trouble Shooting
	14.1	Excessive Temperatures
	14.2	Steam
30	14.3	Excessive Pressure and Spikes
	14.4	Design Pressure
	14.5	Pressure Spikes
31	14.6	Fluid Incompatibility
32	14.7	Leak Detection and Elimination
33	15.0	Service History Log
34	15.1	Service History Log

NAME PLATE:

To assist in a rapid reply to any questions please quote your serial number

PROCESS SIDE		SERVICE SIDE	
DATE BUILT	<input type="text"/>	UNIT TYPE	<input type="text"/>
SERIAL NO.	<input type="text"/>	SURFACE AREA	<input type="text"/> f2
DESIGN PRESS.	<input type="text"/> PSI	DESIGN TEMP.	<input type="text"/> C
TEST PRESS.	<input type="text"/> PSI	EMPTY WEIGHT	<input type="text"/> lbs
PLATE MAT'L.	<input type="text"/>	GASKET MAT'L	<input type="text"/>
CHANNEL ARRANGEMENT X PASS NO.	<input type="text"/>		
ORIGINAL TIGHTENING DISTANCE	<input type="text"/> mm		
WORK COVER APPROVAL No .	<input type="text"/>		



SEC Plate and Frame Heat Exchangers
2546 Iona Road, Belfast
Prince Edward Island
Canada C0A 1A0

Tel: 902.659.2424 / Toll Free: 800.335.6650
Fax: 902.659.2800 / Email: info@secheatexchangers.com

CUSTOMER NAME:

Basic Unit Information:
See enclosure for full unit details



	<u>UNIT TYPE:</u>	<u>SERIAL NUMBER:</u>	<u>HOT SIDE</u>	<u>COLD SIDE</u>
DUTY	<input type="text"/>	<input type="text"/>	IN: OUT: FLOW:	IN: OUT: FLOW:
DUTY	<input type="text"/>	<input type="text"/>	IN: OUT: FLOW:	IN: OUT: FLOW:
ADDITIONAL UNITS:				

	<u>UNIT TYPE:</u>	<u>SERIAL NUMBER:</u>	<u>HOT SIDE</u>	<u>COLD SIDE</u>
	<input type="text"/>	<input type="text"/>	IN: OUT: FLOW:	IN: OUT: FLOW:
			IN: OUT: FLOW:	IN: OUT: FLOW:

1.0 PRINCIPLE OF THE PLATE HEAT EXCHANGER (PHE)

1.1 PRINCIPLE

The PHE is composed of corrugated thin alloy plates, which are hung between top and bottom guide bars.

The plates are compressed by bolts in between fixed and movable frames, until metal to metal contact is reached and a channel is formed. The manner in which the gaskets are fitted enables alternative flow channels to be created and heat transfer to pass from one side of the plate to the other.

The alternative channels maximises the heat transfer surface in a compact manner. Therefore, it can produce the most effective performance from the compact size.

1.2 FEATURES OF PHE

- **High performance** : The total heat transfer co-efficient of the PHE is 2,000-6,000 Kcal/m²/hrC. The value is 3 to 10 times higher than the traditional shell and tube heat exchanger.
- **High economic tendency**: The PHE can maximise energy transfer efficiently from the unique combination of high turbulence and thin plate technology for any given unit size.
- Maintenance costs are also reduced due to it's compact size.
- **Variety of Options**: The PHE has been developed to allow many types of plates and gaskets for a large number of applications.

Changing the number of plates or configuration of the plate pack allows for a change in duty requirements in the shortest possible time. Maintenance is also greatly simplified, should Re-gasketing or the cleaning of the plate surfaces be required.

- **Excellent versatility** :

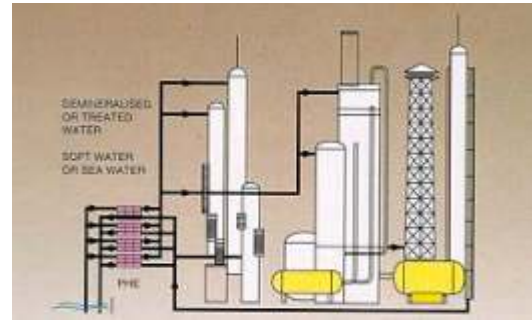
The PHE can carry out many kinds of processes from ice making, cooling, heating and condensing or evaporation etc.with one set of suitable plates

- **High quality ISO9001 Certified**:
The highest standards of manufacture are employed and combined with extensive technological know how gained from over 20 years of experience the performance of your PHE is assured.
- All design and construction operations are performed by computerised systems. Performance calculations are optimised for your particular duty requirements.

1.3 APPLICATIONS

CHEMICAL INDUSTRY

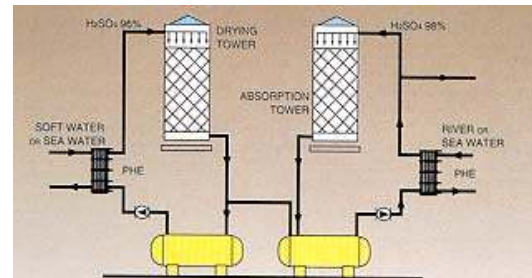
Cooling of Soda, Pigments, Fertilisers, Refined Oils, Oil and Fat, Medicines, Acids, Kerosene, Soft Water, Brine, Hexane, Polymerisation Process and Heating of Glycerine and Condensing of Ethanol



Cooling of oil Refinery, Intermediate Loop

STEEL INDUSTRY

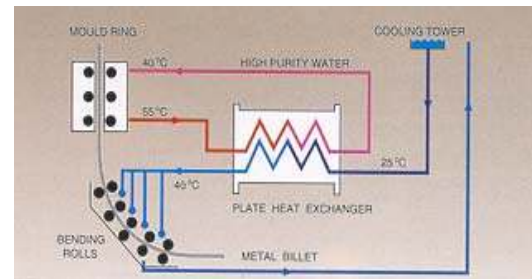
Cooling of Mould, Furnace, Coking Plant, Casting Facilities, Ammonia Water, Electrolysis Gilt, Compressor, Oil Press Oil, and Recovering of Waste Heats.



Concentrated Sulphuric Acid Cooling

MECHANICAL INDUSTRY

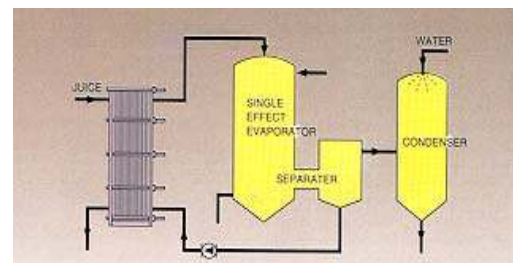
Cooling of Mechanical Apparatus, Emulsion, Press Oil, Grinding Liquid, Furnace, Engines, and Waste Heat Recovery.



Cooling of Continuous Casting Machine

FOOD INDUSTRY

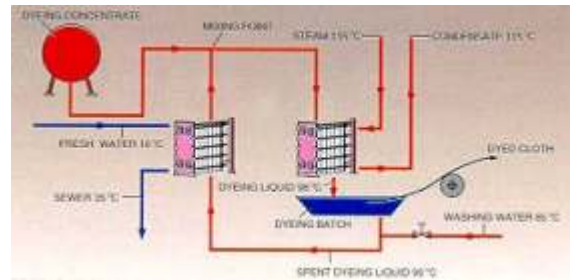
Cooling, Heating, Heat Recovery, Concentration, and Sterilisation of Juice, Milk, Soy and Sesame Oil, Sugar Liquid, and Alcoholic Liquids.



Juice Preheating Before Evaporation

TEXTILE INDUSTRY

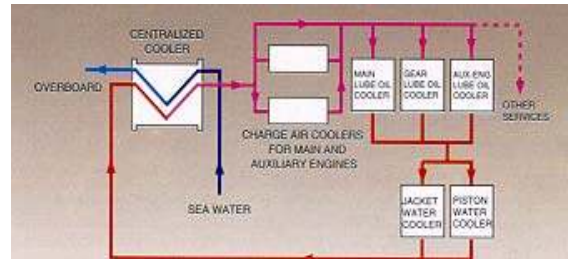
Cooling of Cleaning Water for Spinning and Weaving, NaOH Liquid, and Dyeing Water. Recovering of Waste Heats.



Preparation of Dyeing Liquid

SHIP BUILDING INDUSTRY

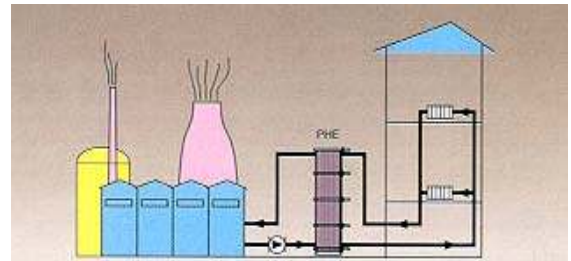
Central Cooling, Lube Oil, Jacket, Piston Water, Heavy Oil, Transmission Oil, Heating Oil
 Central Cooling, Cooling of Lube Oil, Jacket, Piston Water, Heavy Oil, and Transmission Oil, and preheating of Heating Oil.



Ship Engine Cooling

BUILDING FACILITY

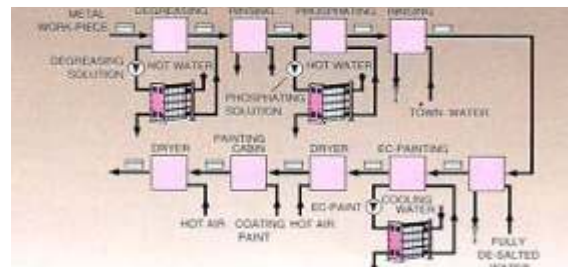
Local Heating, Supplying Water Heating, Air Conditioning Systems, Heating and Cooling of Circulating Water.



Heat Pump Applications

AUTOMOTIVE INDUSTRY

Spray Booth Cooling of Heat Treatment Liquids, Cutting Liquids, Coating, and Spray Booth Paint, and Heating of Pre-treatment Liquid.



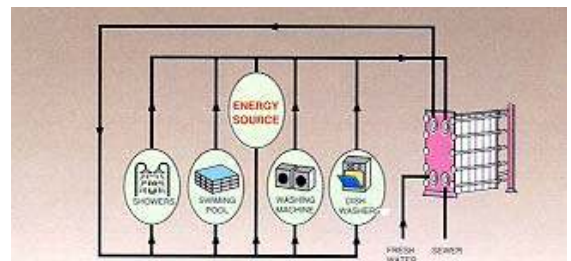
Painting Installation

PULP & PAPER INDUSTRY

Cooling of Black process water, Heating of incoming Supply water, and Waste Heat Recovery.

VARIOUS OTHER APPLICATIONS

Heat Transfer and Waste Heat Recovery of Electric, Electronic, Semiconductor, Factories, Power Stations, Sea water, Heating or cooling of buildings (HVAC).



Waste Heat Recovery

2. CONSTRUCTION OF THE PLATE HEAT EXCHANGER

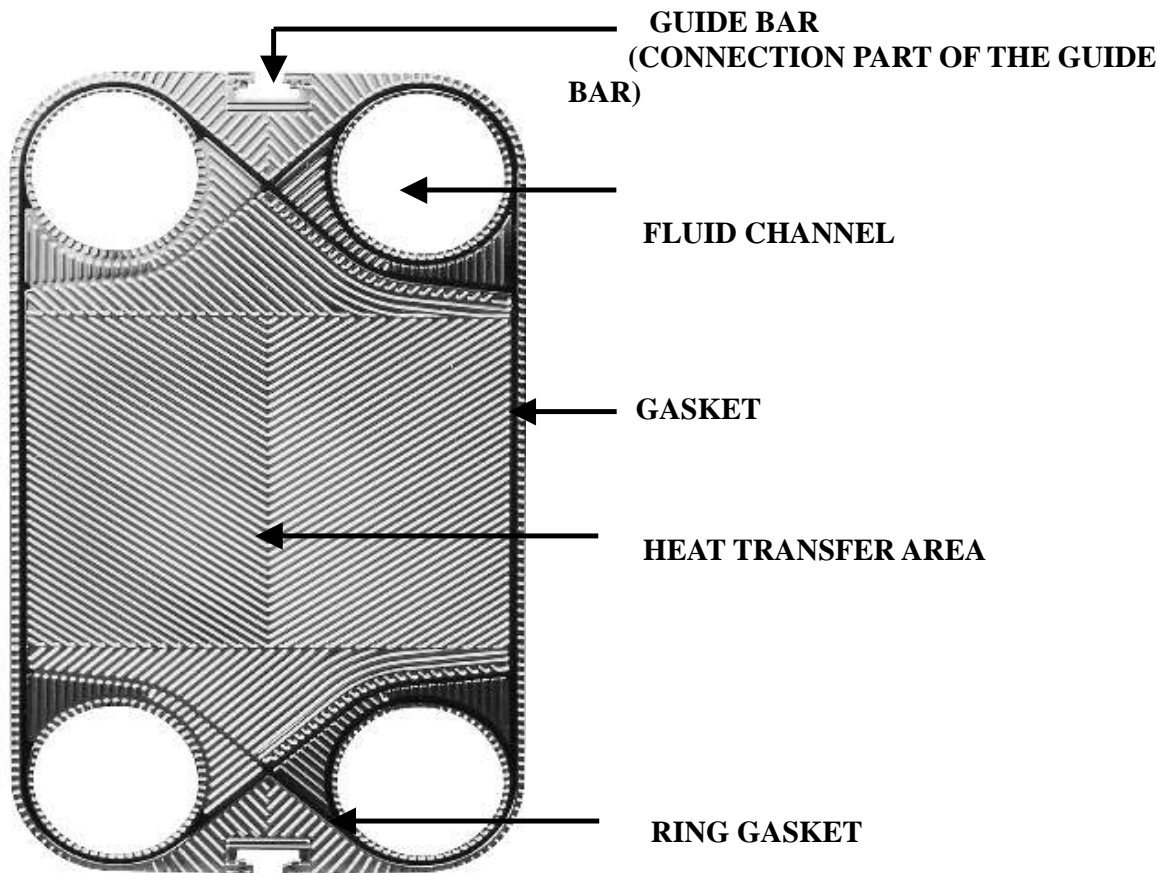
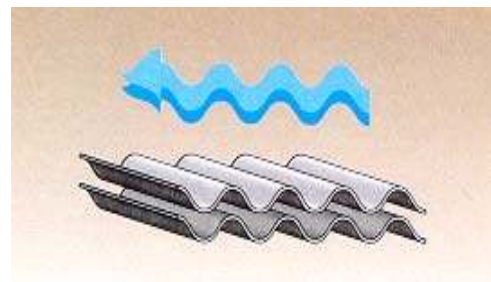


Fig. 1 PLATE
(MAIN FEATURES OF A HEAT TRANSFER PLATE)



2.1 PLATE CHARACTERISTICS

Plate thickness is normally in the range 0.6-1.0mm. Stainless steel, Titanium, Hastelloy, Copper-Nickel and Al-brass are available.

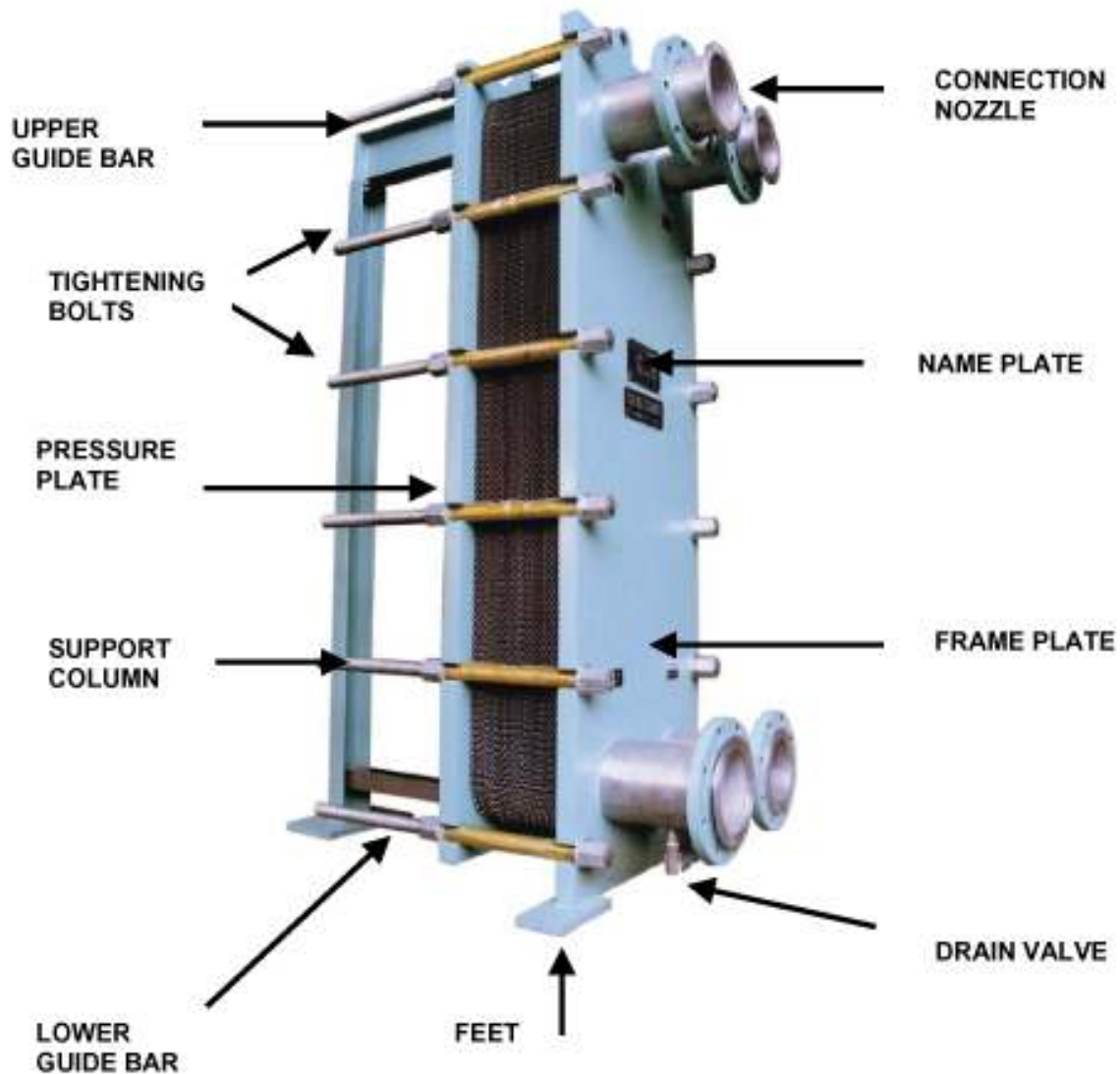
The plates are pressed to form corrugations which increase the surface area and strength of the plates. The plate has up to four connection holes for fluid transfer, with gaskets fitted to confine the liquids. Gaskets are made from composed rubber and are chosen in accordance with the types of fluids to be used in the PHE. The corrugated shape on the plates maximises the heat transfer efficiency by creating high turbulence in the channels.

Centrally located cut outs on the top and bottom ends of each plate is designed to make the plate hang correctly either side to the top and bottom guide bars.



HERRINGBONE TYPE

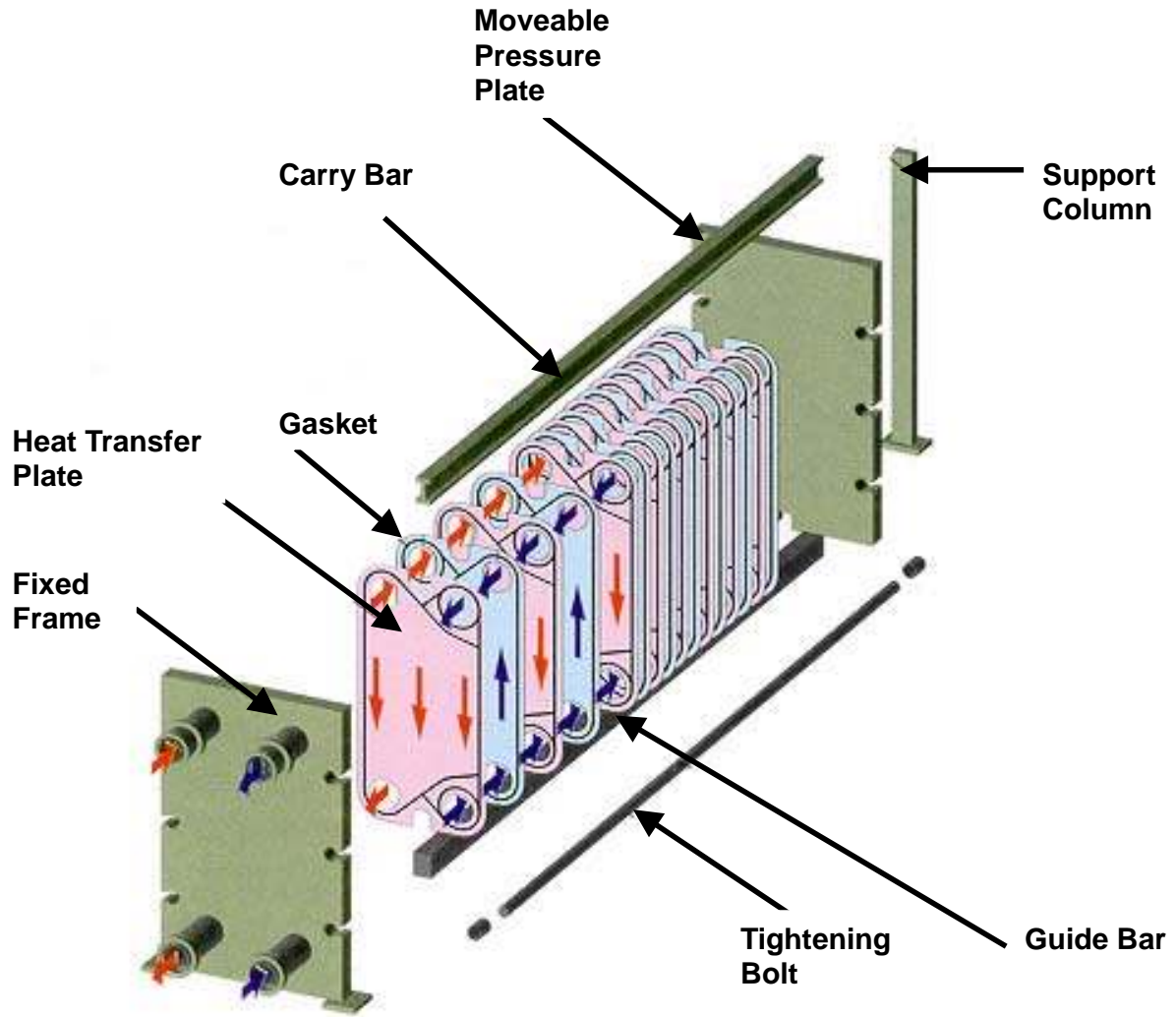
2.2 FRAME COMPONENTS



PART	QTY	DESCRIPTION	PART	QTY	DESCRIPTION
FRAME PLATE	1	CARBON OR STAINLESS	HEAT TRANSFER PLATE	*	ALLOY
PRESSURE PLATE	1	CARBON OR STAINLESS	TIGHTENING BOLT	*	HIGH TENSILE
SUPPORT COLUMN	1	CARBON OR STAINLESS	NAME PLATE	1	STAINLESS
UPPER GUIDE BAR	1	CARBON OR STAINLESS	CONNECTION NOZZLE	*	STAINLESS
LOWER GUIDE BAR	1	CARBON OR STAINLESS	DRAIN VALVE	*	STAINLESS

DETERMINED BY UNIT TYPE AND DESIGN

2.3 TYPICAL FLUID FLOW



2.4 CONSTRUCTION OF THE GASKET

The gaskets are designed as a duplicate structure to prevent mixing the fluids.

Should the ring gasket fail the liquid vents to the atmosphere ('B' part), and is prevented from mixing with the opposing liquid by the diagonal gasket.

In a similar manner if the diagonal gasket fails the ring gaskets acts as a secondary seal.

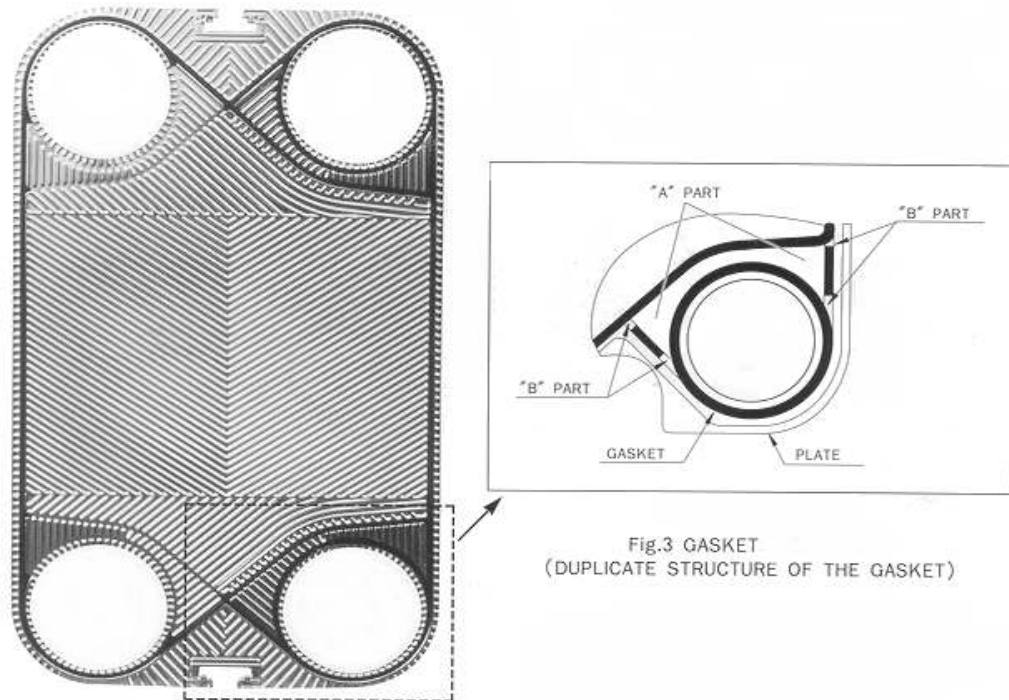


Fig.3 GASKET
(DUPLICATE STRUCTURE OF THE GASKET)

2-5 CONSTRUCTION AND APPLICATION OF THE FRAME

The construction of the frames is dependent on the application, pressure requirements and the type of the plates held in the frame.

The frames are protected from the liquids due to the welding or pressing of liners into the appropriate connection.

In general terms the construction and operation of the frames is the same for all PHE'S

2-6 FLUID FLOW ARRANGEMENT “A” to “B” CONFIGURATION

Forming of the plate pack channels is accomplished by hanging the plates (gasketed plates should be faced to the frame) in alternative “A” then “B” fashion.

As can be seen in Fig.6, the plate which has the ring and diagonal gasket on the right hand side and chevron pattern pointing down, the plate is called the 'A' plate and when rotated becomes the 'B' plate. One fluid flows on the surface of each of the 'A' plates, while the alternative fluid flows over the 'B' plate.

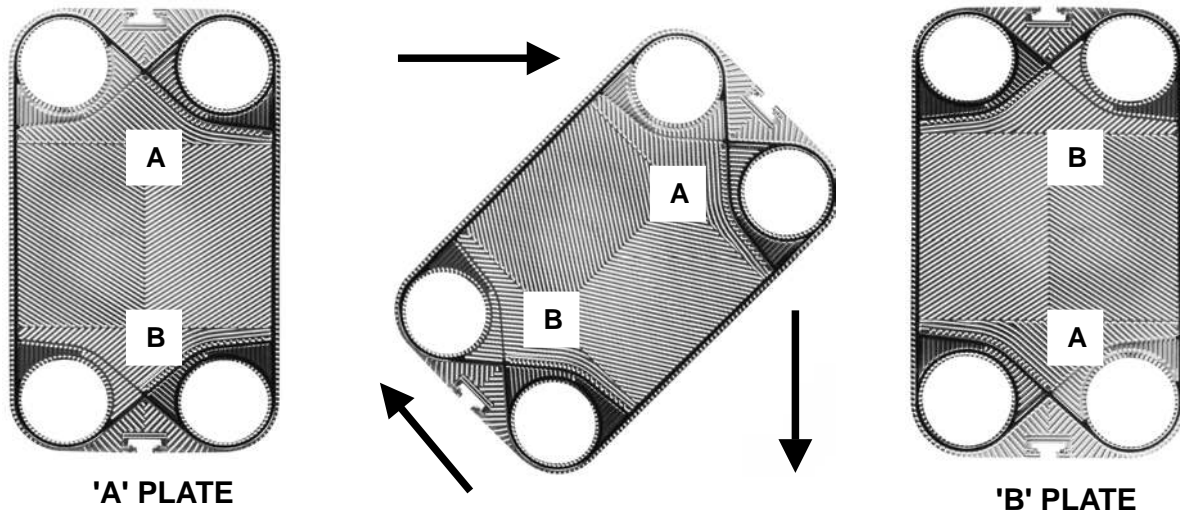


FIG: 6

The flow directions are normally counter current to each other. The hot fluid flows with two parallel lines, top to bottom and bottom to top, and the cold fluid with 4 parallel lines flows bottom to top.

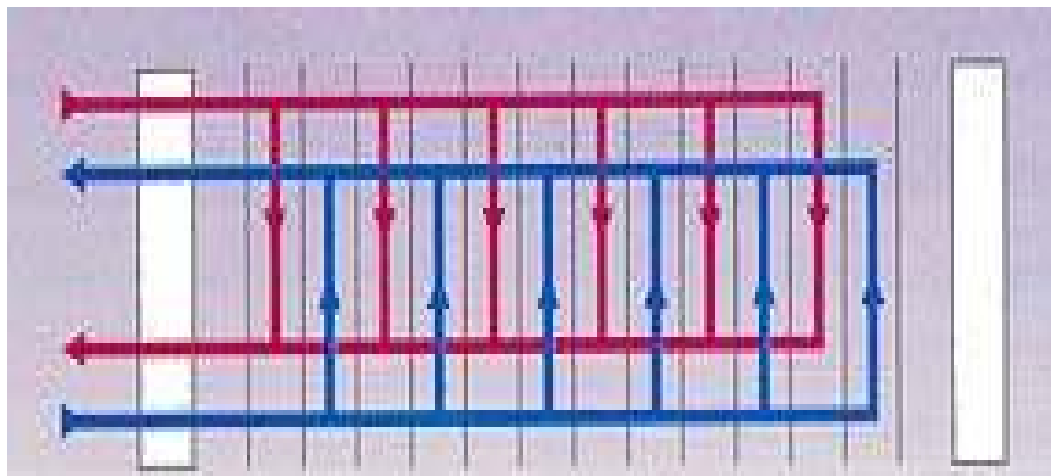
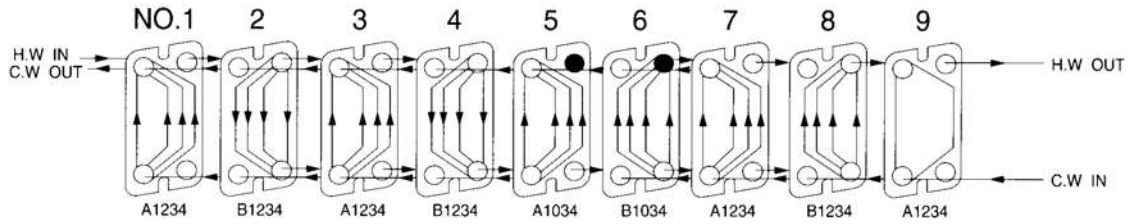
The plate arrangement can be written as $\frac{2 \times 2 + 1}{4 \times 1}$

where + 1 represents the end plate which does not perform any heat transfer.

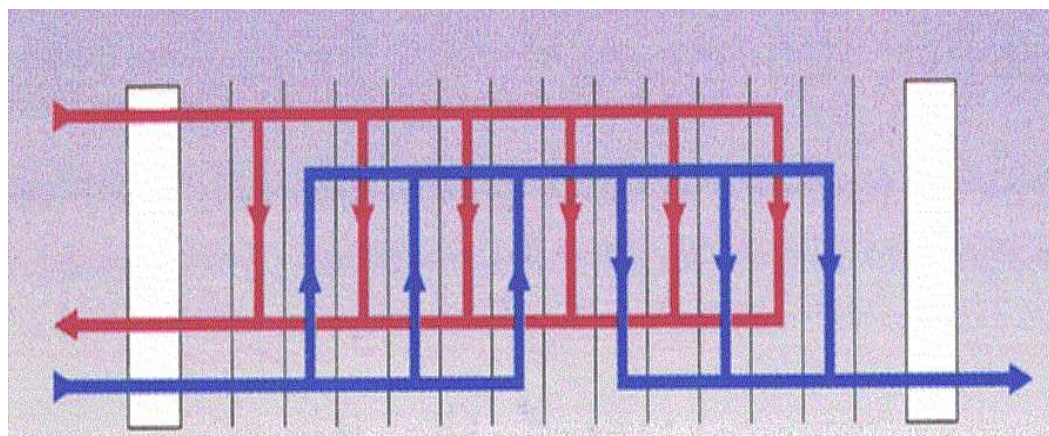
The four holes in the plate are distinguished as 1, 2, 3, and 4 from their positions, and '0' means no hole. There are 16 hole combinations possible depending on the application and temperature approach.

2.7 TYPICAL PLATE ARRANGEMENTS

EXAMPLE OF PLATE ARRANGEMENT AND FLOW

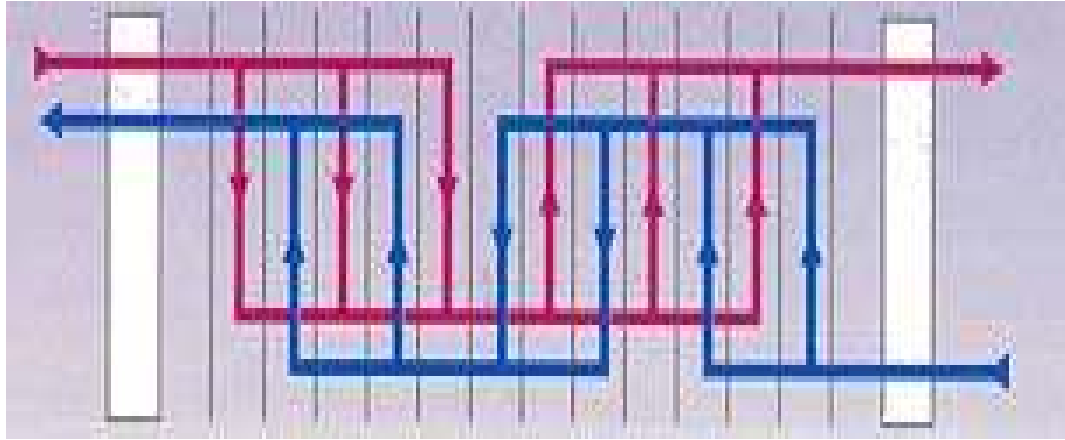


SINGLE PASS ARRANGEMENT

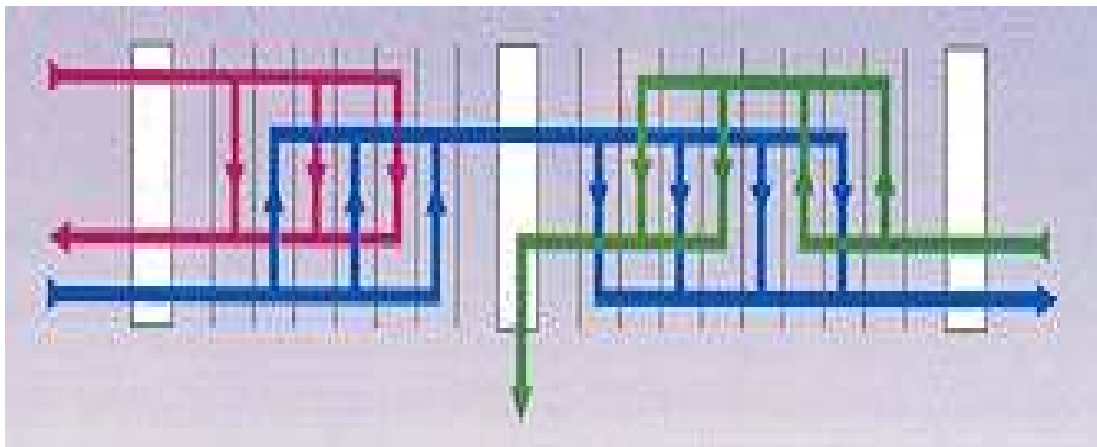


SINGLE AND MULTI PASS ARRANGEMENT

2.7.1 ADDITIONAL PLATE ARRANGEMENTS



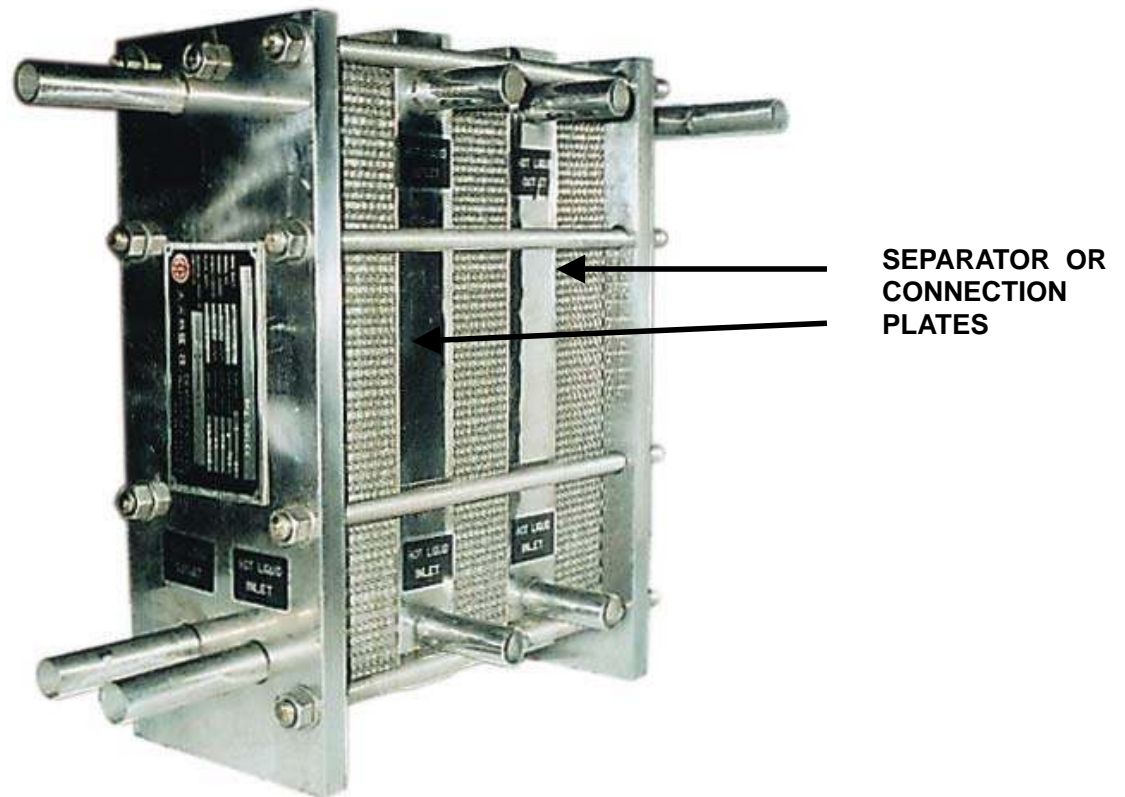
MULTI PASS ARRANGEMENT



SINGLE & MULTI- MULTI PASS ARRANGEMENT

2.7.2 SEPARATOR (CONNECTION PLATE)

Should more than one heat transfer duty be required in the same unit, a separator or connection plate can be incorporated. The separator allows two or more individual heat exchanger duties to be performed and is especially suited to UHT pasteurisation duties.



**HEAT EXCHANGER WITH
TWO CONNECTIONS**

3.0 DISASSEMBLING A UNIT

Remove frame:

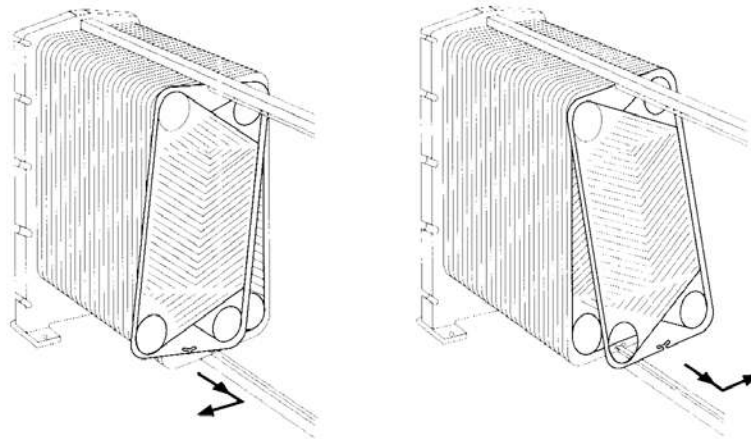
- 1) Remove any foreign material and apply grease to all bolts.
- 2) Loosen the intermediate bolts and remove from the frame.
- 3) Loosen the diagonals in sequence to maintain the pressure plate parallel to the frame plate.

Caution

Never allow the pressure plate to be at an angle to the plate pack as the plates may be distorted, due to excessive loading.

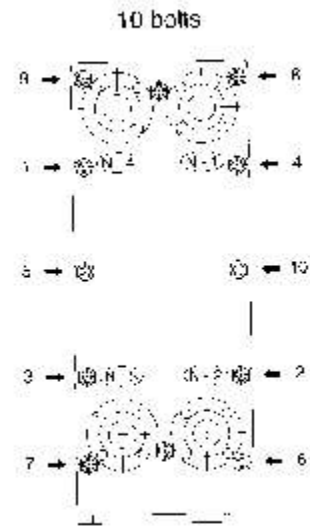
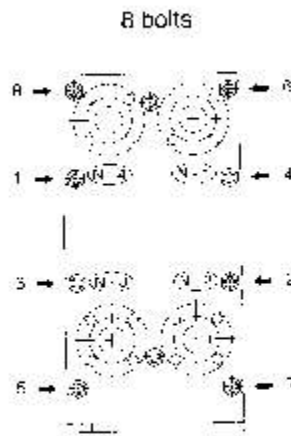
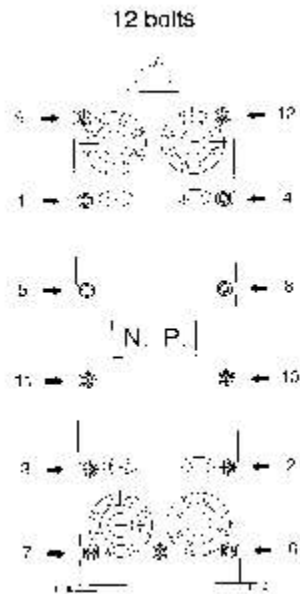
To Disassemble the plates:

- 1) Remove any foreign material and apply grease to the top guide bar for easier movement of the plates.
- 2) Remove each plate one at a time in the direction of the arrows as shown, ensuring that the gasket is not held onto the plate in front of it.



3.1 RE-ASSEMBLING THE UNIT

- The first plate is the “A” plate followed by a “B” plate, until all plates are hanging in the frame.
- Re-assemble the unit in the opposite sequence of disassembling see bolt tightening sequence below



3-2 CLEANING

Follow the next sequence to clean the plates after disassemble.

- 1) Clean the plates one by one with high pressure water or chemical clean in an appropriate acid or caustic.
- 2) Remove clip-on gaskets and ensure the gasket groove is clean before reattaching the gasket. Any foreign material left will cause the gasket to leak on resealing of the unit.

(3) Cleaning the gasket.

Do not use a steel brush or the gasket will be marked and a leak will occur on re-tightening of the unit. Mild soap or water should be used with a cloth

- (4) Should your unit have a corrosive duty, ensure that any opening of the unit is kept to a minimum. This will prevent excessive swelling of the gasket. Ask your heat exchanger supplier for more details on applicable duties.

5) Removing Calcium Deposition (Ask your heat exchanger supplier for details).

5-1) Submerge the plate in phosphoric or nitric acid
(nitric acid of specific gravity 1.4, 1 litre + water 10 litres) for 5-10 minutes at normal temp and rinse wash with water.

5-2. After acid cleaning passivate the plate with a neutraliser such as caustic and again rinse clean with water.

3.3 Cleaning in Place (CIP) (Ask your heat exchanger supplier for details).

An alternative cleaning method is CIP cleaning which does not require the disassembling of the plate pack see.

- Cleaning Brine:

- the brine should be expelled completely and then run the system with pure water at normal flow rates, until the unit is clean.
Cleaning brine with hot water, follow the sequence above and loosen the retaining bolts for gasket's expansion 100 plates / 5mm.

The flow rate of the cleaning water should be higher than the duty flow rate for maximum affect.

In chemical cleaning, the temperature and density of caustic are not that critical but for nitric or phosphoric acids, higher temperatures accelerate the acids activity. Nitric acid should not be used on any material, except stainless steel.

If the PH of the acid falls below 5, adjust to over 7 for improved performance.

3.4 Cleaning of Edible Oil.

Heat exchangers on food duties should be cleaned every day, a suggested method is.

- Discharge the fluid with water and monitor the situation through the glass tube.
- Pass pure water through the heat exchanger for 5-10 minutes.
- Circulate 70 litres water for 20-30 minutes.
- Circulate 60-70 litres, 0.7% nitric acid for 30 minutes.
- Circulate pure water to flush out any material.
- Neutralise the plates with 60-70 litres 0.7-1% caustic for 30-60 minutes.
- Circulate pure water again.

? Caution

Take care that the temperature and density of the nitric acid does not exceed the limitations above.

The cleaning sequence, nitric treatment and caustic cleaning, can be changed but there must not be any residual acid left in the unit.

Nitric acid should not come in contact anything except stainless steel.

- Food duty heat exchangers must be sterilised after cleaning. The most common way is to sterilise with hot water or steam.
- If you are using a chlorine based disinfectant, Titanium plates are required.

4.0 Tightening device (Hydro Torque Wrench)

Automatic Type:

Pre-assemble the heat exchanger and after placing the tightening units on the diagonal nuts, apply oil pressure. The piston will travel forward and rotate the pitch wheel to tighten the nut.

For disassembling a unit reverse the unit and apply oil pressure.

Manual Type:

Pre-assemble the heat exchanger and after placing the tightening units on the diagonal nuts, apply oil pressure. The piston will travel forward and the pressure plate will travel in the same direction. If there is a gap between pressure plate and fixed nut, turn the nut by hand. Repeat this sequence to arrive at the required 'Q' distance.



MANUAL UNIT



AUTOMATIC UNIT

5.0 TRANSPORTATION & INSTALLATION OF THE P. H. E

The most desirable way to transport a PHE is either by the use of lifting lugs if supplied or connection below the top two tightening bolts.

Never lift on the connections or guide bars.

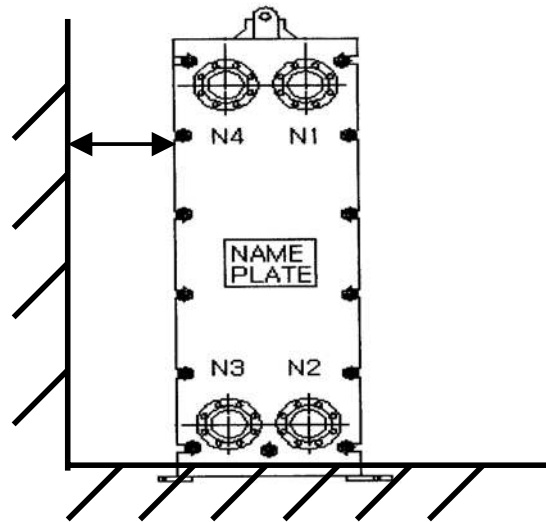
Note: On arrival of your unit check that the bolts do not require re-tightening, as they may have loosened during transport.



6.0 INSTALLATION and MINIMUM CLEARANCE

On arrival at the installation site, keep the unit horizontal and fix it with anchors or setting bolts.
The required minimum clearance on either side of a unit is 0.6m, to allow for removal of the plate pack.

TYPICAL P.H.E.



MINIMUM DISTANCE FROM OBSTRUCTION (600mm)

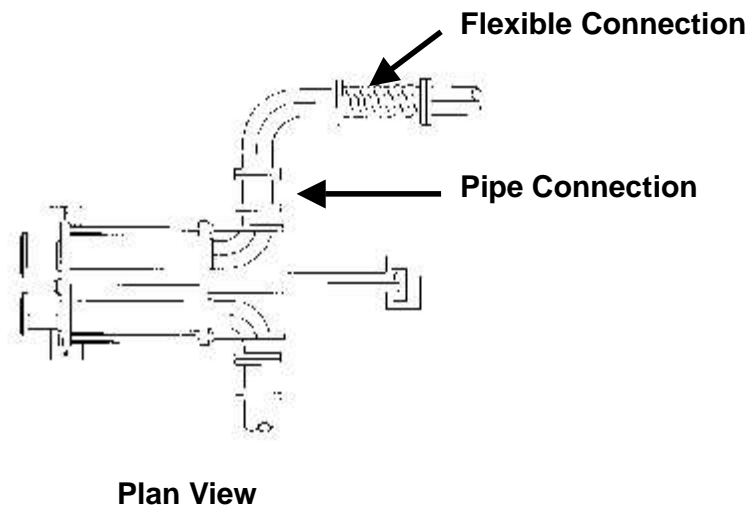
7.0 PIPING & FITTING ON MULTI PASS UNITS

Pipe work may be connected directly to the nozzles.

However an alternative is offered and this will make maintenance faster and cleaning easier.

Support the nozzle as shown below, do not place excessive weight on the pipe work at this point.

Insert a flexible pipe section to make it possible to enlarge the amount of plates if required.



8.0 FLUSHING

Before first running a unit, the pipes should be flushed out and all foreign material removed e.g. (sand, welding slag etc).

Failure to do so may void the warranty and affect heat transfer rates.

9.0 GENERAL OPERATING INSTRUCTIONS

- Check the sealing of the plates.
- Check the outlet valve is opened.
- Open the inlet valve of the PHE.
- Run the pump.
- Open the pump outlet valve slowly, watching the PHE's inlet pressure meter, if fitted.
- Control the amount of liquid according to the temperature gradient.
- Start the cold side of the unit first and then the hot side.
- In the case of steam, pass the medium liquid first, then steam slowly.

10.0 RE-GASKETING

For units fitted with clip-on gaskets, clean the gasket groove and fit the gaskets with all tags facing out.

For glued gaskets it is recommended that you contact your heat exchanger supplier for detailed instructions.

10.1 General Instructions for Glued Gaskets:

- After plate cleaning
- Paint a contact adhesive (glue should not contain chlorides) on the grooved area in which the gasket will be attached, with a strong brush tip.
- Naturally dry the glue for 3-5 minutes and press the gasket onto the exact grooved area.
- Press the stacked plates for at least 10 hours, the longer the better. Remove excessive adhesive with solvent.
- Do not use excessive amounts of glue, as distortion of the plate may occur on reinstallation.

10.2 Long Term Storage

When the PHE has not been in operation for an extensive period of time, make the following arrangements.

- Disassemble and clean the plates, and loosen the bolts (100 plates / 500mm)
- If the PHE is not easily disassembled, clean the PHE with water or chemical solvent and loosen the bolts to release the liquid.
- Do not keep any unit in an unclean condition for an excessive period of time, as corrosion of the plate surface may occur.

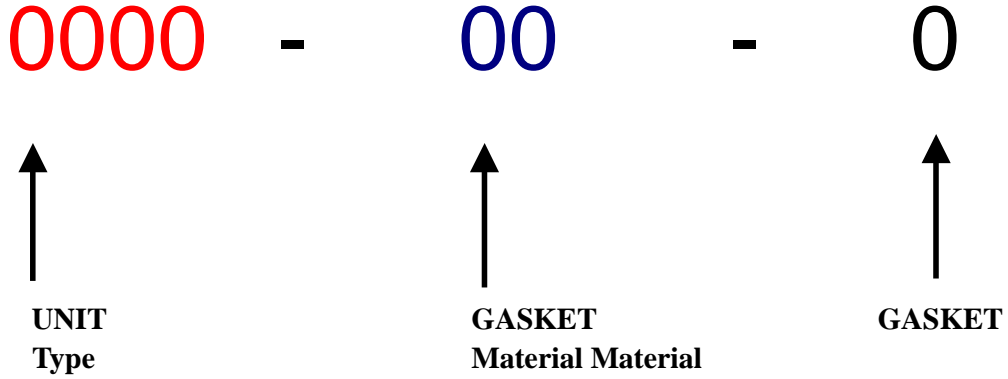
11.0 Spare Parts Numbering System

All parts are created by the application of either an alpha / numeric or numeric code system.

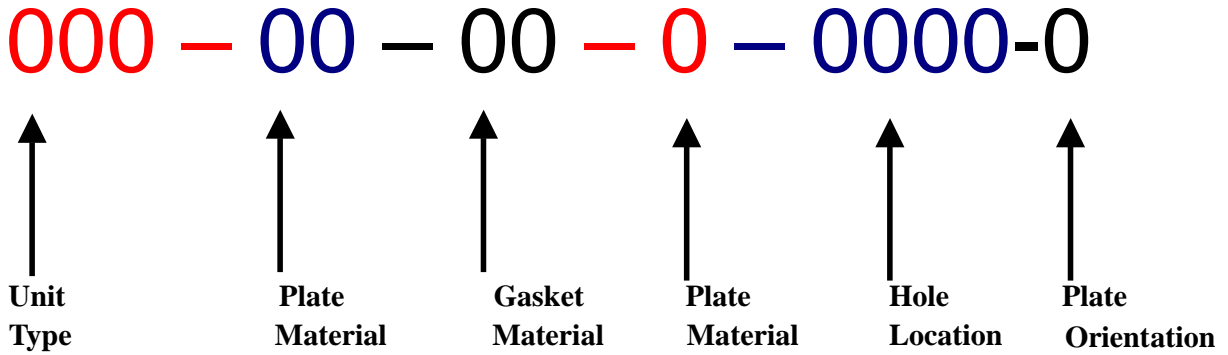
A part number can be created for any gasket, plate with gasket or frame component by applying the appropriate code.

Ask your plate heat exchanger representative for detailed part numbers for your particular units.

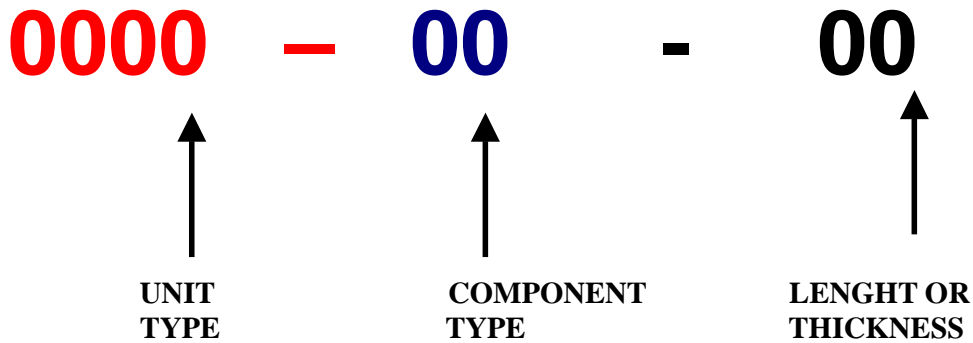
11.1 GASKET CODE SYSTEM:



11.2 PLATES WITH GASKET CODE SYSTEM:



11.3 FRAME COMPONENT CODE SYSTEM:



12.0 Pipe Loading

The plate heat exchanger offers a variety of port arrangements to suit customer requirements.

The alloy-clad studded port is offered as standard with elastomeric liners, and ANSI lap-joint loose flange connections offered as alternates.

The loose flange connection cannot withstand external loading, and all piping must be supported and preferably connected to the unit with flexible connections.

While it is always considered good engineering practice to support all piping, the clad and lined ports can take considerably more load as the frame takes the support rather than a nozzle.

In all port configurations, pumps should be mounted a minimum of six pipe diameters from nozzle flanges.

13.0 Assistance and Field Service

An in-house group of highly specialized engineering and service personnel to deal with questions and problems related to our plate heat exchangers, together with many other manufacturers.

These groups are at your disposal at all times to help with and answer questions pertaining to:

Design	Engineering Systems	Applications		
Gasket Compatibility	Plate Compatibility	Installation	Operation	
Maintenance	Field Service	In-House Servicing		
Regasketing				

14.0 TROUBLE SHOOTING

14.1 EXCESSIVE TEMPERATURES

The normal maximum operating temperature for a plate heat exchanger is approximately 120 degrees Celsius.

Higher temperatures may be reached with special gasket and adhesive materials.

Operating any plate heat exchanger at temperatures above the design temperature of the gasket material will result in gasket and adhesive failure.

An excessive temperature gasket failure is indicated by a hard, shiny-surfaced gasket face. Quite often, these gaskets are so brittle they can be crumbled with the fingers.

Points to look for are:

- a. Excessive hot-side fluid or steam temperatures.
- b. Unit being operated under conditions for which it was not designed.
- c. Superheated steam.
- d. Cold fluid stoppage on units operating at upper gasket temperature limits.

Corrective measures should include checking for excessive operating temperatures and lowering where needed or replacing with higher temperature gaskets.

If the unit is being used for services other than those for which it was designed, the necessary adjustments or gasket replacement should be done to ensure gasket compatibility with the operating temperature.

14.2 STEAM

Quite often high pressure steam is put through a reducing station without going through a desuperheater.

The steam is now at a lower pressure while still retaining much of its previous high - pressure temperature.

This, of course, has a very detrimental effect upon gaskets and greatly reduces the overall performance of the heat exchanger because of the decreased availability of latent heat while steam is in the superheated state.

Plates and gaskets will generally be at a temperature between the hot and cold fluids. Intermittent cold flow conditions can cause problems in units operating at borderline temperature conditions.

As the cold flow is interrupted, the unit will begin to come up to the temperature of the hot fluid and damage gaskets if upper temperatures are exceeded.

This can be alleviated by ensuring a constant cold-side flow or by throttling down the hot side during flow interruption.

14.3 EXCESSIVE PRESSURE AND SPIKES

The normal maximum operating pressure for a plate heat exchanger is generally 16 bar for ASME-code units. ASME units require ASME relief devices per UG-125 of ASME Code, Section VIII, Div. 1, Preventing Excessive Pressure.

However, plate heat exchangers which can operate at pressures up to 25 bar are available.

14.4 DESIGN PRESSURE

Operating a plate heat exchanger above its design pressure will result in gasket sealing problems.

These problems vary depending on the type of plate being used but are most often indicated by protruding gaskets which will extrude between plates and be visible on the perimeter of the plate pack.

Leakage may or may not be present; but in either case, steps must be taken to correct the situation.

Excessive pressure must be reduced to limits within the design pressure of the unit. All regulating and throttling valves are to be placed on the inlet sides of the exchanger.

Excessive lengths of piping being stopped by valves on nozzle outlets can cause tremendous pressure on gaskets, and this is to be avoided at all times.

14.5 PRESSURE SPIKES

Pressure spikes can also cause extremely high pressures.

Some of the causes are totally closed systems without allowances for expansion, booster-pump start-up, and rapid-acting control valves.

When these conditions exist, they should be handled with vented closed systems, slow acting control valves, and accumulators whenever possible.

Negative pressure (vacuum) on a standard-design plate heat exchanger may also result in gasket leakage problems.

A plate heat exchanger must never be subjected to vacuum (unless designed for vacuum application) during normal operations or during start-up and shut-down procedures.

14.6 FLUID INCOMPATIBILITY

This is evidenced by swelling of gaskets upon unit opening, tacky or liquid surface to gaskets, and gaskets failing off plates.

Advice should be obtained from factory personnel whenever these conditions are encountered.

Quite often, minute quantities of tramp contaminants in the fluid can have a large effect upon some elastomers.

Fluid sample testing and gasket coupon testing of various elastomers in the customer's process fluid can determine the proper compound to use.

In extremely difficult cases, a dual gasketing system using two different gasket materials on the fluids may solve the problem.

14.7 LEAK DETECTION AND ELIMINATION

Because of vented areas between portholes and plate faces, barring corrosion completely through plates, fluids cannot cross within the unit.

If any leakage does occur, it will be to the outside of the unit and observed as a slow leak.

If a unit starts leaking, check operating temperatures, pressures, and the "Q" dimension.

When pressures and/or temperatures are in excess of design conditions, take measures to correct them and restart the unit.

If the above are within design conditions, allow the unit to cool to ambient temperature and relieve the pressure on all fluid circuits within the unit.

At this time, begin tightening the compression bolts in the prescribed manner but do not go below the "Q" dimension by more than 1%.

If the unit still continues to leak, it may contain damaged or worn-out gaskets. Open the unit and individually examine gaskets for particulates, glue failure, or damage and wear.

Remove those gaskets which appear to have reached their life span and replace with new gaskets.

If there appears to be a problem with fluid crossing, that is, internal leakage-this indicates a condition that has been favorable for corrosion, causing pinholes through the plates.

The damaged plate or plates may be located by two methods for single-pass units:

Shut the unit down and relieve all pressure within the unit.

The piping on one side of the unit is now removed to allow viewing of the portholes for the length of the plate pack.

At this time, pressure is again turned on to the piped side, and leakage may be observed by shining a flashlight into the porthole to view and locate the leak.

With multiple-pass units, the above procedure will only allow partial viewing of the plate pack because of the non punched portholes in some locations.

In this case, the unit is opened and all plates are either wiped dry or allowed to air dry.

The compression bolts are then replaced, and the unit is re-tightened to the "Q" minimum dimension.

One side only is now pressurized for approximately 15 minutes.

Pressure is then relieved and the unit is now reopened. Carefully separate the plates one at a time, going from movable frame to fixed frame.

It will be noticed that every other flow channel is wet with a dry channel in between.

When you find two adjacent wet channels, you have located the affected plate. It will be one of the two plates in the centre.

Once the suspected leaking plate is located, you may confirm with visual inspection or dye penetrant techniques.

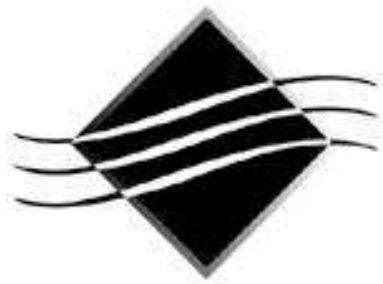
If the plate at fault is punched 1-2-3-4, the unit may be rapidly put back on line by removing an adjacent plate with the same punching.

Heat transfer will be reduced only to a minor extent.

If this punching arrangement is other than above, you will have to remove and replace the faulty plate(s) before restart.

Always reduce the "Q" dimension when removing plates by the thickness of the gasketed plates.

The amount of reduction in the "Q" dimension necessary for each plate removed may be obtained by using the multiplier shown on the data plate.



SEC Plate and Frame Heat Exchangers
2546 Iona Road, Belfast
Prince Edward Island
Canada C0A 1A0

Tel: 902.659.2424 / Toll Free: 800.335.6650
Fax: 902.659.2800 / Email: quotes@secheatexchangers.com

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