Introduction

About this document
- In addition to this document, the Manuals for HISAKA PHEs consist of the following five documents. Read them thoroughly and understand the precautions regarding the safety of the equipment and its functions before handling the equipment.
- You can also download these documents on our company website. [http://www.hisaka.co.jp/english/](http://www.hisaka.co.jp/english/)
- This document is the operation and maintenance manual for “Slit-in” type plates of plate heat exchangers (PHE) to which gaskets are installed without adhesives. Refer to the separate operation and maintenance manual for food product PHE (FX-A Series).
- This document is created for a person who fully understands the language it is written in. If a person, who is not able to understand the language written herein, will handle the equipment, please provide safety instructions to the personnel/operators.
- The PHE supplied may differ from the drawings and pictures in this document depending on the optional parts if any. Also, for the purpose of explanation, the drawings and pictures in this document may omit the details, accessories, or the like.
- Changing the contents of this document, in part or in whole, or using this document for anything other than its intended purpose is prohibited.

About gasket use
- To prevent injury and damages, do not use the gaskets other than for their intended purpose and specifications. Also, during maintenance, follow the instructions of related documents.

About worker limitations
- PHE maintenance should be carried out by a worker who has received training in safety and danger prevention.
- Work in high places should be carried out by a worker who fully understands the danger of the work and has received training in safety and danger prevention.

Export Regulations on the Equipment
- In case of export of HISAKA PHE and its component parts such as plate, gasket and so on, please follow the local law and regulations.

Disposal of the Equipment
- Do not incinerate gaskets. Incinerating gaskets releases toxic gas and is extremely dangerous.
- Any unnecessary gasket should be disposed as industrial waste in accordance with international, national, prefectural, and municipal regulations.

Disclaimer
- HISAKA accepts no liability for any failures in the function or performance of the equipment caused by use of any other than genuine parts.
- HISAKA accepts no liability for any injuries or damage borne by the user, caused by use of any other than genuine parts.
- HISAKA accepts no liability for any failures in the function or performance of the equipment caused by use of this equipment in a manner that does not adhere to the procedures indicated in this manual.
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1 Safety Precautions

Read through this manual carefully before use and use the PHE properly as indicated. If you have any questions, please inquire with our company.

Precautions are categorized using the following symbols.

![WARNING]
WARNING This symbol indicates content where mishandling could result in death or severe injury.

![CAUTION]
CAUTION This symbol indicates content where mishandling could result in injury or property damage.

![NOTE]
NOTE This symbol indicates important matters and/or useful information.

- **Meanings of Symbols**
  - Indicates items that are "prohibited (something that you must NOT do)."
  - Indicates items that are "mandatory (something that you must do)."

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**WARNING**
- Do NOT loosen PHE's tightening bolts/nuts except for maintenance work. The PHE could come apart if tightening bolts/nuts are loosened before installation.
- Do NOT use flange gasket for the nozzle of heat exchangers with synthetic rubber covering. Sealing performance could be decreased and it could be a cause of leaking. (Flange gaskets are required for nozzles with metal covering.)
- In general, do NOT perform pneumatic test for medium and large size PHE. For small size PHE, do NOT perform pneumatic test at the same pressure as hydrostatic test pressure.

**CAUTION**
- Do NOT operate in excess of the design conditions (temperature, flow rate, pressure, etc.). It may cause deformation of the heat transfer plates or leakage. Also, the required performance may not be achieved.
- Do NOT loosen the thermometer, pressure gauge, tightening bolts and nuts, or any other accessories during operation and when the PHE are pressurized. If fluid spills from the PHE during disassembly, it may cause burns or lacerations.
- Do NOT use tightening bolts with damage such as significant rust or cracks. If a tightening bolt breaks during operation or during disassembly, not only will the fragments fly off, but there is also danger of the fluid in the heat exchanger interior spraying out.

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**NOTE**
- Do NOT use tightening bolts with loosened bolt heads. If the bolt head loosens and the bolt head (nut) comes off the bolt, it could fly off at high speed. This is dangerous and contact could cause serious injury or property damage.
- Do NOT incinerate gaskets. Incinerating gaskets releases a toxic gas and is very dangerous. Any unnecessary gaskets should be disposed as industrial waste in accordance with international, national, prefectural, and municipal regulations.
- Install a protective cover on heat exchangers that handle high temperatures, high pressure, or dangerous fluids such as strong acids or strong alkalies. If a dangerous fluid leaks, it could cause a serious accident.
- Perform gasket replacement in a well-ventilated area or area with ventilation equipment. The gasket dedicated adhesives "S-1" and "F-2" contain organic solvents. Breathing the volatile ingredients for a long time may cause symptoms such as headache, dizziness, and nausea. Should these symptoms occur, move somewhere with fresh air and rest, stay calm and warm, and seek medical attention.
2 “Slit-in” Plates and Gaskets

2-1 Plates
- “Slit-in” plates are indicated by the letter “A” at the end of the model number indication. (Examples: UX-016A and UX-216A)
- “Slit-in” plates have slits (holes) that are used for fixing gaskets to the plate.
- These slits (holes) are located on the outside of the plate gasket groove and in the port holes (excluding UX-005A and UX-01A).

2-2 Gaskets
- “Slit-in” gaskets are indicated by the letter “A” in front of the material indication. (Examples: A-NBR and A-EPDM)
- “Slit-in” gaskets have protrusions for fixing the gasket to a plate.
- Handle gaskets with care because a protrusion can be cut easily.

3 “Slit-in” Gasketting Procedures

3-1 Type of “Slit-in” Gasket Protrusions
- There are four types of protrusions depending on each PHE model (Fig. 1).

![Fig. 1 Type of Gasket-Fixing Protrusions](image)

Table 1 Type of Gasket-Fixing Protrusions by Model

<table>
<thead>
<tr>
<th>Model</th>
<th>L-type</th>
<th>O-type</th>
<th>I-type</th>
<th>Hook-lock type</th>
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<td>UX-005A</td>
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3-2 Procedures for Setting L-type Protrusions
1) Press the gasket protrusion at point A by hand for inserting into the slit (hole) on the plate as shown in Fig. 2.
2) Keep pressing at point A by hand, press point B to the plate surface.
   It is more effective and secure to use a flat-blade screwdriver or similar tool than by hand.
Set the gasket body into the plate groove properly. Press the gasket in point C as shown in Fig. 3 and 4 with pressing the protrusion in point A and B for O-type / point A for I-type.

**3-3 Procedures for Setting O-type/ I-type Protrusions**

Set the gasket body into the plate groove properly. Press the gasket in point C as shown in Fig. 3 and 4 with pressing the protrusion in point A and B for O-type / point A for I-type.

**3-4 Procedures for Setting Hook-Lock Type Protrusions**

Set the gasket body into the plate groove properly. Press the gasket in point C as shown in Fig. 5 with pressing the protrusion in point A and B.

**3-5 Procedures for Setting Gaskets without Port Hole (Excluding UX-005A and UX-01A)**

1) In case of no slit on plate, cut the protrusion of Gasket (* part in Fig.6) with scissors as below Fig.6 and 7.
2) After cutting the protrusion of the port hole for UX-30A, UX-40A or SX-40A, Peel back one side only of Sekisui Double-Faced Tape No. 575. Fix double seal connection to the plate by the tape. Refer to below Fig. 8.

![Fig. 8 Procedures for fixing by Tape](image)

3-6 **Set Checking**

Check the setting of all gasket protrusions properly.

4 **“Slit-in” Gasket Removal Procedures**

Push up gasket protrusion from the backside of the plate. Pay attention not to cut protrusions. Wear cut-resistant gloves while working this procedure to prevent injury.

5 **Plate Disassembly and Assembly**

When disassembling plates, some gasket protrusions might slip out of the slits. Reset the slipped out protrusions into their slits before assembly and tighten frame.

6 **D-Plate Gasketting Procedures**

Each model has different gasketting procedures. Refer to “3. Gasketting Manual” of your PHE model for gasket names and installation positions.

This section indicates the gasketting procedures for D-gasket, “Slit-in” type. Models not indicated in table-2 are regardless of “Slit-in” type, adhesive is necessary for D-gasket setting. Refer to “3. Gasketting Manual” for gasketting by adhesive.

<table>
<thead>
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<th>Models: UX-005A, UX-30A, SX-40A and SX-70A</th>
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<td>● The figure shows model UX-005A. Plate type and protrusion position are different depending PHE model.</td>
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<td>● Refer to “3. Gasketting Manual” of your PHE for gasket names and type.</td>
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7 **Other Precautions**

1) Wash and remove solid scales and/or other foreign material before assembly.
2) Long period use make double seal of transfer surface side (refer to Fig. 6) insufficient fit to plate groove. Existing gasket still can be re-used. Fix it as same procedure as 3-5 2)
## Inquiries

**Contact info for inquiries**

**HISAKA WORKS, LTD., Heat Exchanger Div., Sales Department**
Osaka: 2-1-48, Higashi-Konoike-cho, Higashi-Osaka, Osaka, 578-0973, Japan
Tel : +81-(0)72-966-9601
Fax : +81-(0)72-966-8923

Tokyo: KYOBASHI OM BLDG. 1-19-8, Kyobashi, Chuo-Ku, Tokyo, 104-0031, Japan
Tel : +81-(0)3-5250-0760
Fax : +81-(0)3-3562-2759

Nagoya: Fujifilm Nagoya Bldg. 12th Floor, 1-12-17, Sakae, Naka-Ku, Nagoya, Aichi 460-0008, Japan
Tel : +81-(0)52-217-2491
Fax : +81-(0)52-217-2494

URL : http://www.hisaka.co.jp/english/

### Global Network

**HisakaWorks S.E.A. Sdn. Bhd. (MALAYSIA)**
No.2, Jalan TP2. Taman Perindustrian SIME UEP, 47600 Subang Jaya, Selangor
Tel : +603-8081-4185
Fax : +603-80817185
E-mail : heatexc@hisaka-asia.com

**HisakaWorks S.E.A. Sdn. Bhd. PENANG BRANCH (MALAYSIA)**
No 2680, 2nd Floor, Jalan Chain Ferry, Taman Inderawasih, 13600 Perai, Penang, Malaysia
Tel : +60-16-203-2527
Fax : +60-4-390-8588
E-mail : cyyap@hisaka-asia.com

**HisakaWorks S.E.A. Sdn. Bhd. JOHOR BRANCH (MALAYSIA)**
30-02, JalanMolek 1/10, Taman Molek, 81100 Johor Bahru Malaysia
Tel : +60-12-227-4882
Fax : +60-7-351-6840
E-mail : cswong@hisaka-asia.com

**Hisaka Works (Thailand) Co., Ltd. (THAILAND)**
15th Floor, Phairoj Kijja Tower, Zone C, 825 Bangna-Trad Road, Kwang Bangna, Khet Bangna, Bangkok 10260, Thailand
Tel : +66-2-744-3287
Fax : +66-2-744-3286
E-mail : heatexc@hisaka-thai.com

**Hisaka Works (Thailand) Co., Ltd. RAYONG SERVICE CENTER (THAILAND)**
300/118, Moo1, Tambol Tasit, Amphoe Pluakdaeng, Rayong 21140, Thailand
Tel : +66-3-802-9532
Fax : +66-3-802-9530
E-mail : heatexc@hisaka-thai.com

**Hisaka Works (Singapore) Pte Ltd. (SINGAPORE)**
No.18, Boon Lay Way, #02-118, Trade Hub 21 Singapore 609966
Tel : +65-6897-8489
Fax : +65-6686-4579
E-mail : heatex@hisaka-sing.com

**PT.HISAKA WORKS INDONESIA (INDONESIA)**
RukoPuri Botanical, Jln. Joglo Raya Blok I 10/29, Kebun Jeruk, Jakarta Barat 11640, Indonesia
Tel : +62-21-5880-0090
Fax : +62-21-5890-0091
E-mail : hisakindo@hisaka-asia.com

**Hisapino (Hisakaworks S.E.A. Philippines Sales Representative Office) (PHILIPPINES)**
20th Floor, One Global Place, Office Business Center, 5th Avenue & 25th Street, Bonifacio Global City, Taguig 1632, Philippines
Tel : +63-2-224-4129
Fax : +63-2-224-4130
E-mail : hisapino@hisaka-asia.com
Hisavina (Hisakaworks S.E.A. Vietnam Sales Representative Office) Ho Chi Minh Representative Office (VIETNAM)
4th Floor, Hoang Dan Building, 47-49, Hoang Sa Street, Da Kao Ward, District 1, Ho Chi Minh City, Vietnam
Tel : +84 (8) 3910 7355
Fax : +84 (8) 39107356
E-mail : hisavina@hisaka-asia.com

Hisavina (Hisakaworks S.E.A. Vietnam Sales Representative Office) Hanoi Representative Office (VIETNAM)
8th Floor, Sannam Building, Duy Tan Street, Dich Vong Hau Ward, Cau Giay District, Hanoi, Vietnam
Tel : +84-4-3795-9900
Fax : +84-4-3795-9911

Hisaka Works (China) Co., Ltd. (CHINA)
No.1 Xiangyuan Road, Changshu Southeast Economic Development Zone, Changshu City, Jiangsu Province 215542, China
Tel : +86-512-5213-3000
Fax : +86-512-5213-3008

Hisaka Works (China) Co., Ltd. Shanghai Branch (CHINA)
Room 1603 Shanghai Orientalcenter, 699 West Nanjin Road, Shanghai 200041, China
Tel : +86-21-5211-0701
Fax : +86-21-5211-0720
E-mail : hisaka-sha@hisaka.co.jp

Hisaka (China) Co., Ltd. Guangzhou Branch (CHINA)
Room 1208 R&F Tianhe Commercial Bldg., 4 Huaning Rd. Tianhe, Guangzhou, Guangdong, China
Tel : +86-20-3810-5515
Fax : +86-20-3847-7539

Hisaka Middle East Co., Ltd.
P.O. Box 8221, 5017 King Saud Rd, Al-Hosan Bldg. 5th floor, Dammam 31482, Kingdom of Saudi Arabia
Tel : +966-3-8331473
Fax : +966-3-8331471
Email : info@hisaka-me.com
URL : www.hisaka-me.com

Hisaka Korea Co., Ltd.
Gwanghwamun Bldg. 15F, 149 Sejong-daero, Jongno-gu, Seoul, 110-730, Korea
Tel : +82-(0)2-739-8861~3
Email : heatexc@hisakakorea.com
Fax : +82-(0)2-739-8864

Hisaka Korea Co., Ltd. BUSAN BRANCH
13th Floor, Kyowon Building, 216 Jungang-daero, Dong-gu, Busan 48733, South Korea
Tel : +82-51-747-0265
Fax : +82-51-747-0266
[NOTE]
• Please inform us the "MFG. Number" and "Model" described on the nameplate or Plate Arrangement Drawing and Assembly Drawing.

• For more information
  Hisaka Works, Ltd. official homepage (http://www.hisaka.co.jp/english/).

• Customer's memo
  Please fill in the table below with PHE information.

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Hisaka Works, Ltd., Heat Exchanger Division acquires both ISO9001 and ISO14001 certification.