

## Applying Double-Sided Tape Procedure



Thank you for purchasing a Hisaka Plate Heat Exchanger.

With the end of sales of F2 adhesive, please use double-sided tape (No. 1110) for PHE used for food applications.

Since this manual only describes the position where the double-sided tape is attached, please refer to

**3 Gasketing Manual** (10 series in total) posted on our website for the attachment position on the plate.

Drawings (Plate Arrangement Drawing and Assembly Drawing) of supplied model are to be supplied with the equipment.

Use as directed in these Manuals for safe and proper operation and maintenance.

Keep these Manuals in hand.

All description details, including appearance and specifications, presented in this manual are subject to change for improvement without prior notice.

For the latest information, please refer to our website, if necessary.

# HISAKA PLATE HEAT EXCHANGER

## Applying Double-Sided Tape Procedure

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# 1 How to remove adhesive

Before applying double-sided tape, make sure that no adhesive remains on the gasket setting surface of the plate. If the adhesive remains, remove it with a commercially available gasket remover, etc., and then attach the gasket with double-sided tape.

## Steps for removing adhesive

**Step 1** : Check whether there is any remaining adhesive on the gasket setting surface.

If adhesive remained like Photo 1., remove it according to the following steps.

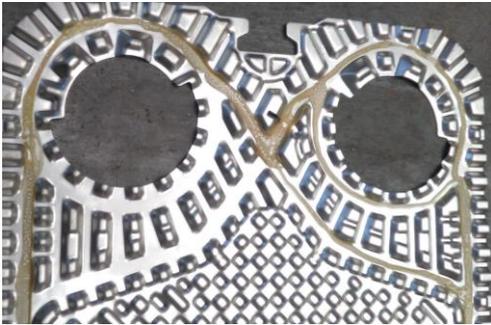


Photo 1. Plate on which adhesive remains

**Step 2** : Applying gasket remover

Apply with remover to soften the adhered adhesive.

**Caution** : When using a remover follow the precautions for the product and take safety measures such as by using rubber gloves, protective glasses, etc..

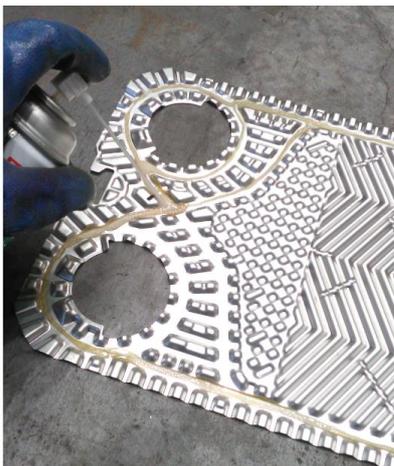


Photo 2. Applying remover

**Step 3** : Removing the adhesive

Using a clean dust cloth, scrape the softened adhesive. As shown in Photo 4, make sure that no adhesive residue remains.

**Caution** : Do not scrape off with a hard tool in order to avoid scratching on the gasket setting surface.

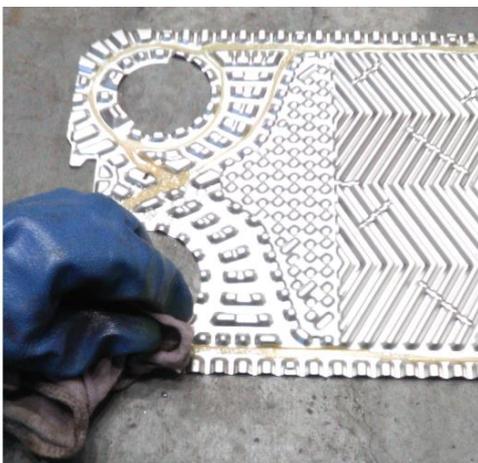


Photo 3. Removing work with a dust cloth

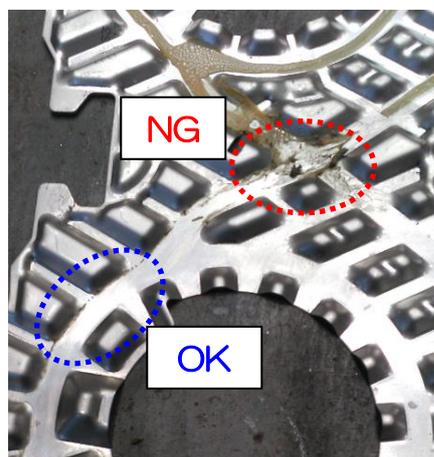


Photo 4. Adhesive residue

**Step4 : Wash with water**

To remove adhesive residue and remover, be sure to wash with water before next process installing the gasket.

Supplement: For acceptance criteria of the gasket groove residue

Regarding the residue in the gasket groove, if it gets caught in the nail, it is NG, and even if the residue is seen, if it does not get caught in the nail, judge it as OK.

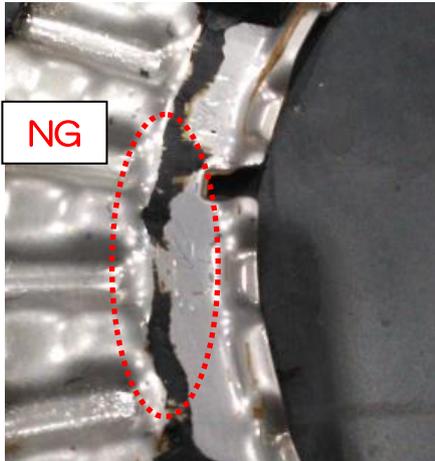


Photo 5. Gasket remaining example

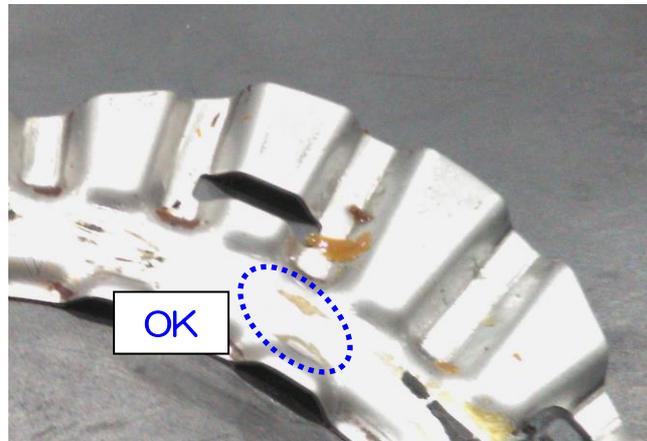


Photo6. Adhesive remaining example

## 2 Precautions for using double-sided tape

Please observe the following precautions when installing gaskets with double-sided tape.

The pasting position shown on the next page is just an example. Since the purpose is to fix the gasket, there is no detailed specification of the sticking position or length.

**Note 1:** Double-sided tape is not intended to come into direct contact with food, so attach it so that it does not protrude from the gasket groove as much as possible.

**Note 2:** Apply double-sided tape to the back of the gasket or the groove of the plate gasket.

In this guideline, the D / E plate gasket is on the back side of the gasket and the plate gasket is on the plate groove because sticking position can be easily understood.

**Note 3:** Please note that if the double-sided tape is twisted and becomes a step, it may cause leakage. (See Photo 7)

**Note 4:** Please note that there is a risk of leakage due to steps if double-sided tape is applied in layers. (See Photo 8)

**Note 5:** Please attach the gasket immediately after removing the release paper. If dust adheres to the adhesive, it may cause leakage.



Photo 7. Twist of double-sided tape



Photo 8. Overlapping double-sided tape

### 3 How to apply double-sided tape to gaskets for D/E plates

#### • S-Distance piece

S-Distance pieces refers to string-shaped gasket, which are used for preventing deformation on D/E plates. There are S-Distance pieces as various shape as long to short one.

Typical examples of the position applied double-sided tape are shown in the photo below.

(Since the purpose is to fix S-Distance pieces on plate's gasket groove, it is accordingly adjustable where, how many and how many lengths of double-sided tape to apply.)

- 1) In case of short and/or thick S-Distance pieces, it is recommended to apply double-sided tape through its whole length.



Photo 9. Front side of short/thick S-Distance piece



Photo 10. Back side of short/thick S-Distance piece

- 2) In case of long and/or thin S-Distance pieces, apply double-sided tape to its both ends, and to one or several points in the center, and set it on the plates.



Photo 7. Front side of long/thin S-Distance piece



Photo 8. Back side of long/thin S-Distance piece

 : Both ends part, on which double-sided tape must be applied to prevent the S-Distance piece from running onto gasket groove wall due to its floating.

 : Center part. In case it is difficult to set the S-Distance piece in place, set it by adding double-sided tapes.

#### • UX series

Model:UX-005 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	

Model:UX-01 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	

Model:UX-10 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
   	   

Model:UX-20 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	

両面テープ(No.1110)貼付け位置

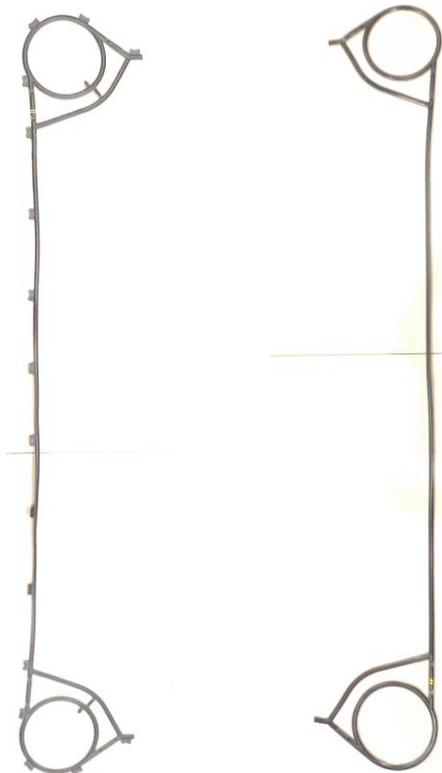
※プレートへの装着位置詳細は取説『ガスケット装着説明書』を参照下さい

Model:UX-30 type

D PLATE GASKET

Gasket surface

Gasket reverse



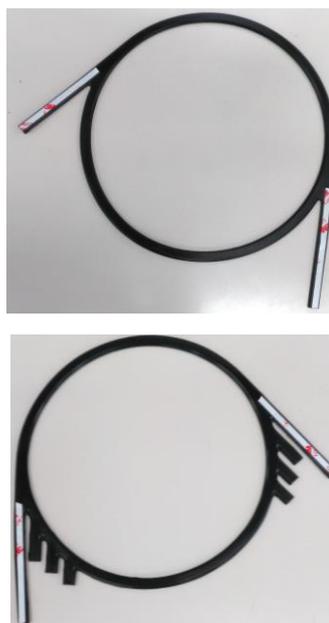
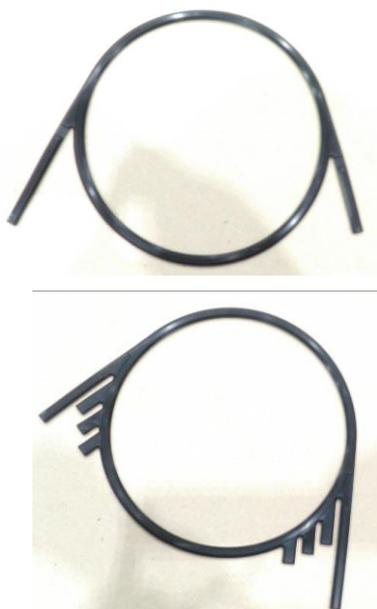
The ather can be fixed with slit.

Model:UX-40 type

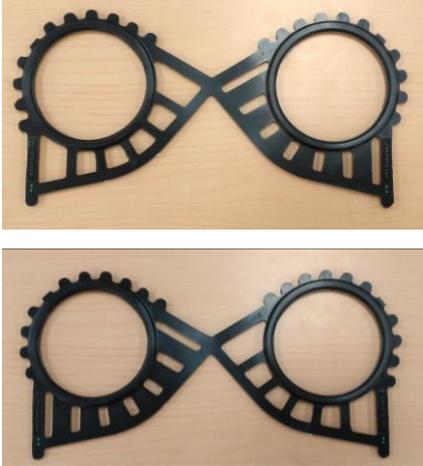
D PLATE GASKET

Gasket surface

Gasket reverse



• LX series

Model:LX-00 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	
E PLATE GASKET	
Gasket surface	Gasket reverse
	

Model:LX-10 type

D PLATE GASKET

Gasket surface



Gasket reverse



E PLATE GASKET

Gasket surface

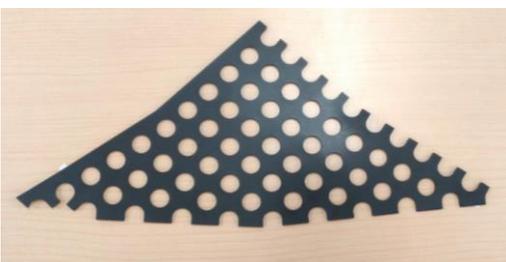


Gasket reverse

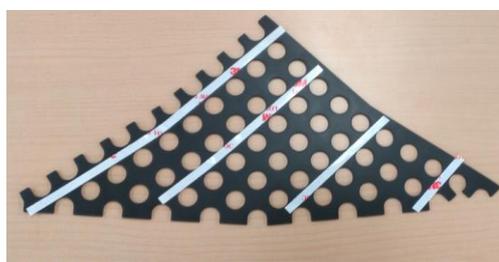


T DISTANCE

Gasket surface



Gasket reverse



Model:LX-20 type

D PLATE GASKET

Gasket surface



Gasket reverse

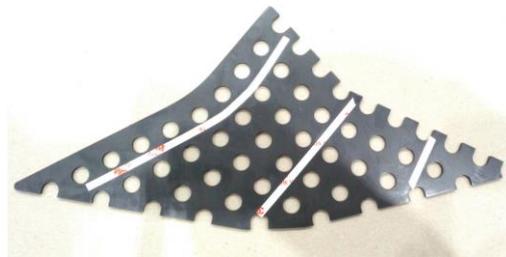


T DISTANCE

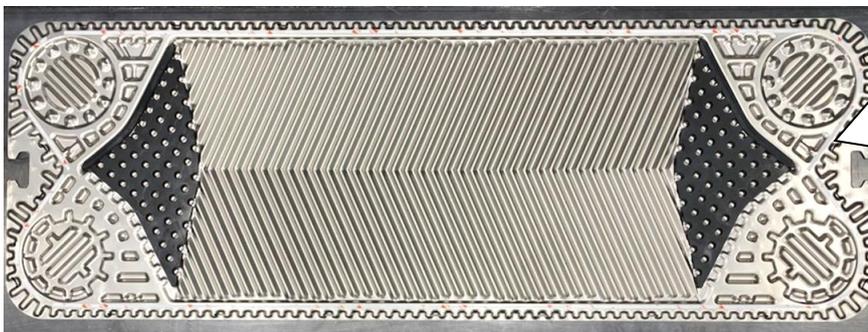
Gasket surface



Gasket reverse



E PLATE SHEET GASKET

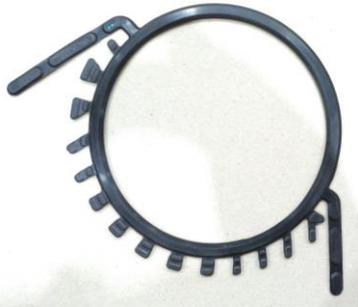


Double-sided tape sticking position

Model:LX-30 type

D PLATE GASKET

Gasket surface



Gasket reverse

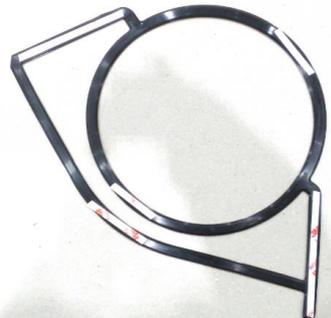


E PLATE GASKET

Gasket surface

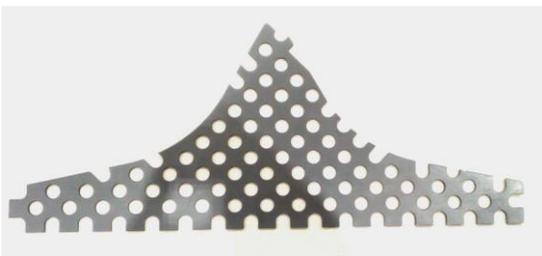


Gasket reverse



T DISTANCE

Gasket surface



Gasket reverse



Model:LX-40 type

D PLATE GASKET

Gasket surface

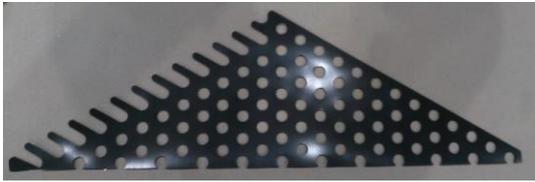


Gasket reverse

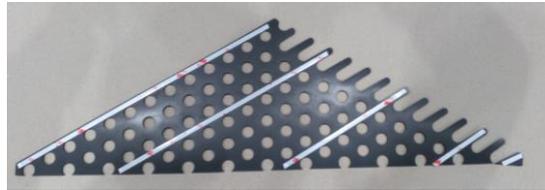


T DISTANCE

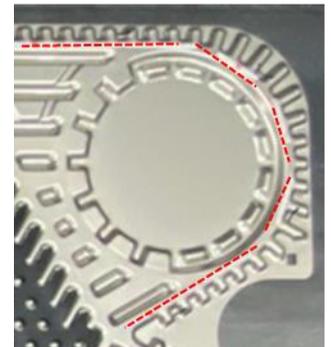
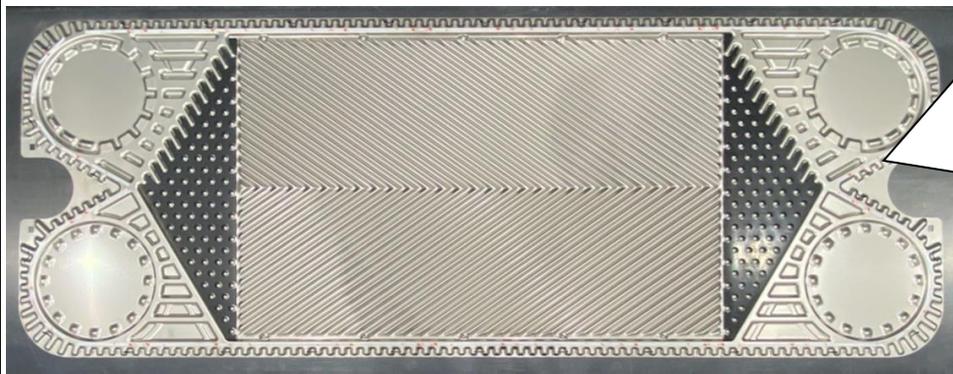
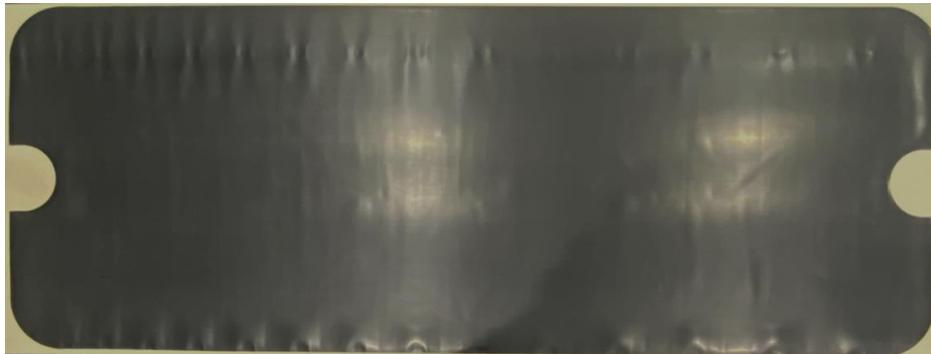
Gasket surface



Gasket reverse



E PLATE SHEET GASKET



Double-sided tape sticking position

• RX series

Model:RX-00 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	
E PLATE GASKET	
Gasket surface	Gasket reverse
	

Model:RX-11 type

D PLATE GASKET

Gasket surface

Gasket reverse



E PLATE GASKET

Gasket surface

Gasket reverse



Model:RX-13 type

D PLATE GASKET

Gasket surface



Gasket reverse



E PLATE GASKET

Gasket surface



Gasket reverse



Model:RX-30 type

D PLATE GASKET

Gasket surface

Gasket reverse



E PLATE GASKET

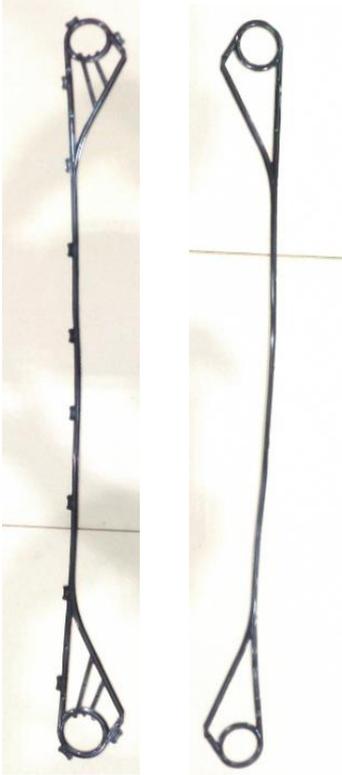
Gasket surface

Gasket reverse



• FX series

Model:FX-01 type	
D/E PLATE GASKET	
Gasket surface	Gasket reverse
	

Model:FX-02 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px; width: fit-content;"> <p>The ather can be fixed with slit.</p> </div>

Model:FX-03 type

D PLATE GASKET

Gasket surface

Gasket reverse



E PLATE GASKET

Gasket surface

Gasket reverse

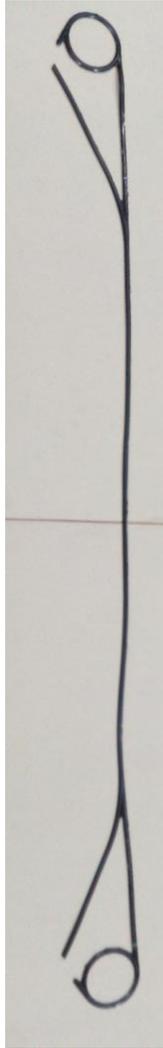
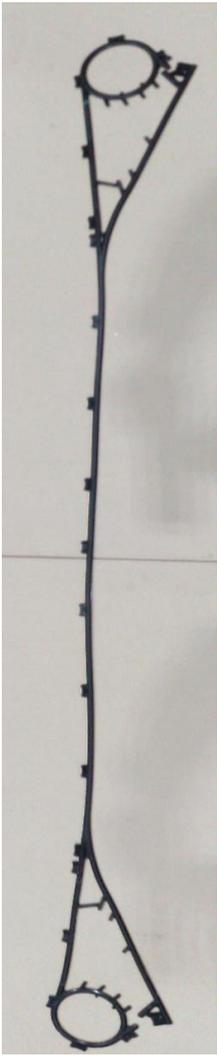


Model:FX-04 type

D PLATE GASKET

Gasket surface

Gasket reverse



The ather can be fixed with slit.

Model:FX-05 type

D PLATE GASKET

Gasket surface

Gasket reverse



E PLATE GASKET

Gasket surface

Gasket reverse



• EX series

Model:EX-11 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	

Model:EX-15 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	

## 4 Contact information

Contact info for inquiries

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**[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/>).



# HISAKA WORKS, LTD. HEAT EXCHANGER DIVISION

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

EX2022-012ER1
2023.02.24