12-3-2 Replacement of Plate Gasket

Replace a plate gasket if it has any wearing, cracks, swelling, carbonization, adhesion, or foaming.
For types of plate gaskets, refer to each model's "Gasketting Manual".

(1) Removing the plate gasket

1) Remove the used gasket.
   - Remove the used gasket with moderate force not to deform the heat transfer plate.
     At this time, be careful not to damage the heat transfer plate.

2) Clean the plate gasket groove of heat transfer plate.
   - Use solvent on the market to wipe away any adhesive remaining in the heat transfer plate's gasket groove.
   - Remove dirt, dust, which is stuck on the heat transfer plate's gasket groove.

(2) Preparing to replace the plate gasket

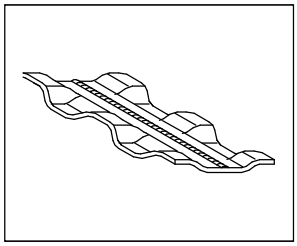
1) If replacing plate gaskets, check and prepare the number of required gasket.
   Visually check that there is no dirt, dust, which is stuck on the plate gasket's front and back surfaces. If there is any visible scale on the front or back surface of the plate gasket, wipe it off using a clean dust cloth.

2) Prepare appropriate adhesive for the plate gasket material.
   There are the following four types of adhesive. Use the adhesive HISAKA specified.

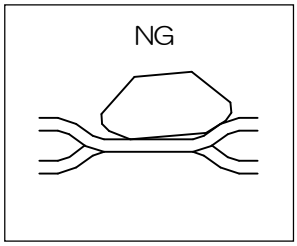
Types of adhesive	Purpose of use
S-1	General use
F-2	For food products
Silicon type	For silicon gaskets
Double-sided tape	PTFE encapsulated gaskets, etc.

(3) Gasket adhesion.....Glued gaskets

1) Applying adhesive
   - Uniformly apply the specified adhesive to heat transfer plate's gasket groove.
     Adhesion work should be done at a well-ventilated location because "S-1" and "F-2" adhesives contain organic solvents. Work in improperly vented room is prohibited.
   - Adjust the quantity of adhesive applied not to overflow the adhesive from the heat transfer surface when the plate gasket is set on heat transfer plate.



2) Gasketting on heat transfer plate
   - Set plate gasket on heat transfer plate gasket groove.
     At this time, be careful to prevent the gasket from run on to gasket groove wall.
   - The gasket expands during hot season and shrinks during cold season. When gasketting, put the gasket in tight and or extend it.



3) Curing and pressing (Refer to P5 only if the plate gasket is type "B" or "None".)
   - Pile up gasketted heat transfer plate, place a weight (approx. 5kg) and a board for curing. Perform curing time is 15 minutes and over.
   - Be careful not to fall over piled plates.
     As recommendation, piled height is up to max. 1,000 mm.