

ROShell 8" SIDE PORT PRESSURE VESSEL

RS80S SERIES 300 PSI, 450 PSI

USER MANUAL



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1. Versions and Revisions

Revision 1 – 2015 January.

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2. General information

ROShell 8" Side Port RS80S Series is a fiberglass pressure vessels designed for the continuous, long-term use as housing for reverse osmosis membrane elements.

The RS80S Series designed to accommodate from 1 to 7 membranes at length 40" in one vessel.

The vessel body produced by a continuous filament winding process and the feed and concentrate pipes connections are located on the side of vessel body.

ROShell vessels for reverse osmosis membranes are designed for pressure of up to 1200 psi (82 bar).

Testing of ROShell vessels conforms to all industrial standards, assuring superior technical parameters.

ROShell quality is guaranteed by computer-controlled automatic equipment and high-qualified staff. Production quality control is maintained in accordance with ISO 9001 requirements.

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3. Safety precautions

- ROShell® pressure vessels are designed for high pressure operations. Improper installation, operation service or maintenance may cause severe damage to property, physical injury or death.
- Inspect end closures regularly; replace components that have deteriorated and correct causes of corrosion.
- Regularly inspect the system to verify that head locking components are properly placed and secured. Replace any faulty component.
- It is recommend that only a qualified mechanic, experienced in servicing high-pressure hydraulic systems, should assemble or disassemble vessel.
- Provide overpressure protection in the system safety devices.
- Do not use corroded parts. They may cause difficulties in removing some components.
- Do not operate vessel at temperature over 120°F and do not operate vessel at pressures in excess of specific rating.
- Do not service any component until you verify that vessels and piping are fully depressurized.
- Do not pressurize vessels without element in place, unless permeate ports are plugged properly.
- Do not tolerate leaks or allow end closures to be routinely wetted in any way.

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4. Installation notes

Carefully study the vessel engineering drawings for key dimensions and technical requirements.

Vessels must be installed correctly to ensure safe use and long service life.

Make sure that the vessel is horizontally installed on support saddles.

Straps should be tightened enough to hold the vessel onto the support pads, but never so tightly as to restrict expansion.

Vessel should not support any other system components.

Ensure enough space is reserved around the two ends of the vessel for installation and removal of the membrane elements.

The piping system must be connected to the ports using flexible connectors (victaulics or others) in order to allow relative movement of the vessels and the piping system.

Inspect if all components are in place.

Inspect if all components in as-new condition, clean and free of damage or corrosion.

Inspect if retaining ring is fully seated in the retaining ring groove.

Read and follow the membrane manufacturer installation instructions along with this manual.

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Example

8" side port vessel for six standard elements, 300 Psi, with 4 side-ports, which diameter is 2", color blue:

RS806.300.S420B

RS80S Series 300 psi modifications:

Model	Membrane Qty.	Shell Length L, mm
RS801.300.S	1 x 40"	1506
RS802.300.S	2 x 40"	2522
RS803.300.S	3 x 40"	3538
RS804.300.S	4 x 40"	4554
RS805.300.S	5 x 40"	5570
RS806.300.S	6 x 40"	6586
RS807.300.S	7 x 40"	7602

RS80S Series 450 psi modifications:

Model	Membrane Qty.	Shell Length L, mm
RS801.450.S	1 x 40"	1506
RS802.450.S	2 x 40"	2522
RS803.450.S	3 x 40"	3538
RS804.450.S	4 x 40"	4554
RS805.450.S	5 x 40"	5570
RS806.450.S	6 x 40"	6586
RS807.450.S	7 x 40"	7602

6. Technical data

ROShell RS80S Series pressure vessels are designed to provide safe operation over a long service life if properly installed, operated, and maintained. The operating conditions:

Model: RS80n.300.S **Drawing Number:** S80.00.01 **Design Pressure:** 300 Psi/21 Bar

Model: RS80n.450.S **Drawing Number:** S80.00.02 **Design Pressure:** 450 Psi/31 Bar

Min. Operating Temp: 14°F / -10°C

Max. Operating Temp: 120°F / 49°C

Factory Test Pressure: Standard: 1.5x Design Pressure

ASME: 1.1x Design Pressure

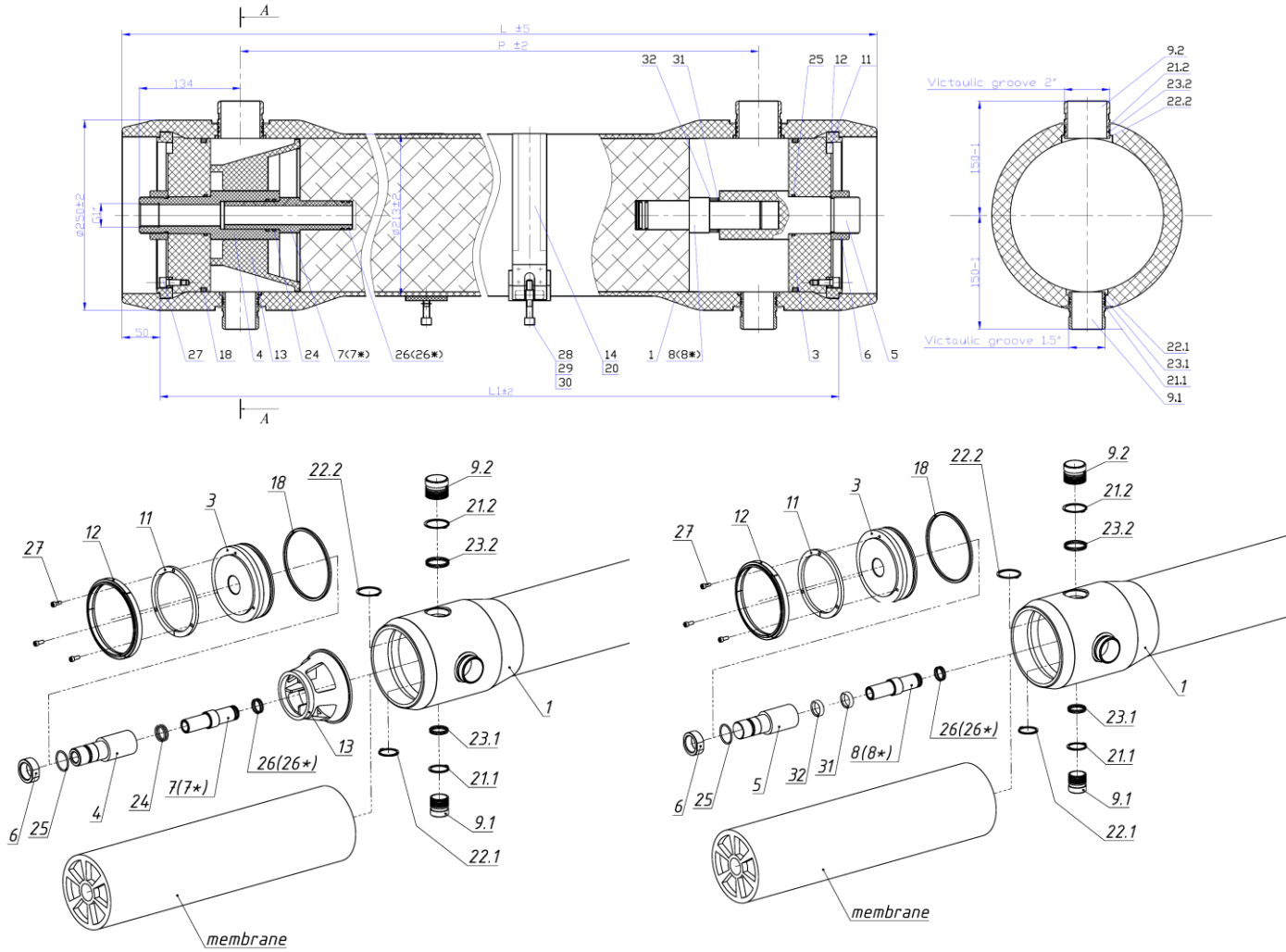
Permeate internal pressure: not to exceed 125 PSI (8.6bar) at temperature 120° F (49 °C). Do not operate the vessel permeate port over 125PSI.

The allowable water PH range: 3-10 under normal operating conditions and 2-12 if the vessel is periodically cleaned.

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7. Construction and component identification

RoShell 8" PRESSURE VESSEL 300 PSI Side Port assembly



Ref	Description	Part number	Q - ty	Material
1	Pressure shell 300 psi	S80.01.300	1	GRE
3	End plate	S80.03.01	2	POM
4	Permeate port	S80.04.00	1	PVC
5	Permeate port (blind)	S80.05.00	1	PVC

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6	Nut	80.06.00	2	PVC
7*	Adaptor 1.5"	80.07.02	1	PET
7	Adaptor 1.125"	80.07.12	1	PET
8*	Adaptor 1.5" (blind)	80.08.02	1	PET
8	Adaptor 1.125 (blind)	80.08.12	1	PET
9.1	Concentrate port 1.5"	S80.09.11	2 – 4***	SS316L
9.2	Concentrate port 2.0"	S80.09.21	2 – 4***	SS316L
11	Ring	S80.11.00	2	Polietilen
12	Locking kit segment	80.12.01	2	Poliamid
13	Thrust ring	S80.13.00	1	PPGF30
14	Strap	80.14.01	2 – 3**	SS304
15	Saddle	80.15.00	2 – 3**	SBR
18	O-ring	80.18.00	2	EPDM
20	Strap lining	80.20.00	2 – 3**	SBR
21.1	Retaining ring Ø48	DIN 471	2 – 4***	SS304
21.2	Retaining ring Ø60	DIN 471	2 – 4***	SS304
22.1	Retaining ring Ø48	XDNS 48 S16	2 – 4***	SS316
22.2	Retaining ring Ø60	XDNS 60 S16	2 – 4***	SS316
23.1	O-ring Ø44 x 2.5	06-250-4400	4 – 8*	EPDM
23.2	O-ring Ø56 x 2.5	06-250-5600	4 – 8*	EPDM
24	O-ring Ø36 x 3.6	06-360-3560	2	EPDM
25	O-ring Ø49 x 3.5	06-353-4921	2	EPDM
26*	O-ring Ø33 x 2.6	06-262-3255	4	EPDM
26	O-ring Ø24 x 2.6	06-265-2360	4	EPDM
27	Locking segment screw	M8x20	6	A2
28	Strap screw	M8x70	4 – 6**	A2
29	Spring washer	DIN 127B M8	4 – 6**	A2
30	Washer	DIN 125 M8	4 – 6**	A2
31	Adaptor shim 3 mm	80.21.01	2	PP
32	Adaptor shim 10 mm	80.21.02	1	PP

* Dependent on concentrate feed rates and quantities.

** Depends on body length (from 5 membranes hull length is equipped with three holders).

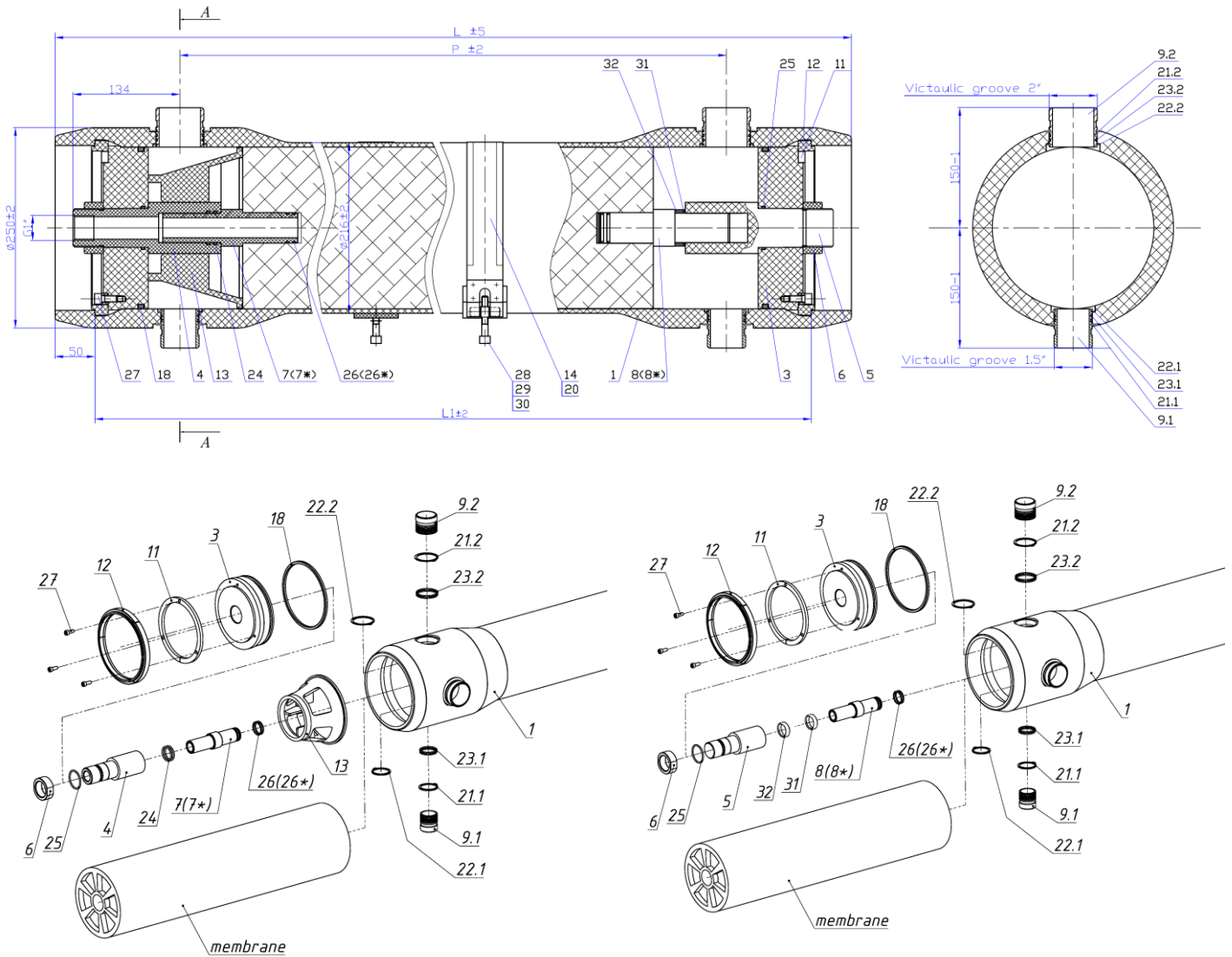
*** Dependent on concentrate feed rates and quantities.

PRESSURE VESSEL 300 PSI DIMENSIONS:

Memb. Q-ty	40"x1	40"x2	40"x3	40"x4	40"x5	40"x6	40"x7
L	1.506	2.522	3.538	4.554	5.570	6.586	7.602
L1	1.406	2.422	3.438	4.454	5.470	6.486	7.502
P	1.194	2.210	3.226	4.242	5.258	6.274	7.290

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RoShell 8" PRESSURE VESSEL 450 PSI Side Port assembly



Ref	Description	Part number	Q - ty	Material
1	Pressure shell 300 psi	S80.01.450	1	GRE
3	End plate	S80.03.01	2	POM
4	Permeate port	S80.04.00	1	PVC
5	Permeate port (blind)	S80.05.00	1	PVC
6	Nut	80.06.00	2	PVC
7*	Adaptor 1.5"	80.07.02	1	PET
7	Adaptor 1.125"	80.07.12	1	PET

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8*	Adaptor 1.5" (blind)	80.08.02	1	PET
8	Adaptor 1.125 (blind)	80.08.12	1	PET
9.1	Concentrate port 1.5"	S80.09.11	2 – 4***	SS316L
9.2	Concentrate port 2.0"	S80.09.21	2 – 4***	SS316L
11	Ring	S80.11.00	2	Polietilen
12	Locking kit segment	80.12.01	2	Poliamid
13	Thrust ring	S80.13.00	1	PPGF30
14	Strap	80.14.01	2 – 3**	SS304
15	Saddle	80.15.00	2 – 3**	SBR
18	O-ring	80.18.00	2	EPDM
20	Strap lining	80.20.00	2 – 3**	SBR
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23.1	O-ring Ø44 x 2.5	06-250-4400	4 – 8*	EPDM
23.2	O-ring Ø56 x 2.5	06-250-5600	4 – 8*	EPDM
24	O-ring Ø36 x 3.6	06-360-3560	2	EPDM
25	O-ring Ø49 x 3.5	06-353-4921	2	EPDM
26*	O-ring Ø33 x 2.6	06-262-3255	4	EPDM
26	O-ring Ø24 x 2.6	06-265-2360	4	EPDM
27	Locking segment screw	M8x20	6	A2
28	Strap screw	M8x70	4 – 6**	A2
29	Spring washer	DIN 127B M8	4 – 6**	A2
30	Washer	DIN 125 M8	4 – 6**	A2
31	Adaptor shim 3 mm	80.21.01	2	PP
32	Adaptor shim 10 mm	80.21.02	1	PP

* Dependent on concentrate feed rates and quantities.

** Depends on body length (from 5 membranes hull length is equipped with three holders).

*** Dependent on concentrate feed rates and quantities.

PRESSURE VESSEL 450 PSI DIMENSIONS:

Memb. Q-ty	40"x1	40"x2	40"x3	40"x4	40"x5	40"x6	40"x7
L	1.506	2.522	3.538	4.554	5.570	6.586	7.602
L1	1.406	2.422	3.438	4.454	5.470	6.486	7.502
P	1.194	2.210	3.226	4.242	5.258	6.274	7.290

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8. Technical service

8.1. Instruction for assembling vessels 8" 300-450 psi

Carefully study the vessel engineering drawings. Check all the components of vessel visually before assembling it. The components must not have a visible damage, which may have an effect during the operation (chips in the places for rubber rings, thread breakage in threaded connections, dents on the internal surface and rents of concentrate channel or cracked rubber rings).

1. Inspect vessel for a mechanical damage in the inner surface of the place, where is installed O-ring (pos. 18).
2. During the installation lubricate all rubber rings with silicone oil (111 Compound Molykote).
3. Take the end plate (pos. 3) and in the permeate channel insert the rubber O-ring (pos.25).
4. Put the O-ring (pos.18) around the end plate (pos. 3).
5. Take the permeate port and in the inner channel insert two O-rings (pos.24).
6. Insert the permeate port (pos. 4) into the internal plate (pos. 3), as shown in the drawing. It is recommended to lubricate seating surface of the channel with a silicone grease.
7. Put the assembly on the end part of the permeate port, that the product will be in a horizontal position. Thread the locking nut (pos. 6) on the permeate port.
8. Insert assembled construction into the vessel. Lubricate seating surface of the vessel with silicone grease.
9. Secure the assembled construction in the vessel with the locking kit (pos. 12), the ring (pos. 11) and screws M8 (pos.27).
10. Take the concentrate ports (pos. 9.1, 9.2, 9.3), insert two O-rings around them and put them into the concentrate holes in the vessel. It is recommended to lubricate outer surface of the concentrate port. Fix the concentrate ports with retaining rings. Carefully look at the drawing for kit positions.

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The same sequence for assembling the second end of vessel.

The second permeate port of the vessel has a blinded construction without rubber rings.

8.2. Instruction for opening vessels 8"

1. Shut off all sources of pressure and relieve pressure from the vessel
2. Disconnect all pipes from ports connecting the vessel's heads with the manifolds.
3. Inspect the vessel at each end for corrosion which may interfere with head assembly removal. If corrosion is evident, proceed as follows:
 - Clean any rusts with a small wire brush
 - Flush away loosened rusts with clean water.
 - Open vessel.
4. Before removing the assembled construction (head) from the vessel, unscrew screws M8 (pos.27), remove the locking kit (pos. 12) and the ring (pos. 11).
5. Gently tap the assembled construction with a rubber mallet.
6. Thread a 1" NPT Male threaded piece of PVC (or similar material) pipe into the head permeate port to hand tightness.
7. Carefully move head assembly back on forth to release the seal.
8. If the head seal remains in the vessel bore, it should be removed at this time.

8.3. Head disassembling/assembling

8.3.1. Head disassembling

Inspection: Make sure all pressure has been relieved from the vessel, following system manufacturer's recommendations. Make sure that the head is removed from the vessel according to "Instruction for opening vessels".

- Remove the Membrane Adapter from the permeate port. Grasp the end of the adapter in one hand and the internal plate in the other and pull them apart.
- Remove the O-ring(s) from the Permeate port adapter.
- Remove the permeate port nut located on the external side of the end plate by rotating it CLOCKWISE. Note that the port nut has LEFT hand threads.
- Remove the permeate port out of the end plate.
- Remove the seals from the end plate and permeate port.

8.3.2. Head reassembling

- Lubricate the permeate port seals and place them in the grooves located on the inside diameter of the permeate port. Lubricate the permeate port seals and place it onto the outer edge of the permeate port.
- Lubricate an internal plate seals and place it in the grooves located on the inside diameter of an internal plate.

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- Lubricate the adaptor seals and place them in the grooves of the adaptor.
- Insert permeate port; Thread the permeate port locknut onto the threads of the permeate port.
- Install the adaptor. Insert the end without seals into the hole of the permeate port.
- Install the head O-ring. Lubricate the O-ring and seat it into the groove located on the outside diameter of the sealing plate.

8.4. Vessel cleaning and inspection

When the head have been removed, perform a visual inspection of the vessel head and fittings, to locate any signs of corrosion or salt concentrations. If corrosion or salt concentrations are found, follow the following steps:

- Use a small wire brush to loosen any large deposits.
- Put the components in a soapy water and wash their surfaces until all corrosion is removed.
- Rinse components with clear water.
- Blow components dry with compressed air.
- Examine components for damage that may affect structural strength or sealing properties.
- Clean the inner surface and groove of the vessel by removing the residue or corrosions with a mild soap solution and then flush with clean water.

Inspect vessel, if there are scratches on the inner surface of the vessel up to 20 cm depth, grind the area carefully with sand paper until it is smooth.

8.5. Loading/replacing membrane elements

Membrane elements must be loaded at the feed (upstream) end of the vessel, and unloaded through the concentrated (downstream) side of the vessel. Always remove and install elements in the direction of feed flow.

Make a matching list for the removed membrane and the vessel to avoid possible disorder during membrane loading.

8.5.1. Steps to unload membrane

Inspection

- Verify all pressure has been relieved from the vessel, following system manufacturer's recommendations.
- Ensure the vessel is opened according to **instruction for opening vessels**.

Disassemble membrane components

- Remove the thrust ring located at the concentration side.
- Remove the adapter from the membranes on both sides of the vessel.

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Unload the membrane

- Clean off any lubricant residue or salt build up from the inside diameter at both ends of the vessel.
- Remove the membrane out of the vessel according to the membrane manufacturer requirements.

8.5.2. Installation of head assembly at downstream end

1. Apply a layer of Lubricant on the O-ring.
2. Install the thrust ring onto the head for the concentrate (downstream) end of the vessel.
3. Insert a head assembly into vessel. Do not rotate head assembly after insertion into vessel as this may cause head seal to become detached.
4. Hold head assembly square to axis of shell and slide it straight in until a slight resistance is felt.
5. Using both hands, firmly push head in as far as it will go (a sharp, forceful thrust may be necessary to push head seal into vessel bore.) When head is in correct position, insert ring and locking Kit Segment and screw bolts.

8.5.3. Load membrane elements from upstream end of the vessel

1. Inspect the membrane element surface to find any imperfections that could scratch the vessel bore element loading. If a defect is found, which cannot be easily corrected contact the element manufacturer.
2. Using an approximate 50% mixture of glycerin in water, lubricate the inside of the vessel. This may best be accomplished using a suitably sized swab soaked in the mixture. This procedure will ease membrane element loading and reduce chance of scratching the vessel bore.
3. Load the membrane from the feed end of the vessel; ensure that the membrane is properly orientated. If there are more than one membrane to be loaded into the vessel, do not push the first membrane into the vessel completely but reserve around 200mm to facilitate the connection of the next membrane.
4. Inspect and make sure the membrane interconnector is clean and intact. Apply a thin layer of glycerin onto the interconnector seals without excessive amount; otherwise the membrane may get contaminated. Install the interconnector into the loaded membrane.
5. Install and connect the next membrane with the loaded one with the interconnector.
6. Load all membrane elements in the same way. Push all the membranes into the vessel until the adaptor at the concentration end is inserted into the center hole of the first membrane and the membrane face is pushed against the thrust ring.

8.5.4. Installation of head assembly at upstream end

1. Apply a layer of Lubricant on the O-ring. Insert a head assembly into vessel. Do not rotate head assembly after insertion into vessel as this may cause head seal to become detached.

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2. Hold head assembly square to axis of shell and slide it straight in until a slight resistance is felt.
3. Using both hands, firmly push head in as far as it will go (a sharp, forceful thrust may be necessary to push head seal into vessel bore.) When head is in correct position, insert ring and locking Kit Segment and screw bolts.

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9. Troubleshooting

1. If locking kit segment's screw is too tight to thread out, proceed as follows:
 - Apply penetrating fluid (such as WD-40 similar) onto the locking kit segment and gently tap it with a mallet until the screw can be threaded off. Please take care not to contaminate the membrane elements.

2. If there is leakage, the possibilities can be:
 - Deteriorated head seals after running for over 2 years
 - Seals are deformed due to the pH of the medium
 - Seals are deformed due to the high temperature of the medium
 - Seals are damaged due to improper installation
 Proceed as follows:
 - Check the temperature, and pH of the medium.
 - Replace the seals.

3. Body damage of the vessel, the possibilities can be:
 - During transportation.
 - During installation.

4. If damage is serious, replace the vessel.

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10. Transportation and storage

10.1. Vessel Handling Precautions

- **DO NOT** drop vessel or allow it to hit hard on the ground or against other objects.
- Use padding to protect the vessels during handling to prevent damage.
- **DO NOT** Scratch or damage to the inner surface of the vessel.
- **DO NOT** lift the vessel from the Feed/Concentrate ports or permeate ports.
- **DO NOT** impose excessive external force on the vessel.
- **DO NOT** climb on the vessel.
- Damaged vessel must not be used.

10.2. Storage Requirements

- Vessel storage area shall be well leveled, clean and dry.
- Vessels shall not be stored outdoors. Long term exposure to outdoor environment would accelerate aging of FRP and also discoloring and peeling of paint. Vessels placed outdoors for a short period of time shall be covered with oilcloth.
- Make a list of product and spare parts before storage.
- Store vessels in their original packaging.
- Vessel storage area shall be far away from heat source.
- Store in a safe area to keep the vessel from shaking or falling.
- Height: not exceeding 3 packing units. Do not stack any other articles on top of vessels.

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11. Limited warranty

The warranty obligations of Nowadays Technologies are limited to the terms set forth below:

What is Covered:

ROShell vessel (Product) and parts (Parts) are warranted to the original owner to be free of defects in material and/or workmanship under normal use for a period of five (5) year from date of Invoice.

What is Not Covered:

This warranty does not cover:

- defects resulting from improper or unreasonable use or maintenance;
- defects not reported to Nowadays Technologies within the above described warranty period;
- failure to follow operating instructions;
- damage caused by acts of nature or problems resulting from abuse, misuse, negligence or accident;
- unauthorized alteration or modification or attempted repair of Product or Parts;
- damages caused by inadequate packing or shipping procedures;
- Normal wear of replaceable components, including elastomeric Seals, Spacers etc. These parts require maintenance as part of a yearly service schedule.
- Products purchased from unauthorized dealers.
- What Nowadays Technologies will do:
- During the warranty period, Nowadays Technologies will, at its sole option, issue a credit in the amount of the original purchase price of the product, or repair or replace any defective parts within a reasonable period of time.

How to Obtain a Remedy under this Limited Warranty:

If the buyer discovers within this period a failure of the product to conform to specifications, or a defect in material or Workmanship, the buyer must promptly notify Nowadays Technologies in writing. In no event may that notification be received by Nowadays Technologies more than 30 days after the end of the warranty period. Any goods that the buyer believes to be defective are to be returned to Nowadays Technologies factory for examination. However, upon request of the buyer, Nowadays Technologies may, at its discretion, agree to examine the goods in the field. If, upon examination by Nowadays Technologies, any goods sold under this agreement or purchase order do fail to conform to Product specifications, or prove to be defective in material or workmanship, Nowadays Technologies will supply an identical or substantially similar part F.O.B., Nowadays Technologies factory; or Nowadays Technologies, at its option, will repair such part or give credit to the buyer for the original cost of such goods.

Other conditions:

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THE PROVISIONS OF THIS LIMITED WARRANTY ARE IN LIEU OF ANY OTHER WARRANTY, WHETHER EXPRESSED OR IMPLIED, WRITTEN OR ORAL, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. NOWADAYS TECHNOLOGIES MAXIMUM LIABILITY SHALL NOT EXCEED THE ACTUAL PURCHASE PRICE PAID FOR THE PRODUCT.

To the maximum extent permitted by applicable law, in no event shall Nowadays Technologies be liable for any damages whatsoever (including without limitation, loss of time, inconvenience, expenses such as telephone calls, labor or material charges incurred in connection with the removal or replacement of the Product(s) or Part(s), special, incidental, consequential, or indirect damages for personal injury, loss of business profits, business interruption, loss of business information, or any other pecuniary loss) arising out of the use of or inability to use the defective Product(s) or Part(s), even if Nowadays Technologies has been advised of the possibility of such damages.

Disclaimers:

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Other legal rights:

This limited warranty gives you specific legal rights, and you also may have other rights that vary from state to state or country to country. Some places do not allow limitations on implied warranties or the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you.

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