

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

Table of Contents

1	How to remove adhesive	P1
2	Precautions for using double-sided tape	P2
3	How to apply double-sided tape to gaskets for D/E plate gaskets	
	• S-Distance piece	P3
	• UX series	P3 to 5
	• LX series	P6 to 12
	• RX series	P13 to 17
	• FX series	P18 to 21
	• EX series	P22
3	How to apply double-sided tape to Channel-plates	P23, 24
4	Contact information	P25

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

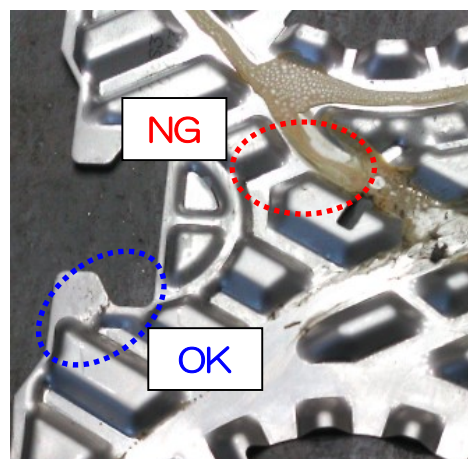


Photo 4. Adhesive residue

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.

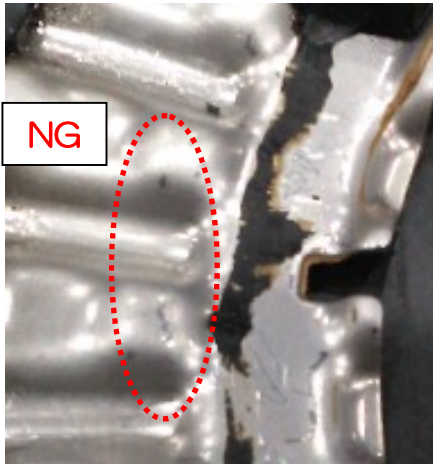


Photo 5. Gasket remaining example

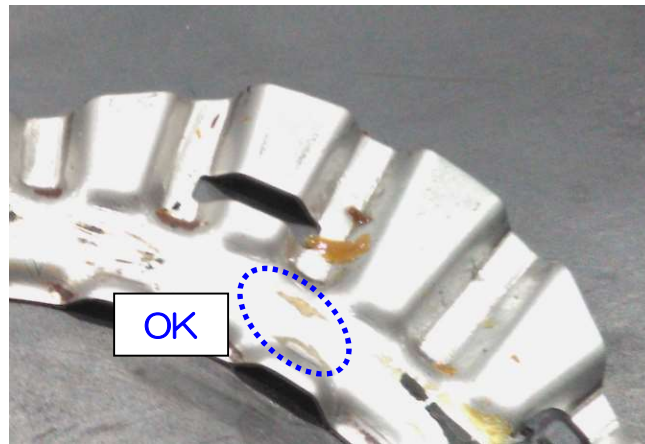


Photo 6. Adhesive remaining example

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

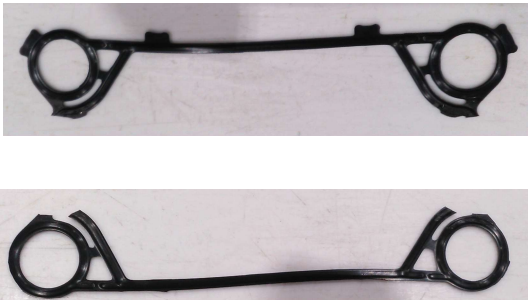





Photo 8. Back side of long/thin S-Distance piece









 : 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

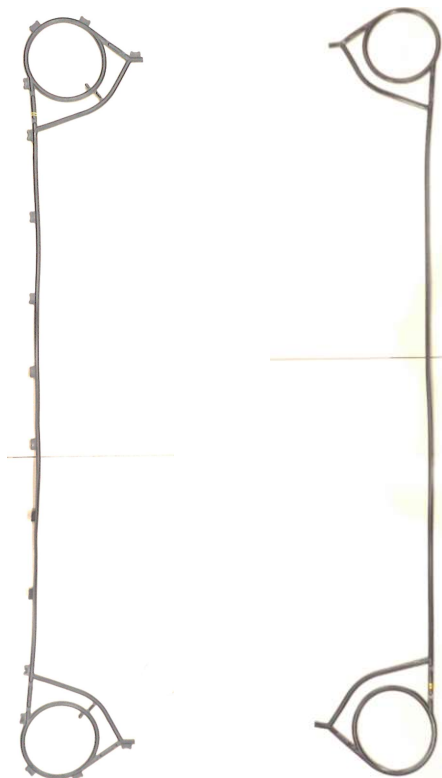
※プレートへの装着位置詳細は取説『ガスケット装着説明書』を参照下さい

Model:UX-30 type

D PLATE GASKET

Gasket surface

Gasket reverse



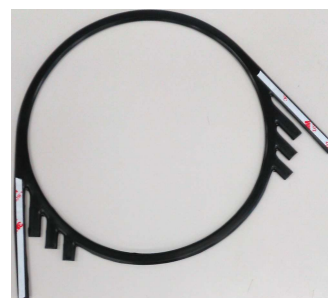
The ather can be fixed with slit.

Model:UX-40 type

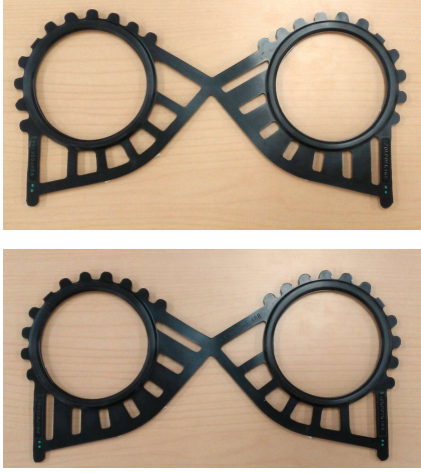



D PLATE GASKET

Gasket surface

Gasket reverse



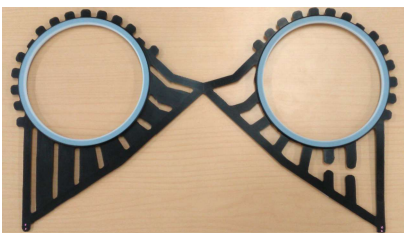
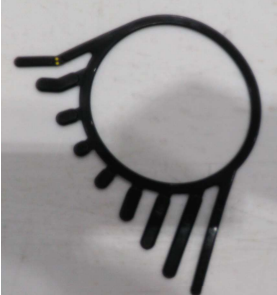
• LX series

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

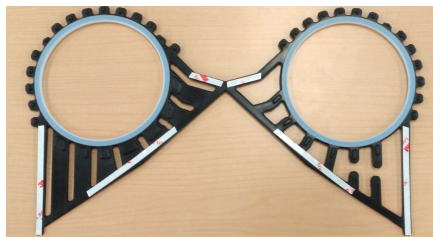
Model:LX-10 type

D PLATE GASKET

Gasket surface



Gasket reverse



E PLATE GASKET

Gasket surface

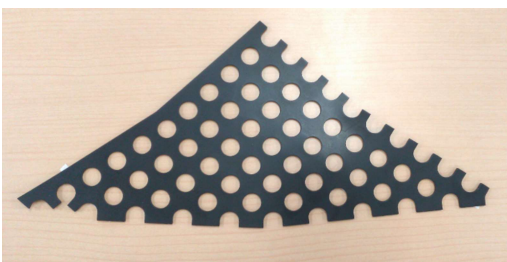


Gasket reverse

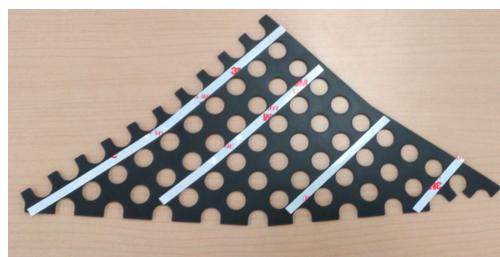


T DISTANCE

Gasket surface



Gasket reverse



Model:LX-20 type

D PLATE GASKET

Gasket surface



Gasket reverse

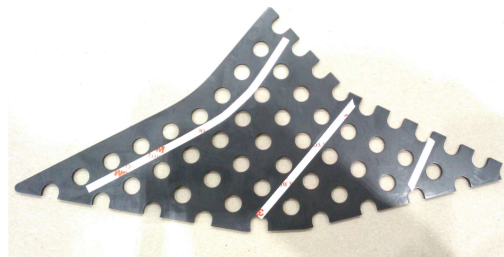


T DISTANCE

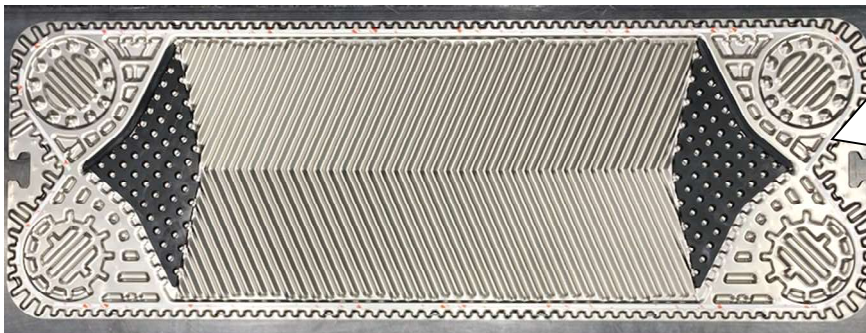
Gasket surface



Gasket reverse



E PLATE SHEET GASKET

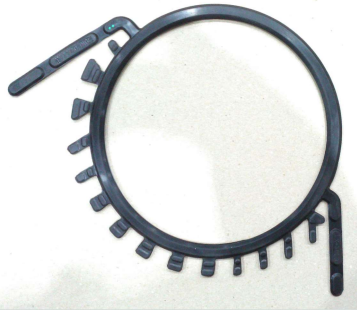


Double-sided tape sticking position

Model:LX-30 type

D PLATE GASKET

Gasket surface



Gasket reverse

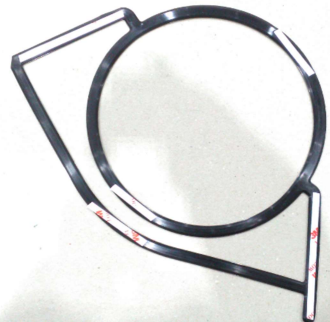


E PLATE GASKET

Gasket surface

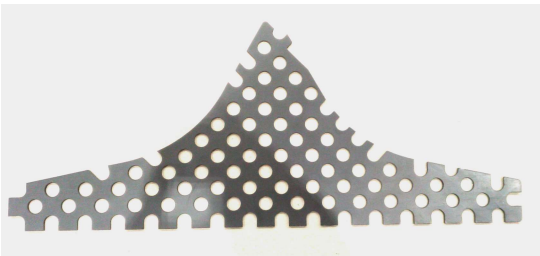


Gasket reverse



T DISTANCE

Gasket surface



Gasket reverse



Model:LX-40 type

D PLATE GASKET

Gasket surface

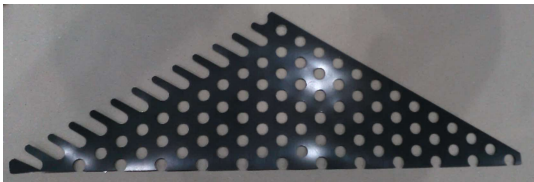


Gasket reverse

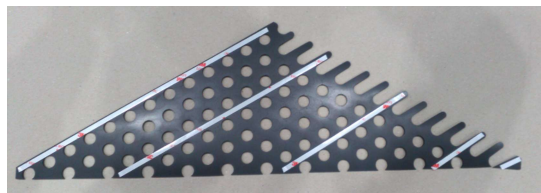


T DISTANCE

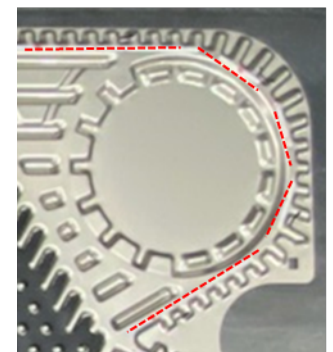
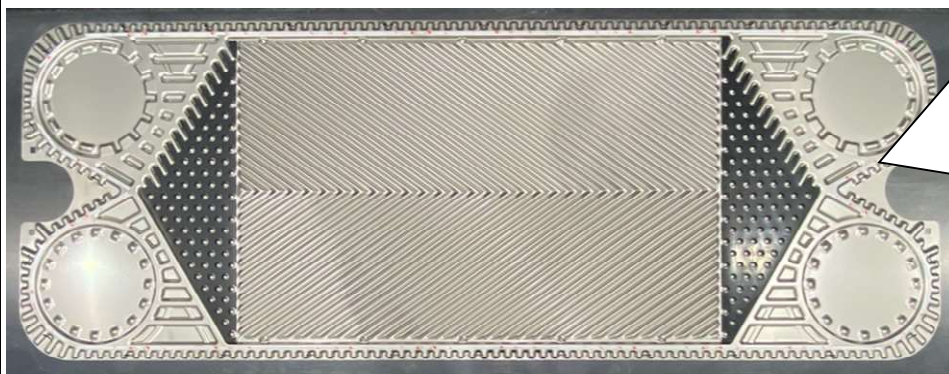
Gasket surface



Gasket reverse






E PLATE SHEET GASKET



Double-sided tape sticking position

• RX series

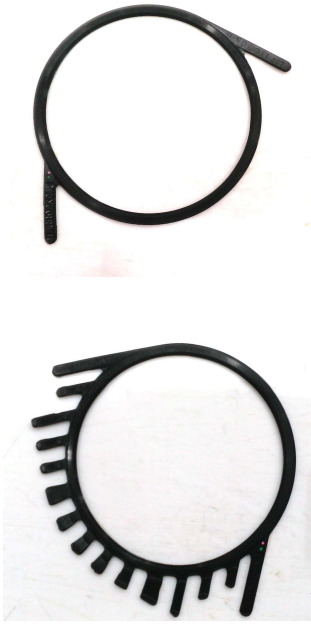
Model:RX-00 type	
D PLATE GASKET	
Gasket surface	Gasket reverse
	
E PLATE GASKET	
Gasket surface	Gasket reverse
	

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

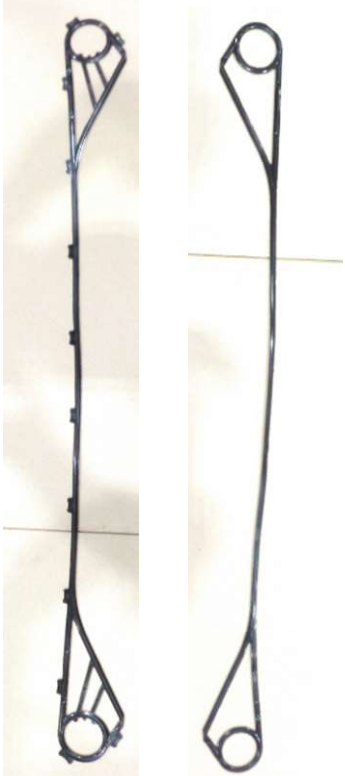

Gasket surface

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; width: fit-content; margin-left: auto; margin-right: auto;"> <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




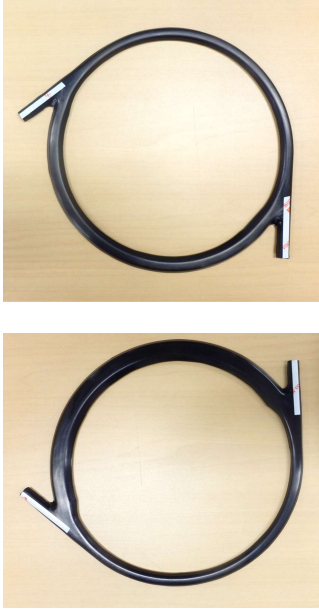
E PLATE GASKET



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

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

Hokkaido: Sapporo Shiraishi Daiichi Seimei Bldg. 6-1-20, Higashi Sapporo 3jo,
Shiraishi-Ku, Sapporo, Hokkaido 003-0003, Japan

Tel : +81-(0)11-868-8010

Fax : +81-(0)11-868-8011

Onomichi: 14-15, Nishigosho-cho, Onomichi, Hiroshima, 722-0037, Japan

Tel : +81-848-21-2750

Fax : +81-848-21-2751

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,
Malaysia

Tel : +60-3-8081-4185

E-mail : heatexc@hisaka-asia.com

Fax : +60-3-8081-7185

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 : cy Yap@hisaka-asia.com

HISAKAWORKS S.E.A. SDN. BHD. JOHOR BRANCH (MALAYSIA)

30-02, Jalan Molek 1/10, Taman Molek, 81100 Johor Bahru, Johor, Malaysia

Tel : +60-16-228-4209

E-mail : cswong@hisaka-asia.com

HISAKA WORKS (THAILAND) CO., LTD. (THAILAND)

12th Floor, 825 PhairojKijja Tower, Debaratana Road, Bangna-Nua, Bangna, Bangkok
10260, Thailand

Tel : +66-2-744-3287

E-mail : heatexc@hisaka-thai.com

Fax : +66-2-744-3286

HISAKA WORKS (THAILAND) CO., LTD. SATTAHIP SALES OFFICE (THAILAND)

222/28, Moo.10, Eastiny Park 5 Village, Bang Saray, Sattahip, Chonburi 20250, Thailand

Tel : +66-3-819-9819

E-mail : heatexc@hisaka-thai.com

Fax : +66-3-819-9820

HISAKAWORKS SINGAPORE PTE LTD. (SINGAPORE)

No.18, Boon Lay Way, #02-118, Trade Hub 21, Singapore 609966

Tel : +65-6-897-8489

E-mail : heatex@hisaka-sing.com

Fax : +65-6-686-4579

PT.HISAKA WORKS INDONESIA (INDONESIA)

Ruko Grand Aries Niaga, Jalan Taman Aries Blok E1 No.3H, Jakarta Barat, Jakarta
11620, Indonesia
E-mail : hisakindo@hisaka-asia.com

Tel : +62-21-2931-9235

Fax : +62-21-2931-9235

HISAPINO Manila Representative Office (PHILIPPINES)

20th Floor, One Global Place, Office Business Center, 5th Avenue & 25th Street,
Bonifacio Global City, Taguig 1632, Philippines
E-mail : hisapino@hisaka-asia.com

Tel : +63-2-224-4129

Fax : +63-2-224-4130

HISAVINA 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
E-mail : hisavina@hisaka-asia.com

Tel : +84- 8-3910-7355

Fax : +84-8-3910-7356

HISAVINA 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.117 Xiangyuan Road, Changshu National New & Hi-tech Industrial Development
Zone, Changshu City, Jiangsu Province 215542, P.R. China

Tel : +86-512-5213-3000

Fax : +86-512-5213-3008

HISAKA WORKS (CHINA) CO., LTD. SHANGHAI BRANCH (CHINA)

Room 1603, Shanghai Oriental Center, 699 West Nanjing Road,
Shanghai 200041, P.R. China
E-mail : hisaka-sha@hisaka.co.jp

Tel : +86-21-5211-0701

Fax : +86-21-5211-0720

HISAKA WORKS (CHINA) CO., LTD. GUANGZHOU BRANCH (CHINA)

Room 1208, R&F Tianhe Commercial Building No.4 Huanting Road,
Tianhe District, Guangzhou 510610,P.R. China

Tel : +86-20-3810-5515

Fax : +86-20-3847-7539

HISAKA MIDDLE EAST CO., LTD.

P.O. Box 7102, Building No.3861, Al Khudhariya Industrial Area, Dammam 32435,
Kingdom of Saudi Arabia
Email : info@hisaka-me.com
URL : www.hisaka-me.com

Tel : +966-13-838-4700

Fax : +966-13-838-5800

HISAKA KOREA CO., LTD.

15th Floor, Gwanghwamun Building, 149 Sejong-daero, Jongno-gu, Seoul 03186, South
Korea
Email : heatexc@hisakakorea.com

Tel : +82-2-739-8861/2/3

Fax : +82-2-739-8864

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/>).



HISAKA WORKS, LTD. HEAT EXCHANGER DIVISION

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

EX2022-012ERO
2023.01.27