

Oil Treatment Plant
6000/12000 litre/hour
KATO ELECTRIC MFG.
Japan



Messrs: TIRA THAI SERVICE CO., LTD.
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OPERATION AND MAINTENANCE

I N S T R U C T I O N M A N U A L

F O R

HIGH VACUUM OIL PURIFIER

MODEL KLVC-5/6AXSO-II

KATO WORKING NO. E-1065

Date: September, 1995

(CIM-1/1065-A



KATO ELECTRIC MFG. CO., LTD.

Tokyo Office:

203, 17-19, Ebara, 2-chome, Shinagawa-ku, Tokyo, Japan.

Tel. No.: 03-3783-5761 Fax. No.: 03-3784-6309

Telxe: 246-6049 "KATOFIL J"

Cable Address: KATODENFILT TOKYO



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Sheet No.: TO-3906 (1/4)
Date: Sept. 30, 1995

TEST RECORD FOR HIGH VACUUM OIL PURIFIER

MODEL KLVC-5/6AXSO-II

Messrs: TIRA THAI SERVICE CO., LTD.

1. Date of Test: Sept. 30, 1995
2. Place: Kato Electric Mfg. Co., Ltd.
Mishima Plant
317-1 Aza-Kishida, Honjyuku,
Nagaizumi-cho, Sunto-gun,
Shizuoka-Pref., Japan.
3. Wether & Temperature: Fine 28 °C
4. Test Rocord No.: TO-3906
5. Working No.: E-1065
6. Type & Rating:
 - (1) Capacity: 6,000/12,000 L/H
 - (2) Power Source: 3 ph. 380 V 50 Hz
 - (3) Heater: 3 ph. 120 KW (30 KW x 4)
 - (4) Type: Indoor use, Portable type
 - (5) Vacuum Pump: 2,500 L/M
Model VS1501 (ULVAC)
 - (6) Mechanical Booster: 1,000 M3/H
Model PMB-012C (ULVAC)
 - (7) Oil Pump: 6,000/12,000 L/H
Model L-32 (VIKING)

(2) Operation & Performance Test: ----- Satisfact
(by single pass)

Item	Cheking Point	Result
a. Starting, Running & Stopping	As per Instruction Manual & DWG. No. M33-30274a	Satisfactory
b. Measurement for:	As per Instruction Manual & DWG. No. M32-30639c	Satisfactory
<u>Pressure</u> At initial stage	PI1 0 - 5 Kg/cm2 PI2 30 - 76 cmHg PI3 0 - 5 Kg/cm2 PI4 0 - 5 Kg/cm2	0.2 Kg/cm2 50 cmHg 0.4 Kg/cm2 0.4 Kg/cm2
<u>Oil Temperature</u>	TI 30 - 50 °C	38 °C
<u>Final Vaccum Pressure</u>	4 Torr less	2.2 Torr (PIRANI)
<u>Flow Rate</u>	6,000/12,000 L/H	12,000 L/H valves fully opened

(3) Characteristic Test for Treated Oil: ----- Satisfact
(by single pass)

Item	Cheking Point	Result
a. Water content in Oil by ASTM D-1533	from 50 PPM to 2 PPM less by one pass	2.0 PPM
b. Gas content in Oil by ASTM D-2945	from 10 Vol.% to 0.1 Vol.% less by one pass	0.1 Vol.%
c. Dielectric Strength by JIS standard C2101-20-1978R	from 30 KV to 70 KV more by one pass	70 KV
d. Micron rating (Cuno micro klean)	1 micron	1 micron

* Characteristic of Untreated Oil:

Water Content in Oil	-	52.0	PPM
Gas Content in Oil	-	8.1	Vol.%
Dielectric Strength	-	22	KV
Oil Temperature	-	32	°C

(4) Dielectric Strength Test

AC 2,000 V 50 Hz. 1 minute ----- Satisfactory

(5) Insulation Resistance Test

100 M-ohm by 1,000 V Megger ----- Satisfactory
between living parts and ground

(6) Result: GOOD
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- E. & O. E. -

Tested by: Y. Sudo
Y. SUDO

Checking & Approved by: M. Iwamura
M. IWAMURA
ENGINEERING

Checking & Approved by: S. Nagayoshi
S. NAGAYOSHI
DIRECTOR FOR PRODUCTION
& DESIGN ENGINEERING