

- A positive system pressure at the highest point of 5 to 10 psi.
 - Make up water valve should be designed to add water to the system at the outlet of the boiler and should not be fed directly into the boiler.
2. Air removal equipment, including air separator and automatic air breather valves.
 3. A functioning expansion tank designed to system specifications.
 4. Filtration to remove particulates installed inline with the suction side of the recirculating pump.
 5. Bypass chemical feeder for corrosion inhibitor maintenance.
 6. Optionally a water meter could be installed in series with the automatic pressure activated water make up valve to monitor any make up water.
 7. Ensure water quality meets the following:

- Oxygen - less than 250 ppb (operating condition)
- pH - must be in the range of 8-10
- Total Iron & Copper - less than 25 ppm
- Corrosion Inhibitor - level capable of maintaining iron corrosion rates < 2 mpyr. Due to changing environmental restrictions, a non-heavy metal, all organic inhibitor is recommended, which is designed for multi-metal systems including ferrous metals and yellow metals such as copper and brass.
- Chlorides - less than 250 ppm as Cl. Limit applicable only to installations utilizing duplex steel pressure vessel components.

Install Water Piping

The bottom connection to the boiler is the INLET and must be connected as the return from the system. The top connection on the boiler is the OUTLET and must be connected as the supply to the system.

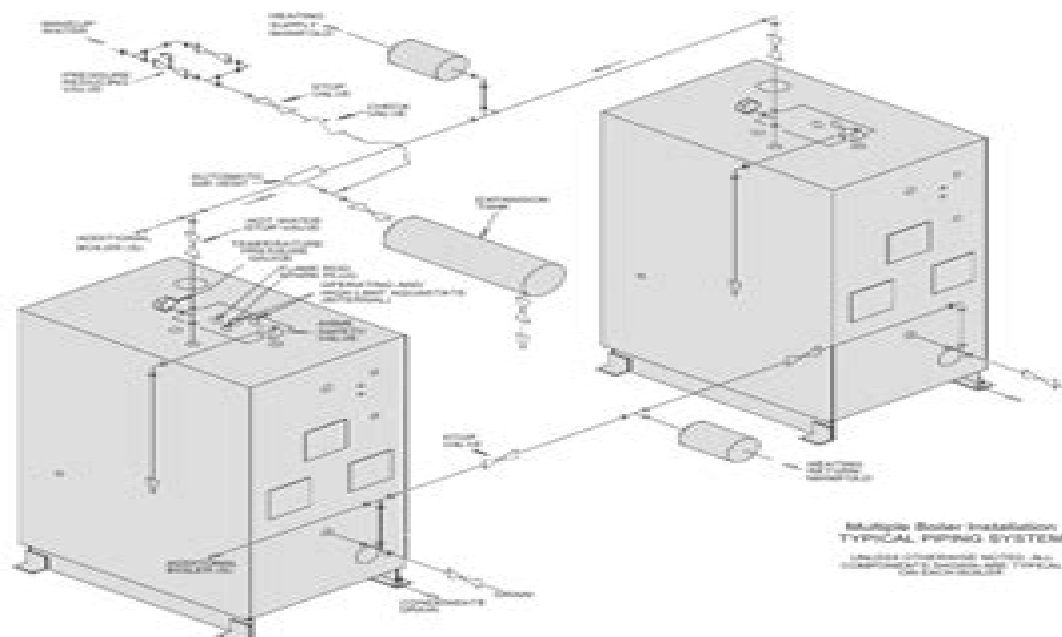


FIGURE 6 - TYPICAL PIPING (MULTIPLE BOILER SYSTEM)

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