



# PRECISION BOILERS

*Installation and  
Operating Instructions*

**ELECTRIC HOT WATER**

**&**

**STEAM BOILERS**



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## *Installation and Operating Instructions*

### **ELECTRIC HOT WATER & STEAM BOILERS**

#### **FOR YOUR SAFETY**

This manual supplies information on the application, installation and operation of Precision Electric Hot Water & Steam Boilers. Review all application and installation procedures completely before proceeding with the installation. Consult the Precision Boilers' Factory or local Factory Representative with any problems or questions regarding this equipment. Experience has shown that improper installation causes most operation problems.

#### **WARNING**

Improper installation, adjustment, alteration, service or maintenance can cause injury or property damage. **Read this manual thoroughly and follow the instructions herein.** The PRECISION Boilers shall be installed according to the procedures detailed in this manual, or the Precision Boilers Limited Warranty may be voided. The installation must conform to the requirements of the local jurisdiction having authority, and to the latest edition of the National Fuel Gas Code, ANSI Z223.1. Any modifications to the boiler or its gas / oil controls may void the warranty. If field installation requires modifications, consult either the local Precision Boilers' Representative or the Factory.

RETAIN THESE INSTRUCTIONS NEAR THE EQUIPMENT FOR READY REFERENCE



### **WHAT TO DO IF YOU SMELL GAS**



- ▲ **DO NOT** try to light any appliance.
- ▲ **DO NOT** touch any electrical switch;  
**DO NOT** use any phone in your building.
- ▲ **IMMEDIATELY** call your gas supplier from a neighbor's phone. Follow the gas supplier's instructions.

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## 1.0 GENERAL INFORMATION

### 1.1 Introduction

PRECISION has made a commitment to product improvement and follows a continuing quest for the highest standards of product performance. In pursuing this policy of continuous development of products, the manufacturer reserves the right to vary any details in this manual without notice.

This Electric Hot Water / Steam Boiler and Water Heater Operation and Maintenance Manual present information that will help to properly operate and care for the equipment. Study the contents carefully. The unit will provide good service and continued operation if proper operating and maintenance instructions are followed. The standard Limited Warranty is not applicable with equipment not installed or operated in accordance with these procedures.

The boilers are designed and engineered to provide excellent service and to give long life on the job. Although the unit and its components afford a high degree of protection and safety, operation of the equipment is not be considered free from hazards inherent in the handling of electricity and pressurized hot water or steam.

Pay close attention to WARNINGS and CAUTIONS as these present situations of potential hazard, and remember no amount of written instruction can replace intelligent thinking and reasoning.

### 1.2 Local Regulations

Consult local building and safety codes before proceeding with work. The operation of this equipment by the owner and his operating personnel must comply with all requirements or regulations of the authorities having jurisdiction.

### 1.3 Recommendations

#### 1.3.1 Preventative Maintenance

A Preventative Maintenance Schedule is provided as a recommendation for periodic equipment Inspections Recording of daily weekly, monthly and year maintenance activities, as well as the recording of any unusual operation, will serve as a valuable guide to any necessary investigation.

The standard Limited Warranty does not cover any damage caused by lack maintenance.

**1.3.2 Water Treatment for Boilers** of required Feedwater and Boiler Water Properties should be maintained in accordance with the table provided in this manual (Section 8.0). It is customary to engage the services of a qualified water treatment consultant to recommend the proper water treatment program. Damage from scaling, corrosion or erosion attributed to improper treatment of boiler water is not covered by the standard Limited Warranty.

## 2.0 STORAGE & HANDLING

### 2.1 Receiving

Each boiler / water heater is completely inspected at the factory and carefully packaged for shipment. Upon receipt of the shipment, immediately inspect the packing for signs of exterior damage. Verify receipt of all packages listed on the packing slip. Advise the carrier of any shortage or damage. Any such claims should be filed with the carrier. The carrier, not the shipper, is responsible for shortages and damage to the shipment.

### 2.2 Storage

Electrical equipment can be damaged if exposed to adverse weather. The boiler should be stored inside. The electrical panel and controls should be covered with plastic throughout all construction to avoid accumulation of dust and moisture on the controls and load components. The contactors can be damaged by dust / dirt in the mechanism.

## 2.3 Uncrating

2.3.1 Care must be taken not to damage controls or deform the boiler sheet metal during removal of the crate.

2.3.2 If using pry bars or fork lifts, be certain to support the boiler weight by the skids or channel base.

## 2.4 Placement

**CAUTION:** If the equipment is to be placed in a room with little or no ventilation, a supply of ducted filtered air may have to be brought to the lower portion of the control cabinet to limit the control cabinet interior temperature to 50°C (122°F) maximum.

**CAUTION:** If the equipment is to be placed in a room with little or no ventilation, a supply of ducted filtered air may have to be brought to the lower portion of the control cabinet to limit the control cabinet interior temperature to 50°C (122°F) maximum.

2.4.1 Provide a firm, level foundation for the equipment.

**NOTE:** Standard electric boilers / water heaters are not suitable for placement on combustible flooring.

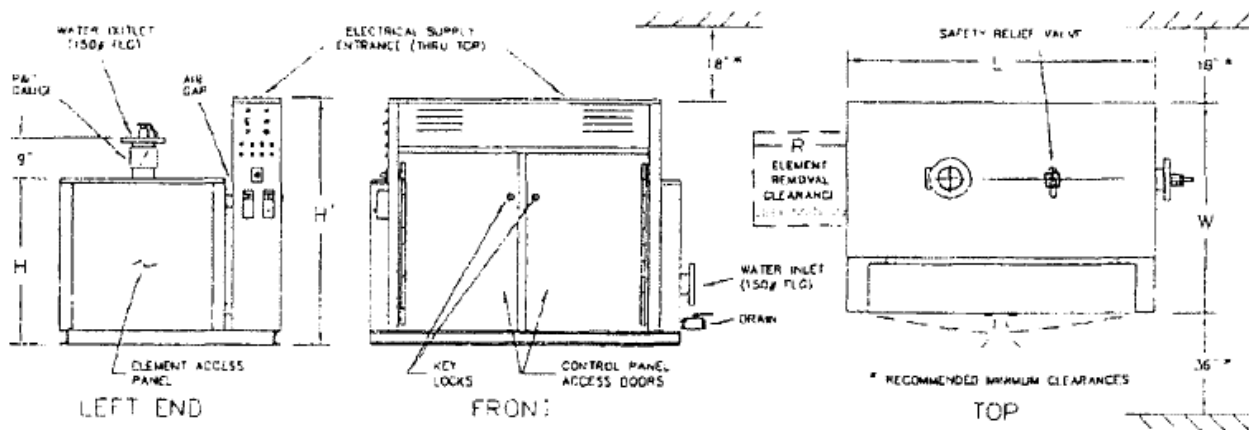
2.4.2 Leave a permanent space for element removal opposite element access panels as shown on the Dimensional Drawing (DD), and 36 inches opposite electrical panels.

**NOTE:** Electric panels require 42" opposite any opposing conductive surface.

2.4.3 Be sure to keep electrical panels and controls covered at all times while construction work is in process.

**CAUTION:** Do not use the equipment housing top for scaffolding.

**Figure 1 –  
Minimum Clearance Recommendations and General Dimensional Data for Boiler Placement**



## 3.0 INSTALLATION

### 3.1 Piping Connection

**NOTE:** Some of the following piping may have been completed at the Factory.

3.1.1 Boiler piping connections and values MUST comply with state and local codes, in addition to compliance with ANSI piping requirements

**CAUTION:** The pipe extensions outside the unit are usually the extensions of pipes which are permanently welded into the unit's vessel. Normally the only removable (threaded) connection is the drain pipe. DO NOT ATTEMPT TO REMOVE ANY OTHER PIPING!

**3.1.2** Install the safety relief valve(s) on the pipes provided. Plumb the relief valve outlet connections full size to the floor drain. Check local codes for proper safety valve discharge for steam boilers above 15 psi, which normally are required to be piped to overhead discharge outside safely away from personnel.

**3.1.3** Hot water boilers may be equipped with an air vent pipe on the top of the boiler. Plumb this connection to the expansion tank or install an automatic air vent on this pipe.

**3.1.4** The direction of flow through hot water boilers and water heaters must be from the inlet to the outlet (IE: bottom to top). Do not reverse these connections.

**NOTE:** Do not oversize feedwater piping and valves on steam boilers, as this may result in severe pressure fluctuations during feedwater cycles if the fill rate is too rapid.

## **3.2 Electrical Connections**

### **3.2.1 Power Feed Wiring**

The recommended wire size is listed on both the unit's Bill of Material (BOM) and the Wiring Diagram (WD). Also, the full load amperage and maximum voltage are stamped on the unit's nameplate. The feeder must be sized for 125% of the full load amperage in accordance with Article 424-3 of the NEC. The wiring must have insulation rated 75°C or greater. Copper wiring is recommended for all power connections. The recommended size is noted in the 'Notes' on the wiring diagram.

**CAUTION:** Do not exceed the maximum voltage as listed on the nameplate. For resistance loads, amperage increases proportionally with voltage.

### **3.2.2 Equipment Grounding Conductors**

The unit is equipped with grounding lugs(s) inside the power panel(s). The grounding conductors must be installed and sized in accordance with NEC Article 424-14. The recommended size is noted in the "Notes" on the diagram.

### **3.2.3 Control Wiring**

Alteration of, or additions to, control wiring may void both the Underwriters Laboratories Listing and the Manufacturer's Limited Warranty. Field-installed controls, control connections, and modifications must be approved in writing by the Factory.

**NOTE:** All power connections are 3-Phase, 3-Wire. (Exception: If unit is single phase.) There is no provision for a neutral connection; (IE: the unit should not be wired 'wye' or 'star').

## **3.3 Filling the System**

**3.3.1** The system and the boiler / water heater must be thoroughly flushed before the final fill. Steam boilers should be "boiled out" before operation.

### **3.3.2 Water Treatment**

Consult a local water treatment firm for recommendations on proper water treatment and boilout procedure to prevent damage to the boiler vessel, components and heating elements. The internal materials of boilers are Steel, Incoloy and Cast Iron, which all are compatible with standard boilout compounds. In lieu of a commercial boilout compound, the following mix of chemicals can be used for every 1,000 gallons of water:

- 30 lbs. TSP (tri-sodium phosphate;  $\text{Na}_3\text{PO}_4$ ), commonly found in many building supply centers.
- 5 lbs. caustic soda (50% pure sodium hydroxide;  $\text{NaOH}$ )
- 2 lbs. ordinary powdered laundry detergent. (Example: Tide)

These chemicals should be dissolved in warm water prior to their addition to the boiler. The boiler should be heated for at least 3 hours, then drained and flushed.

**NOTE:** Standard hot water boilers are suitable for ethylene glycol mixtures up to a 50/50 mix.

## 4.0 PRE-STARTUP INSPECTION

### 4.1 Minimum Equipment Required For Startup And Troubleshooting

- Volt-Ohm Meter
- Clamp-On Ammeter
- Megohm Meter
- Torque Wrench – inch lbs
- Torque Wrench – foot lbs

### 4.2 Mechanical System Checks

#### 4.2.1 Plumbing Connections Completed

- Inlet / Makeup water?
- Discharge / Outlet?
- Drain / Blowdown?
- Relief / Safety Valve discharge?

#### 4.2.2 Feedpumps / Circulating Pumps

- Pumps wired, connected and checked for proper rotation?
- Is the boiler filled to the proper level with water?

#### 4.2.3 System Flush

- Has the System been flushed?
- Has the unit been cleaned of all construction debris?

#### 4.2.4 Valves

- Are all valves in the proper open or closed positions?

### 4.3 Electrical System Checks

**WARNING:** All **POWER** supplying boiler should be off and locked out with the unit(s) main power switch(es) **OFF** and **Locked out!**

- Inspect all components, external and internal, to assure that there has been no damage during shipment or installation
- Remove one of the unit's control circuit transformer primary fuses. Then check the resistance phase-to-phase for all three phases. Make sure that there are no short circuits phase-to-phase or phase-to-ground.

With a megger (500VDC minimum) check contactor load side terminals to ground. If a reading of <1 megohm is obtained, consult the Factory.

Replace the control transformer fuse which was previously removed.

- Remove element access panel(s) and open doors to the electrical control panel(s). Run an inspection of the tightness of all electrical connections (IE: at fuse lugs, power entrance lugs, contactors, heating elements). All branch circuit connections should be tightened to 40 – 50 inch lbs. (actual value listed on components). Torque to avoid component damage from heat build-up. This tightness inspection is vital, because the vibration during shipment can often loosen electrical connections. If this is not done, damage may occur to component parts when power is switched on, and those damaged parts will not be covered under the manufacturer's Limited Warranty.

**NOTE:** See Maintenance Section on rechecking the torque on these components after an initial break-in period. Typically one to two weeks after start-up and then at least annually.

- With an ohmmeter, check the resistance between the phases on the load side of the contactors. Each should read the same and approximately what is shown on the wiring diagram.
- Check the electrical panels for loose material, dust and / or moisture. Thoroughly vacuum the panels if dust or foreign materials have accumulated there. If there has been severe exposure to dust, the contactors should be disassembled and cleaned. Dust in the contactors will cause contractor chattering and eventual destruction of the contacts. All components should be clean and free of dust, moisture, and foreign matter!
- Verify that field-installed control and load connections have been properly completed.
- Check the tightness of all control circuit connections.

## 4.4 Heating Element

**CAUTION:** Moisture in the elements may result in damage to the elements.

**NOTE:** There is a possibility that during shipment or storage prior to operation, the elements may accumulate moisture. The moisture will turn to steam when the elements are turned on and may rupture the element casing.

### 4.4.1 How To Check Elements for Moisture

Take a reading with a megger between the contactor terminals (load side) to ground for each contactor. Moisture is present if the reading is less than 1 megohm for standard 3-phase connection.

### 4.4.2 Removal of Moisture in Element (method #1)

Remove the fuses going to that contactor. The fuses should be removed so that, during the first day of operation, the affected element will not be energized allowing the hot water to drive the moisture out at a controlled rate.

### 4.4.3 Removal of Moisture in Element (method #2)

An alternate heating method is to direct a heat lamp at the suspect element, or remove the element, bake it in a 200°F oven for 8 hours, then reinstall and rewire.

**4.4.4** After completion of either of the above methods for moisture removal, re-check the element with a megger. When the reading indicates an acceptable level, the element may be put in operation by replacing the fuses.

**4.4.5** Replace all Element Access Panel(s) and close electrical / control panel doors.

## 4.5 Inspection Power/Voltage

Verify the boiler's ON/OFF switch is in the "OFF" position. Close the boiler main switch, switch the control switch to "ON" and then:

- Check the phase-to-phase voltage at the main terminals in the boiler electrical panel. The phase-to-phase voltage between any two of the phases **must not exceed** the boiler nameplate voltage.
- Check the voltage at the boiler control circuit fuse. It should be between 105 volts and 125 volts.
- Open the boiler main power switch.

If all of the above prove satisfactory, proceed with "Startup Instructions". Replace all covers and close all doors.

## 5.0 STARTUP INSTRUCTIONS

### 5.1 Control Settings

#### 5.1.1 Controller

(See Parts List for Part No. and Type)

**5.1.1.1** The controller is the pressure or temperature sensing device which controls the operation of the contactors directly or indirectly via the step control.

**5.1.1.2** Set the Controller for the desired Outlet Water Temperature (or Steam Pressure).



**NOTE:** (For Water Heaters) The maximum water temperature for lined vessels is 160°F, except for cement lined vessels which can operate at 180° F.

**NOTE:** (For Hot Water Boiler) Outdoor reset (dual bulb) controllers are set at the temperature at which the Boiler should operate when the outdoor temperature is 70°F (this outdoor reference temperature is adjustable on most solid state controls; fixed on Honeywell T991B controllers). The reset ration (fixed on Honeywell T775J) is the number of degrees the boiler control temperature will increase for a 1 degree decrease in outdoor temperature.

#### **5.1.1.3 Throttling Range**

The throttling range is the number of degrees (or psi) the outlet water temperature (or steam pressure) must change to drive the step controller from full-off to full-on.

For instance, if the controller is set at 160°F, and the throttling range is set for 10°F, the step controller will be full-on at 165°F (1/2 of throttling range above setpoint). The more stable the load on the unit (from system demands), the smaller the throttling range may be set.

#### **5.1.2 High Limit (Temperature or Pressure)**

Manual reset limits should be set slightly higher than the automatic reset limits. For steam boilers, the manual reset high limit should be set at least 10% below the safety valve set pressure.

#### **5.1.3 Low Water Cutoffs**

These cutoffs are always factory-set. If additional cutoffs are field-installed, the cut-offs should be at least three inches above the highest heating element. Manual reset cutoffs should be set below automatic rest cutoffs.

#### **5.1.4 Low Limit Sensors (Temperature or Pressure)**

Low limits should be set below the controller setting by at least the same margin as specified for high limits to be above the controller setting.

## **5.2 Operating Instructions**

**5.2.1** With the unit's control power ON/OFF or ON/OFF/PREHEAT switch 'OFF', close the main power switch(es).

**NOTE:** Units with shunt trip disconnects and remote 120-volt control power may require turning the control power switch 'ON' and activating the 120-volt control power, before closing the main power switch(es).

#### **5.2.2 Electric Door Interlocks**

For units equipped with electric door interlocks, do not attempt to open electrical panel doors after the main switch is closed. The lock tabs are mechanically restrained by the electric interlocks.

**5.2.3** Switch all the 'enable / disable' pilot switches the 'OFF' position (toggle down).

#### **5.2.4 120-Volt Power Source**

If a separate 120-volt power source is provided, close it's disconnect switch.

**5.2.5** Turn the control power ON/OFF or ON/OFF/PREHEAT switch to 'ON'.

#### **5.2.6 Alarm and Reset Circuits**

**5.2.6.1** If the alarm sounds when the control switch is turned 'ON', depress the alarm silence button. Check the unit to make certain that no limit condition exists by noting if the alarm pilot is illuminated. The alarm will sound momentarily on some units when power is initially applied.

**5.2.6.2** Units with Manual Rest Button(s) may require resetting of the manual reset switch upon initial application of power, and after the interruption or power or the trip-out of a limit control.

#### **5.2.7 Sequencing of Elements Circuits**

**5.2.7.1** On units with step controls, the unit will always start with no steps energized.

**5.2.7.2** As the steps begin cycling on, the LED's on the step control (circuit board inside cabinet) will light up one at a time, indicating that step control is operating properly.

**NOTE:** The enable pilot lights or contractors will not be activated at this time since the 'enable / disable' switches are in the off position.

**5.2.7.3** With the step control board full on, individually enable each step. The respective pilot light should light and the contactor(s) applying power to the respective elements.

**5.2.7.4** For units with ON/OFF/PREHEAT switches, only part (approximately 25% may be activated when the switch is down in the 'PREHEAT' position. This PREHEAT option is now rarely used.

**5.2.7.5** If PREHEAT switch is used. When the outlet water temperature (or steam pressure) is at or near setpoint, turn the ON/OFF/PREHEAT switch 'OFF', then to 'ON' again. The controls will recycle to the no-load condition. The steps should then begin to cycle on as needed, and all of the steps may come on if necessary.

## **6.0 SEQUENCE OF OPERATION**

### **6.1 Activation of Heating Element Circuits**

#### **6.1.1 Contactors**

The heating elements are energized by pilot operation. That is, the power to an element circuit is supplied through the contacts of a contactor. The contactor is activated (on a call for heat) by the closure of a temperature (or pressure) switch or by a contact in the step control circuit.

#### **6.1.2 Fuses**

All power leads to the elements are fused. The fusing is on the line side of the contactors.

### **6.2 Sequencing Controls**

#### **6.2.1 Staged Control Circuit**

**6.2.1.1** In this type circuit, the contractor coils are energized directly by the contracts of immersion thermostats (or pressuretrols). There is usually on thermostat (or pressuretrols) for each stage; or a multi-stage thermostat (or pressuretrols) may be provided in some cases.

**6.2.1.2** The safety limit devices (high temperature, low water, etc.) interrupt the power to the contactor coil circuits.

#### **6.2.2 Proportional Step Controls**

##### **6.2.2.1 Step Control Sequence**

The controller senses the unit's water temperature (either via 135-ohm device or thermistor) or steam pressure (either via 135-ohm device or 4-20 ma transducer). The output signal or the controller causes the step control to sequence the steps on, or off, depending on whether the unit's output is below or above setpoint.

When one of the switches closed on the step control, a contractor coil (or coils) is energized in a step-wise fashion. This type of step control will mid-position (bring on half of the steps) when the unit's water temperature (or steam pressure) is at setpoint.

**For example:** an 8 step steam boiler with the pressure controller set at 12 PSIG, will have 4 steps on when the boiler steam pressure is at 12PSIG.

##### **6.2.2.2 Progressive Sequence Step Controls**

These controls are provided as standard and include Selectronix SLC series and Viconics' model R851B. They provide first-on, first-off staging of the element circuits.

As the unit's temperature (or pressure) drops below setpoint, the control brings on more steps. As the temperature (or pressure) increases and approaches setpoint, the step control drops out stages. The first step to drop off is the one that has been on the longest. This provides even usage of the system's components.

##### **6.2.2.3 Linear Sequence Step Controls**

This type of step control is limited to the some Selectronix models and Viconics' model R851B. In this sequence progression, the control applies power by progressing from Step 1 to the maximum number required to satisfy the load, and then decreases power by retracing this sequence down toward the first step.

NOTE: Refer to the applicable vendor literature provided on the step control installed in your unit.

### 6.2.3 Recycle Feature

All step controls now incorporate the recycle feature which returns the step control to the no-load condition upon loss of control power.

### 6.2.4 Manual Step 'ENABLE / DISABLE' Toggle Switches

All units with >1 step now include manual 'ENABLE / DISABLE' toggle switches to provide a positive 'OFF' override of each step. These are used to disable a faulty step, limit total output or allow for a slow preheat.

### 6.2.5 Preheat Switch (Boilers Only)

The preheat switch is a manual limit switch. In order to preheat the boiler, the ON/OFF/PREHEAT switch must be in the down position. When the ON/OFF/PREHEAT switch is in its down or PREHEAT position, the boiler output is limited to approximately 25% of full load power. This allows the operator to limit the boiler output during startup cycles (particularly if the boiler is shut off at night and turned on again in the morning), which could lessen electrical demand charges.

When the boiler has been brought up to the setpoint temperature (or pressure), the ON/OFF/PREHEAT switch is moved slowly from its down or PREHEAT position to its up or ON position passing through the OFF position to cause the step control to recycle to the NO LOAD position. Thereafter, the boiler can operate up to full load if necessary.

**NOTE:** The PREHEAT switch is included as an option on boilers of 9 or more steps. It is intended to be used to prevent setting demand peaks on 'cold starts'. It does not have to be used if so desired.

## 7.0 OPERATIONAL TESTING

### 7.1 Standard Controls

#### 7.1.1 135-ohm Controllers (T991,T915,L91,etc.)

With the water temperature (or steam pressure) at setpoint, the step controller should bring on nominally one half of the steps. An adjustable proportional band is provided on the controller (sensor) to enable tuning the unit to system demand.

#### 7.1.2 Solid State Controls

With the water temperature (or pressure) at setpoint, the step controller should bring on nominally one half of the steps. An adjustable proportional band is provided on the controller (sensor) to enable tuning the unit to system demand.

**IMPORTANT:** The timing between stages adjustable (with step control). Steam boilers normally have delay of between 15-20 seconds while stepping up and 3-5 seconds while stepping down. Water boilers can normally respond slower so 25 – 40 seconds up and 5 – 10 seconds down is usually appropriate. The slower the step sequencing, the less wear on both the contractors and heating elements (yet still able to control the process as needed) the less heat is generated in the cabinet which results in longer component life.

### 7.2 Outdoor Reset Controls

#### 7.2.1 135-ohm Type Outdoor Reset Controller (Hot Water Boilers Only) (Honeywell T991B type)

These controllers have a fixed reset ratio: either 1-to-1, 1-to-1.5 or 1.5-to-1. The outdoor reference temperature is 70°F (IE: the boiler outlet water control point temperature is equal to the setting on the controller when the outdoor temperature, at the outdoor bulb, is 70°F). In order to test the operation of this controller.

**7.2.1.1** Check the outdoor temperature at the outdoor air sensing bulb; then determine the number of degrees this temperature is above, or below 70°F.

**7.2.1.2** Check the boiler outlet water temperature; if the outdoor temperature is below 70°, multiply the difference between 70°F and the actual outdoor temperature by the reset ratio (1.0, .67 or 1.5); and subtract this from the temperature of the boiler outlet water.

**7.2.1.3** Then set the controller at this resultant temperature; the step controller should maintain nominally half of the steps on. Setting the OUTDOOR RESET CONTROLLERS basic information is shown in **Table 1** below.

<b>Table 1</b>		<b>SETTING THE TEMPERATURE CONTROLLER</b>	
		Reset Ratio:	1:1-1/2 (IE: 2/3:1)
		Outdoor Temperature:	40°F
		Boiler Water Temperature:	130°F
<b>Step 'A'</b>	Difference between outdoor temp and 70°F		70 – 40 = 30°
<b>Step 'B'</b>	Multiply 30°F times the Reset Ratio 2/3 (and then)		30 x 2/3 = 20°F
	Subtract 20°F from the Boiler Water Temp 130°F		130 – 20 = 110°F
<b>Step 'C'</b>	Set the Controller at 110°F		
Note:	If the Outdoor Temperature is above 70°F, add the difference in Step 'A', multiplied by the Reset Ratio, to the Boiler Water Temperature.		
<b>See Honeywell manual for specific details.</b>			

**7.2.2 Solid State Dual Input Reset Controls (Honeywell T775J controls)**

These are dual sensor reset controllers with adjustable reset ration and outdoor reference temperature. The 'reset ratio' is the ratio of the change in the temperature at the secondary sensor to the opposing change in the control point. If the reset ratio is 2:1, every 2°F change at the outdoor sensor will cause an automatic inverse change of 1°F at the control point.

NOTE: Refer to the applicable vendor literature provided on both the setpoint controls and step controls installed in your boiler.

**8.0 PREVENTIVE MAINTENANCE**

**8.1 General**

Electrical immersion heating element boilers and water heaters are automatic, quiet and safe. Consequently, they are all too often neglected. Like any piece of electrical / mechanical equipment, they require care and maintenance to keep them in top working condition.

If electrical connections are allowed to become loose or dirty, there is danger of an electrical fault. If the elements are not inspected periodically for leaks, the water from leaking elements can leak onto adjacent elements, causing external element damage and resulting in blowing of load fuses in the boiler electrical panels. If the boiler water is not properly treated, element failure could occur due to the formation of scale. Treat the boiler with respect.

**CAUTION:** Always work on the boiler with all electrical power sources disconnected.

**8.2 Water Treatment (Boilers Only)**

Boiler water should be periodically checked through a sampling procedure. Properties should be maintained in accordance with **Table 2** at the end of this section. For consultation relative to water treatment, please contact a reputable water treatment firm.

## 8.3 Electrical System Maintenance

**8.3.1** Clean the control cabinets periodically (as often as needed) to keep both the interior and the exterior free of dust, moisture and foreign matter. The interior cleaning of the electrical panels must be done with the **POWER OFF!**

**NOTE:** For units supplied with control cabinet cooling fans, the condition of the fan filter must be periodically checked and the filters cleaned or replaced as necessary.

**8.3.2** With the POWER OFF, periodically check the tightness of electrical connections; particularly at power entrance lugs, fuses (line side) and contactors (load side). This should be done at time of commissioning, at 7 – 14 days thereafter and at least annually. Replace any components that show signs of heat damage (IE: discoloration, charring, melted insulation, etc.).

**8.3.3** Inspect the condition of the contactors. Look for burned or corroded contacts or overheated coils and wires. If the contactors chatter or hum during operation, they should be either disassembled and cleaned to remove dust or other foreign material in the mechanism or replaced.

**8.3.4** Inspect the heating elements. Make sure that the terminal contacts are tight, clean, and corrosion-free.

**8.3.5** Check all the wiring throughout the unit for frayed or brittle insulation. Replace any wiring showing insulation degradation.

## 8.4 Boiler Mechanical System Maintenance

**8.4.1** With the POWER OFF, remove the element access covers. Inspect all internal vessel connections, particularly at the heating elements. Spot check torque on element flange bolts. The acceptable torque range is 10 – 15 ft. lbs.

**CAUTION: Do not over tighten elements!**

**8.4.2** Remove and replace any leaking elements or element gaskets. Inspect handhole and manhole gaskets. If these gaskets are brittle, they should be replaced.

**WARNING: Over-torquing of the elements nuts will damage the element gasket.**

**8.4.3** Repair any leak at any place on the unit or adjacent piping. Re-torque flange bolts on system piping.

**8.4.4** For all boilers, the interior of the pressure vessel must be inspected at least once a year. If there is any presence of scale, refer to 'Preventative Maintenance Water Treatment' above a consult a local water treatment firm immediately. Scale formation on the elements will cause heating element failures. Scale formation elsewhere in the boiler can cause erratic control operation / failure, particularly on water level controls.

**8.4.5** When the boiler is inspected, rod out the pipes to the water column(s) and inspect the operation of the float(s) in the level controller(s).

**8.4.6** Remove and clean the low water cutoff probe.

**8.4.7** Steam Boiler Special Maintenance

**8.4.7.1** All PRECISION steam boilers are supplied with a surface blow-off connection. If surface blowoff valves are not Factory-installed, they should be installed in the field. The surface blow-off should be used as often as necessary to remove organics which accumulate at the water surface, and to limit TDS. (Boiler water TDS should not exceed 3500 ppm).

**8.4.7.2** Both the boiler and water column should be blown down periodically to remove bottom sludge.

**8.4.7.3** The water column should be blown down daily to assure proper operation of the level control / LWCO assembly.

**8.4.7.4** Water Treatment

Water treatment is required for satisfactory operation of steam boilers to prevent both deposition of scale and corrosion from acids, oxygen and other harmful elements that may be in the water supply. A qualified water treatment specialist should be consulted to establish a proper water treatment program.

## 8.5 Element Replacement Procedure (4-Bolt Style Element)

**CAUTION:** Before element replacement, make certain main power to the unit is turned off, that there is no pressure in the unit, and that the unit is drained below the element opening.

**NOTE:** To prevent hazardous conditions of leaking water / steam at the element terminal ends, defective elements or element gaskets should be replaced immediately upon leak detection.

- 8.5.1 Adequately tag wire and then remove wires from defective elements
- 8.5.2 Remove element by removing the four (4) attachment nuts.
- 8.5.3 Install replacement element with the new gasket and torque nuts to 10 -15 ft. lbs.

**WARNING: Do not exceed 15 ft. lbs.**

- 8.5.4 Connect phase wires to new element.
- 8.5.5 When the unit is filled and pressurized, check for leaks.

Table 2		Recommended Feedwater and Boiler Water Properties		
FEEDWATER				
Type of Boiler	Hardness (ppm)	pH	Oxygen (cc/l)	TDS (ppm) Total Dissolved Solids
Hot Water	0 – 10	7.5 – 9.5	4.0	0 – 500
Steam	0 – 5	7.5 – 9	.03	0 – 350
BOILER WATER				
Type of Boiler	Hardness (ppm)	pH	Oxygen (cc/l)	TDS (ppm) Total Dissolved Solids
Hot Water	0 – 10	7.5 – 9.5#	0	0 – 5000
Steam	0	7.5 – 9.5#	0	0 – 3500
# - The limit of 9.5 pertains to copper elements; a pH of 10.5 is allowable for Incoloy elements.				