



Operation Manual
LP 420 Nitrox Generator™
Rev. 10.12

If you have any questions on this equipment please contact Technical Support at:

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Warning

This operation manual contains important safety information and should always be available to those personnel operating this equipment. Read, understand, and retain all instructions before operating this equipment to prevent injury or equipment damage.

Every effort was made to ensure the accuracy of the information contained within. Nuvair, however, retains the right to modify its contents without notice. If you have problems or questions after reading the manual, stop and call Nuvair at 1-805-815-4044 for information.

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Separate Manuals Included:

- Nuvair Pro O₂™ Oxygen Analyzer Operation Manual
- Rotair S.p.A. Operating Manual

1.0 Introduction

Nuvair has taken extreme care in providing you with the information you will need to operate this system. However, it is up to you to carefully read this manual and make the appropriate decisions about system safety.

This manual will assist you in the proper set-up, operation and maintenance of the Nuvair LP 420 Nitrox system. Be sure to read the entire manual.

Throughout this manual we will use certain words and symbols to call your attention to conditions, practices, and / or techniques that may directly affect your safety. Pay particular attention to information introduced by the following signal words:

Danger

Indicates an imminently hazardous situation, which if not avoided, will result in serious personal injury or death.

Warning

Indicates a potentially hazardous situation, which if not avoided, could result in serious personal injury or death.

Caution

Indicates a potentially hazardous situation, which if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.

Notice

Notifies people of installation, operation or maintenance information which is important but not hazard-related.

2.0 Safety Warnings

Warning

This equipment is used to provide breathing gas for the purpose of underwater life support. Read this manual in its entirety. Failure to heed the warnings and cautions contained in this document may result in severe injury or death.

Warning

The equipment you will be using to manufacture nitrox (oxygen rich air) will expose you to both low and high-pressure gas. Gas, even under moderate pressures, can cause extreme bodily harm. Never allow any gas stream to be directed at any part of your body.

Warning

Any pressurized hose can cause extreme harm if it comes loose or separates from its restraint (or termination) while under pressure and strikes any part of your body. Use appropriate care in making and handling all gas connections.



Danger

Pure nitrogen is a colorless, odorless, tasteless gas that will not support life. Breathing gas mixtures containing more than 84% nitrogen at surface pressures will lead to unconsciousness and may cause death.



Warning

The nitrogen discharge from the membrane system must be vented to the exterior of any closed building, boat, or similar enclosed space. Breathing gas mixtures containing more than 84% nitrogen at surface pressure will lead to unconsciousness and may cause death.



Warning

Do not use any form of mineral oil or synthetic lubricant not rated for nitrox in any compressor in this system. Use only the recommended nitrox compressor lubricant. Never mix the nitrox compressor lubricant with other lubricants. Remove all existing lubricant and replace with the proper nitrox compressor lubricant prior to installing the membrane system. The use of improper lubricants can lead to fire or explosions, which may cause serious personal injury or death.



Warning

Do not use this system to produce nitrox mixtures containing more than 40% oxygen. Pumping nitrox mixtures with higher concentrations of oxygen may lead to fires or explosions, which can cause serious personal injury or death.

⚠ Warning

The use of enriched air nitrox does not eliminate the risk of decompression sickness (DCS) in diving. Decompression sickness can lead to permanent disability or death.



⚠ Warning

Do not pump nitrox mixtures at pressures above the H.P. compressor manufacturer's rating, and never above 3600 P.S.I. (250 bar). The system is not rated for pressures above 3600 P.S.I. (250 bar). Higher pressures may lead to explosions which may cause serious personal injury or death.

⚠ Caution

Ambient room temperature should never exceed 104° F (40° C) during operation of the nitrox system. Operation at higher temperatures may lead to system damage and malfunction. A damaged membrane will not produce the correct nitrox mixture which can lead to severe personal injury if the gas is used for diving purposes without proper analysis.

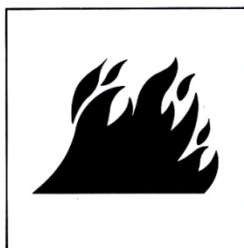
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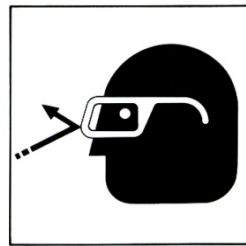
Moving belts



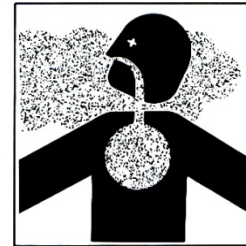
Electrocution



Fire



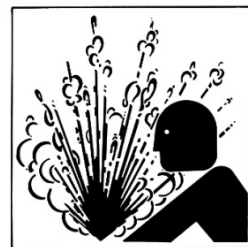
Eye protection



Gas inhalation



Skin damage



Explosion



Explosion



Electrocution



Machinery

Abbreviations commonly used in this manual:

P.S.I. Pounds Per Square Inch
 H.P. High Pressure
 L.P. Low Pressure
 O₂ Oxygen
 CO Carbon Monoxide
 CO₂ Carbon Dioxide
 N Nitrogen

C.F.M. Cubic Feet Per Minute
 R.P.M. Rotations Per Minute
 P.P.M. Parts Per Million
 L/min Liters Per Minute
 O₂% Oxygen Percentage of Gas
 B.P. Back Pressure

Cubic Feet Per Minute
 Rotations Per Minute
 Parts Per Million
 Liters Per Minute
 Oxygen Percentage of Gas
 Back Pressure

3.0 Safety And Operation Precautions

Because a compressor is a piece of machinery with moving and rotating parts, the same precautions should be observed as with any piece of machinery of this type where carelessness in operations or maintenance is hazardous to personnel. In addition to the many obvious safety precautions, those listed below must also be observed:

- 1) Read all instructions completely before operating any compressor or nitrox system.
- 2) For installation, follow all local electrical and safety codes, as well as the National Electrical Code (NEC) and the Occupational Safety and Health Administration (OSHA) standards.
- 3) Electric motors must be securely and adequately grounded. This can be accomplished by wiring with a grounded, metal-clad raceway system to the compressor starter; by using a separate ground wire connected to the bare metal of the motor frame; or other suitable means.
- 4) Protect all power cables from coming in contact with sharp objects. Do not kink power cables and never allow the cables to come in contact with oil, grease, hot surfaces, or chemicals.
- 5) Make certain that power source conforms to the requirements of your equipment.
- 6) Pull main electrical disconnect switch and disconnect any separate control lines, if used, before attempting to work or perform maintenance. "Tag Out" **and** "Lock Out" all power sources.
- 7) Do not attempt to remove any parts without first relieving the entire system of pressure.
- 8) Do not attempt to service any part while system is in an operational mode.
- 9) Do not operate the system at pressures in excess of its rating.
- 10) Do not operate compressor at speeds in excess of its rating.
- 11) Periodically check all safety devices for proper operation. Do not change pressure setting or restrict operation in any way.
- 12) Be sure no tools, rags or loose parts are left on the nitrox system.
- 13) Do not use flammable solvents for cleaning the air inlet filters or elements and other parts.
- 14) Exercise cleanliness during maintenance and when making repairs. Keep dirt away from parts by covering parts and exposed openings with clean cloth or Kraft paper.
- 15) Do not operate the compressor without guards, shields, and screens in place.
- 16) Do not install a shut-off valve in the compressor discharge line, unless a pressure relief valve, of proper design and size, is installed in the line between the compressor unit and shut-off valve.
- 17) Do not operate this compressor in any location where there is a possibility of toxic levels of carbon monoxide (CO), carbon dioxide (CO₂), nitrogen (N), or any flammable or toxic fumes being sucked into the compressor intake.
- 18) Be careful when touching the exterior of a recently run electric, gasoline, or diesel motor - it may be hot enough to be painful or cause injury. With modern motors this condition is normal if operated at rated load - modern motors are built to operate at higher temperatures.
- 19) Inspect unit daily to observe and correct any unsafe operating conditions found.
- 20) Do not "play around" with compressed air, or direct air stream at body, because this can cause injuries.
- 21) Compressed air from this machine absolutely must not be used for food processing or breathing air without adequate downstream filters, purifiers and controls and periodic air quality testing.
- 22) Always use an air pressure-regulating device at the point of use, and do not use air pressure greater than marked maximum pressure.
- 23) Check hoses for weak or worn conditions before each use and make certain that all connections are secure.

The user of any compressor or nitrox system manufactured by Nuvair is hereby warned that failure to follow the preceding Safety and Operation Precautions can result in injuries or equipment damage. However, Nuvair does not state as fact or does not mean to imply that the preceding list of Safety and Operation Precautions is all-inclusive, and further that the observance of this list will prevent all injuries or equipment damage.

4.0 Legal Precautions

It is highly recommended that a Nitrox fill log be maintained when filling Scuba cylinders to document the following information. This log must be of permanent binding style with no loose pages.

- ◆ Fill date and time of day
- ◆ Tank serial number
- ◆ Supplier's check of oxygen content O₂% plus signature and date
- ◆ User's check of oxygen content O₂% plus signature and date
- ◆ Fill pressure
- ◆ MOD (maximum operating depth) in user's handwriting
- ◆ Nitrox certifying agency and card number

5.0 Theory of Operation

The LP 420 Nitrox Generator™ system is a system that produces oxygen-rich air (nitrox) ready for delivery to a High Pressure (H.P.) compressor to fill scuba tanks or storage cylinders. The package is designed to be fully automatic with an operator overseeing the production to maintain proper Nitrox mixtures not to exceed 40% oxygen. Although it is described as the “nitrox compressor”, it can also be used to pump air.

The nitrox system allows for efficient and cost effective nitrox production using electric power, without the hazards or expense of blending with stored high-pressure oxygen (O₂). Instead, the system uses a semi-permeable membrane to produce nitrox from air. A portion of the nitrogen in air is separated out, leaving an oxygen rich nitrox mixture.

The LP 420 Nitrox Generator™ uses a rotary screw L.P. compressor, air / oil aftercooler, (optional) refrigerated air dryer, and filtration to provide the membrane system with a source of clean, pressurized feed air for separation. The air is filtered to CGA Grade D or better air quality prior to entering the membrane system so it will not damage or plug the membrane fibers. Specifications for Grade D air are provided in the appendix.

The LP 420 Nitrox Generator™ membrane system is rated for a maximum feed air pressure of 300 P.S.I. (21 bar) and has been configured to work well with the 175 P.S.I. (12 bar) maximum pressure delivered by the L.P. compressor. A back-pressure regulator is used to adjust the amount of air the screw compressor produces to meet the appropriate levels for various O₂% nitrox production. The air is then heated to a temperature that provides stability over a wide range of ambient conditions, is optimal for membrane permeation, and prevents moisture condensation.

The heated air enters the membrane, which is made up of thousands of miniature hollow fibers. The walls of these fibers are semi-permeable and designed for different gases to move through them (or permeate) at different speeds. The resulting gas mixture is known as the “permeate.” As air flows through the hollow fibers, both oxygen and nitrogen permeate through the fiber walls. The oxygen permeates faster than the nitrogen, which produces permeate with oxygen content greater than air. The gas that reaches the end of the hollow fibers without permeating is almost entirely nitrogen and is discharged. The flow rate of this discharge is set by the factory via a fixed orifice, which controls the permeate.

The permeate is a concentrated mixture that is diluted with air prior to entering the H.P. compressor. It exits the membrane at ambient to slightly negative pressure and travels into the mixing tube, where it mixes homogeneously with filtered outside air. The amount of dilution, and thus final O₂%, is obtained by adjusting the amount of air produced by the compressor and supplied to the membrane, with the back pressure regulator. As air flow to the membrane is increased, permeate flow increases and a higher O₂% nitrox is produced. As air flow to the membrane is decreased, permeate flow decreases, compressor intake air increases, and a lower O₂% nitrox is produced.

This relationship between permeate flow and intake air flow exists because the total of these two flow rates will always equal the intake flow rate demanded by the H.P. compressor. The resulting nitrox mixture is analyzed for O₂% before entering the H.P. compressor for approximate content and again when pumping nitrox for precise content. The H.P. compressor pumps the nitrox to a maximum pressure of 3600 P.S.I. (250 bar) to fill scuba tanks or storage cylinders.

A unique feature of Nuvair nitrox systems is that the feed air pressure that correlates to a specific nitrox O₂% is repeatable. For example, if your H.P. compressor pumps 36% O₂ when the feed air pressure is at 125 P.S.I. (9 bar), then adjusting the back pressure regulator to 125 P.S.I. (9 bar) during the next use will produce the same mixture.

6.0 Low Pressure Rotary Screw Compressor Technical Data

RVK15

- ◆ Capacity and Power Consumption:
 - ◆ Normal working pressure – 175 P.S.I. (12 bar)
 - ◆ Capacity at normal working pressure – 44cfm (1.25 m³/min)
 - ◆ Shaft power at normal working pressure – 15 hp (11.6 kW)
 - ◆ Maximum working pressure – 175 P.S.I. (12 bar)
 - ◆ Minimum working pressure – 44 P.S.I. (3 bar)
 - ◆ Idling shaft power consumption – 3.35 hp (2.5 kW)
 - ◆ Transmission – Belt drive
- ◆ Cooling
 - ◆ Allowed ambient temperature – 32-104°F (0-40°C)
 - ◆ Compressed air temperature above cooling medium temperature – 50°F (10°C)
 - ◆ Cooling air flow – (0.8 m³/s)
 - ◆ Maximum cooling air pressure drop – 0.12 in H₂O (30 Pa)
 - ◆ Cooling air temperature rise – (14°C)
 - ◆ Oil cooler heat rejection – (9.2 kW)
 - ◆ Aftercooler heat rejection – (1.3 kW)
- ◆ Motor and electrical values:
 - ◆ Motor - F class, IP55, 15 hp (11.2 kW)
 - ◆ Speed of rotation – 60Hz 3500 RPM 50Hz 2930 rpm
 - ◆ Fuse (max) 230/380/440V 100/50/25
 - ◆ Compressor current 230/380/440V 17 A at 440 V E3 50 Hz or 60 Hz
22 A at 380 V E3 50 Hz or /60Hz
39 A at 220 V E3 50 Hz or /60Hz
 - ◆ Control voltage – 230 V
- ◆ General technical data
 - ◆ Oil Quantity – 4 liters
 - ◆ Oil Content – 3 mg/m³ before filtration
 - ◆ Noise level (Cagi Pneurop) - 70dB
 - ◆ Compressor weight – 826lbs (375 kg)

Notice

Rotary screw compressors are continuous duty rated workhorses that are not made to run for short intervals or sit without use for long periods of time. The rotary screw compressor must be run for a minimum of one continuous hour per week in tropical settings to insure moisture does not build up in the compressor. The oil filter and oil/air separator must be changed every 2000 hours or a minimum of once per year. In tropical conditions the oil should be checked every month for moisture by draining a small amount off the bottom of the compressor into a clear glass. If moisture is found it can be drained off and a visual inspection should be done on all filters checking for rust or corrosion.

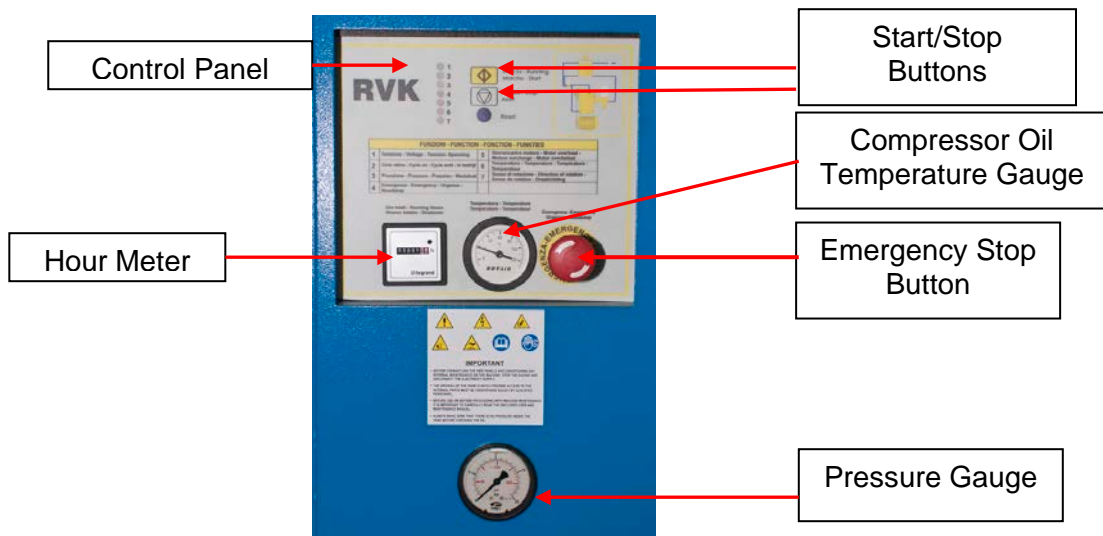
7.0 System Components

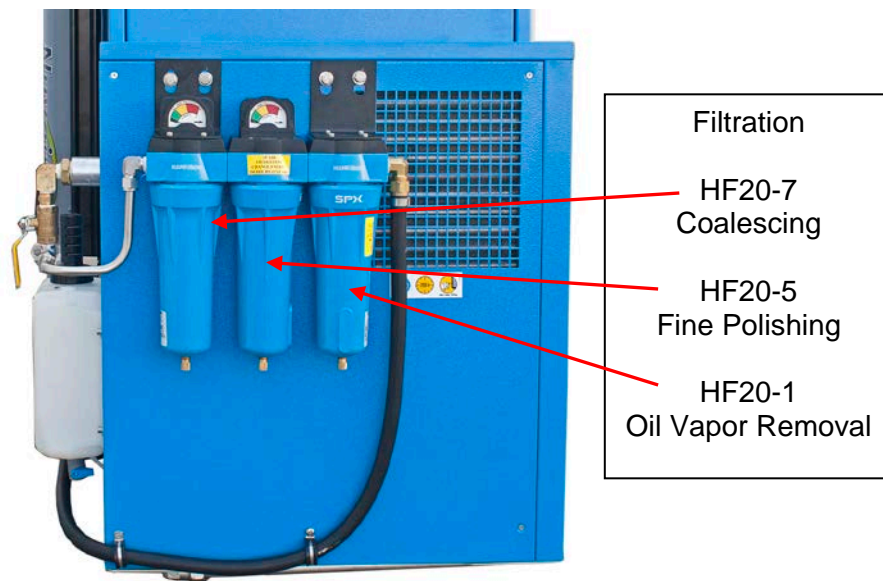
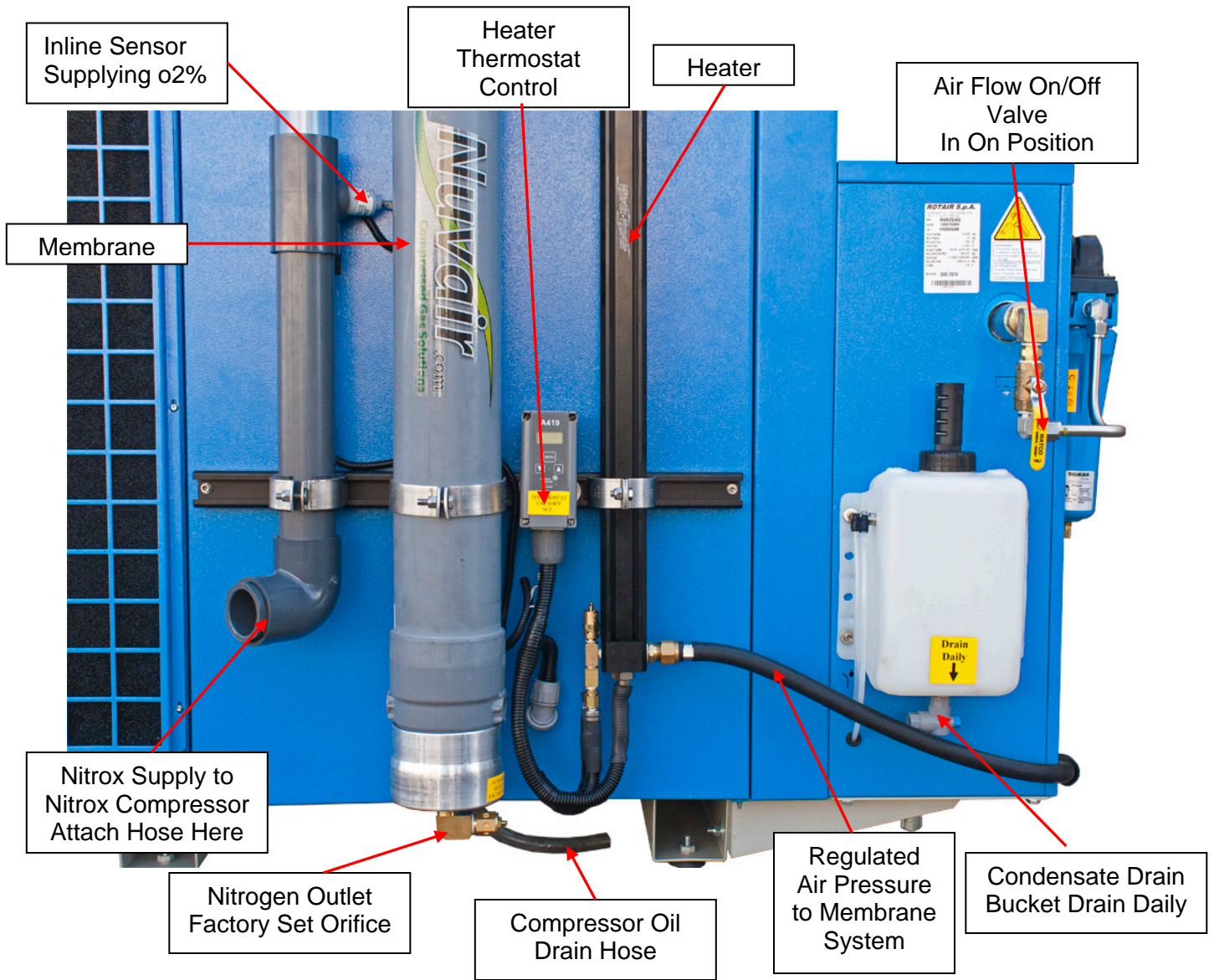
- ◆ Low Pressure Rotary Screw Compressor
- ◆ Refrigerated Air Dyer
- ◆ Nuvair 546™ Food Grade Rotary Screw Compressor Lubricant
- ◆ On/Off Flow Valve
- ◆ L.P. Compressor Output Regulator with Pressure Gauge:
 - ◆ Adjusted Pressure Output 90-175 P.S.I. (6-12 bar) depending on Nitrox %O₂
- ◆ Low Pressure Filtration, Grade D Breathing Air, including three stages:
 - ◆ Coalescing & Particle Removal to 1 micron, auto drain, differential pressure indicator
 - ◆ Water & Oil Vapor Removal to 0.01 micron, auto drain, differential pressure indicator
 - ◆ Oil Vapor Removal to 0.003 PPM, manual drain
- ◆ Heater including:
 - ◆ Thermostat Control
 - ◆ Digital Temperature Gauge
 - ◆ Pressure Switch
 - ◆ Semi-Permeable Membrane – compatible with H.P. compressors rated up to 15 cfm (420 L/min)
 - ◆ F.A.D. for 40% O₂ 15 CFM (420 L/min)
 - ◆ F.A.D. for 36% O₂ 19 CFM (530 L/min)
 - ◆ F.A.D. for 32% O₂ 26 CFM (730 L/min)
- ◆ Mixing Tube & Air Intake Filter
- ◆ Nuvair Pro O₂ Remote™ Panel Mount Inline Oxygen Analyzer
- ◆ Compressor Intake Hose for Nitrox Compressor
- ◆ Nitrogen Discharge Hose (optional)
- ◆ Nuvair Pro O₂™ Fill Oxygen Analyzer, including:
 - ◆ High Pressure>Low Pressure Regulator
 - ◆ Flow Restrictor, 1 - 5 L/min
- ◆ Nitrox Compressor Lubricant:
 - ◆ Nuvair 455™ Food Grade Lubricant (standard)
 - ◆ Nuvair 751™ Diester Based Lubricant (optional)
- ◆ High pressure compressor filtration, Grade E breathing air
- ◆ Air/Nitrox Quality Analysis Kit

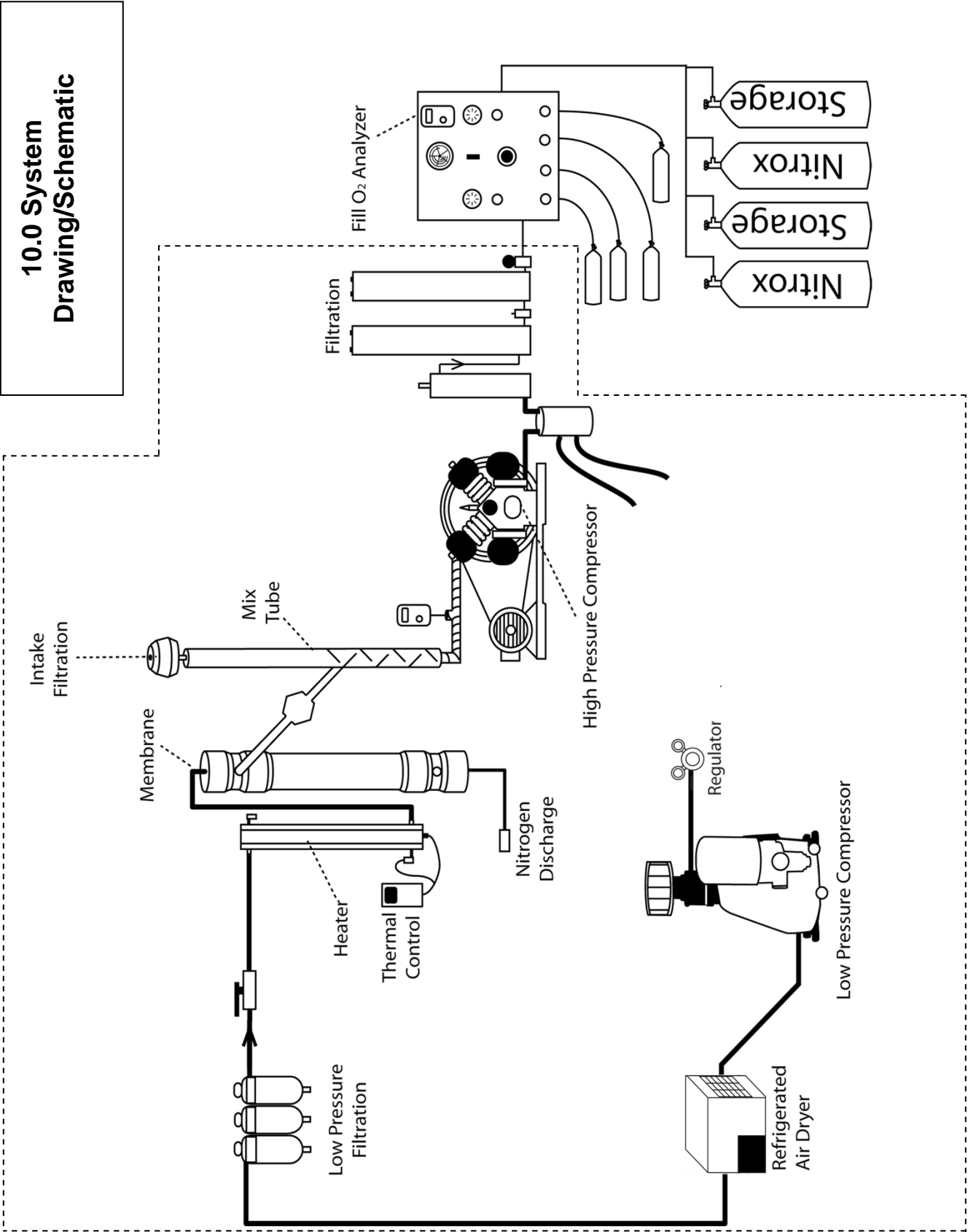
8.0 Nitrox System Specifications

Nuvair Nitrox Generator		Model LP 420
Physical Specifications	Height	76 in (193 cm)
	Width	52 in (132 cm)
	Depth	34 in (86 cm)
	Weight	872 lb (396 kg)
Electrical Specifications	Full Load Amps 440V/E3/50-60 Hz 380V/E3/50 Hz 230V/E3/50-60 Hz	 21A 24A 48A
Membrane Input	Operating Pressure Range	90-175 psi (6-12 bar)
	Maximum Input Pressure	300 psi (20 bar)
	Supply Air Volume Range	10-36scfm (280-1250 L/min)
	LP Supply Air Quality	Grade D
	Optimum Temperature	110 +/- 5°F (43 +/- 3°C)
	Nitrox %O2 Supplied to Compressor	24 - 40%
HP Nitrox Compressor	@40% UP to Charging Rate	15.0 CFM (≤420 L/min)
	@32% Up to Charging Rate	19 CFM (≤530 l/m)
	Horsepower - Electric	5.5-15 hp (4.0-11 kW)
	Horsepower – Gas or Diesel	9-28.5hp

9.0 Component Identification

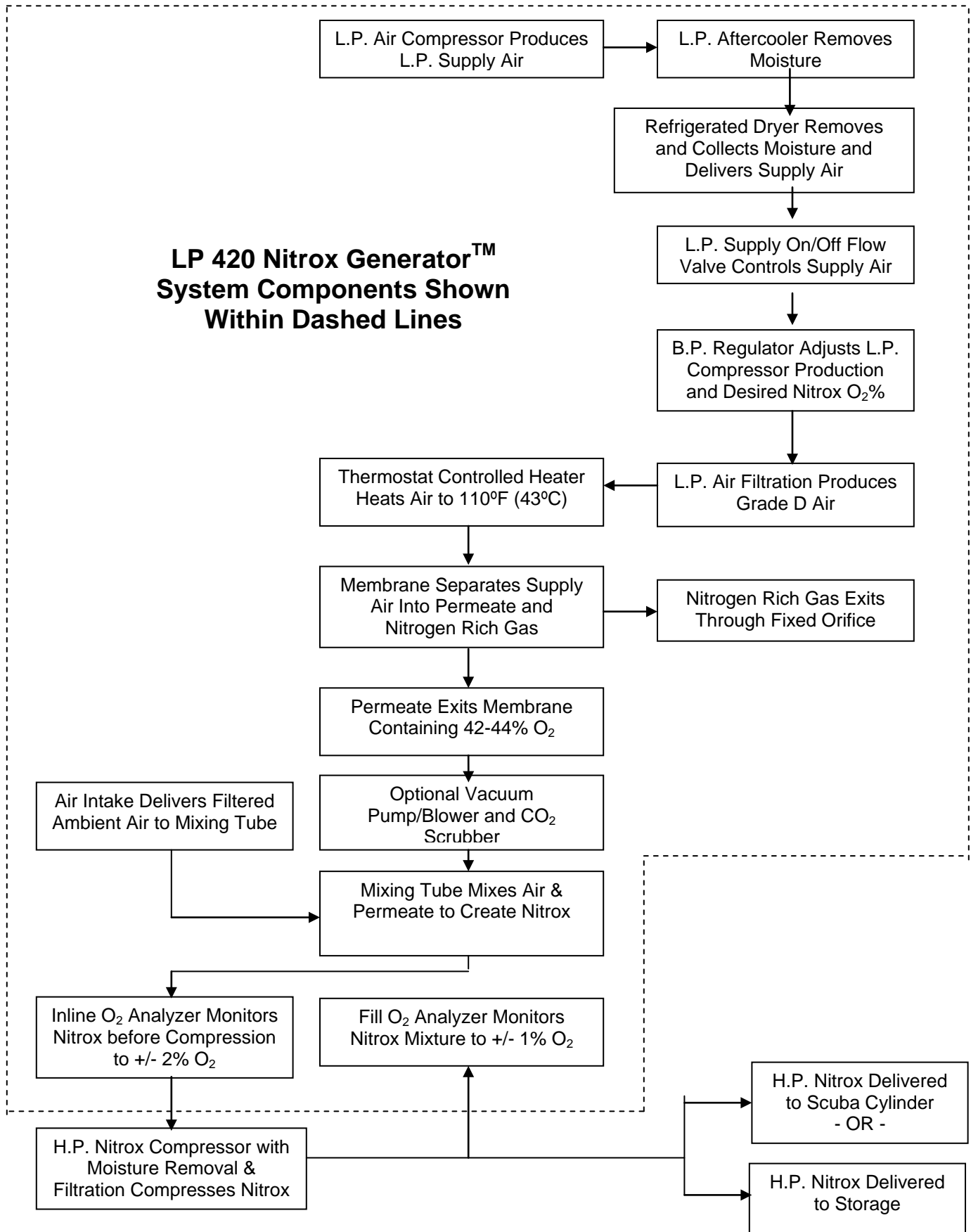






10.0 System Drawing/Schematic

11.0 System Flow Chart



12.0 Preparing Existing HP Compressors



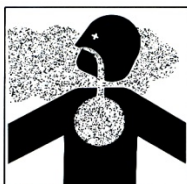
Warning

Some compressors are not suitable for compressing oxygen-rich air, i.e., Nitrox. Use of an unsuitable compressor may lead to possible compressor damage and/or fires or explosion. This can lead to serious personal injury or death. If there is any doubt regarding the use of an existing compressor, contact Nuvaair or the compressor manufacturer before you connect your Nitrox System to your machinery.

12.1 Purification System

The purification system on the existing H.P. compressor to which the Nitrox System will be installed must produce Grade E breathing air appropriate for diving use. This is the same standard applied to all breathing air compressors. Please make sure you place extra caution on timely replacement of the filters in the purification system to ensure these standards at all times. Specifications for Grade E air is provided in the Appendix.

A recent air quality test from your existing Compressor is highly recommended prior to installing the Nitrox System. After installation, test a Nitrox sample using the Air/Nitrox Quality Analysis Kit provided. Quarterly testing is mandatory once the System is operational.



Caution

Breathing air compressors must produce breathing air appropriate for diving use in accordance with the appropriate CGA Grade. Periodic air quality testing is mandatory to assure compliance.

12.2 Replacement of Compressor Lubricant

For an existing Compressor to be used with the Membrane System, all traces of old Lubricant must be removed and replaced with Nitrox Compressor Lubricant. Nitrox Compressor Lubricant is compatible with both air and Nitrox.

- 1) Start Compressor and run for 10 minutes to warm Compressor Lubricant. Shut off Compressor, remove Lubricant, and replace Lubricant Filter if any.
- 2) Refill Compressor with the Nuvaair Air/Nitrox Compressor Lubricant supplied. Do not overfill.
- 3) After 10 hours, repeat Steps 1 and 2.



Nuvaair™ 455
Premium Synthetic
Food Grade Air/Nitrox
Compressor

Nuvaair™ 751
Premium Synthetic
Diester Based
Air/Nitrox



Warning

Any oil spilled during the oil and oil filter change could cause personnel to slip and fall. Wear anti-slip footwear. Remove any traces of spilled oil immediately. Slips and falls may cause severe personal injury or death.

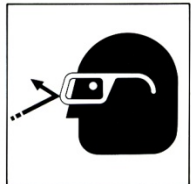


Warning

Do not carry out any maintenance tasks if the compressor has just shut down. Wait for the compressor to cool to avoid skin burns.

Notice

Recommended Nitrox Compressor Lubricant change intervals after the 10-hour flush are at 25, 50, and 100 hours. After reaching 100 hrs, change lubricant in 100 hour cycles.



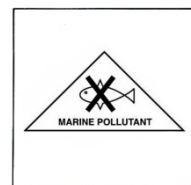
Caution

Wear eye protection, gloves, and skin protection when performing oil changes. Although the oil is not classified as a dangerous substance, the oil can be irritating to your eyes and skin.



Warning

Use only the specified Nuvair lubricants in this system. The use of incompatible lubricants presents a risk of fire and/or explosion, and may result in system damage. This can lead to severe personal injury or death.



Caution

Both oil and oil filter are classified as “special wastes” and must be disposed of properly according to applicable national and local laws. Failure to dispose of these wastes properly can lead to death of wildlife as well as government

fines and penalties.

12.3 Installation of Fill Oxygen Analyzer

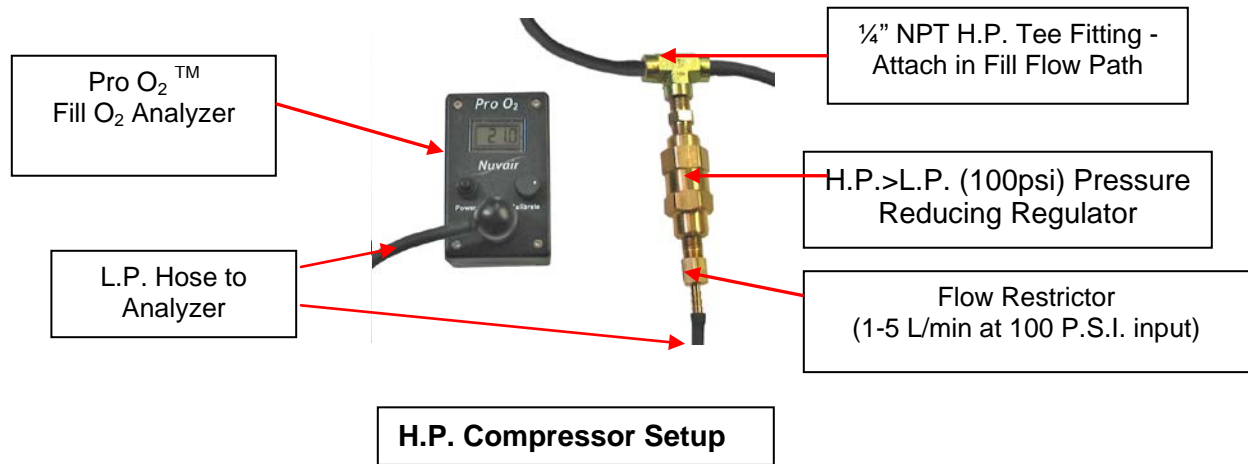
The Fill Oxygen Analyzer is installed where the Nitrox is pumped (Compressor Fill Whip, Fill Panel, etc.) to monitor the final oxygen content. A sample stream of Nitrox is delivered to the Analyzer to provide accurate results and prevent damage to the Analyzer. A Regulator and Flow Restrictor are used to control the pressure and flow of the sample stream. After installation, always use the Fill Oxygen Analyzer when pumping Nitrox to ensure proper oxygen content.

Warning

Never expose the Oxygen Analyzer sensor to pressures other than ambient or you may damage it and/or cause false readings. A damaged sensor will not provide accurate gas analysis. Inaccurate gas analysis can lead to serious personal injury or death when the gas mixture that was analyzed is used for breathing.

The Nitrox sample stream is obtained at the Fill Whip location on the Compressor or Fill Panel. Tap into the Fill Whip manifold or install a H.P. “T” fitting, then attach the inlet of the Regulator/Flow Restrictor Assembly using H.P. hose and fittings as required (hose and fittings not included).

Mount the Fill Oxygen Analyzer in a secure location, then attach the outlet of the Regulator/Flow Restrictor Assembly to the Analyzer using the hose provided.



⚠ Notice

If any information in this manual conflicts with any of the other manuals call our headquarters at 805-815-4044 before proceeding.

13.0 Installing the Nitrox System

13.1 Precautions

- 1) Please read all information supplied before physically installing the Nitrox System.
- 2) Unpack the system and remove from the pallet. Visually inspect the system to make sure there has been no damage during shipping. If damaged, please call Nuvair to file a damage report. Please take photos and supply detailed information about the damage.
- 3) Place the system in a permanent location near the existing HP Compressor. Allow a minimum spacing of 18" from adjacent walls. Select a location where ambient room temperature will never exceed 105°F (40°C).
- 4) The Heater Thermostat has been set in the factory. Do not adjust.
- 5) A 13 foot corrugated Compressor Intake Hose has been provided to connect the Nitrox System to the HP Compressor intake. If a longer hose is required, the diameter must also be increased. Contact Nuvair for assistance.

13.2 Attaching Compressor Intake Hose

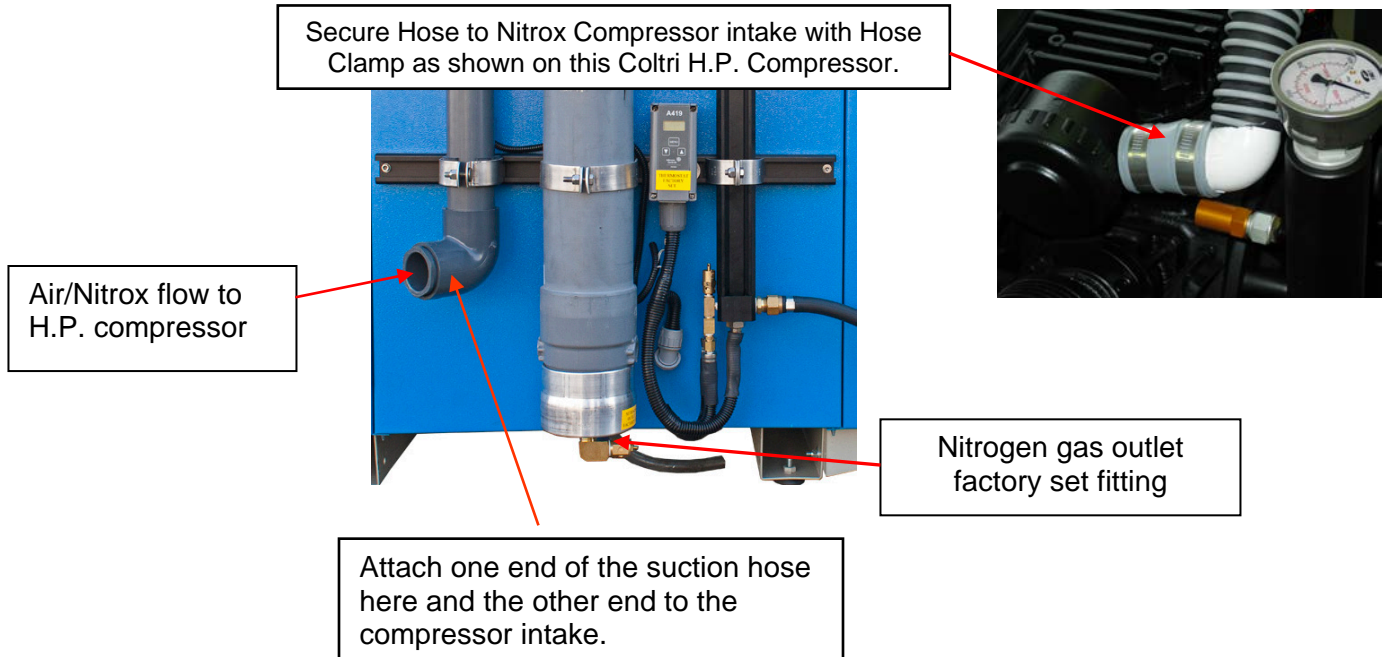
- 1) Only use the corrugated Compressor Intake Hose provided with the Nitrox System. If a longer hose is required, contact Nuvair for assistance.
- 2) Cut the Intake Hose to proper length to reach between the Nitrox System and HP Compressor. Reattach end fittings
- 3) Attach the Intake Hose to the Membrane System outlet.
- 4) Attach the other end of the Intake Hose to the intake of the HP Compressor and secure with the hose clamp provided.

⚠ Caution

Do not use a compressor Intake Hose longer than 13 feet to connect the Nitrox System to the compressor intake. Use of a longer hose will increase the amount of suction the compressor must generate which can cause overheating and damage to the compressor. Damaged compressors can pump impurities into the diver's breathing gas.

! Caution

Do not substitute a compressor intake hose of a smaller diameter than the supplied by NuVair. Use of a smaller diameter hose will increase the amount of suction the compressor must generate which can cause overheating and damage to the compressor. Damaged compressors can pump impurities into the diver's breathing gas.



13.3 Attaching Nitrogen Discharge Hose (Optional)

The nitrogen discharge from the Membrane must be isolated from the air intakes of the Membrane System and L.P. Compressor. This requirement will be met if the Nitrox System is installed in a well-ventilated room that meets industry standards for Compressor installations. If the Nitrox System is installed in a closed building, boat, or similar enclosed space, the nitrogen discharge must be vented to the outside. An optional Nitrogen Discharge Hose may be needed. If your installation requires the use of a Nitrogen Discharge Hose, please contact NuVair for assistance.



! Warning

Pure nitrogen is a colorless, odorless, tasteless gas that will not support life. Breathing gas mixtures containing more than 84% nitrogen at surface pressures will lead to unconsciousness and may cause death.



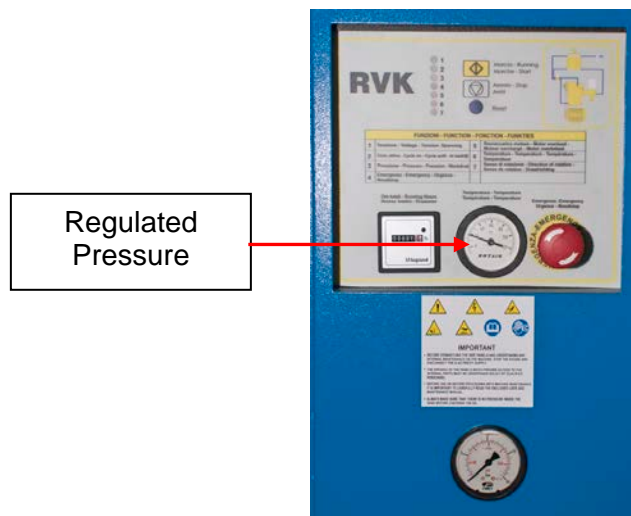
! Warning

The nitrogen discharge from the membrane should be vented to a well-ventilated room or to open air with good circulation. Failure to isolate the discharge from the air intake of the membrane system or L.P. compressor could lead to incorrect nitrox mixtures, resulting in serious personal injury or death. If you allow this pure nitrogen to accumulate in an enclosed space, anyone entering this space will quickly lose consciousness and will die if not immediately resuscitated.

13.4 Output Pressure Adjustments

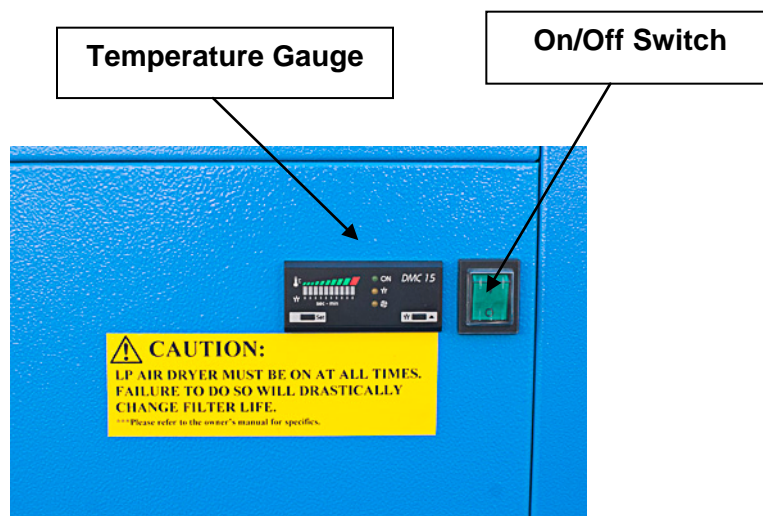
The L.P. compressor output is adjusted with the control regulator located on top. The control regulator can be used to adjust the output pressure from 90-175 PSI (6-12 bar).

This output adjustment allows the system to be used with a H.P. compressor having a rated capacity up to (see page12). If your H.P. compressor is smaller, the inlet pressures required for the Membrane System may be lower.



13.5 Refrigerated Air Drier

1. It is best to leave the drier on at all times. If your application requires turning the drier off when not in use, turn the drier on at least 1 hour before using.
2. Check that during operation the temperature gauge is operating in the green.
3. Listen for the solenoid valve opening and draining condensate every 5 minutes or less.
4. L.P. filter life may change drastically if the drier is not operating properly.



13.6 Electrical Power Connection

Electrical wiring and connections should be made by a qualified electrician in accordance with all national and local electrical codes. Check all System Specifications provided in this manual.

Do not use extension cords.

Amperage Load for System

440 V 21Amp
380 V 24 Amp
230V 48 Amp

Note Proper Direction of Rotation



L.P. Compressor Rotation Check

Always turn on (bump) starter and run motor very briefly to check for proper direction of rotation before operating the compressor initially. (see arrow above pulley).

⚠ Notice

Operation in reverse direction for extended periods of time will cause a reciprocating compressor to run hot and perform poorly and may cause permanent damage. Reverse rotation for a rotary screw compressor for even a short period of time will cause damage.



⚠ Warning

Never use extension cords to provide power to your nitrox system. The system must be properly wired according to national and local electrical codes by a qualified electrician. Improper wiring may lead to fires, which can cause serious personal injury or death.

The cabinet power switch must be in the off position to remove the front panel of the compressor. This switch terminates power to the compressor and electrical panel. Store the compressor with this switch in the off position. **When working on the compressor the main breaker at the power source must be "locked out" and "tagged out" in the "Off" position.** The Nitrox System has circuit breaker protection for the compressor motor and Membrane System heater located behind the front panel.



Electrical Box
Located on right side behind panel.



Emergency Shut Down Switch

Adjusted Pressure

14.0 Pre-Operation Instructions



Warning

Do not allow nitrox to be discharged into the air storage system. Nitrox introduced into the air storage system could cause a diver to suffer from oxygen poisoning at depth. Oxygen poisoning is extremely dangerous and can lead to death by drowning.

Warning

Do not allow air to be discharged into the nitrox storage system. Air introduced into the nitrox storage system could cause a diver to suffer decompression sickness if the nitrox mixture is not analyzed properly and is used underwater under the assumption it is a different mix.

14.1 Compressor Oil Levels

Check oil levels before starting the L.P. and H.P. Compressors, and add lubricant as required. Use only the specified lubricants in section 17.3.

Check LP
Compressor
Oil Level

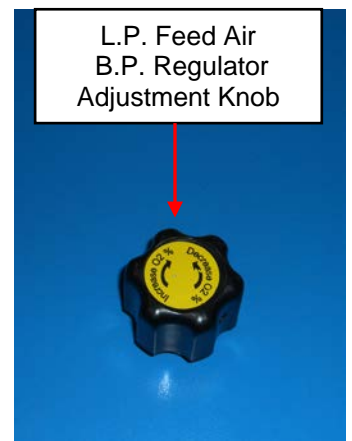


14.2 Membrane System Feed Air Regulator and Flow Valve

A low pressure feed air regulator is used to reduce supply pressure to the Membrane System to a typical range of 90–175 P.S.I. (6-12 bar). An On/Off Flow Valve is used to control the flow of L.P. supply air into the Membrane System. Prepare the Membrane System as follows:

- 1) Reduce input pressure to minimum pressure setting by turning the B.P. regulator adjustment knob counter-clockwise (CCW) until it spins freely.
- 2) Turn B.P. regulator knob clockwise (CW) until you first feel resistance, which means that the spring is starting to compress.
- 3) Make sure the ON/OFF feed air supply valve is in the off position.

L.P. Feed Air
B.P. Regulator
Adjustment Knob

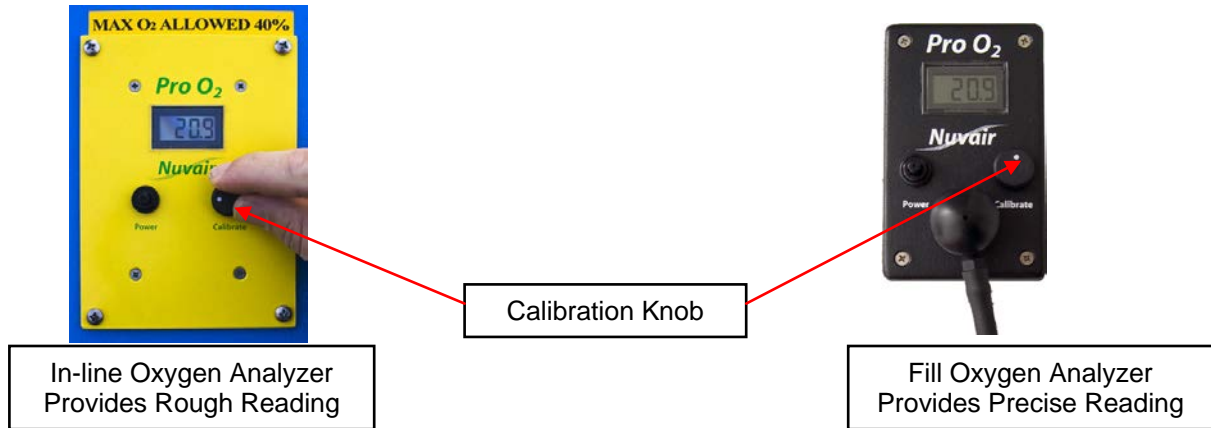


On/Off Flow Valve
Handle in On Position



14.3 Oxygen Analyzer Calibration

Gas production is monitored with the permeate oxygen analyzer before the compressed gas enters the H.P. compressor to obtain a rough estimate of O₂% (+/- 2%). Do not rely on this reading as a proper indication of percentage of oxygen at the H.P. compressor outlet. Prior to pumping nitrox from the compressor, it must be monitored with the fill oxygen analyzer to obtain a precise measurement of O₂% (+/- 1%). **Both oxygen analyzers must be calibrated prior to each use.**



Warning

Oxygen Analyzers must be calibrated before each use. See Oxygen Analyzer manuals for correct calibration procedures. Improper calibration of the Fill Oxygen Analyzer may result in the use of incorrect nitrox mixtures, which may cause serious injury or death to the diver using the gas mixture.

Warning

At altitudes above sea level, a correction factor must be used when calibrating the fill oxygen analyzer. It may not be possible to achieve all desired mixtures at altitude. See fill oxygen analyzer manual for correcting analyzer readings at various altitudes. Improper calibration of the fill oxygen analyzer may result in the use of incorrect nitrox mixtures, which may cause serious injury or death to the diver using the gas mixture.

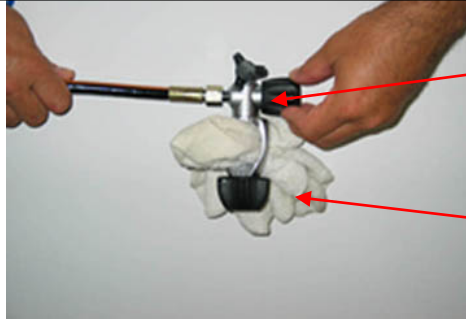
Warning

The permeate oxygen analyzer supplies oxygen readings that can vary +/- 2% O₂ due to heat, humidity, and pressure changes experienced in the nitrox flow and therefore should only be used for rough estimates of O₂%. The fill oxygen analyzer supplies more accurate oxygen readings, within +/- 1% O₂. For cylinder nitrox fills, the user must always verify the final fill with a third independent oxygen analyzer.

14.3 continued - Calibrate Oxygen Analyzers as follows:

- 1) Turn on the high pressure compressor and allow to run for 1-2 minutes or until analyzers stabilize.
- 2) Crack open the bleed valve on the side of the compressor so that the running H.P. compressor maintains 1500-2000 P.S.I. (100-136 bar) outlet pressure. Air will now be flowing past both oxygen analyzers for calibration purposes.
- 3) Monitor all gauges for proper operating range and check all connections for leaks.
- 4) Calibrate oxygen analyzers while the H.P. compressor is pumping air. Refer to the oxygen analyzer manual included with the nitrox generator for details. Note that special calibration procedures may be required when operating at altitudes above sea level.

Optional Sound Muffler for H.P. Nitrox Compressor



Adjust Fill Whip Valve to Maintain Pressure

Insert Clean Rag in Fill Whip Yoke

- 5) Fill oxygen analyzer – Turn calibration knob so display reads 20.9%.
 - a. Fill oxygen analyzer – Remove the flow adapter cap covering the sensor.
 - b. Expose the sensor to ambient air for approximately 15 seconds.
 - c. Adjust calibration knob until display reading stabilizes at 20.9%.
 - d. Reinstall the flow adapter cap to the analyzer.
 - e. The fill oxygen analyzer is now ready for use.

Different settings may be used depending on heat; humidity and altitude verify your actual ambient conditions and refer to the oxygen analyzer manual for details.

- 6) Turn on the L.P. compressor and increase the pressure to a minimum of 90 P.S.I.
- 7) Allow the compressors to run for a 10 minute warm up period for the membranes to warm up and stabilize. Check the heater temperature gauge to verify air temperature rises and is between 105-120 °F (40-49 °C).
- 8) Now that the system temperature has stabilized, you must recalibrate the fill O₂ analyzer. See step (5a) above for calibration.

Fill O₂ Analyzer

Sensor cap

Calibration knob

⚠ Notice

The oxygen analyzers may require re-calibration after 10-20 minutes of operation due to humidity and temperature change effects on the sensor. To recalibrate, turn off the L.P. feed air and follow calibration instructions.

14.4 Attaching Scuba Cylinder

Notice

Only one fill whip is attached to a Scuba Cylinder at this point. The second whip will continue to be used to control H.P. Compressor outlet pressure.

1. Attach a H.P. compressor fill whip to a scuba cylinder. Leave the cylinder valve closed.
2. Additional cylinders or storage tanks can be attached after pre-operation is complete.



Fill Whip Attached to Scuba Cylinder

Notice

High-pressure cylinders that are filled quickly will become hot and due to the increased internal temperature the cylinder pressure will increase. This will leave a diver with less pressure inside the cylinder once cooling has occurred. This will decrease the amount of time the diver may spend underwater which may be critical during a deep dive. Customers must be warned of this possibility if cylinders are delivered for use while warm. Always fill all breathing gas cylinders slowly to avoid overheating.

15.0 Producing Nitrox

Before using your nitrox system to pump nitrox, test a sample of the nitrox produced using the air/nitrox quality analysis kit provided to verify compliance with CGA standards or applicable standards for intended use. Quarterly testing is mandatory once the system is operational.

Warning

The equipment you will be using to manufacture nitrox (oxygen rich air) will expose you to both low and high-pressure gas. Gas, even under moderate pressures, can cause extreme bodily harm. Never allow any gas stream to be directed at any part of your body.

Notice

Do not change the temperature setting on the thermostat control without contacting Nuair. Changes in temperature settings may cause membrane damage. A damaged membrane will not produce the correct nitrox mixture which can lead to severe personal injury if the gas is used for diving purposes without proper analysis.

15.1 Flow to Membrane

- 1) Verify that Oxygen Analyzer calibration is complete.
- 2) Check that On/Off Feed Valve is in the Off position.
- 3) Turn on L.P. Compressor using On/Off Switch and allow system to build up pressure until it unloads
- 4) Turn on your H.P. compressor. Allow outlet pressure to build up to approximately 2300 P.S.I., then crack open the **unconnected** fill whip to maintain 1500-2300 P.S.I.
- 5) Verify that Inline oxygen analyzer reads 20.9%.
- 6) Turn on Membrane System by slowly opening the On/Off Flow Valve.
- 7) Adjust input pressure to approximately 100 P.S.I to activate Heater Pressure Switch. Increase pressure by slowly turning the B.P. regulator knob clockwise or decrease pressure by turning the B.P. knob counter clockwise.
- 8) Verify that heater thermostat control green indicator light is on. The light will remain on until operating temperature is reached and will then cycle on and off. When light turns off, check Heater Temperature Gauge to verify air temperature is between 105-120°F (40 -49°C). Temperature is preset at the factory and changes to the thermostat control should not be required.

LP Compressor On/Off Switch

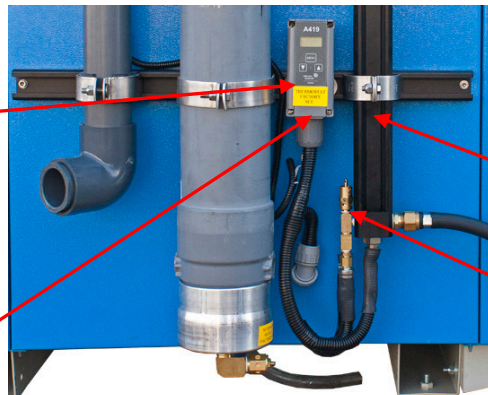


Regulated Pressure Gauge

B.P. Regulator Adjustment Knob



Heater Temperature Gauge



Heater

Heater Thermostat Control

Safety Pressure Switch



On/Off Flow Valve Handle in On Position

⚠ Caution

The On/Off Flow Valve on the Nitrox Membrane System must be opened slowly. A sudden rush of gas can damage the Membrane and other system components.

⚠ Notice

The Heater Thermostat Control green indicator light will stay on until operating temperature is reached.

15.2 Setting Proper Pressure

The input pressure to the Membrane System determines the %O₂ of the Nitrox mixture produced. As input pressure is increased, a higher %O₂ Nitrox is pumped. As pressure is decreased, a lower %O₂ Nitrox is pumped.

- 1) Increase input pressure by slowly turning the Regulator knob clock wise while monitoring the Pressure Gauges and Inline Oxygen Analyzer. As the pressure rises, watch the corresponding increase in the Analyzer %O₂ reading.
- 2) Increase or decrease pressure slowly until the Inline Oxygen Analyzer displays the %O₂ desired in the final Nitrox mixture.
- 3) Allow system pressure and temperature to stabilize (approximately 5-8 minutes).
 - ◆ Regulated Membrane System pressure range should be 90– 175 P.S.I (6-12 bar), depending on Nitrox %O₂ being produced.
 - ◆ Heater temperature range should be 105-120 °F (40-49 °C).



Inline Oxygen Analyzer



Regulated Pressure Gauge

15.3 Final Adjustments Before Pumping Nitrox

- 1) As the Nitrox initially makes its way through the running Nitrox Compressor, the %O₂ reading on the Fill Oxygen Analyzer will slowly increase to read approximately the same %O₂ as the Inline Oxygen Analyzer. This should happen within 3-5 minutes.
- 2) When the two Analyzers read within +/- 1%, make any final adjustments to the Membrane System input pressure necessary to obtain the exact Nitrox %O₂ desired as indicated on the Fill Oxygen Analyzer.
- 3) The system is now ready to pump Nitrox.



Fill Oxygen Analyzer

15.4 Producing Nitrox

 **Warning**

The use of enriched air nitrox does not eliminate the risk of decompression sickness (DCS) in diving. Decompression sickness can lead to permanent disability or death.

 **Warning**

The permeate O₂ analyzer supplies oxygen readings that can vary +/- 2% O₂ due to heat, humidity, and pressure changes in the nitrox flow and should only be used for rough estimates of O₂%. The fill O₂ analyzer supplies more accurate readings, within +/- 1% O₂. For scuba cylinder fills, the user must always verify the fill with a third independent O₂ analyzer.

 **Warning**

Do not use this system to produce nitrox mixtures containing more than 40% oxygen. Pumping nitrox mixtures with higher concentrations of oxygen may lead to fires or explosions, which can cause serious personal injury or death.

 **Warning**

Do not pump nitrox mixtures at pressures above the H.P. compressor rating, and never above 3600 P.S.I. (250 bar). The system is not rated for pressures above 3600 P.S.I. (250 bar). Higher pressures may lead to explosions which may cause serious personal injury or death.

 **Notice**

No oxygen cleaning of standard cylinders or plumbing is mandatory when using the nitrox system to produce nitrox containing a maximum of 40% oxygen. When filling oxygen clean cylinders, hyper-purification of the nitrox is required using an optional oxygen compatible air purification system available from Nuair.

 **Warning**

This nitrox system does not produce nitrox mixtures acceptable for 100% oxygen service. Mixing nitrox mixtures with 100% pure oxygen may lead to fires and / or explosions, which may cause serious personal injury or death.

 **Warning**

Never fill a cylinder that is marked, "For Oxygen Service," with nitrox that has been produced by anything other than 100% oxygen clean system. Filling an oxygen clean cylinder with breathing gas containing hydrocarbons can lead to explosions if the cylinder is subsequently filled with gas mixtures containing gas mixtures containing greater than 40% oxygen. Explosions may cause serious injury or death.

Warning

Only provide scuba cylinder nitrox fills to customers who have proof of nitrox training and certification. Improper use of nitrox can cause severe personal injury or death.



Danger

This system is not cleaned for oxygen service and not all components are compatible with gas mixtures containing greater than 40% oxygen. Pumping gas mixtures containing greater than 40% oxygen will lead to explosions which may cause severe personal injury or death.

Warning

Each scuba cylinder belonging to a customer must be analyzed by that customer at the nitrox filling facility, using an oxygen analyzer independent of those used with the nitrox system. An employee must witness that the customer has properly analyzed the gas in each cylinder, noted the maximum operating depth for that mixture, and signed and dated the fill log. The time of day must also be included with the date, since some customers may fill the same cylinder more than once a day.

Pump Nitrox as follows:

- 1) When filling a scuba cylinder, follow all industry standards. Do not exceed rated pressure of cylinder, and do not exceed 3600 P.S.I. (250 bar) under any condition.
- 2) With fill whip bleed valve open and nitrox flowing, verify that fill oxygen analyzer O₂% reading equals the desired nitrox O₂%.
- 3) Close bleed valve, open cylinder valve, and fill cylinder. Monitor system for proper operation:
 - a) Monitor oxygen analyzers and recalibrate as required
 - b) Listen for proper operation of automatic condensate drains every 10-15 minutes.
 - c) Monitor all system gauges as shown in the table below.

Notice

The Oxygen Analyzers may require re-calibration after 10-20 minutes of operation due to humidity and temperature change effects on the Sensor. To recalibrate, turn off the L.P. feed air switch and follow calibration instructions.

Notice

When the H.P. compressor auto drain engages and dumps condensate, the fill oxygen analyzer reading will decrease momentarily due to the pressure drop in the system. It will return to its previous reading within seconds after the auto drain sequence stops.

GAUGE	RECOMMENDED SETTING
Compressor Gauges	According to manufacturers recommendations
Heater Temperature	105 - 120° F (40 - 49° C)
Cabinet Temperature	Less than 100° F (38° C)
Membrane Feed Air Pressure	90 – 175 P.S.I. (6 - 12 bar) depending on Nitrox O ₂ %
Fill Oxygen Analyzer	Showing the proper reading for intended fill
Nitrox Storage Pressure	DO NOT exceed rating of tank or 3600 P.S.I (250 bar)

- 4) After filling is complete, close the cylinder valve, vent the bleed valve, and remove the cylinder.
- 5) Test the nitrox O₂% in the cylinder using an independent oxygen analyzer such as the Nuair O₂ Quickstick™. Calibrate the analyzer before use in accordance with manufacturer's instructions.
- 6) Repeat steps 1-5 until you have filled all scuba cylinders.
- 7) Mark each tank with fill date, O₂%, fill pressure, and M.O.D. (Maximum Operating Depth).
- 8) Log every nitrox fill to document the following information:
 - Fill date and time of day
 - Tank serial number
 - Supplier checks oxygen content (O₂%) adds signature and date
 - User checks oxygen content (O₂%) adds signature and date
 - Fill pressure is noted
 - M.O.D. (Maximum Operating Depth) is noted by user in their handwriting
 - Nitrox certifying agency and card number is noted
- 9) When filling a H.P. nitrox storage tank, verify that fill oxygen analyzer O₂% reading equals the desired nitrox O₂%. Open applicable line valves and tank valve, and fill with nitrox. Do not exceed rated pressure of cylinder, and do not exceed 3600 P.S.I. (250 bar) under any condition. After filling is complete, close all valves and allow nitrox system to shut down.



Use independent oxygen analyzer for verification

Notice

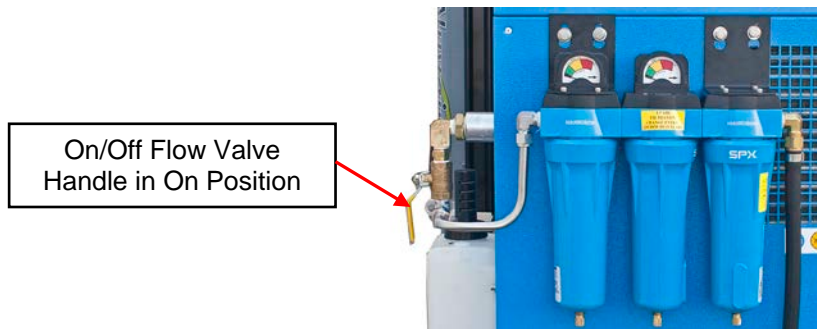
High-pressure cylinders that are filled quickly will become hot and due to the increased internal temperature the cylinder pressure will increase. This will leave a diver with less pressure inside the cylinder once cooling has occurred. This will decrease the amount of time the diver may spend underwater which may be critical during a deep dive. Customers must be warned of this possibility if cylinders are delivered for use while warm. Always fill all breathing gas cylinders slowly to avoid overheating.

Notice

Always use Oxygen Analyzers to monitor oxygen content of any gas flowing through the system. Both air and nitrox are subject to variations in oxygen content.

15.5 Pumping Air

To use the system to pump air, simply move the On/Off flow valve to the off position. No nitrox will be supplied to the H.P. compressor, and it will pump air only. When the H.P. compressor is pumping air, the permeate oxygen analyzer and the fill oxygen analyzer should both read 20.9% O₂.



Notice

Always use Oxygen Analyzers to monitor oxygen content of any gas flowing through the System. Both air and Nitrox are subject to variations in oxygen content.

15.6 Shutting Down

- 1) Shut off the Nitrox Membrane System by turning the regulator adjustment knob counter clockwise to reduce input pressure to minimum setting and then closing the on/off flow valve.
- 2) Manually drain all filter, compressor, and optional volume tank condensate drains.
- 3) Turn off L.P. compressor on/off switch. The compressor will go into shut down mode.
- 4) Turn off H.P. compressor when it has returned to pumping air, as determined by a fill Oxygen Analyzer reading close to 20.9% O₂.

16 Nitrox Operation Notes

- Ensure all personnel who operate the system are properly trained in its use.
- Keep a log with details of each cylinder filled with nitrox, including the time and date, name of operator of system, name and certification number of diver, gas analysis, MOD, and cylinder pressure.

16.1 Correlation of Feed Air Pressure to Oxygen Content

After the 10 hour break-in period for your nitrox system, you will notice that specific nitrox oxygen percentages always match specific feed air pressures once the system has warmed up. These pressures and percentages will be repeatable. If you find that the fill oxygen analyzer reads 36% O₂ when the feed air pressure is at 125 P.S.I. (9 bar), record this pressure or make a mark on the feed air pressure gauge indicating the O₂%. Do this for each O₂% that you normally make, making sure system has warmed up first. The next time nitrox with 36% O₂ is needed, adjust the regulator to 125 P.S.I. (9 bar) and wait for the oxygen analyzer reading to stabilize. You will find the analyzer reading to be very close to 36% O₂, requiring only minor adjustments of the regulator to achieve the exact desired O₂%.

Notice

Use the fill oxygen analyzer to verify the nitrox oxygen percentage prior to pumping. When using the feed air pressure reading to obtain specific oxygen percentage, minor adjustments of the feed air pressure regulator may be required to obtain the exact percentage desired.

16.2 Hot Fills

While in the process of filling H.P. nitrox storage tanks, you may have a need to supply a walk-in customer with a scuba cylinder fill of a different nitrox mix. You can change mixes as follows:

- 1) With the nitrox system operating, isolate the H.P. nitrox storage tanks from the H.P. compressor by closing the appropriate valves.
- 2) Record the membrane system feed air pressure reading.
- 3) Slightly open fill whip valve on the H.P. compressor, and adjust so the running compressor maintains 1500-2000 P.S.I. (100-136 bar) outlet pressure.
- 4) Adjust the backpressure feed air regulator to the pressure corresponding to the desired nitrox O₂% for the scuba cylinder fill.
- 5) Allow the fill oxygen analyzer reading to stabilize, make any minor adjustments necessary to achieve the desired O₂%, and then fill cylinder in normal manner.

When finished return regulator to previous setting, and allow the fill oxygen analyzer reading to stabilize. Make any minor adjustments necessary to achieve the desired O₂%, and then resume filling storage tanks.

17 Maintenance

The following list of daily and routine maintenance items is intended as a guide. Refer to L.P. and H.P. Compressor manuals for complete maintenance requirements.

17.1 Daily Maintenance

Caution

Be sure to check compressor lubricant levels prior to each day of operation. Failure to ensure the proper lubricant level will lead to system damage.

- 1) Check Lubricant levels of both L.P. and H.P. compressors and add proper Lubricants as required. See Section 17.3 and compressor manuals for details.
- 2) Check H.P. compressor filtration for condensate and proper operation of condensate drains. Refer to H.P. compressor manual for details.
- 3) Check L.P. filtration for condensate and proper operation of condensate drains.

17.2 Routine Maintenance



Warning

Use only the specified Nuvair lubricants in this system. The use of incompatible lubricants presents a risk of fire and/or explosion, and may result in system damage. This can lead to severe personal injury and death.



Warning

Be sure that all pressure has been relieved from the system prior to opening any filtration canister. Failure to vent pressure from the system prior to opening the canister can lead to serious personal injury or death.

Caution

If system is located in an area where there is high humidity and high heat, the life of all filtration elements may be as little as 35% of rated operating capacity. Check the compressor manual and appendix for details on filter element life factors.

- 1) L.P. Compressor Lubricant: Change compressor lubricant after 50 hours and then every 1000 hours or annually. Only use lubricants rated for use with nitrox, such as Nuvair 546™. Never mix compressor lubricants. See Section 17.3 and L.P. compressor manual for details.
- 2) L.P. Air Filtration Inspection: On a weekly basis, inspect each filter bowl for the presence of moisture and each element for any unusual degradation or wetness. See section 17.4 for details

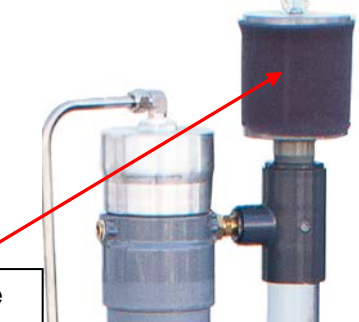
⚠ Caution

Special attention needs to be given to the arrangement of the four L.P. Air Filtration Elements and Bowls. Properly reinstall each Element and Bowl to the correct Housing. Improper sequence can cause damage to downstream components.

- 3) L.P. Air Filtration Elements: Change L.P. filter elements every 500 hours or annually to maintain CGA Grade D air standards. Visual liquid level and differential pressure indicators assist with monitoring replacement intervals. See Section 17.4 for details. If the nitrox system is operated in high humidity and/or high temperature, filter elements must be changed more often. See appendix for details on filter element life factors.
- 4) Semi-Permeable Membrane: No maintenance required. Service life exceeds 20 years if L.P. air filtration is properly serviced to maintain oil free Grade D air standards.
- 5) Membrane System Air Intake Filter: Inspect filter element every 3 months for visible particles. Change every 12 months or sooner if particles are visible.
- 6) Oxygen Analyzers: Replace oxygen sensor and battery as required. See separate manual included with Nitrox System.



DP Indicator Changes from Green to Red as Filter Ages. Do Not Use When Red.



Air Intake Filter

⚠ Danger

Do not swallow (ingest) either the electrolyte from the oxygen sensor or the sensor itself. The Potassium Hydroxide chemical contained in the sensor can cause severe injury or death. If electrolyte or the Sensor is swallowed, seek medical attention immediately.



⚠ Danger

If after handling the oxygen analyzer or sensor, you find that your fingers or other parts of your body feel “slippery” or the skin or eyes sting, immediately flush affected area with clean, fresh water for at least 15 minutes. The stinging or slippery sensation is an indication of a leaking Sensor. The Potassium Hydroxide chemical contained in the sensor can cause severe injury or death. Seek immediate medical attention if eye contact is made or skin stinging persists.

17.3 L.P. Compressor Lubricant

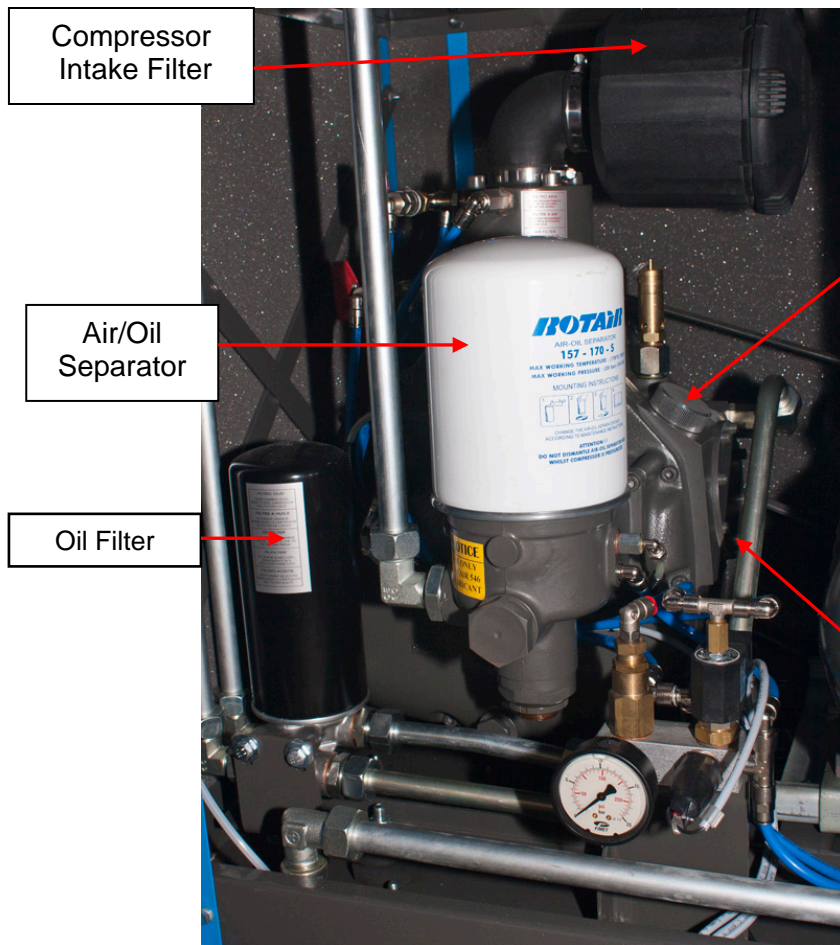


Warning

Use only the specified Nuvair lubricants in this system. The use of incompatible lubricants presents a risk of fire and/or explosion, and may result in system damage. This can lead to severe personal injury or death.

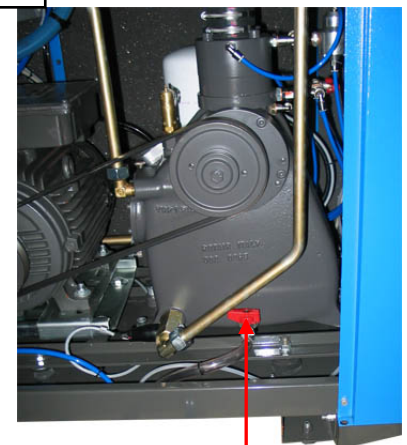
The following items are not integral parts of the Nitrox System, but proper maintenance is required to assure optimum performance.

- 1) H.P. Compressor Lubricant: Change H.P. compressor lubricant every 100 hours of operation in accordance with manufacturer's guidelines. Only use Lubricants rated for use with Nitrox, such as Nuvair 455™ or 751™. Never mix compressor lubricants. Refer to H.P. compressor manual for details.
- 2) Breathing Air Filters: Change H.P. compressor filter elements in accordance with manufacturer's guidelines to maintain CGA Grade E breathing air standards.
- 3) Air/Nitrox Quality Analysis: Take breathing air/Nitrox samples quarterly for analysis to assure compliance with CGA Grade E breathing air standards.



Lubricant Level Dipstick

Lubricant Drains at the rear of compressor



Oil Drain valve is behind pump and requires you to reach around right side to drain. (picture above shows rear panel off for visual reference)

17.3 L.P. Compressor Lubricant

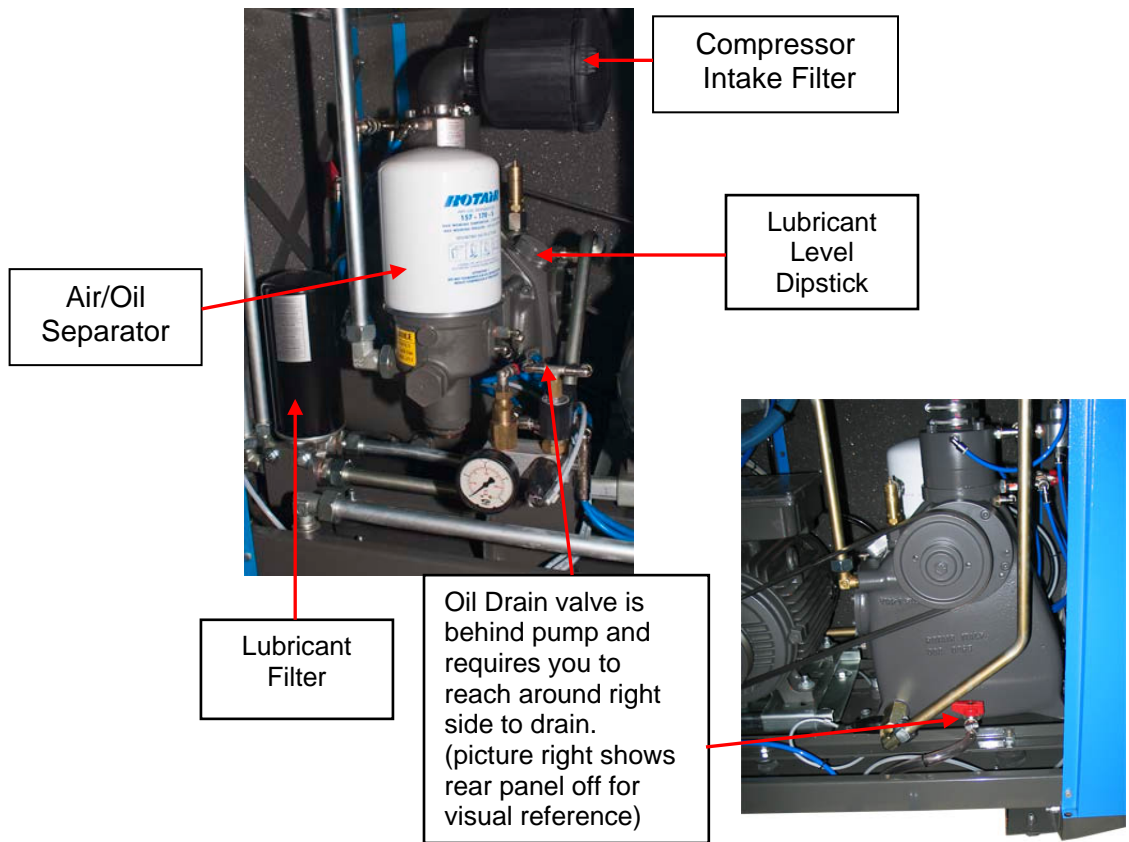
The L.P. compressor in your nitrox system comes standard with Nuvair 546™ synthetic food grade compressor lubricant for rotary screw compressors. Customers may specify different lubricants, check lubricant page at the back of manual for accepted lubricants.

To access the lubricant level sight gauge, filter, and drain, the front panel of the cabinet must be opened. Turn off all electrical power to Nitrox System before opening cabinet. See L.P. compressor manual for details on servicing lubricant and filter.



⚠ Warning

Use only the specified Nuvair lubricants in this system. The use of incompatible lubricants presents a risk of fire and/or explosion, and may result in system damage. This can lead to severe personal injury or death.



Rotary Screw Air Intake Filter	Rotair RVK 15 LP-420	162-0075-S
Rotary Screw Air Oil Separator	Rotair RVK 15 LP-420	157-170-S
Rotary Screw Pre-Filter	Rotair RVK 15 LP-420	157-172-S
Rotary Screw Oil Filter	Rotair RVK 15 LP-420	099-012-S

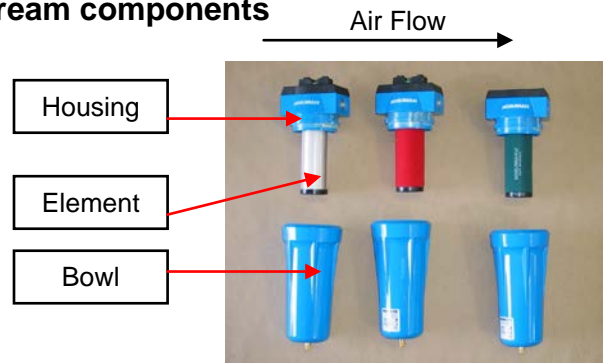
17.4 L.P. Filtration

Caution

Special attention needs to be given to the arrangement of the four L.P. feed air filtration elements and bowls. Properly reinstall each element and bowl to the correct housing. Improper sequence can cause damage to downstream components

The use of Grade D or better feed air is critical to prevent the passing of any residual oil vapor into the Membrane System. Three stages of Hankison L.P. filtration are used to produce Grade D air:

- 1) Coalescing & Particle Removal to 1 micron (Model No. HF7-20)
- 2) Water & Oil Vapor Removal to 0.01 micron (Model No. HF5-20)
- 3) Oil Vapor Removal to 0.003 PPM (Model No. HF1-20)



HF7-20 Coalescing & Particle Removal to 1 micron	HF5-20 Water & Oil Vapor Removal to 0.01 micron	HF1-20 Oil Vapor Removal to 0.003 PPM
------------------------------------------------------------	-----------------------------------------------------------	-------------------------------------------------

Filtration Inspection

Open each Filter and inspect as follows:

1. Inspect bowl for the presence of moisture. A high level of moisture build-up in the HF7 or HF5 filter indicates improper operation of auto-drain floats. Any evidence of moisture in the HF1 Filter indicates the air is not cooling properly and moisture is not properly being removed. Excess moisture will prevent the final filter from operating properly.
2. Inspect Elements for any unusual degradation or wetness. Element degradation can indicate more serious problems. Contact Nuvair for assistance,



HF7 & HF5 Filters with Auto-Drain Floats & Differential Pressure Indicators.

HF1 Filter with Manual Drain – Should not contain moisture

Changing Filtration Elements

Change Filter Elements every 500 hours. If the Nitrox System is operated in high humidity and/or high temperature, Filter Elements must be changed more often. See Appendix for details on Filter Element Life Factors. Visual DP indicators on the HF7 and HF5 filters assist with monitoring replacement intervals.

- 1) Push up on the Bowl, rotate CCW, and lower to remove.
- 2) Gently rotate Filter Element and pull down off mounting post.
- 3) Replace Element and reassemble in reverse order.



Differential Pressure Indicator Changes from Green to Red as Filter Ages. Do Not Use When Red.

Notice

The interior of the Filter Bowls can be cleaned with a diluted solution of Simple Green™ and flushed thoroughly with clean water. This will assist to prolong the life of the element, bowl, and auto drain.

17.5 Spare Parts List

See Rotary Screw compressor manual for L.P. compressor parts list. Other Nitrox System components and related items are listed below.

Nitrox System Components	Type	Part Number
Rotary Screw Compressor Lubricant, Food Grade	Nuvair 546, 1 Gal (Other Sizes Available)	9409
L.P. Filtration Element	Hankison HF 7-20	E7-20
	Hankison HF 5-20	E5-20
	Hankison HF 1-20	E1-20
Rotary Screw Air Intake Filter	Rotair RVK15 LP-420	162-0075-S
Rotary Screw Air Oil Separator	Rotair RVK15 LP-420	157-170-S
Rotary Screw Pre-Filter	Rotair RVK15 LP-420	157-172-S
Rotary Screw Oil Filter	Rotair RVK15 LP-420	099-012-S
Heater Assembly	2400 Watt, 38" Length	H2400
Heater Thermostat Control	110V/220V	A419
Heater Pressure Switch		3100-052
Membrane	250 Series	NUV250
Air Intake Filter Element	LP420	18P
Mixing Tube Assembly	2 inch	
Oxygen Analyzer	Pro O ₂	9450
	Pro O ₂ Remote Panel Mount	9460
Oxygen Sensor	See Analyzer Owners Manual	
Compressor Hose Coupler	1-1/4"-1-1/2" to 1-1/2"	RDTC40X32
	1-1/2" to 2"	RC50X40
Membrane to compressor suction hose	2" suction hose	2ARH
Related Equipment Components		
Air/Nitrox Quality Analysis Kit	Specify: (1) CGA Grade Required (2) Single Use or Program Use	
Air/Nitrox Compressor Lubricant		
Reciprocating Compressor, Food Grade	Nuvair 455, 1 Gal	9406
Reciprocating Compressor, Diester Based	Nuvair 751, 1 Gal	9403
	(Other Sizes Available)	

Appendix

Supply and Breathing Air Specifications

All supply and breathing air must meet the following requirements of CGA G-7.1-1997. Supply air delivered to the Nitrox Membrane System must be purified to meet Grade D or E quality, and periodic air quality testing to assure compliance is recommended. All breathing air for diving produced by the downstream Compressor must be purified to meet Grade E quality, and periodic air quality testing to assure compliance is mandatory.

Item	Grade D	Grade E
◆ Oxygen	◆ 19.5-23.5%	◆ 20-22%
◆ Carbon Dioxide (maximum)	◆ 1000 PPM	◆ 1000 PPM
◆ Carbon Monoxide (maximum)	◆ 10 PPM	◆ 10 PPM
◆ Hydrocarbons (maximum)	◆ Not specified	◆ 25 PPM
◆ Water Vapor (maximum)	◆ Not specified	◆ Not specified
◆ Dew Point (maximum) (1)	◆ Not specified	◆ Not specified
◆ Oil & Particles (maximum) (2)	◆ 5 mg/m ³	◆ 5 mg/m ³
◆ Odor	◆ None	◆ None

Notes: (1) Dew Point of supply air must be >10°F (6°C) colder than coldest ambient air expected
 (2) Supply air delivered to the Membrane System must contain <0.003 PPM Oil Vapor

All breathing Nitrox produced for diving must be purified to meet these same requirements, except for oxygen content. Nitrox oxygen content must measure within +/- 1% O₂ of the specified value of the mixture using a properly calibrated Oxygen Analyzer (i.e. Nitrox produced with a target content of 32% O₂ must measure in the range of 31-33% O₂). Periodic air quality testing to assure compliance is mandatory.

Filter Element Life Factors

Breathing air filter element life is typically rated by manufacturer based on an air temperature of 80°F at the filter inlet. Under normal operation this temperature is 12°F (5°C) warmer than the ambient air, resulting in an equivalent ambient temperature rating at 68°F (20°C).

To determine element life at a different ambient temperature, multiply the rated life by the life factor listed below:

Filter Inlet Temperature	Ambient Temperature	Filter Element Life Factor
53°F (12°C)	41°F (5°C)	2.6 x Life
62°F (17°C)	50°F (10°C)	1.8 x Life
71°F (23°C)	59°F (16°C)	1.35 x Life
80°F (27°C)	68°F (20°C)	1 x Life
89°F (32°C)	77°F (25°C)	0.8 x Life
96°F (36°C)	84°F (29°C)	0.55 x Life
105°F (41°C)	93°F (34°C)	0.45 x Life
114°F (46°C)	102°F (39°C)	0.35 x Life

Material Safety Data Sheet**Nuvair™ 546 Premium Synthetic Food Grade Air/Nitrox Compressor Lubricant**

Effective Date: 03/19/2010

Supersedes:

I. Product Identification:

Trade Name: Nuvair 546
 Chemical Name: Polyalphaolefin
 Chemical Family: Synthetic hydrocarbon

II. Components & Hazard Statement:

This product is non-hazardous. This material is not considered hazardous by the OSHA Hazard Communication Standard (29 CFR 1910.1200)

III. Physical Data:

Viscosity: 46 cSt. @ 40°C
 Specific Gravity (Water = 1.0): 0.84
 Boiling Point: Not Determined
 Vapor Pressure: Negligible
 Appearance & Odor: Clear & odor Mild
 Solubility in Water: Negligible
 Other Data: Non-Toxic USDA H-1 Approved

IV. Fire & Explosion Hazard Data:

Flash point: 500°F / 260°C
 Auto ignition Temperature: Not Determined
 Flammability Limits: Not Determined
 Extinguishing Media: Dry Chemical; CO2 Foam; Water Spray
 Special Fire Fighting Procedure: Burning may produce irritating/noxious fumes. Firefighters should use NIOSH/MNSA approved self-contained breathing apparatus. Use water to cool fire-exposed containers to prevent pressure build-up.

V. Reactivity Data:

Stability: Stable under normal conditions.
 Materials to Avoid: Incompatible with oxidizing agents.
 Hazardous Decomposition Products: Carbon monoxide, Carbon dioxide

VI. Health Information:

Eye Contact: Flush eyes with water for 15 minutes. Call physician if irritation develops.
 Skin Contact: Wash skin with soap and water.
 Inhalation: Remove to fresh air.
 Ingestion: First aid not normally required. If uncomfortable, call physician.

VII. Health Hazard Data:

Exposure Limit: Not Applicable
 Effects of Overexposure: Low oral and dermal toxicity. Prolonged or repeated exposure may cause irritation, nausea, and vomiting.

VIII. Employee Protection:

For general personal hygiene, wash hands thoroughly after handling material. Avoid contact with skin and eyes. Chemical impervious gloves are not required, but may be recommended for prolonged exposure. Use in a well ventilated area.

IX. Storage, Spill, & Disposal Procedures:

Storage: Store in clean, dry area.
 Spills: Use absorbent materials to soak up fluid.
 Disposal: Incinerate this product and all associated wastes in a licensed facility in accordance with Federal, state, and local regulations.

X. Hazard Rating Information:

NFPA Health: 0
 Flammability: 1
 Reactivity: 0
 Personal Protection: B

This information contained herein is based on the data available to us and is believed to be true and accurate. Nuvair makes no warranty, expressed or implied, regarding the accuracy of this data or the results to be obtained from the use thereof. Nuvair assumes no responsibility for injury from the use of this product.

Material Safety Data Sheets**Nuvair™ 455 Premium Synthetic Food Grade Air/Nitrox Compressor Lubricant**

Effective Date: 03/19/2010

I. Product Identification:

Trade Name: Nuvair 455
 Chemical Name: Polyalphaolefin
 Chemical Family: Synthetic hydrocarbons/Esters

II. Components & Hazard Statement:

This product is non-hazardous. This material is not considered hazardous by the OSHA Hazard Communication Standard (29 CFR 1910.1200).

III. Physical Data:

Viscosity: 100 cst. @40°C
 Specific Gravity (Water = 1.0): 0.85
 Boiling Point: N.A.
 Vapor Pressure: Negligible
 Appearance & Odor: Clear – with Mild odor
 Solubility in Water: Negligible

IV. Fire & Explosion Hazard Data:

Flash point: 464°F / 240°C / COC
 Auto ignition Temperature: Not Established
 Flammability Limits: Not Established
 Extinguishing Media: Dry Chemical; CO2 Foam; Water Spray
 Special Fire Fighting Procedure: Burning may produce irritating/noxious fumes. Firefighters should use NIOSH/MNSA approved self-contained breathing apparatus. Use water to cool fire-exposed containers to prevent pressure build-up.

V. Reactivity Data:

Stability: This product is stable and will not react with water.
 Materials to Avoid: Avoid strong oxidizers
 Hazardous Decomposition Products: Carbon monoxide, Carbon dioxide

VI. Health Information:

Eye Contact: Flush eyes with water for 15 minutes. Call physician if irritation develops.
 Skin Contact: Wash skin with soap and water.
 Inhalation: Remove to fresh air.
 Ingestion: First aid not normally required. If uncomfortable, call physician.

VII. Health Hazard Data:

Exposure Limit: Not Applicable
 Effects of Overexposure: Low oral and dermal toxicity. Prolonged or repeated exposure may cause irritation, nausea, and vomiting.

VIII. Employee Protection:

For general personal hygiene, wash hands thoroughly after handling material. Avoid contact with skin and eyes. Chemical impervious gloves are not required, but may be recommended for prolonged exposure. Use in a well ventilated area.

IX. Storage, Spill, & Disposal Procedures:

Storage: Store in clean, dry area.
 Spills: Use absorbent materials to soak up fluid.
 Disposal: Incinerate this product and all associated wastes in a licensed facility in accordance with Federal, state, and local regulations.

X. Hazard Rating Information:

NFPA Health: 0
 Flammability: 1
 Reactivity: 0
 Personal Protection: B

This information contained herein is based on the data available to us and is believed to be true and accurate. Nuvair makes no warranty, expressed or implied, regarding the accuracy of this data or the results to be obtained from the use thereof. Nuvair assumes no responsibility for injury from the use of this product.

Material Safety Data SheetNuvair™ 751 Premium Synthetic Diester Based Air/Nitrox Compressor Lubricant

Effective Date: 3/10/2010

Supersedes:

I. Product Identification:

Trade Name: Nuvair 751
 Chemical Name: Diester
 Chemical Family: Diester

II. Components & Hazard Statement:

This product is non-hazardous. This material is not considered hazardous by the OSHA Hazard Communication Standard (29 CFR 1910.1200).

III. Physical Data:

Viscosity: 146 cst. @40°C
 Specific Gravity (Water = 1.0): 0.94
 Boiling Point: Not determined
 Vapor Pressure: Negligible
 Appearance & Odor: Amber / Mild odor
 Solubility in Water: Negligible
 Other Data: Non-toxic USDA H-2 approved

IV. Fire & Explosion Hazard Data:

Flash point: 520°F / 271°C COC ASTM D-92
 Auto ignition Temperature: 765°F ASTM D-2155
 Flammability Limits: Not Established
 Extinguishing Media: Dry Chemical; CO2 Foam; Water Spray
 Special Fire Fighting Procedure: Burning may produce irritating/noxious fumes. Firefighters should use NIOSH/MNSA approved self-contained breathing apparatus. Use water to cool fire-exposed containers to prevent pressure build-up.

V. Reactivity Data:

Stability: Stable under normal conditions.
 Materials to Avoid: Incompatible with oxidizing agents.
 Hazardous Decomposition Products: Carbon monoxide, Carbon dioxide

VI. Health Information:

Eye Contact: Flush eyes with water for 15 minutes. Call physician if irritation develops.
 Skin Contact: Wash skin with soap and water.
 Inhalation: Remove to fresh air.
 Ingestion: First aid not normally required. If uncomfortable, call physician.

VII. Health Hazard Data:

Exposure Limit: Not Applicable
 Effects of Overexposure: Low oral and dermal toxicity. Prolonged or repeated exposure may cause irritation, nausea, and vomiting.

VIII. Employee Protection:

For general personal hygiene, wash hands thoroughly after handling material. Avoid contact with skin and eyes. Chemical impervious gloves are not required, but may be recommended for prolonged exposure. Use in a well ventilated area.

IX. Storage, Spill, & Disposal Procedures:

Storage: Store in clean, dry area.
 Spills: Use absorbent materials to soak up fluid.
 Disposal: Incinerate this product and all associated wastes in a licensed facility in accordance with Federal, state, and local regulations.

X. Hazard Rating Information:

NFPA Health: 0
 Flammability: 1
 Reactivity: 0
 Personal Protection: B

This information contained herein is based on the data available to us and is believed to be true and accurate. Nuvair makes no warranty, expressed or implied, regarding the accuracy of this data or the results to be obtained from the use thereof. Nuvair assumes no responsibility for injury from the use of this product.

OWNER'S WARRANTY RESPONSIBILITIES

Failure of the owner to prevent equipment damage by complying with the procedures outlined below and in the Operation Manual will void the Nitrox System warranty.

Installation:

- All set up requirements and procedures provided in the Nitrox System Operation Manual must be followed in their entirety including supply air cleanliness, Compressor preparation, and installation of the Nitrox System.
- Supply air to the Membrane must be properly filtered to CGA Grade D air quality or better to prevent damage to the Membrane. Air quality testing of the supply air should be performed periodically and documented to assure compliance.
- If there is any doubt regarding the suitability of a HP Compressor for compressing Nitrox, contact Nuvair or the Compressor manufacturer before you connect your Nitrox System.
- If an existing HP Compressor is to be used for compressing Nitrox, all traces of the old Lubricant must be removed and replaced with a Nitrox Compressor Lubricant approved by Nuvair.
- Electrical wiring and connections should be made by a qualified electrician in accordance with all national and local electrical codes.
- Do not change the temperature setting on the Heater Thermostat Control. Changes in temperature settings may cause Membrane damage.
- To prevent Compressor damage, only use the Compressor Intake Hose provided. If a longer hose is required, contact Nuvair for assistance.

Operation:

- Do not use the Nitrox System to supply a H.P. Compressor with Nitrox mixtures containing more than 40% oxygen. Compressing higher concentrations of oxygen may cause severe Compressor damage.
- Do not pump Nitrox mixtures at pressures above the compressor manufacturer's rating, and never above 3600 P.S.I. Compressing Nitrox at higher pressures may cause severe HP Compressor damage.
- To prevent Membrane damage, drain all low pressure filter and optional volume tank condensate on a daily basis.

Maintenance:

- Change low pressure filter elements on a schedule determined by filter capacity and ambient temperature and humidity. Contact Nuvair if you need assistance establishing a schedule for your equipment and location.
- Replace Membrane System Air Intake Filter on a regular basis to prevent flow obstruction.
- Keep all nuts, bolts, fittings, connectors, and clamps tight.
- Keep a service record book showing that regular maintenance work has been carried out. If a warranty claim becomes necessary, it will aid in demonstrating that damage has not been caused by insufficient maintenance. Proof of maintenance may be required prior to determining the validity of a warranty request.

NUVAIR NITROX SYSTEM WARRANTY

NUVAIR extends a limited warranty, which warrants the Nitrox System to be free from defects in materials and workmanship under normal use and service for a limited period. The specific Membrane Component of the Nitrox System is warranted according to the pro-rated terms as set forth below. All other Original Equipment Manufacturer (OEM) components used in the system are warranted only to the extent of the OEM's warranty to NUVAIR. NUVAIR makes no warranty with respect to these OEM components, and only warrants the workmanship that NUVAIR has employed in the installation or use of any OEM component. This warranty is not transferable.

NUVAIR will, at its discretion and according to the terms as set forth within, replace or repair any materials which fail under normal use and service and do not exhibit any signs of improper maintenance, misuse, accident, alteration, weather damage, tampering, or use for any other than the intended purpose. Determination of failure is the responsibility of NUVAIR, which will work together with the customer to adequately address warranty issues. When any materials are repaired or replaced during the warranty period, they are warranted only for the remainder of the original warranty period. This warranty shall be void and NUVAIR shall have no responsibility to repair or replace damaged materials resulting directly or indirectly from the use of repair or replacement parts not approved by NUVAIR.

Pro-Rated Terms:

NUVAIR warrants the Membrane Component of the Nitrox System to be free from defects in material and workmanship for a period of thirty-six (36) months from date of installation or forty-two (42) months from date of shipment by NUVAIR, whichever may occur first. The warranty covers parts only and is prorated as follows:

- First Year Repair or replacement free of charge
- Second Year Warranty allowance of 70% of the current Membrane Component list price
- Third Year Warranty allowance of 40% of the current Membrane Component list price

A warranty registration card, supplied with system documentation, must be filled out and submitted to NUVAIR for the warranty to be in full effect. If the warranty registration card is not received within thirty (30) days of installation, the thirty-six (36) month warranty will begin with the date of shipment from NUVAIR.

Maintenance Items:

Any materials which are consumed, or otherwise rendered not warrantable due to processes applied to them, are considered expendable and are not covered under the terms of this policy. This includes maintenance and consumable items listed as part of a suggested maintenance program included with system documentation.

Return Policy:

Application for warranty service can be made by contacting NUVAIR during regular business hours and requesting a Return Material Authorization number. Materials that are found to be defective must be shipped, freight pre-paid, to the NUVAIR office in Oxnard, California. Upon inspection and determination of failure, NUVAIR shall exercise its options under the terms of this policy. Warranty serviced materials will be returned to the customer via NUVAIR's preferred shipping method, at NUVAIR's expense. Any expedited return shipping arrangements to be made at customer's expense must be specified in advance.

Limitation of Warranty and Liability:

Repair, replacement or refund in the manner and within the time provided shall constitute NUVAIR'S sole liability and the Purchaser's exclusive remedy resulting from any nonconformity or defect. NUVAIR shall not in any event be liable for any damages, whether based on contract, warranty, negligence, strict liability or otherwise, including without limitation any consequential, incidental or special damages, arising with respect to the equipment or its failure to operate, even if NUVAIR has been advised of the possibility thereof. NUVAIR makes no other warranty or representation of any kind, except that of title, and all other warranties, express or implied, including warranties of merchantability and fitness for a particular purpose, are hereby expressly disclaimed. No salesman or other representative of NUVAIR has authority to make any warranties.

Additional Record of Changes

It is the responsibility of the owner of this product to register their ownership with Nuvair by sending the warranty card provided to Nuvair. This card is to establish registration for any necessary warranty work and as a means of communication that allows Nuvair to contact the user regarding this product.

The user must notify Nuvair of any change of address by the user or sale of the product. All changes or revisions to this manual must be recorded in this document to ensure that the manual is up to date.

Change Date	Description of Change
10.2.12	Updated warnings and images from 12/07 original.



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