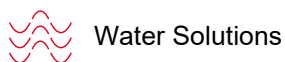


DuPont™ IntegraTec™ Modules for Open Platform

Assembly Manual

Version 5

September 2025



NOTICE: Any translations of this document into languages other than English provided to you by DuPont are not official translations and are intended solely as a convenience for non-English reading recipients. The only DuPont-approved and valid version of this document is the most current English version provided by DuPont at the time of sale.

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1. Legal Notice

1.1 Product

This manual applies to DuPont™ IntegraTec™ Modules for Open Platforms, parts and components for installation, assembly, and disassembly.

Duplication and archiving in any form whatsoever – including of excerpts – is only permitted with the written consent of the manufacturer.

All brand and company names in these process and design guidelines are registered trademarks of the corresponding companies.


1.2 Change Policy

The manufacturer reserves the right to change this manual or any part thereof at any time in the interest of continuous product improvement.

The company/party responsible for process and design of the system described in this manual should obtain the current DuPont™ IntegraTec™ Modules for Open Platforms Assembly Manual at regular intervals:

- Download at: <https://www.dupont.com/brands/integrattec-ultrafiltration.html>


2. About these Instructions

<i>NOTE</i>	
	<p>READ THE INSTRUCTIONS!</p> <p>Read these instructions completely before assembling and disassembling the equipment. The information contained herein will help you perform the work properly.</p> <p>It is important to follow the safety instructions to prevent injury and property damage.</p> <p>Keep these instructions in a readily accessible place close to the DuPont™ IntegraTec™ Module. Include these instructions if you pass the DuPont™ IntegraTec™ Module on to a third-party.</p>

2.1 Objective of these Instructions

- These instructions will enable you to properly, safely, and quickly assemble and disassemble a DuPont™ IntegraTec™ Module.
- These instructions contain additional important information on maintaining the DuPont™ IntegraTec™ Module.
- The order in which these instructions are presented is designed for optimal learning, enabling you to work your way into the subject matter step by step.

Warranty Policy

<i>NOTE</i>	
	<p>ADHERENCE TO ALL INSTRUCTIONS!</p> <p>Full and proper compliance with the Assembly Instructions is a prerequisite for making a claim under the warranty.</p> <p>Any translations of this document into languages other than English provided to you by DuPont are not official translations and are intended solely as a convenience for non-English reading recipients. The only DuPont-approved and valid version of this document is the most current English version provided by DuPont at the time of sale.</p> <p>In the event of making a warranty claim, the operator agrees to automatically provide DuPont with a complete set of documentation.</p> <p>Please contact DuPont if you wish to deviate from any of the guidelines or specifications provided in this document and request written approval in advance. Otherwise, you risk invalidating any warranty claims that you may make in the future.</p>

3. Introduction

Ultrafiltration (UF) involves pressure-driven separation of materials from a feed solution. The technology achieves separation through sieving and is used to remove particulate and microbial contaminants but does not remove ions or molecules of low molecular weight. The process typically operates with a feed pressure of 4 to 100 psig (0.28 to 6.9 bar). UF plants are automated and have low operational labour requirements. Depending on the feed water quality, these systems can require frequent cleaning. UF membranes generally may have a service life of five years or longer, depending on system operations. UF technology is commercially available in tubular, hollow-fiber, plate and frame, flat sheet, and spiral wound configurations.

UF membranes reject solutes ranging in size from 0.005 microns and larger. Figure 1 provides a guide to the relationship between common material sizes, separation processes, and pore size measurements. The UF membrane process separates molecules in solution based on size. The pore size and molecular weight cut-off (MWCO) are often used to characterize a membrane. The pore size is the nominal diameter of the openings or micropores in the membrane expressed in micron (micron meters μm). The MWCO is the molecular mass or weight of a solute that rejects greater than 90 percent. The unit of measurement for MWCO is the Dalton (D).

Different membrane materials with the same nominal MWCO may have differing solute rejection. Pore size distribution and uniformity rather than the chemical nature of the membrane material may cause this effect. Because factors other than pore size or MWCO affect the performance of membranes, challenge studies are used to demonstrate membrane performance and benchmark different membranes.

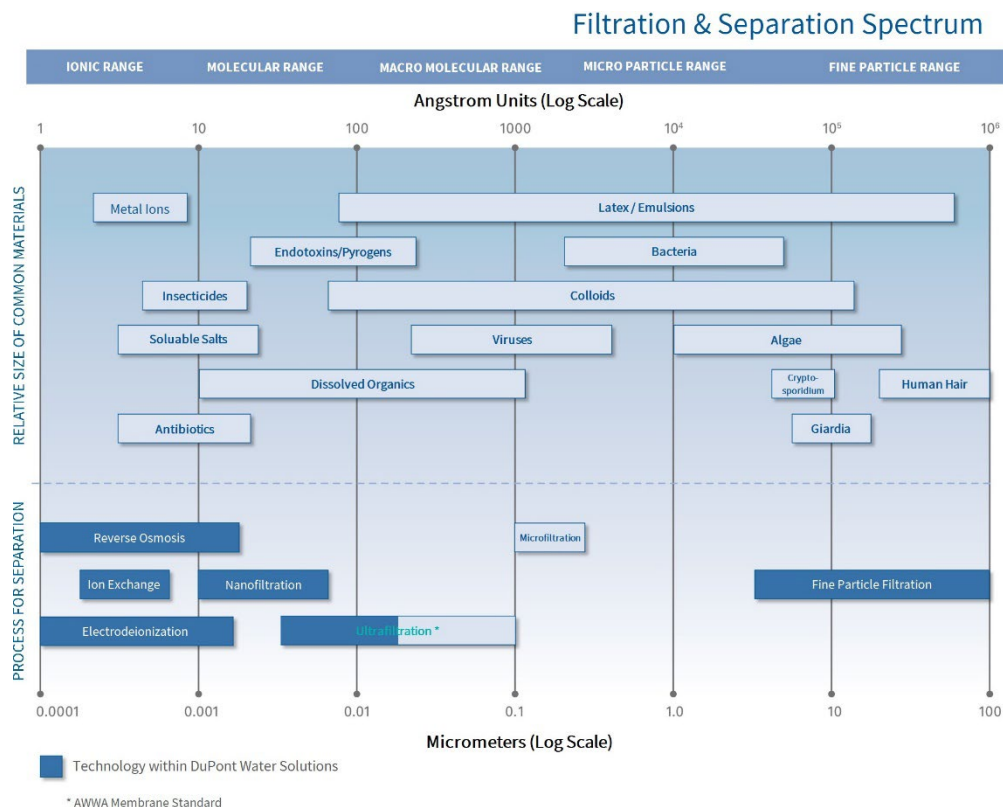


Figure 1 Material Size and Membrane Process Guide

The DuPont ultrafiltration hollow fiber membrane shown in Figure 2 is 1.3 mm outside diameter and 0.7 mm inside diameter and is made from PVDF polymer. The fibers are strong because of a combination of the polymer type, the wall thickness, high porosity sub structure, and smaller pores at the surface of the fiber. The PVDF membranes offer high chemical resistance and are tolerant to temperatures ranging from 1 to 40°C.

The 0.03 μm nominal pore size combines high filtration performance and high flux. The smaller pore size provides stable long term filtration performance compared to microfiltration hollow fiber membranes. DuPont has taken its ultrafiltration technology to a new product format, referred to as DuPont™ IntegraTec™ modules. This range includes interconnecting end caps that reduce skid capital costs and engineering design efforts.

4. DuPont™ IntegraTec™ Module Description

4.1 DuPont™ IntegraTec™ Module Features

The DuPont™ IntegraTec™ ultrafiltration modules are made from high strength, hollow fiber membranes and are engineered to reduce design and fabrication requirements with features and benefits including:

- 0.03 µm pore size for removal of bacteria, viruses, and particulates, a 6-log removal of bacteria, a 2.5 log removal on viruses and a <2.5 SDI guarantee with proper operation
- PVDF fibers which offer strength, chemical and fouling resistance which allows for extended membrane life and consistent long-term performance
- Outside-In flow configuration which allows higher TSS feed waters, while maintaining reliable system performance and producing high quality filtrate

Innovative end-cap design enables direct coupling of modules reducing the need for piping and manifolds. The outside-in flow configuration allows the use of highly effective air scour cleaning which enhances particle removal and improves recovery. A dead-end flow format achieves higher recovery and energy savings. The module housing design eliminates the need for separate pressure vessels while the vertical orientation allows easy removal of air from cleaning and integrity testing processes.

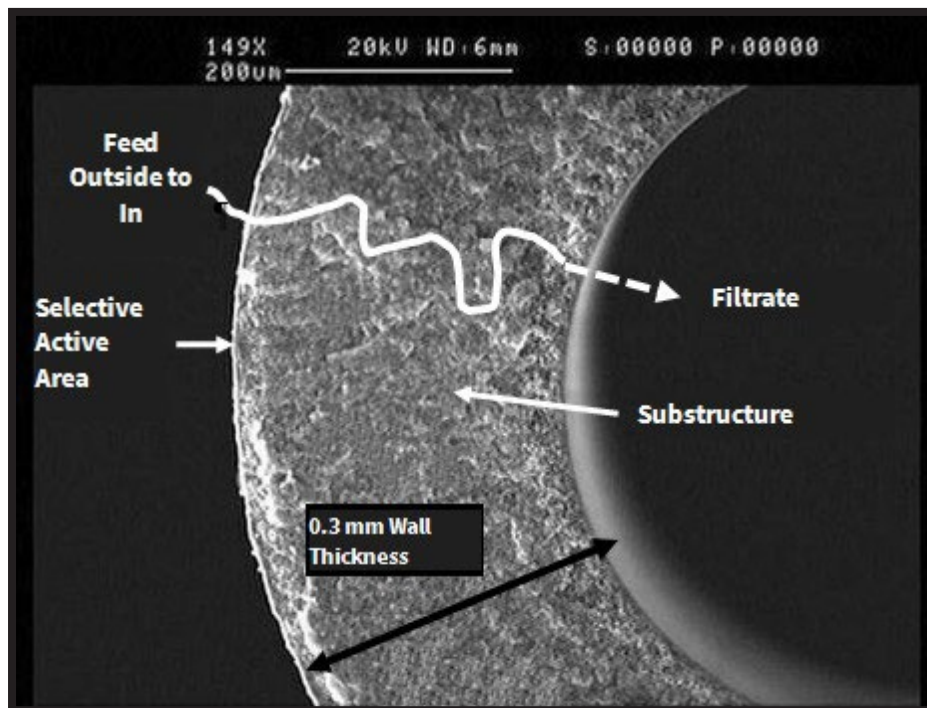


Figure 2 Wall Cross Section of the Hollow Fiber

DuPont™ IntegraTec™ Module Description

Feed flow enters and is distributed into the modules through the side feed ports located on the bottom end cap. Feed flow enters the module on the outside of the fiber. The air connection is located on the side of the bottom end cap and is used for air scouring and integrity testing. The concentrate (discharge of waste flows from the outside of fiber) and filtrate ports (inside of fiber) are located on the top cap.

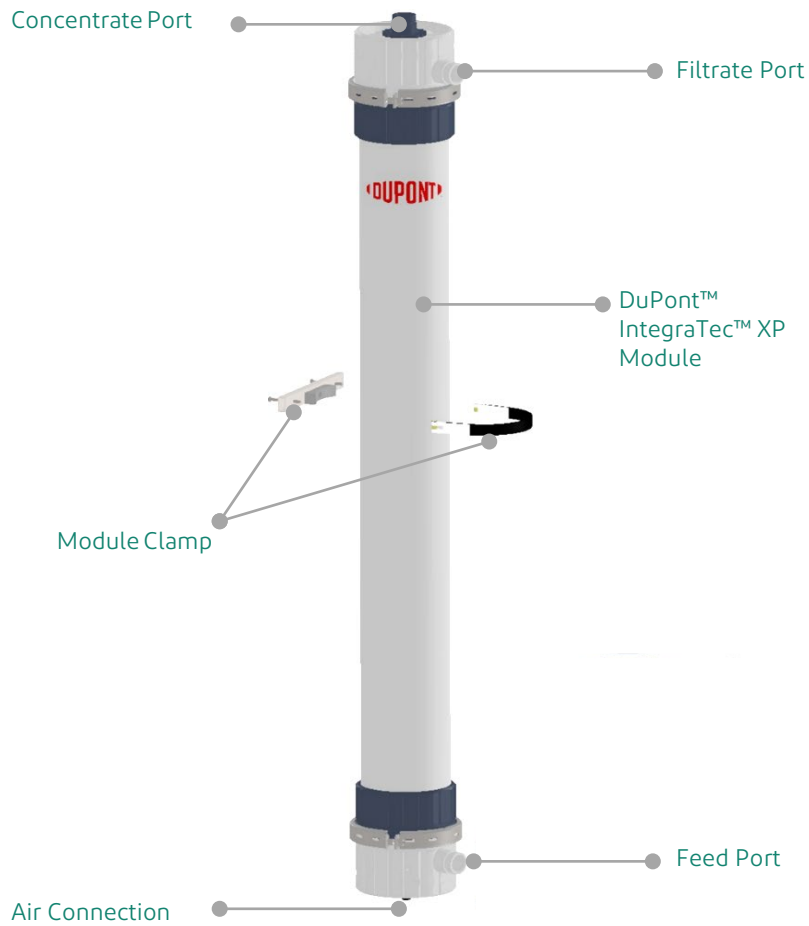
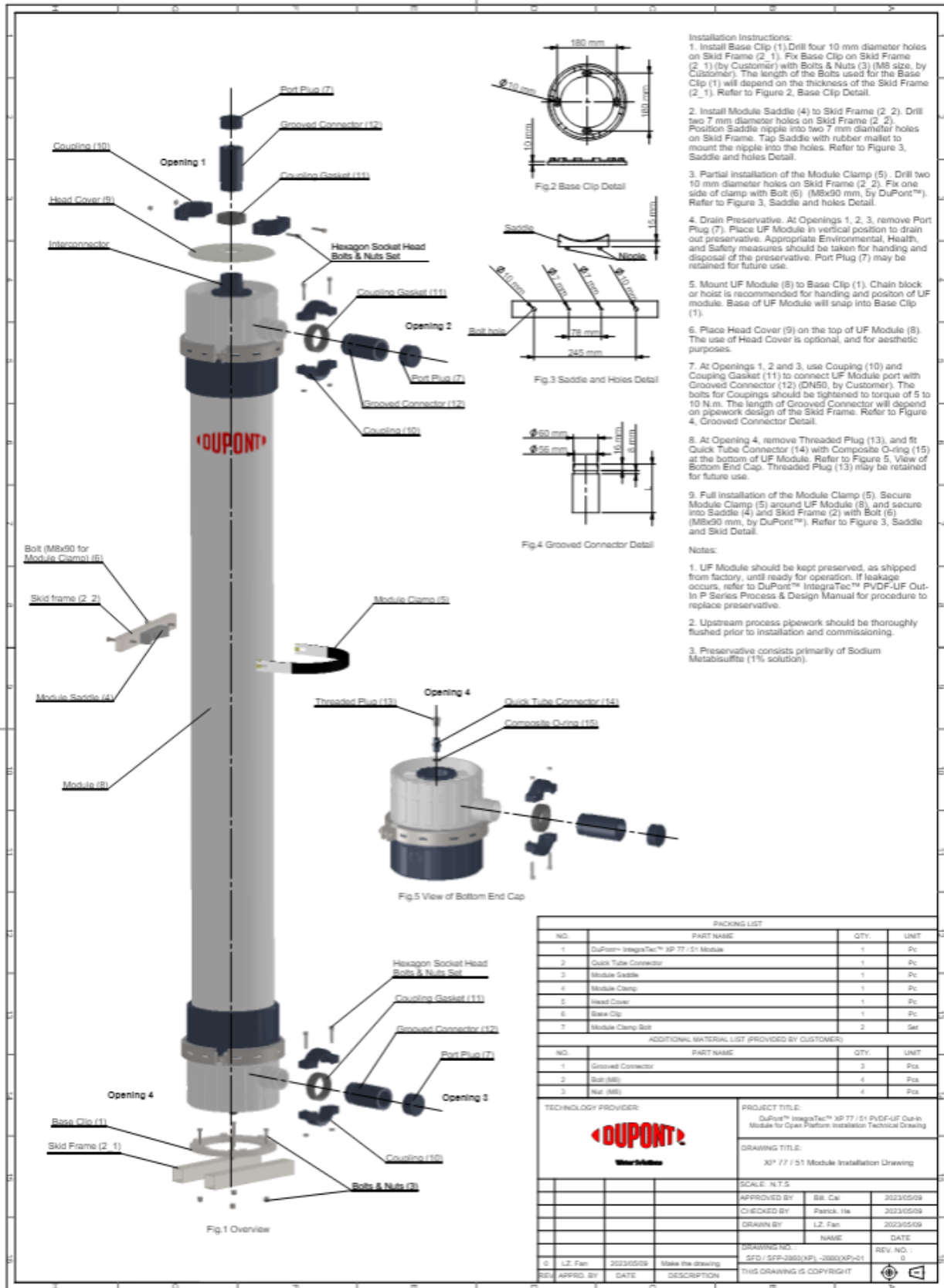


Figure 3 DuPont™ IntegraTec™ ultrafiltration module connections

DuPont™ IntegraTec™ Module Description



Installation Instructions:

1. Install Base Clip (1). Drill four 10 mm diameter holes on Skid Frame (2, 1). Fix Base Clip on Skid Frame (2, 1) (by Customer) with Bolts & Nuts (3) (M8 size, by Customer). The length of the Bolts used for the Base Clip (1) will depend on the thickness of the Skid Frame (2, 1). Refer to Figure 2, Base Clip Detail.
2. Install Module Saddle (4) to Skid Frame (2, 2). Drill two 7 mm diameter holes on Skid Frame (2, 2). Position Saddle nipple into two 7 mm diameter holes on Skid Frame. Tap Saddle with rubber mallet to mount the nipple into the holes. Refer to Figure 3, Saddle and holes Detail.
3. Partial installation of the Module Clamp (5). Drill two 10 mm diameter holes on Skid Frame (2, 2). Fix one side of clamp with Bolt (6) (M8x90 mm, by DuPont™). Refer to Figure 3, Saddle and holes Detail.
4. Drain Preservative. At Openings 1, 2, 3, remove Port Plug (7). Place UF Module in vertical position to drain out preservative. Appropriate Environmental, Health, and Safety measures should be taken for handling and disposal of the preservative. Port Plug (7) may be retained for future use.
5. Mount UF Module (8) to Base Clip (1). Chain block or hoist is recommended for handling and position of UF module. Base of UF Module will snap into Base Clip (1).
6. Place Head Cover (9) on the top of UF Module (8). The use of Head Cover is optional, and for aesthetic purposes.
7. At Openings 1, 2 and 3, use Coupling (10) and Coupling Gasket (11) to connect UF Module port with Grooved Connector (12) (DN50, by Customer). The bolts for Couplings should be tightened to torque of 5 to 10 N.m. The length of Grooved Connector will depend on pipework design of the Skid Frame. Refer to Figure 4, Grooved Connector Detail.
8. At Opening 4, remove Threaded Plug (13), and fit Quick Tube Connector (14) with Composite O-ring (15) at the bottom of UF Module. Refer to Figure 5, View of Bottom End Cap. Threaded Plug (13) may be retained for future use.
9. Full installation of the Module Clamp (5). Secure Module Clamp (5) around UF Module (8), and secure into Saddle (4) and Skid Frame (2) with Bolt (6) (M8x90 mm, by DuPont™). Refer to Figure 3, Saddle and Skid Detail.

Notes:

1. UF Module should be kept preserved, as shipped from factory, until ready for operation. If leakage occurs, refer to DuPont™ IntegraTec™ PVDF-UF Out-In P Series Process & Design Manual for procedure to replace preservative.
2. Upstream process pipework should be thoroughly flushed prior to installation and commissioning.
3. Preservative consists primarily of Sodium Metabisulfite (1% solution).





PACKING LIST			
NO.	PART NAME	QTY.	UNIT
1	DuPont™ IntegraTec™ XP TT / S1 Module	1	Pc
2	Quick Tube Connector	1	Pc
3	Module Saddle	1	Pc
4	Module Clamp	1	Pc
5	Head Cover	1	Pc
6	Base Clip	1	Pc
7	Module Clamp Bolt	2	Set
ADDITIONAL MATERIAL LIST (PROVIDED BY CUSTOMER)			
NO.	PART NAME	QTY.	UNIT
1	Grooved Connector	3	Pcs
2	Bolt (M8)	4	Pcs
3	Nut (M8)	4	Pcs
TECHNOLOGY PROVIDER:		PROJECT TITLE:	
		DuPont™ IntegraTec™ XP TT / S1 PVDF-UF Out-In Module for Open Platform Installation Technical Drawing	
		DRAWING TITLE:	
		XP TT / S1 Module Installation Drawing	
SCALE: N.T.S.			
APPROVED BY:	BR. CH.	DATE:	2023/05/09
CHECKED BY:	Patrick. He	DATE:	2023/05/09
DRAWN BY:	LZ. Fan	DATE:	2023/05/09
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REV. APPRO. BY:	DATE:	DESCRIPTION:	THIS DRAWING IS COPYRIGHT





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Figure 4 DuPont™ IntegraTec™ module components

5. Installation / Assembly



5.1 Warnings

 DANGER		
	<p>DANGER TO LIFE!</p> <p>Danger of crushing from falling raised loads.</p> <ul style="list-style-type: none"> • Never stand under raised loads! • Keep a sufficient distance when transporting and lifting loads! • Wear a safety helmet! • Wear safety shoes! 	 

 WARNING		
	<p>CONSIDERABLE DANGER OF INJURY!</p> <p>Danger of falling when using ladders, scaffolding and other climbing aids.</p> <ul style="list-style-type: none"> • Only use flawless and approved ladders, scaffoldings, and other climbing aids! • Use a secured safety cage or safety harness when you are being raised by a forklift truck! • Wear a safety helmet! • Use a safety harness if necessary! 	 

 WARNING		
	<p>CONSIDERABLE DANGER OF INJURY!</p> <p>Danger of crushing and shearing from work in the danger zone.</p> <ul style="list-style-type: none"> • Note the specified number of persons required! • Wear safety gloves! • Wear safety shoes! 	 



 WARNING		
	<p>CONSIDERABLE DANGER OF INJURY!</p> <p>Danger of tripping and impact from pallets, packages and assembled parts at the construction site.</p> <ul style="list-style-type: none"> • Wear a safety helmet! • Wear safety shoes! 	 

 CAUTION	
	<p>DANGER OF SLIPPING!</p> <p>Be careful when opening the modules, as residual liquid may still leak from the preservation.</p>

5.2 General Specifications

5.2.1 Calculation of Personnel Requirements

Personnel Requirements for mounting a module without a Crane

 CAUTION	
	<p>DANGER OF INJURY!</p> <p>Danger of injury due to physical strain.</p> <ul style="list-style-type: none"> • Determine the weight of the module in use! • Always note the locally applicable maximum permissible load of persons! • Note the specified number of people required!

To mount the module without a crane, calculate the number of people required as follows.


1. Determine the transport weight of a module you are using from the Technical Data
2. Determine the maximum permissible load on a person from the locally applicable laws and safety regulations.
3. Calculate the required number of persons required to lift a module by dividing the module transport weight by the maximum permissible load per person.


Always use the calculated number of people when a module needs to be lifted and placed on a connecting brace. In our example configuration, a total of 2 people was determined and specified. Always replace this number with the number you determined yourself.

Personnel Requirements for Other Tasks

Unless otherwise specified, all other tasks require one person. If steps require two or more people, this is specified in each case. A maximum of 2 people is needed.

5.2.2 Tools and Consumables

<i>NOTE</i>	
	<p>CAUTION, PROPERTY DAMAGE!</p> <p>If the tightening torques specified in these instructions are exceeded, the system parts may become damaged, and leaks may occur during operation.</p> <ul style="list-style-type: none"> • Always adhere to the specified tightening torques!


<i>NOTE</i>	
	<p>The 2" composite couplings should be tightened until the contact surfaces of both coupling halves are flush and resting against each other without a gap. These types of couplings do not require a specific torque. The usual range of torque for the 2" coupling is 10-15 Nm.</p>

For the entire setup of DuPont™ IntegraTec™ Module, only the following tools and devices are approved:

- Safety Goggle.
- Glove.
- Latex glove.
- Scissors.
- Screwdriver.
- Liquid collection basin.
- Shelf or platform for module placing.
- Glycerin (>97%).


5.2.3 Preparation of gaskets and O-rings

Do not use silicone or any lubricants or sealants that contain silicone during assembly. Only glycerin may be used as a lubricant for gaskets, O-rings, couplings etc. (with a purity of > 97.0%).

<i>NOTE</i>	
	<p>USE DISPOSABLE GLOVES!</p> <p>Use disposable gloves to apply lubricant to the couplings and gaskets.</p>

5.3 Preparing for Assembly

5.3.1 Checking the Available Space

<i>NOTE</i>	
	CAUTION, PROPERTY DAMAGE! Potential damage due to exposure to the weather or impermissible temperatures.



Weather and Temperature Protection

At the location where you are planning to erect the DuPont™ IntegraTec™ Module, ensure the following:

- The unit is always protected by a roof
- Permanent protection against the weather is provided
- The temperatures are always within the permissible temperature range from 1°C to +40°C.

Space Conditions

- Check the space conditions around the assembly area.
- Ensure that there is enough space to allow the DuPont™ IntegraTec™ Module to be installed, disassembled, and operated safely.

 CAUTION	
	DANGER OF INJURY! Danger of injury due to constricted space. <ul style="list-style-type: none">• Provide sufficient space!



Floor Characteristics

Ensure that the floor characteristics meet the following minimum requirements

- Level, smooth surface with the necessary strength
- Recommendation: gullies and drainage channels ensure adequate water drainage, e.g., when emptying the module.

Checking the Floor Load

- Ensure that the maximum permissible floor load of the planned system footprint is not exceeded. The maximum permissible floor load must be at least 2,500 kg/m².

 CAUTION	
	DANGER OF INJURY! Danger of injury and system damage due to exceeding the maximum permissible floor load. <ul style="list-style-type: none">• Do not exceed the maximum permissible for load!

5.3.2 Protecting the Work Area



Structure of the Work Area

The work area consists of the following areas:

- The single parts of the sub-unit that are in storage, have been unpacked, are being tested and/or are being processed,
- The pre-assembled assembly groups,
- The sub-unit currently being processed,
- The final location of the modules
- and additionally on all routes:
- All required access routes to the areas specified above,
- All required walking and driving distance between the areas specified above,
- All escape routes from one of the area or routes specified above

Protecting the Work Area

- Protect the defined work area against access by people who are not involved in the procedures for installing a sub-unit.
- Protect the defined work area against all machines or devices that are not required for the procedures for installing a sub-unit.

 CAUTION	
	<p>DANGER OF INJURY!</p> <p>Danger of injury to bystanders, machines, and devices in the work area.</p> <ul style="list-style-type: none"> • Protect the work area against unauthorized access and against machines and devices that are not involved!

5.4 Checking the Delivery

5.4.1 Moving the Packages to the Work Area

Move all packages of the module being mounted to the vicinity of the work area using suitable transport equipment.

5.4.2 Checking for Damage



Step	Activity
1	Checking Packages and Parts <ul style="list-style-type: none">a) Check all packages of the delivery for damage.b) Open all damaged packages.c) Check all models and/or parts it contains for damage.
2	Procedure for Damaged Modules or Parts <ul style="list-style-type: none">a) Photograph the damage and the associated package label.b) Document all damage and the respective module serial numbers and associated package numbers in writing.c) Inform your contact at DuPont promptly about the damage. Damaged parts of a delivery are not permitted to be installed until a decision has been made by DuPont.d) The decision regarding whether the damaged module or part must be returned or if it can be used is made by your contact at DuPont.



Further Use of Parts

You are only permitted to continue to use and install the following modules and parts:

- All modules and parts without damage
- Damaged modules and parts with written approval from DuPont with a specific reference to the damaged module or part

DuPont decides on the procedure (approval or block) for all damaged modules or parts that have not been approved.



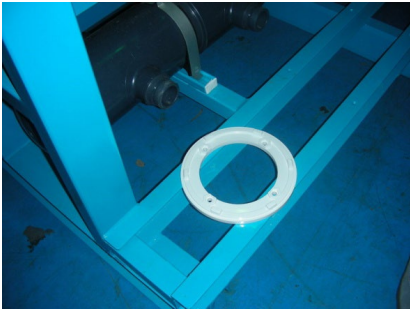


 CAUTION	
	DANGER OF INJURY! Danger of injury during operation due to the installation and use of damaged parts. <ul style="list-style-type: none">• Only use undamaged parts or parts approved by DuPont!






Step	Activity	Figure
c)	Place two liquid collection basin beneath the module ends.	
d)	Dismount module shipping plugs at two ends, and the concentrate plug.	
e)	Remove X-rings and concentrate seal, keep them clean and restore for use.	
e)	Remove X-rings and concentrate seal, keep them clean and restore for use.	
f)	Gradually lift module at filtrate end, keep the module at the inclined angel (<30 degree) and empty the storage solution from feed opening.	



Cautions:

- Each non-anti-freezing module (GMID 99088897, 99088898) contains 4 L storage solution, the major ingredients of the liquid are 1.3% Sodium Metabisulfite, 2.5% Sodium Citric, with the pH at 4~5, CODCr at around 26,000mg/L. Each anti-freezing module (GMID 99090016, 99089156) contains 23L storage solution, the major ingredients of the liquid are 1.2% Sodium Metabisulfite, 2.5% Sodium Citric and 60% glycerin, with the pH at 4~5, CODCr at around 730,000mg/L. Please choose liquid collection basin with proper volume.
- Please dispose the storage solution in compliance with local regulations.
- Always keep the X-rings and seals clean, preventing dust and particle contamination.
- Wear safety goggle and latex glove before opening end caps, be careful of the liquid when dismounting the blind plates and concentrate plug. If storage solution splashes to the operators' hands and skid, please rinse with water immediately.
- Do not lift module too much to slide it off the shelf or platform.

5.6 Mounting Module

Step	Activity	Figure
1	Prepare the module	
	a) Connect the air connection in the bottom end cap of the module before placing the module in vertical position.	
	b) Install the air scour flexible tubing for the air scour system	
	c) Place the module base on the right position in the rack. Insert the bolts in the openings and tighten with the nuts.	
	d) Check the position of the module connections.	
2	Placing the module	
	a) Overhead bridge crane and strap are used to lift the module. Operator(s) should guide and position the UF module.	

Step	Activity	Figure
b)	Feed (Bottom) End of UF module positioned for placement onto the base clip.	
c)	Place the module vertically on the appropriate connection point. Make sure that the connections on the module are flush with the connections on the rack.	
d)	Install loose end of strap (module clamp) to restrain UF module onto UF skid.	
e)	Connect air scour flexible tubing to air scour feed header pipe.	
3	<p>Lubricate the gaskets with glycerin</p> <ul style="list-style-type: none"> a) Remove the gasket rings of the 2" composite coupling set. b) Lubricate the gaskets with glycerin on the inside and outside. c) Place a lubricated gasket ring over a connection on the module. d) Push the gasket ring onto the connection so that it is flush with the connection. e) Repeat procedures a) to d) for all further connections on the module. 	

Step	Activity	Figure
4	<p>Installing the connection points</p> <p>a) Position on the module's connector.</p> <p>b) Pull the gasket ring from the connector over the 2" connection so far that it is placed in the middle between the grooves of both parts.</p> <p>c) Place a flexible coupling 2" half shell around the gasket. Ensure that the contact surfaces of the coupling half shells are resting in the provided grooves.</p> <p>d) Place the second flexible coupling 2" half shell on the first and insert the bolts in the openings.</p> <p>e) Tighten the flexible coupling 2" with two nuts M10 and washers using an open-end or box wrench (size 17) until the contact surfaces of both coupling halves are flush and resting against each other without a gap. Ensure that the nuts are tightened evenly and alternately.</p> <p>f) Repeat steps a) to e) for all three connections of the module.</p>	 

6. Service and Maintenance

6.1 Checks during Operation

Checking for Leak Tightness

Regular general maintenance work on I DuPont™ IntegraTec™ Modules should include checking the tightness and proper working order of all joints and connections (flanges, valves, couplings, etc.) and repairing any damage that may have occurred.

6.2 Eliminating Leaks

Eliminate leaks by exchanging the corresponding coupling components and pipe connections. When doing so, note the warnings and instructions provided in section 5 Installation / Assembly, as applicable.

6.3 Returning Modules

Returns shall only be accepted if this has been agreed in advance with DuPont and authorized in writing. Returns that have been previously agreed and approved by DuPont are subject to the following mandatory requirements:

- All components must be rinsed and cleaned before being returned.
- Modules must be preserved during storage and transport.

7. Disassembly and Disposal

7.1 Checks during Operation

Disassembly work may only be performed by trained and qualified personnel or by a suitable specialist company.

Adequate clear space for movement must be provided to perform the work. The danger area should, if necessary, be marked for third parties and/or cordoned off. The disassembly is performed in reverse order to the assembly.

For details, see section 5 Installation / Assembly

7.2 Checks during Operation

During disposal of the DuPont™ IntegraTec™ Modules, note the following specifications:

- Adhere to the applicable local disposal regulations.
- Adhere to the legal regulations regarding environmental protection.



Have a question? Contact us at:

www.dupont.com/water/contact-us

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