



SCHOTT



SCHOTT PBR
installation and
operation manual

Safety and handling

Where others say no, we say yes.

Because at SCHOTT we believe that shared responsibility can release the energy to achieve the impossible. As a global material technology group, we are constantly exploring unique and innovative ways to make a difference for businesses and people. Being a foundation company, SCHOTT has anchored responsibility, scientific research, society and the environment deeply in its DNA. Represented in over 30 countries by 17,400 employees, we are a highly skilled partner for many high-tech industries. Whatever challenges the future might hold, we can't wait to come up with innovative solutions and turn visions into reality.

With a production capacity of round about 230,000 tons and production sites in Europe, South America and Asia, SCHOTT Tubing is one of the world's leading manufacturers of glass tubes, rods and profiles. More than 60 different glass types are produced in a large variety of dimensional and cosmetic specifications based on a standardized production process and a global quality assurance system. SCHOTT Tubing provides customized products and services for international growth markets such as pharmaceuticals and electronics as well as industrial and environmental engineering.



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Safety measures

You are dealing with glass components. It is their natural behavior upon breakage to create pointed and sharp pieces that may cause injuries. **Generally, handle glass with care!**

1 Photobioreactor (PBR) systems are open to the atmosphere and use filters at both the compressed air or gas inflows and any outlets open to the environment, to prevent contamination. PBR systems are typically not operated under positive pressure or vacuum conditions (pressure equipment). Do not stand close to the photobioreactor longer than necessary. The glass components are designed for much higher loads than those occurring during general operation, but it is the natural behavior of glass to sometimes also break at very low stress (although at extremely low statistical probability). Whenever in close proximity to the photobioreactor, wear goggles, safety gloves, safety shoes and solid clothing which

covers the complete body. Ideally, to avoid accidental approach to the photobioreactor, close off the complete area by fences.

2 When carrying glass components, e.g. after unpacking or during restructuring of the PBR, the walk-ways should be clear and should provide sufficient space not to hit other objects.

3 Tubes that obviously have mechanical defects (scratches, cracks, etc.) should not be installed or put into operation. These tubes have an increased risk of breakage.

The information contained in this manual is intended to ensure the safe handling and installation of SCHOTT glass tubes. SCHOTT shall not be liable for any damage resulting from improper use, disregard of the instructions, or the use of non-approved materials.

Handle glass with care!

4 When installing or renewing tubes at an elevated position, take care that no people are located underneath – ideally, close off the area.

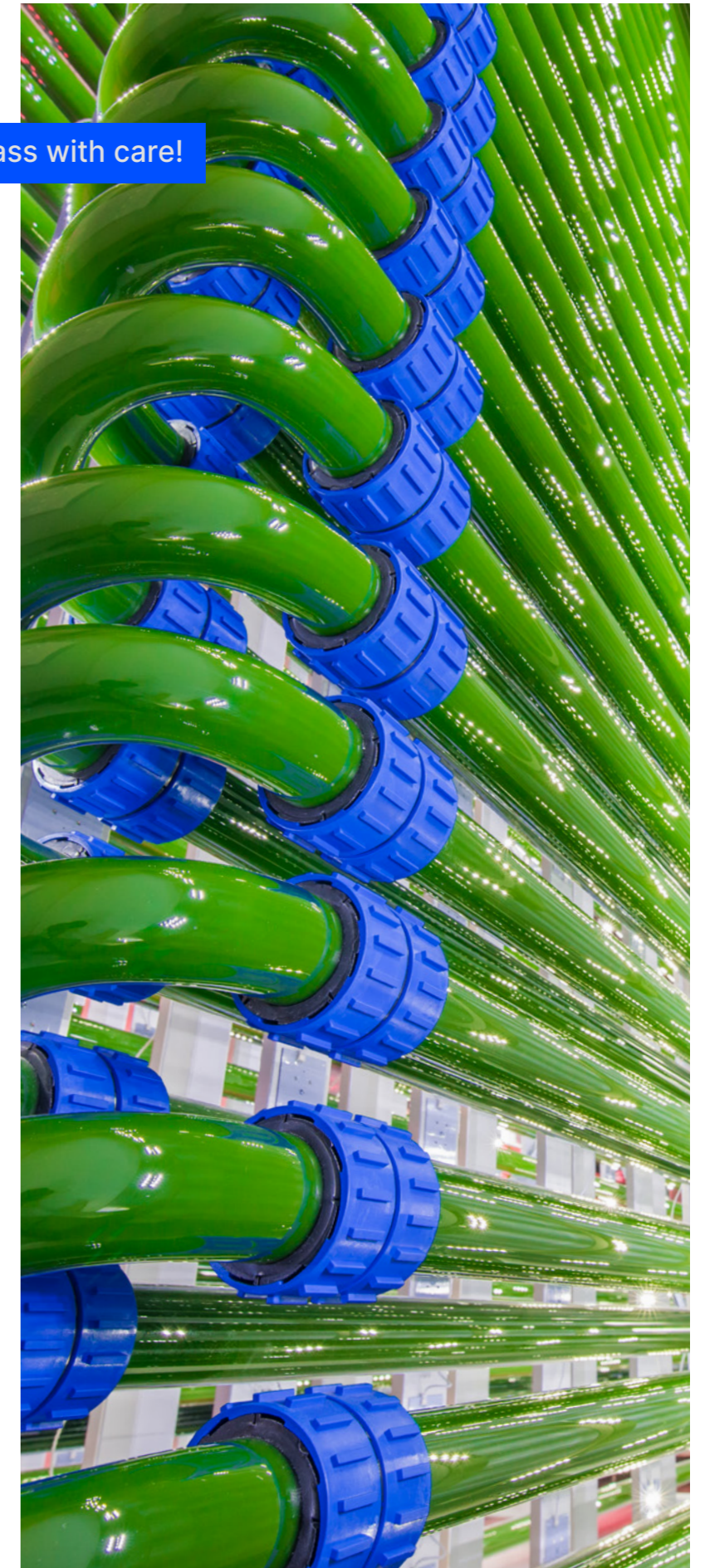
5 SCHOTT recommends wearing goggles and work gloves during transport and handling of glass components and safety shoes when handling heavy glass components.

6 Take care that the tubes lie firmly in their final positions and that the U-bends are mounted correctly to prevent them from being pushed off when the PBR is pressurized.

7 SCHOTT recommends the installation of pressure sensors that open up safety valves and shut down pumps. The sensors should be installed at positions where the highest inside pressures are expected. Note that the inside pressure has three individual contributions: hydrostatic and hydrodynamic pressure components and pressure burst from the pumps. In a worst case scenario, the pump may operate against a clogged tube and build up very high pressures inside the tubular system.

8 SCHOTT recommends a water leak test of the entire photobioreactor before commissioning.

PBR system/microalgae plant:
© Algalif Iceland ehf., Iceland



Installation instructions

This document provides recommendations and information for the handling and installation of glass tubes for photobioreactors. It refers to all dimensions and gives specific information for tubes with standard diameters of 54 mm and 65 mm.

Storage

SCHOTT products for algae cultivation must be stored in dry conditions in closed buildings. The floor must be level and horizontal and have a load-bearing capacity of 1,000 kg/m². Do not stack more than 3 pallets on top of each other. Only move unstacked!

Installation – general comments

The tubes are made of glass. Handle them with care and avoid all contact of the glass components with any other solid objects. When handling the glass tubes and laying them into the supports for their final position always deploy at least two people.

Wear at all times goggles, safety gloves, safety shoes and solid clothing which covers the complete body.

Never let two tube ends get into direct contact with each other. They may break, or the contact may cause small microcracks that can lead to breakage during operation.

Make sure that both, tube ends and couplings are clean before installation. In particular, any sand or similar abrasive material that might scratch the glass surface must be completely removed.

Support distance

It is required to support the tubes at two symmetric positions that typically lie at one quarter of the total tube length from either tube end. The following support positions are recommended by SCHOTT – given as distances from each end:


	54 mm tube L = 5,500 mm	65 mm tube L = 5,500 mm
First support [mm] [inch]	1375 54.1	1375 54.1
Unsupported middle [mm] [inch]	2750 108.3	2750 108.3
Second support [mm] [inch]	1375 54.1	1375 54.1

Table 1: Support distances for glass tubes. In these configurations the ends of water-filled tubes will sag by less than 5 mm and the ends will form an angle of less than 1° with the horizontal.



Ensure that tube supports are capable of holding the maximum mass of a water filled tube as specified below under „Data Sheet Glass Tubes“ (see page 8).



Handle glass with care: Have the tubes laid into their position by two people.



SCHOTT couplings provide a spacer on the inside to prevent the glass tubes from touching each other.

Support shape and material

The tube support should hold the tube in place while not exerting a pressure higher than 1 MPa onto the glass surface. SCHOTT recommends supports with round, bowl-like shapes that hold the tubes in place and that distribute the pressure over large areas on the tube perimeter.

The material in immediate contact with the glass tube should be a soft material, e.g. a polymer or rubber sleeve on a metal support. Avoid direct metal-glass contacts and mechanical stress peaks.

Max. pressure of support on tube	1 MPa 145 psi
Support shape	round (bowl like)
Support area in contact with the tube	> 10 cm ² 1.5 in ²
Surface material in contact with tube	a soft material like rubber or polymer

Couplings

When connecting tubes or glass components a direct glass-to-glass contact must be avoided. Couplings should keep the tube ends apart from each other and should provide a smooth tube-to-tube transition. Note that under thermal expansion the tube ends approach each other. SCHOTT couplings are designed for compensating this expansion.

Thermal expansion [mm] [inch]	54 mm tube L = 5,500 mm	65 mm tube L = 5,500 mm
ΔT = 20 °C = 36 °F	0.36 0.014	0.36 0.014
ΔT = 40 °C = 72 °F	0.73 0.029	0.73 0.029

Table 2: Thermally induced expansion of glass tubes at two exemplary temperature changes



Please note for standard couplings a 40 Nm torque should be applied and 25 Nm torque for the slim couplings.

For installation of the SCHOTT PBR couplings, see tutorial starting on page 9



Pressure limits and fixture

The PBR system components have a pressure resistance of 3 bar, which requires defect-free glass tubes, U-bends, and couplings, as well as proper installation procedures. In typical PBR systems operating under typical hydrostatic and hydrodynamic pressures, which are significantly below the pressure resistance, couplings hold the U-bends in place.

To ensure optimal friction between glass and couplings, the surfaces must be clean and free of grease. Always wear gloves during installation, and tighten the couplings at a temperature between 20 °C and 30 °C using the calibrated torque wrench for optimal performance. If the U-bends become displaced from the sealing lips of the couplings, mechanical fixtures **are required** to keep the U-bends in place.



Inside pressures and forces that tend to push off each U-bend arm:

Pressure [bar] [psi]	54 mm tube 1.8 mm Force [N]	65 mm tube 2.2 mm Force [N]
1 14.5	200	288
2 29.0	399	577
3 43.5	599	865

Table 3: Force on each arm of a U-bend as a function of inside pressure and outside tube diameter. Conversion: 1 bar = 14.5 psi

Data sheet glass tubes

The following gives an overview of nominal values of standard tube parameters that may be useful for installation. Coefficient of thermal expansion [K⁻¹]: 3.3 · 10⁻⁶

	54 mm tube L = 5,500 mm	65 mm tube L = 5,500 mm
Outer diameter OD [mm] [inch]	54 2.13	65 2.56
Wall thickness WT [mm] [inch]	1.8 0.071	2.2 0.087
Length OD [mm] [inch]	5,500 216.54	5,500 216.54
Inner volume [l] [gal]	10.97 2.90	15.86 4.19
Mass of empty tube [kg] [lb]	3.62 7.98	5.32 11.74
Mass of water filled tube [kg] [lb]	14.59 32.17	21.19 46.71

Table 4: Overview of standard tube geometries and quantities (all nominal values). Conversion: 1 pound (lb) = 0,4536 kg, 1 inch = 25.4 mm, 1 gallon (gal) = 3.7854 l



Installation of the SCHOTT PBR couplings

Watch the video!

This tutorial guide provides you with all the information that you need to successfully install your PBR couplings, open the couplings or replace the tubes. It begins with the tools and product types required, followed by a step-by-step guide includes additional information or assistance, please follow the link or QR code to watch our tutorial video.





SCHOTT tool kit

Tools and products Required tools

The following tools are contained in the SCHOTT tool kit for the installation and dismantling of our tubular glass photobioreactor. There are two different tool kits available according to the coupling type used. The necessary tools for the particular instruction are depicted on top of each tutorial.

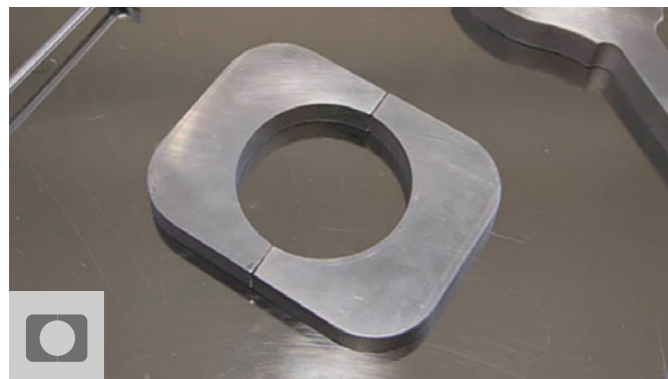
Defined value for torque:
Standard coupling 40 Nm
Slim coupling 25 Nm



Torque wrench (Standard coupling: 40Nm, Slim coupling: 25 Nm)



Jaw wrench



Coupling opener



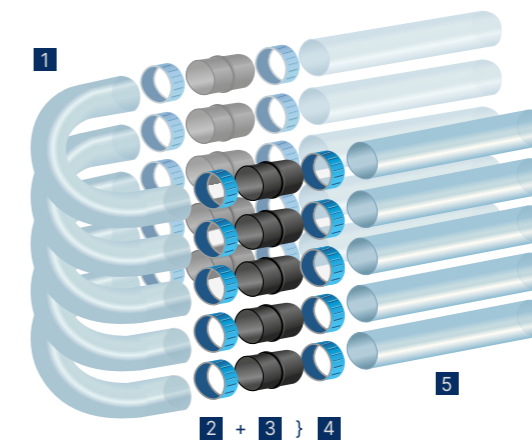
Dismantling tool

Tools and products Product range

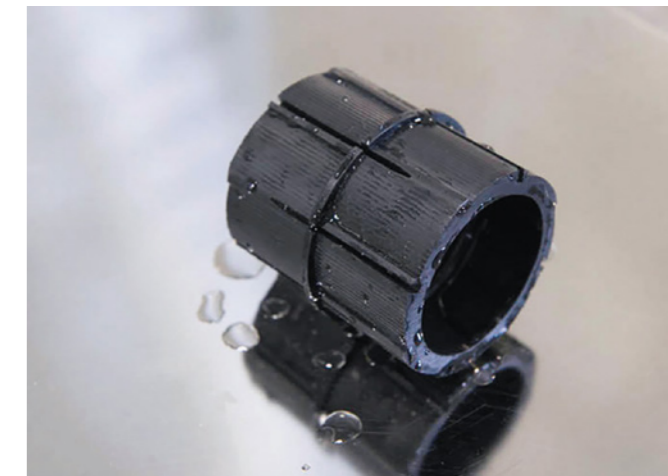
The SCHOTT couplings can be used for all PBR systems. All couplings types consist of one cage and two nuts – standard, slim, maintenance and adapter currently available for sizes 54 mm and 65 mm. See images below.

Helical system

- 1 U-bend
- 2 Nut
- 3 Cage
- 4 Coupling
- 5 Tubing



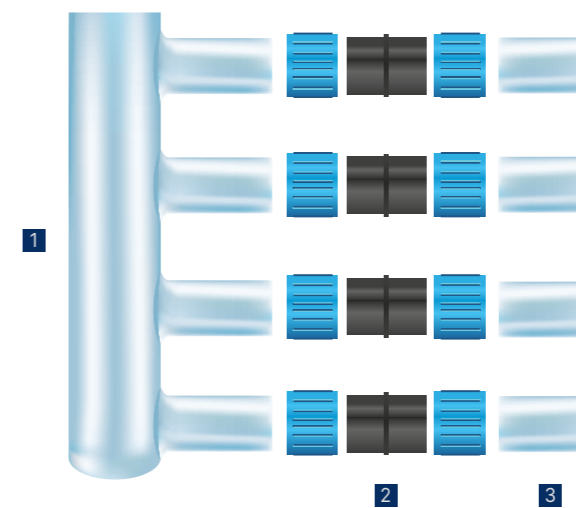
Nut



Cage

Fence system

- 1 Manifold
- 2 Coupling
- 3 Tubing



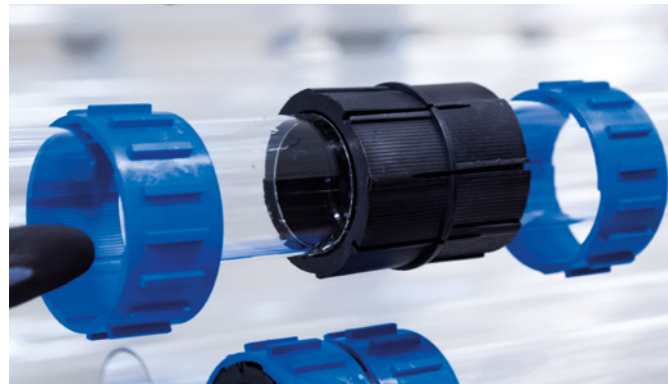
horizontal
or vertical
orientation



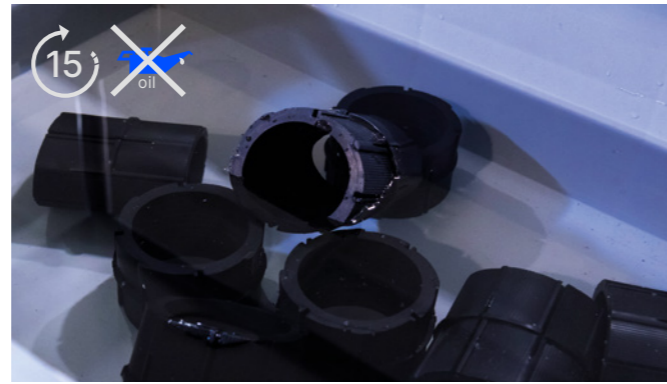
Couplings

Instructions Coupling installation

For a safe connection of the tubular glass parts you will need the torque wrench and the jaw wrench. These tools are used to tighten the couplings.



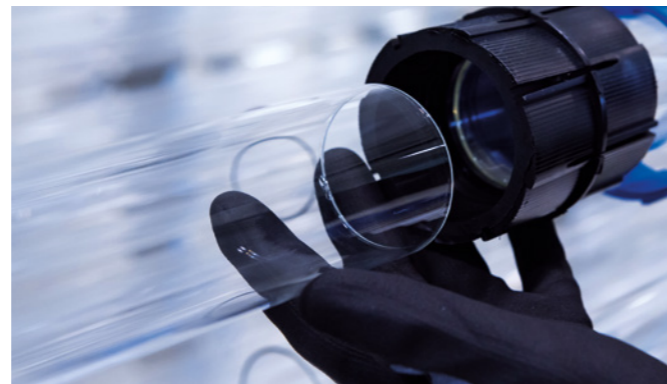
1 The connection of two tubes requires one coupling that consists of two blue nuts and one black cage.



2 Place the cages into warm water (approx. 50°C / 122°F) for a minimum of 15 minutes to allow an easier gliding of the cage over the tube end. The water will lubricate and expand the cage. Please do not use any other lubricants, such as oils or silicones.



3 After positioning the glass tubes slide the blue nuts over the adjacent tube ends. A correct orientation of the nuts is essential.



4 Now take the cage out of the water and push it over one tube end. It is essential to push the cage over the glass tube all the way to the spacer.



5 The other glass tube can now be pushed into the other end of the cage and both tubes are now in their final position. Push the nuts over the cage.



6 Take the correct torque wrench and place it on the left side of the coupling. Required torque for Standard Couplings is 40Nm, for Slim Couplings it is 25Nm. It is important to affix the draw-hook of the tool on the side averted to the body. Make sure there is enough space for the torque wrench to tighten.



7 The jaw wrench should be placed accordingly on the right side of the coupling.



8 Now turn the wrenches in opposing directions until the torque wrench tilts towards your body. The connection process is now completed.



9 Repeat these steps with all other couplings. For the connection of the tube levels please use the U-Bends. The installation of the couplings at the U-Bends is the same as shown before. First, affix two couplings to the U-Bend up to the spacers inside the cages.



10 Next push the U-Bend over two tube ends at the same time. Afterwards tighten the blue nuts as shown, before the U-Bend is fully mounted to the system.

Instructions

Coupling opening

For opening the couplings, the dismantling tool and the coupling opener are required. Please only use the provided tools for these steps.



Note: For opening do not reverse the installation process. This will damage the coupling.



1 Assemble the coupling opener in the middle of the coupling and pull the nuts off the cage, see image on page 8. In case of difficulties with the dismantling the process can be assisted using a rubber mallet.



2 At this point, you may already be able to simply pull the tubes apart. If the tubes are difficult to remove from the cage, you can use the dismantling tool. Slip the nose of the tool into the slit of the cage and pry it open.



3 You can now pull one tube out of the cage and remove the cage from the other tube.



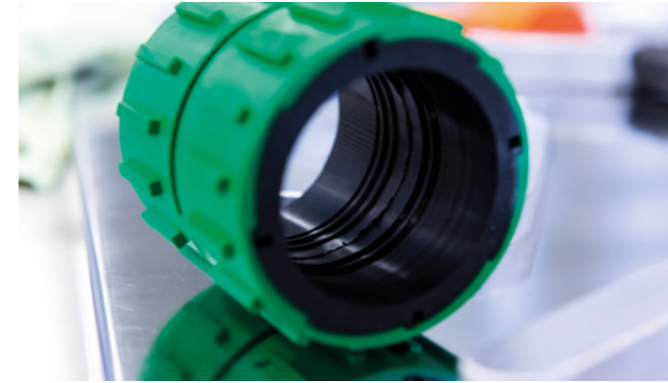
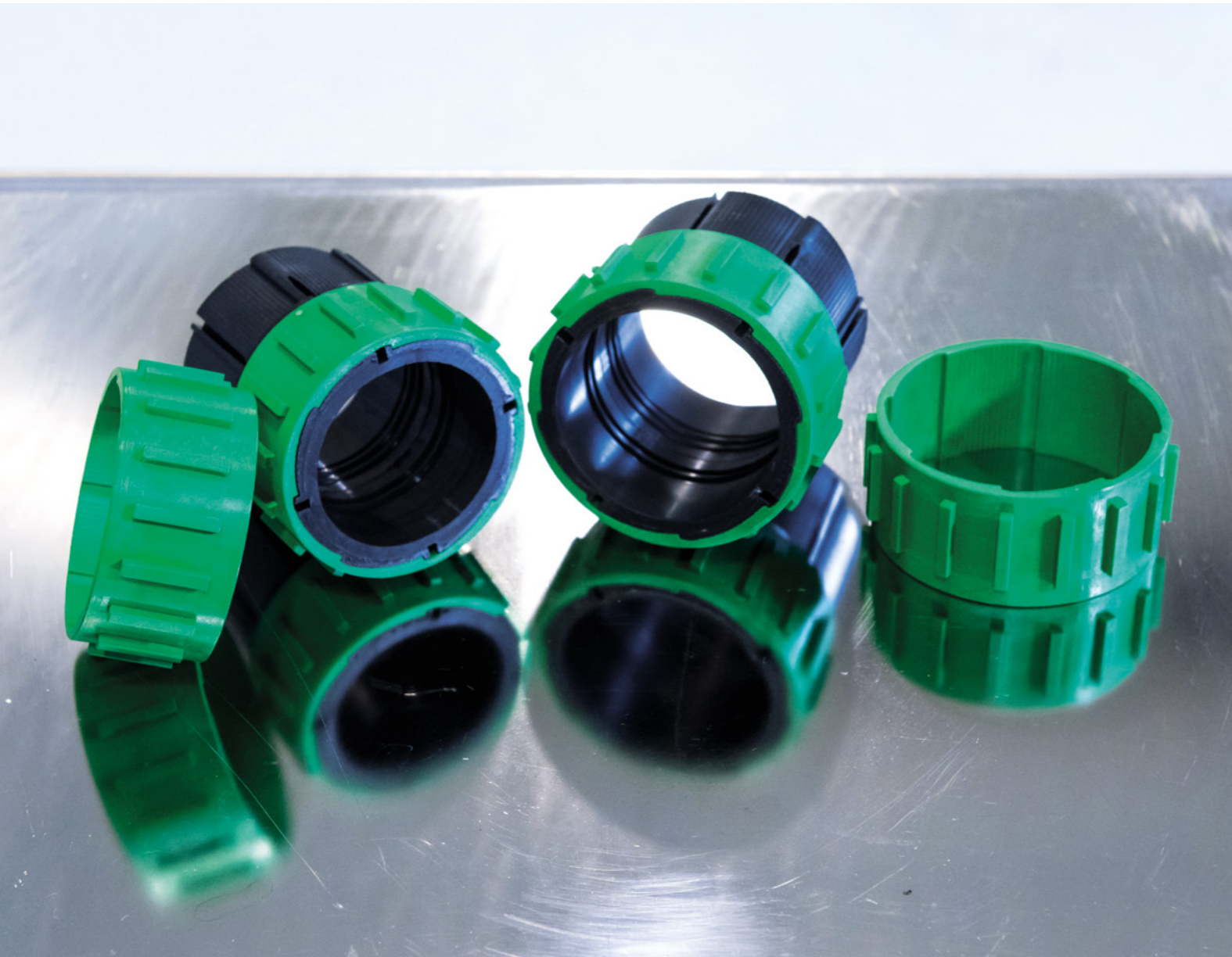
4 Finally wash all components with clean warm water so that they are ready to be reused or stored. Dry all components thoroughly before storage.



Instructions

Individual tube replacement

For this process, the dismantling tool, the torque wrench, the jaw wrench and the coupling opener are required. Please only use the provided tools for these steps. Note: Make sure to use the required torque depending on the coupling type: Standard = 40Nm, Slim = 25Nm.



1 For the replacement of single tubes, you need to use a green maintenance coupling. The difference to the blue standard couplings is the missing spacer in the middle of the cage, that allows you to push the cage completely over the tube.



2 For replacing a tube you will need one standard coupling that is to be pushed over one end of the replacement tube.



3 Push the nut and the cage of the maintenance coupling completely over the other end of the new tube. Slide the other green nut over the end of the already installed tube.



4 Now take the tube and push the standard coupling at a very flat angle into the already installed tube of the system. Be sure to avoid glass to glass contact on the other end.



5 Now push the cage of the maintenance coupling half way over the other tube.



6 The gap between the tubes must be located in the middle of the coupling. You can now close both couplings with the provided tools. Note: Make sure to use the required torque depending on the coupling type: Standard = 40Nm, Slim = 25Nm

Operating instructions



Inside pressure

When operating the photobioreactor make sure to not exceed the specified maximum pressure resistance of the components (for OD 54 mm or 65 mm = 3 bar). Note that the friction of the water flow increases with a square law dependence with the flow speed and therefore higher flow speeds may increase the inside pressure above tolerable levels. Prevent pressure bursts from the pumps.

Temperature

When the outside temperature drops below 0 °C (32 °F) the photobioreactor must be emptied. Freezing water inside the tubes will break the tubes.

Inside cleaning procedure

The tubes are made from borosilicate glass which is chemically resistant. The elastomer of the couplings is EPDM, a material that is known for its high chemical stability which has been proven in the following conditions:

Agent	Chemical formula	Concentration	Temperature	Duration
Citric acid	C ₆ H ₈ O ₇	1%	40 °C	50 days
Hydrogenperoxide	H ₂ O ₂	6%	40 °C	25 days
Sodiumhydroxide	NaOH	4%	40 °C	20 days
Hydrochloric acid	HCl	3.6%	40 °C	60 hours
Salt water	NaCl	4%	40 °C	5 years

The couplings are stable under above conditions. Duration describes the continuous exposure in the given interval (1 day = 24h).

The exposure of the coupling to a chemical agent may occur in several periods distributed over its lifetime. However, the overall exposure time and chemical impact must not be exceeded beyond the data listed in the above table. Please contact SCHOTT before you use other agents than listed.

When using a pig (cleaning sponge) make sure it is free from sand or similar abrasive agents to prevent scratching the inside of the tubes. Use sponges that are soft enough to move through the U-bends without getting stuck.

Outside cleaning procedure

When cleaning the outside do not use abrasives and make sure to not accidentally scratch the tubes with sand or similar agents attached to the surface.

For the outside cleaning as well as for cooling purposes of the PBR tubes, the use of demineralized water (< 1 µS) is strongly recommended to avoid the sedimentation of scale and others that might reduce the transmission of the glass.

Cleaning with demineralized water can be supported by high pressure washers. Please ask SCHOTT for approval of your special set-up (distance to glass tube, max. allowed pressure, effective angle of spray nozzle, etc.). For already existing normal dirt & stains common household glass cleaners can be used.

In case of persistent contamination, the use of special adapted industrial cleaners may be required. The selected cleaner needs approval of SCHOTT, in order to avoid any impact to the glass surface or coupling material.

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