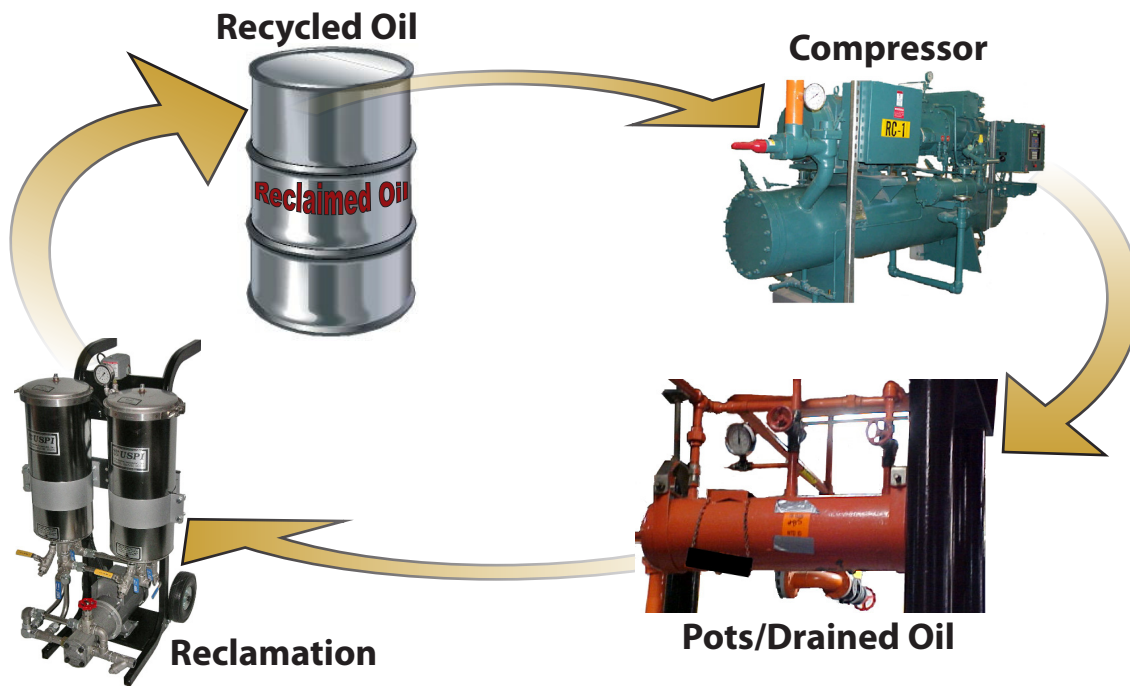




## Reclaiming Used NH3 Oil



1. Collect all waste ammonia oil in a 55-gallon drum that is marked 'Collected Waste NH3 Oil' which is dedicated **solely** to NH3 oil to avoid fluid cross-contamination.
2. Take an oil sample of the collected waste oil and send it off to the lab to confirm that the oil's parameters are OK for re-use. Once USPI has given the OK, you can go on to the next steps.
3. When the 55-gallon drum is full (approximately 4" from the top), attach & plug in a USPI 1500 watt belt heater for 8-12 hours **DO NOT EXCEED 140°F!** This will drop the 'heavy' particulate and free water to the bottom of the drum to be pumped off so it doesn't clog the USPI filter elements.
4. Place a 3-1/2" (2x4 on edge) block under one edge of the 55-gallon drum or use a USPI OD Wedge.
5. Attach a 3/4" x 48" notched pipe to the end of suction hose and insert the notched end into the 2" bung and lower the notched pipe to the bottom of the 55-gallon drum (lowest point).
6. Using the USPI 87DA on transfer mode (close off the canister ball valves so handles are in horizontal position), pump all the water and heavy particulate (approximately 3-5 gallons), which has settled on the bottom of the 55 gallon drum, into a 5 gallon bucket and dispose of it.
7. Put the return hose into a **SECOND CLEAN** 55-gallon drum and transfer the remaining waste oil from the initial waste drum into the second 'Recycle NH3 Only' drum. Place a 3-1/2" (2x4 on edge) block under one edge of the 55-gallon drum or use a USPI OD Wedge.
8. Insert the notched pipe suction into the second drum and switch the 87DA to filter mode (open canister ball valves so handles are in vertical position).
9. Attach return hose to the small bung hole on top of the 55 gallon drum to create a loop cycle.
10. Put your belt heater on the second drum to heat up the oil for lower pressures and better flow on the USPI 87DA portable. **DO NOT EXCEED 140°F!**
11. Begin filtering the remaining waste oil at 25-30 PSI for 24 to 48 hours.
12. Before turning off the unit or making any adjustments, take a sample of the filtered oil (using WearCheck kits) after completion of filtration and send it to the lab to make sure the oil is clean for re-use.
13. Mark the paper form as "Recycled NH3 oil" or "Recycled Drum #1" for clear identification.
14. Shut down the 87DA unit and belt heater, let the oil cool down, put the bungs loosely in place to keep drum sealed but to allow the drum to breath, and wait for the results to be sent to you before re-using the oil. Never store the drum outdoors!