

Fluid Cooling Shell & Tube HC Series

COPPER & STEEL CONSTRUCTION

Performance Notes

- Preferred for new oil-water applications
- Rugged steel construction
- Low cost
- NPT, SAE O-Ring, SAE flange, or BSPP shell side connections available
- End bonnets removable for servicing
- Mounting feet included (may be rotated in 90° increments)



OPTIONS

Optional material construction on tubes, tubesheets and end bonnets

Ratings

Maximum Operating Pressure - Shell Side
300 PSI*

Maximum Operating Pressure - Tube Side
150 PSI

Maximum Operating Temperature
300°F

Materials

Tubes Copper

Tubesheet Carbon steel

Shell Carbon steel

Baffles Carbon steel

End Bonnets Cast iron

Mounting Brackets Carbon steel

Gaskets Nitrile rubber/cellulose fiber

Nameplate Aluminum foil

How to Order

	-		-		-		-		-		-					
Model Series		Model Size Selected		Baffle Spacing (See page xx for options)		Tube Diameter Code 4 - 1/4" (standard for 600 & 800 Series) 6 - 3/8" (standard for 1000, 1200 & 1700 Series)		Tubeside Passes 0 - One Pass T - Two Pass F - Four Pass		Cooling Tube Material Blank - Copper CN - CuNi SS - Stainless Steel AD - Admiralty Brass		End Bonnet Material Blank - Cast Iron B - Bronze SB - Stainless Steel		Tubesheet Material Blank - Carbon Steel W - CuNi S - Stainless Steel		Zinc Anodes Blank - None Z - Zinc

HC = NPT Shell Side Connectors; NPT Tube Side Connections

HCS = SAE ORB Shell Side Connectors; NPT Tube Side Connections

HCF = SAE Code 61 Flanges on Shell Side (UNC Threads); NPT Tube Side Connections

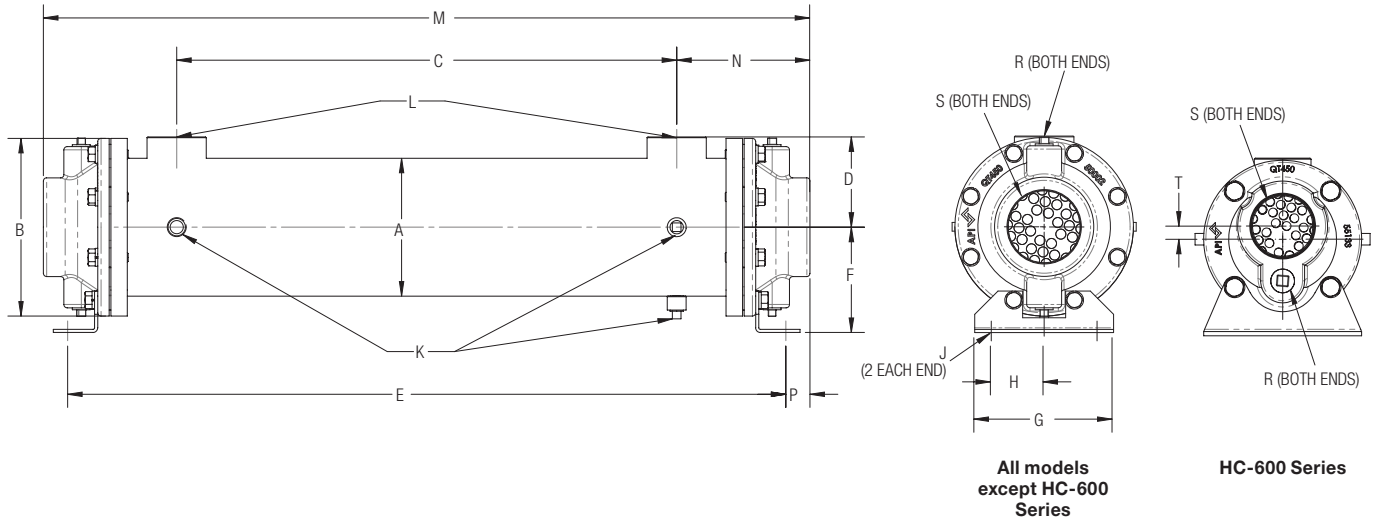
HCM = BSPP Shell Side Connectors; BSPP Tube Side Connections

*HCA = 150# ASME RF Flanges on Shell Side; NPT Tube Side Connections. Shell Maximum Pressure Rating is 150 psi

HCFM = SAE Code 61 Flanges on Shell Side (Metric Threads); NPT Tube Side Connections

Dimensions

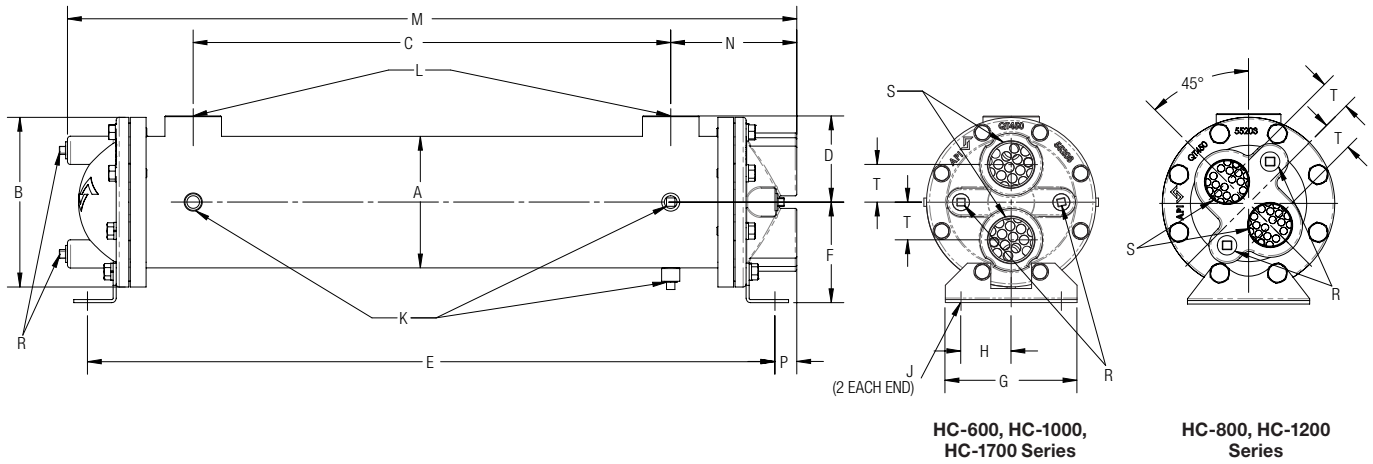
One Pass



Model	A	B	C	D	E	F	G	H	J	K NPT	L NPT	M	N	P	R NPT	S NPT	T
614	3.27	4.50	10.00	2.31	16.37	2.75	4.50	1.63	0.44	0.25	1.00	17.31	3.66	0.47	.38 (2)	1.50	0.38
624	3.27	4.50	20.00	2.31	26.37	2.75	4.50	1.63	0.44	0.25	1.00	27.31	3.66	0.47	.38 (2)	1.50	0.38
814	4.25	6.00	9.00	3.13	16.50	3.50	4.25	1.75	0.44	0.25	1.50	17.88	4.44	0.69	.38 (2)	2.00	—
824	4.25	6.00	19.00	3.13	26.50	3.50	4.25	1.75	0.44	0.25	1.50	27.88	4.44	0.69	.38 (2)	2.00	—
836	4.25	6.00	31.00	3.13	38.50	3.50	4.25	1.75	0.44	0.25	1.50	39.88	4.44	0.69	.38 (2)	2.00	—
1014	5.24	6.75	9.00	3.43	17.29	4.00	5.25	2.00	.50 x .75	0.25	1.50	19.13	5.06	0.92	.38 (4)	2.00	—
1024	5.24	6.75	19.00	3.43	27.29	4.00	5.25	2.00	.50 x .75	0.25	1.50	29.13	5.06	0.92	.38 (4)	2.00	—
1036	5.24	6.75	31.00	3.43	39.29	4.00	5.25	2.00	.50 x .75	0.25	1.50	41.13	5.06	0.92	.38 (4)	2.00	—
1224	6.26	7.75	18.25	4.06	27.00	4.50	6.25	2.50	.50 x .75	0.38	2.00	29.63	5.69	1.31	.50 (4)	3.00	—
1236	6.26	7.75	30.25	4.06	39.00	4.50	6.25	2.50	.50 x .75	0.38	2.00	41.63	5.69	1.31	.50 (4)	3.00	—
1248	6.26	7.75	42.25	4.06	51.00	4.50	6.25	2.50	.50 x .75	0.38	2.00	53.63	5.69	1.31	.50 (4)	3.00	—
1260	6.26	7.75	55.25	4.06	63.00	4.50	6.25	2.50	.50 x .75	0.38	2.00	65.63	5.69	1.31	.50 (4)	3.00	—
1724	8.62	10.50	17.00	5.43	27.25	5.75	7.25	3.50	.63 x .88	0.38	3.00	31.75	7.38	2.25	.50 (4)	4.00	—
1736	8.62	10.50	29.00	5.43	39.25	5.75	7.25	3.50	.63 x .88	0.38	3.00	43.75	7.38	2.25	.50 (4)	4.00	—
1748	8.62	10.50	41.00	5.43	51.25	5.75	7.25	3.50	.63 x .88	0.38	3.00	55.75	7.38	2.25	.50 (4)	4.00	—
1760	8.62	10.50	53.00	5.43	63.25	5.75	7.25	3.50	.63 x .88	0.38	3.00	67.75	7.38	2.25	.50 (4)	4.00	—
1772	8.62	10.50	65.00	5.43	75.25	5.75	7.25	3.50	.63 x .88	0.38	3.00	79.75	7.38	2.25	.50 (4)	4.00	—

Dimensions

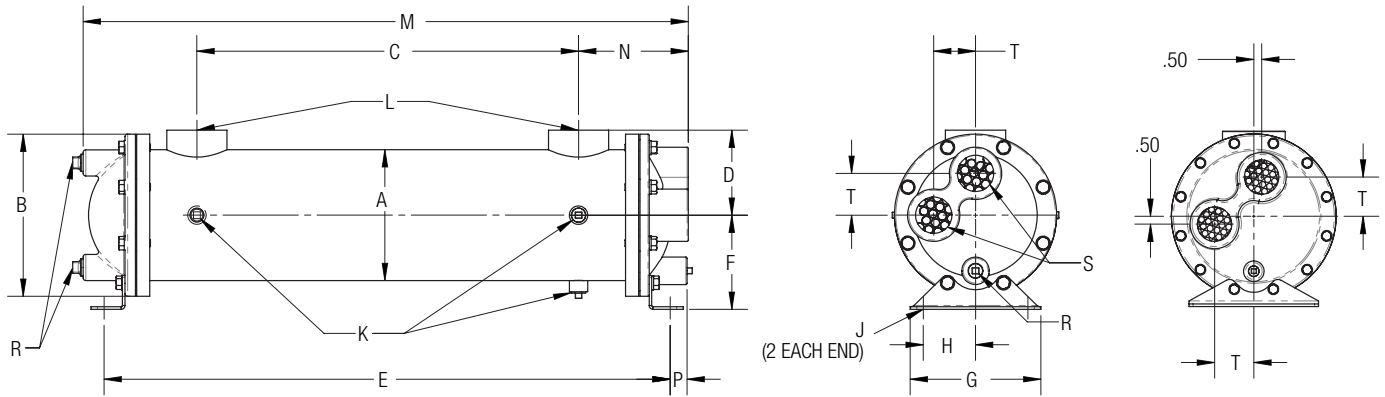
Two Pass



Model	A	B	C	D	E	F	G	H	J	K NPT	L NPT	M	N	P	R NPT	S NPT	T
614	3.27	4.50	10.00	2.31	16.37	2.75	4.50	1.63	0.44	0.25	1.00	17.20	3.64	0.45	.38 (4)	1.00	1.00
624	3.27	4.50	20.00	2.31	26.37	2.75	4.50	1.63	0.44	0.25	1.00	27.20	3.64	0.45	.38 (4)	1.00	1.00
814	4.25	6.00	9.00	3.13	16.56	3.50	4.25	1.75	0.44	0.25	1.50	17.88	4.44	0.69	.38 (4)	1.25	1.06
824	4.25	6.00	19.00	3.13	26.56	3.50	4.25	1.75	0.44	0.25	1.50	27.88	4.44	0.69	.38 (4)	1.25	1.06
836	4.25	6.00	31.00	3.13	38.56	3.50	4.25	1.75	0.44	0.25	1.50	39.88	4.44	0.69	.38 (4)	1.25	1.06
1014	5.24	6.75	9.00	3.43	17.35	4.00	5.25	2.00	.50 x .75	0.25	1.50	19.02	5.02	0.87	.38 (4)	1.50	1.50
1024	5.24	6.75	19.00	3.43	27.35	4.00	5.25	2.00	.50 x .75	0.25	1.50	29.02	5.02	0.87	.38 (4)	1.50	1.50
1036	5.24	6.75	31.00	3.43	39.35	4.00	5.25	2.00	.50 x .75	0.25	1.50	41.02	5.02	0.87	.38 (4)	1.50	1.50
1224	6.26	7.75	18.25	4.06	27.06	4.50	6.25	2.50	.50 x .75	0.38	2.00	28.94	5.25	0.88	.38 (2 - 1/0) .50 (2 - RET)	2.00	1.56
1236	6.26	7.75	30.25	4.06	39.06	4.50	6.25	2.50	.50 x .75	0.38	2.00	40.94	5.25	0.88		2.00	1.56
1248	6.26	7.75	42.25	4.06	51.06	4.50	6.25	2.50	.50 x .75	0.38	2.00	52.94	5.25	0.88		2.00	1.56
1260	6.26	7.75	55.25	4.06	63.06	4.50	6.25	2.50	.50 x .75	0.38	2.00	64.94	5.25	0.88		2.00	1.56
1724	8.62	10.50	17.00	5.43	27.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	30.07	7.20	2.08	.50 (4)	2.50	2.25
1736	8.62	10.50	29.00	5.43	39.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	42.07	7.20	2.08	.50 (4)	2.50	2.25
1748	8.62	10.50	41.00	5.43	51.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	54.07	7.20	2.08	.50 (4)	2.50	2.25
1760	8.62	10.50	53.00	5.43	63.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	66.07	7.20	2.08	.50 (4)	2.50	2.25
1772	8.62	10.50	65.00	5.43	75.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	78.07	7.20	2.08	.50 (4)	2.50	2.25

Dimensions

Four Pass

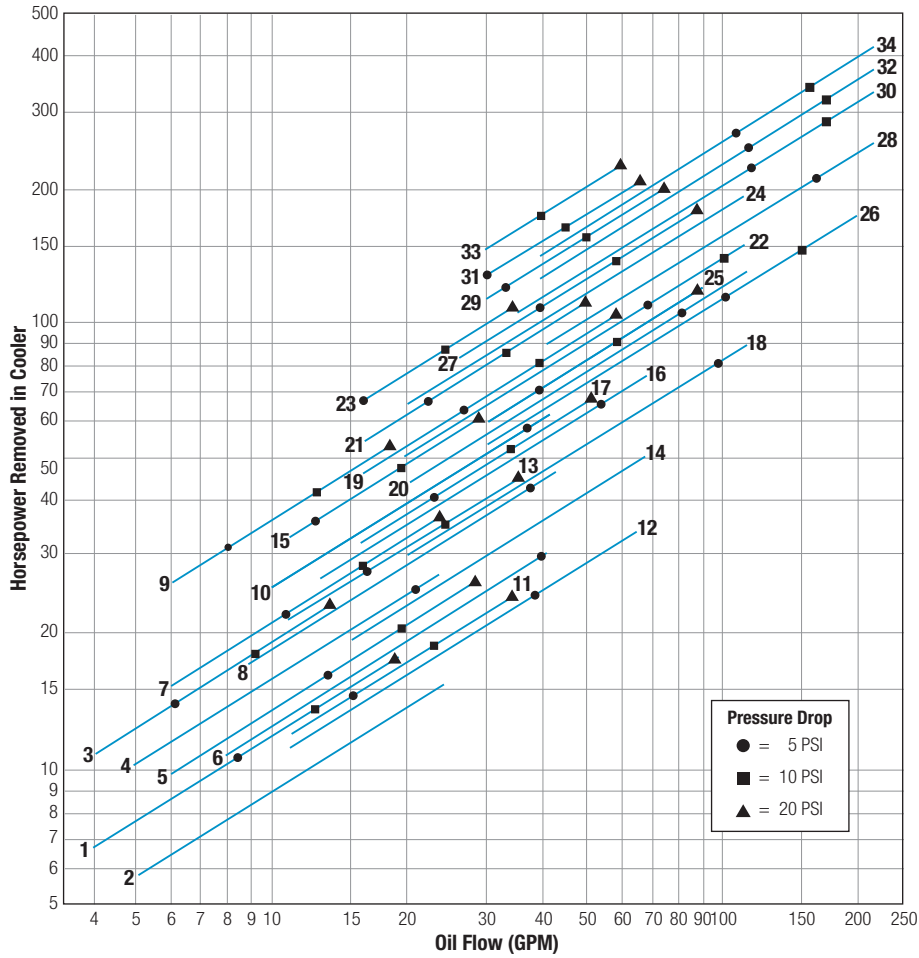


All models except
HC-1700 Series

HC-1700 Series

Model	A	B	C	D	E	F	G	H	J	K NPT	L NPT	M	N	P	R NPT	S NPT	T
614	3.27	4.50	10.00	2.31	16.37	2.75	4.50	1.63	0.44	0.25	1.00	17.19	3.62	0.44	.38 (2)	0.75	1.00
624	3.27	4.50	20.00	2.31	26.37	2.75	4.50	1.63	0.44	0.25	1.00	27.19	3.62	0.44	.38 (2)	0.75	1.00
814	4.25	6.00	9.00	3.13	16.56	3.50	4.25	1.75	0.44	0.25	1.50	17.87	4.44	0.69	.38 (3)	0.75	1.25
824	4.25	6.00	19.00	3.13	26.56	3.50	4.25	1.75	0.44	0.25	1.50	27.87	4.44	0.69	.38 (3)	0.75	1.25
836	4.25	6.00	31.00	3.13	38.56	3.50	4.25	1.75	0.44	0.25	1.50	39.87	4.44	0.69	.38 (3)	0.75	1.25
1014	5.24	6.75	9.00	3.43	17.35	4.00	5.25	2.00	.50 x .75	0.25	1.50	18.83	4.83	0.69	.38 (3)	1.00	1.69
1024	5.24	6.75	19.00	3.43	27.35	4.00	5.25	2.00	.50 x .75	0.25	1.50	28.83	4.83	0.69	.38 (3)	1.00	1.69
1036	5.24	6.75	31.00	3.43	39.35	4.00	5.25	2.00	.50 x .75	0.25	1.50	40.83	4.83	0.69	.38 (3)	1.00	1.69
1224	6.26	7.75	18.25	4.06	27.07	4.50	6.25	2.50	.50 x .75	0.38	2.00	28.94	5.25	0.87	.38 (3)	1.50	2.00
1236	6.26	7.75	30.25	4.06	39.07	4.50	6.25	2.50	.50 x .75	0.38	2.00	40.94	5.25	0.87	.38 (3)	1.50	2.00
1248	6.26	7.75	42.25	4.06	51.07	4.50	6.25	2.50	.50 x .75	0.38	2.00	52.94	5.25	0.87	.38 (3)	1.50	2.00
1260	6.26	7.75	55.25	4.06	64.07	4.50	6.25	2.50	.50 x .75	0.38	2.00	65.94	5.25	0.87	.38 (3)	1.50	2.00
1724	8.62	10.50	17.00	5.43	27.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	30.70	7.20	2.08	.38 (3)	2.00	2.50
1736	8.62	10.50	29.00	5.43	39.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	42.70	7.20	2.08	.38 (3)	2.00	2.50
1748	8.62	10.50	41.00	5.43	51.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	54.70	7.20	2.08	.38 (3)	2.00	2.50
1760	8.62	10.50	53.00	5.43	63.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	66.70	7.20	2.08	.38 (3)	2.00	2.50
1772	8.62	10.50	65.00	5.43	75.31	5.75	7.25	3.50	.63 x .88	0.38	3.00	78.70	7.20	2.08	.38 (3)	2.00	2.50

Performance Curves



Curve Number	Model	Shipping Weight (LBS)
1	HC-614-1.3-4-F	17
2	HC-614-3-4-F	17
3	HC-624-1.3-4-F	24
4	HC-624-3-4-F	24
5	HC-814-1.7-4-F	32
6	HC-814-4-4-F	32
7	HC-824-1.7-4-F	41
8	HC-824-4-4-F	41
9	HC-836-1.7-4-F	53
10	HC-836-4-4-F	53
11	HC-1014-2-6-F	43
12	HC-1014-5-6-F	43
13	HC-1024-2-6-F	57
14	HC-1024-5-6-F	57
15	HC-1036-2-6-F	72
16	HC-1036-5-6-F	72
17	HC-1224-2.5-6-F	85
18	HC-1224-6-6-F	85
19	HC-1236-2.5-6-F	110
20	HC-1236-6-6-F	110
21	HC-1248-2.5-6-F	135
22	HC-1248-6-6-F	135
23	HC-1260-2.5-6-F	160
24	HC-1260-6-6-F	160
25	HC-1724-3.5-6-F	140
26	HC-1724-8.4-6-F	140
27	HC-1736-3.5-6-F	180
28	HC-1736-8.4-6-F	180
29	HC-1748-3.5-6-F	220
30	HC-1748-8.4-6-F	220
31	HC-1760-3.5-6-F	260
32	HC-1760-8.4-6-F	260
33	HC-1772-3.5-6-F	300
34	HC-1772-8.4-6-F	300

Shipping weights are approximate.

Selection Procedure

Performance Curves are based on 100SSU oil leaving the cooler 40°F higher than the incoming water temperature (40°F approach temperature). Curves are based on a 2:1 oil to water ratio.

STEP 1 Determine the Heat Load. This will vary with different systems, but typically coolers are sized to remove 25 to 50% of the input nameplate horsepower. (Example: 100 HP Power Unit x .33 = 33 HP Heat load.)
If BTU/HR is known: $HP = \frac{BTU/HR}{2545}$

STEP 2 Determine Approach Temperature.
Desired oil leaving cooler °F – Water Inlet temp. °F = Actual Approach

STEP 3 Determine Curve Horsepower Heat Load. Enter the information from above:
 $HP \text{ heat load} \times \frac{40}{\text{Actual Approach}} \times \frac{\text{Viscosity}}{\text{Correction A}} = \text{Curve Horsepower}$

STEP 4 Enter curves at oil flow through cooler and curve horsepower. Any curve above the intersecting point will work.

STEP 5 Determine Oil Pressure Drop from Curves. Multiply pressure drop from curve by correction factor B found on oil viscosity correction curve.
● = 5 PSI ■ = 10 PSI ▲ = 20 PSI

Oil Temperature

Oil coolers can be selected by using entering or leaving oil temperatures.

Typical operating temperature ranges are:

Hydraulic Motor Oil	110°F - 130°F
Hydrostatic Drive Oil	130°F - 180°F
Lube Oil Circuits	110°F - 130°F
Automatic Transmission Fluid	200°F - 300°F

Desired Reservoir Temperature

Return Line Cooling: Desired temperature is the oil temperature leaving the cooler. This will be the same temperature that will be found in the reservoir.

Off-Line Recirculation Cooling Loop: Desired temperature is the temperature entering the cooler. In this case, the oil temperature change must be determined so that the actual oil leaving temperature can be found. Calculate the oil temperature change (Oil ΔT) with this formula:

$$\text{Oil } \Delta T = (\text{BTUs/HR}) / (\text{GPM Oil Flow} \times 210)$$

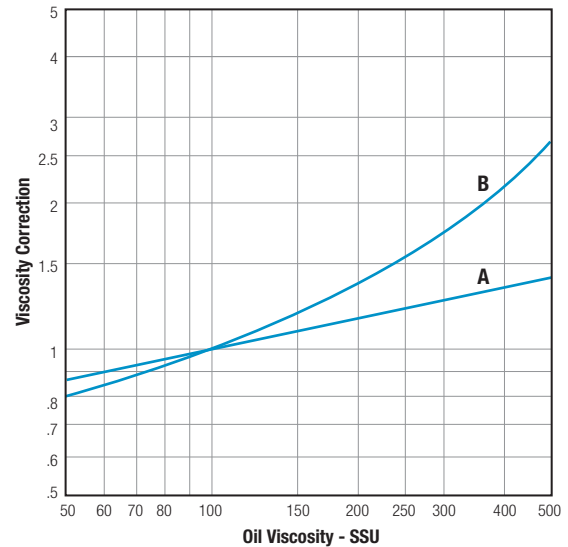
To calculate the oil leaving temperature from the cooler, use this formula:

$$\text{Oil Leaving Temperature} = \text{Oil Entering Temperature} - \text{Oil } \Delta T$$

This formula may also be used in any application where the only temperature available is the entering oil temperature.

Oil Pressure Drop: Most systems can tolerate a pressure drop through the heat exchanger of 20 to 30 PSI. Excessive pressure drop should be avoided. Care should be taken to limit pressure drop to 5 PSI or less for case drain applications where high back pressure may damage the pump shaft seals.

Viscosity Correction



Maximum Flow Rates

Example Model No.
HC - 1024 - 2 - 6 - F

Unit Size	Baffle Spacing	Shell Side (GPM)	Tube Side (GPM)		
			O	T	F
600	1.3, 3	19, 29	48	24	12
800	1.7, 4	32, 69	84	42	21
1000	2, 5	41, 69	146	73	37
1200	2.5, 6	60, 115	224	112	56
1700	3.5, 8.4	125, 253	465	232	116

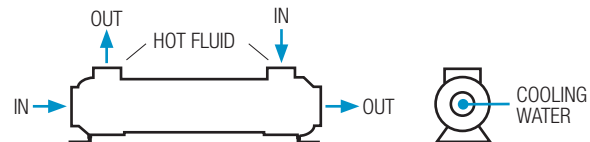
Exceptions to Maximum Shell Side Flows

HC-814-4-4-*	63 GPM Max.
HC-1014-2-6-*	33 GPM Max.
HC-1014-5-6-*	66 GPM Max.
HC-1724-3.5-6-*	105 GPM Max.
HC-1724-8.4-6-*	200 GPM Max.

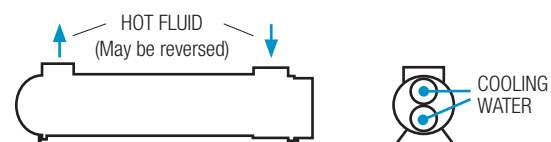
Caution: Incorrect installation can cause this product to fail prematurely, causing the shell side and tube side fluids to intermix.

Piping Diagram

One Pass



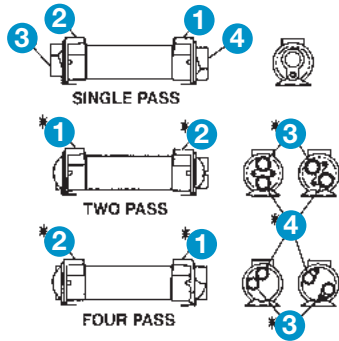
Two and Four Pass



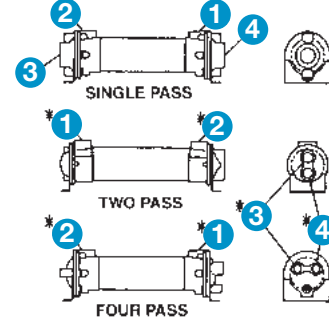
Specific applications may have different piping arrangements. Contact factory for assistance.

Piping Hook-up

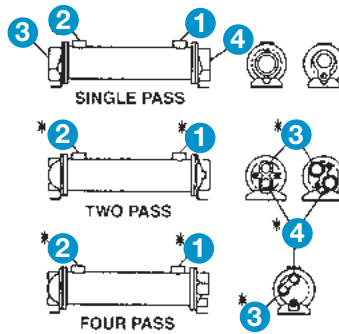
A Series



B Series

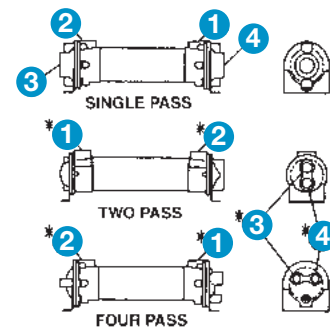


HC / SSC / EC Series

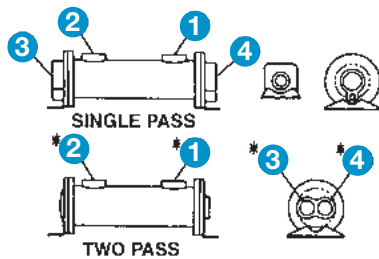


EC bonnet rotation is slightly different from what is shown. See Series literature for details.

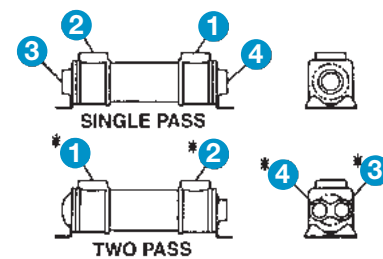
SLE / SL / R Series



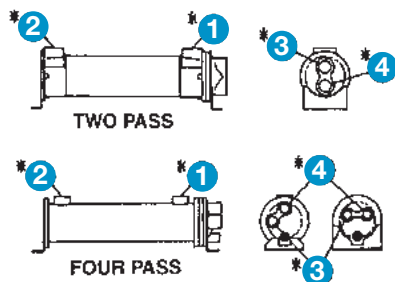
EK / EKS / EKM Series



K / KN Series



U / UC / UR Series



Note baffle location when inserting bundle into shell assembly after cleaning.

- 1** Hot Fluid In
- 2** Cooled Fluid Out
- 3** Cooling Water In
- 4** Cooling Water Out

*Note: For all two pass and four pass heat exchangers: connections **1** and **2** may be reversed, and connections **3** and **4** may be reversed with no effect on performance.

Installation

The satisfactory use of this heat exchange equipment is dependent upon precautions which must be taken at the time of the installation.

1. Connect and circulate the hot fluid in the shell side (over small tubes) and the cooling water in the tube side (inside small tubes). Note piping diagrams.
2. If an automatic water regulating valve is used, place it on the INLET connection of the cooler. Arrange the water outlet piping so that the exchanger remains flooded with water, but at little or no pressure. The temperature probe is placed in the hydraulic reservoir to sense a system temperature rise. Write the factory for water regulating valve recommendations.
3. There are normally no restrictions as to how this cooler may be mounted. The only limitation regarding the mounting of this equipment is the possibility of having to drain either the water or the oil chambers after the cooler has been installed. Both fluid drain plugs should be located on the bottom of the cooler to accomplish the draining of the fluids. Drains are on most models.
4. It is possible to protect your cooler from high flow and pressure surges of hot fluid by installing a fast-acting relief valve in the inlet line to the cooler.
5. It is recommended that water strainers be installed ahead of this cooler when the source of cooling water is from other than a municipal water supply. Dirt and debris can plug the water passages very quickly, rendering the cooler ineffective. Write the factory for water strainer recommendations.
6. Fixed bundle heat exchangers are generally not recommended for steam service. For steam applications, a floating bundle exchanger is required. Note: When installing floating bundle unit, secure one end firmly and opposite end loosely to allow bundle to expand and contract. Consult factory for selection assistance.
7. Piping must be properly supported to prevent excess strain on the heat exchanger ports. If excessive vibration is present, the use of shock absorbing mounts and flexible connectors is recommended.

Service

Each heat exchanger has been cleaned at the factory and should not require further treatment. It may be well to inspect the unit to be sure that dirt or foreign matter has not entered the unit during shipment. The heat exchanger should be mounted firmly in place with pipe connections tight.

Caution

If sealant tape is used on pipe threads, the degree of resistance between mating parts is less, and there is a greater chance for cracking the heat exchanger castings. Do not overtighten. When storing the unit, be sure to keep the oil and water ports sealed. If storage continues into cold winter months, the water chamber must be drained to prevent damage by freezing.

Performance information should be noted and recorded on newly installed units so that any reduction in effectiveness can be detected. Any loss in efficiency can normally be traced to an accumulation of oil sludge, or water scale.

Recommendations

Replace gaskets when removing end castings. It is recommended that gaskets be soaked in oil to prevent corrosion and ensure a tight seal.

Salt water should not be used in standard models. Use salt water in special models having 90/10 copper-nickel tubes, tube sheets*, bronze bonnets and zinc anodes on the tube side. Brackish water or other corrosive fluids may require special materials of construction.

When zinc anodes are used for a particular application, they should be inspected two weeks after initial startup.

At this time, by visual inspection of the anode, determination of future inspection intervals can be made, based on the actual corrosion rate of the zinc metal.

The zinc anodes must be replaced when 70% of the zinc volume has been consumed.

It may be necessary to drain the water chambers of the exchanger to protect it from damage by freezing temperatures. Drains are provided in most standard models.

The oil chamber of the exchanger may become filled with sludge accumulation and require cleaning. It is recommended that the unit be flooded with a commercial solvent and left to soak for one-half hour. Backflowing with the solvent or regular oil will remove most sludge. Repeated soaking and backflowing may be required, depending on the degree of sludge buildup.

It may be necessary to clean the inside of the cooling tubes to remove any contamination and/or scale buildup. It is recommended that a fifty-fifty percent solution of inhibited muriatic acid and water may be used. For severe problems, the use of a brush through the tubes may be of some help. Be sure to use a soft bristled brush to prevent scouring the tube surface causing accelerated corrosion. Upon completion of cleaning, be certain that all chemicals are removed from the shellside and the tubeside before the heat exchanger is placed into service.

When ordering replacement parts or making an inquiry regarding service, mention model number, serial number, and the original purchase order number.

**Available on HC/SSC/SSCA Series models only.*

Maximum Shell & Tube Flow Rates

CAUTION

Incorrect installation can cause this product to fail prematurely, causing the shell side and tube side fluids to intermix. Maximum allowable flow rates are as charted below.

B Series Model No. Example: B-702-A4-F

Unit Size	Shell Side (GPM) / Baffle Spacing					Tube Side (GPM)		
	A	B	C	D	E	O	T	T
400	9.6	—	—	—	—	25		
700	17	29	29	—	—	61	31	15
1000	24	48	69	69	—	146	73	37
1200	29	57	115	115	—	224	112	56
1600	37	75	149	253	—	363	181	91
2000	—	—	187	347*	457*	652	326	163

*281 GPM maximum for all B-2005-D **500 GPM maximum for all B-20080-E and 562 GPM maximum for all B2006-E6 or B-2006-E10
562 GPM maximum for all B-2006-E6 or B-2006-E10

A Series Model No. Example: A-1024-2-6-F

Unit Size	Baffle Spacing	Shell Side (GPM)	Tube Side (GPM)		
			O	T	F
SA-400	.75	7	18	—	—
	2	19			
600	1	14	48	24	12
	1.5	21			
	2	29			
800	4	29	87	43	21
	1.5	29			
	2	38			
1000	3	57	146	73	37
	4	69			
	1.5	32			
	2	42			
1200	3	60	224	112	56
	4	69			
	2	51			
	3	77			
1600	4	103	280	203	101
	6	115			
	26	66			
	3	100			
	4	133			
	6	200			

HC / SSC Series Model No. Example: HC-1024-2-6-F

Unit Size	Baffle Size	Shell Side (GPM)	Tube Side (GPM)		
			O	T	F
600	1.38	19	48	24	12
	2	29			
	3	29			
800	1.38	26	84	42	21
	1.7	31			
	2	38			
	3	57			
1000	4	69	146	23	37
	1.38	24			
	2	41			
1200	3	64	224	112	56
	5	69			
	2.5	60			
	3	77			
1700	3.62	93	465	232	116
	5	115			
	6	115			
	3.	125			
	4	143			
	4.5	161			
	5	179			
6	215				
	7	251			
	8.4	253			

EC Series Model No. Example: EC-1236-6-F

Unit Size	Baffle Size	Shell Side (GPM)	Tube Side (GPM)		
			O	T	F
1000	4	55	66	33	15
	6	70			
	8	70			
1200	4	65	120	60	28
	6	100			
	8	115			
	12	115			
1700	4	90	220	110	52
	6	140			
	8	190			
	12	255			

K / EK Series Model No. Example: EK or K-712-F

Unit Size	Shell Side (GPM)	Tube Side (GPM)	
		O	T
500	20	13	—
100	70	24	12
1000	100	56	28