



Industrial Water Systems

Virtual INPLT Training & Assessment

Session 6

Tuesday – July 21st, 2026

10 am – 11:30 am

Water Virtual Training Agenda

- **Week 1 (June 16th) – Introduction to Industrial Water Assessment**
- **Week 2 (June 23rd) – Understanding System Level Water use**
- **Week 3 (June 30th) – True Cost of Water**
- **Week 4 (July 7th) – Water Quality and MEASUR Tool Working Session**
- **Week 5 (July 14th) – Identifying Water Savings Opportunity**
- **Week 6 (July 21th) – Virtual Water Treasure Hunt**
- **Week 7 (July 28th) – Estimating Water Savings Opportunities**
- **Week 8 (Aug 4th) – Industrial Water System VINPLT Wrap-up Presentations**

Agenda – Session Six

Today's Content:

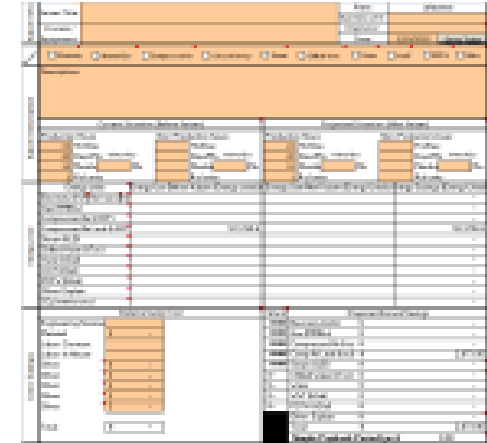
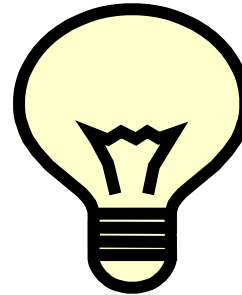
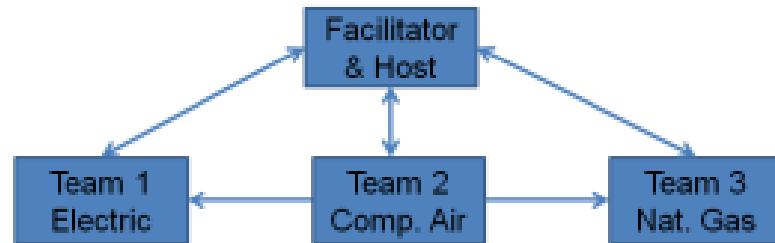
- Treasure hunt
- Finding Opportunities – Scenarios
- Q&A



Better Buildings is an initiative of the
U.S. Department of Energy

Water Treasure Hunt – Overview

Treasure Hunt - The Basic Mission



Assemble with
your teams



Facility walk
through for each
team to generate
ideas



Assess idea
feasibility, gather
data, quantify

Water Treasure Hunt Agenda

- **Week 6 – Virtual Treasure Hunt**

- **July 21st: 10am to 1130am ET – Treasure Hunt Resources Overview**

Participants run a treasure hunt walkthrough and identifies opportunities

- **July 23rd 3pm to 4pm ET: Reviewing Opportunities Identified (Optional office hours)**

- **Week 7 (July 28th) – 10am to 1230am ET**

- **Estimating Water Savings Opportunities: Overview of Tools**
 - **Estimating Savings for Opportunities Identified**

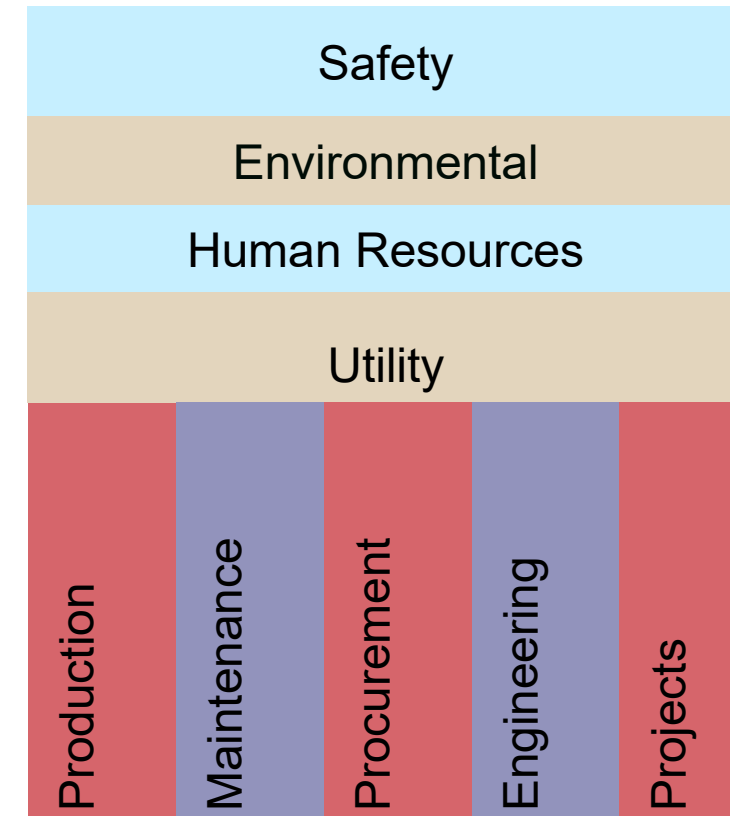
- **Week 8 (Aug 4th) – 10am to 1230am ET**

- **Industrial Water System Assessment Wrap-up Presentations by Participants**

Water Training Team is always available between the weeks for individual calls and discussions

Treasure Hunt – Best Practices while Planning

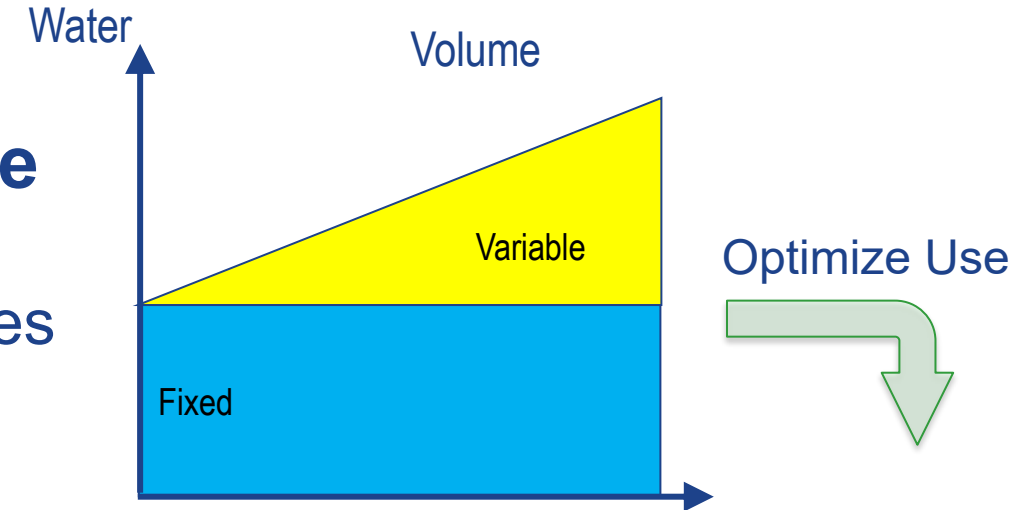
- Include participants from across all operations and from outside the host facility
- Target 3 teams of 5 participants, select focus areas based on your facility
- Include one person in each team familiar with the host facility - Identify a Team Lead
- Understand Facility Operational Schedule
 - Operational opportunities can be ideally identified when facility is idle
 - Rarely is production activity 24 hrs / 7 days a week -
Take note of maintenance downtime / shift changes / off shifts



Categorizing Water Savings Opportunities

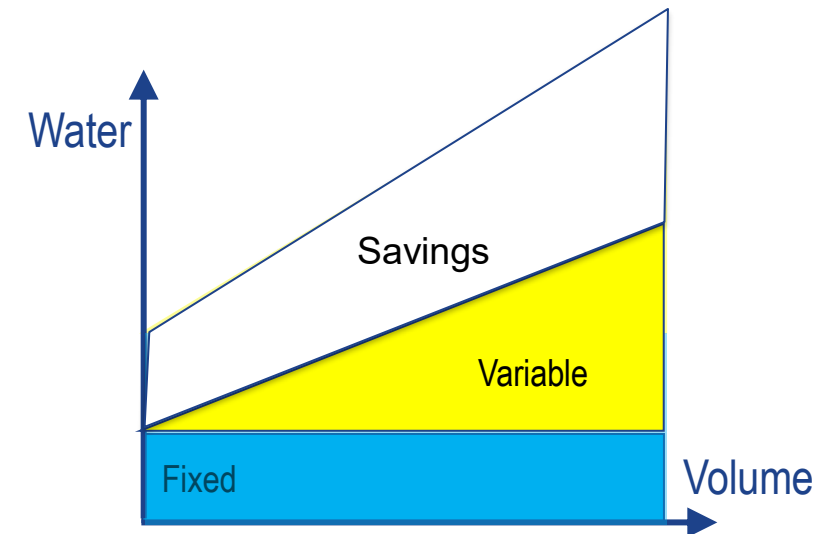
1) Converting fixed water uses to variable

- Automate shutdowns
- Tie water use to production with control values



2) Reducing fixed and variable water usage

- Controlling set points and float levels
- Control operating times



Typical Treasure Hunt opportunities – Cooling System

- Optimize tower blowdown
- Fix leaks and overflows
- Eliminate Single Pass Cooling
- Opportunities with tower components
 - Drift Eliminators
 - Water spray system
 - Anti-splash louvers
- Use air cooling where possible



Typical Treasure Hunt opportunities – Steam

- Condensate Return
- Boiler blowdown optimization
- General steam and condensate leaks
- Broken steam traps
- Reducing open steam usage



Typical Treasure Hunt opportunities – Process Equipment

- Ensure auxiliary water use is minimized during non-production/ idle time
 - Install Automated Control Valves ; Shut off water flows
- Process Equipment Modifications/ Design
 - Low flow nozzles
- Improved Production/ Operations Planning
 - Reduce idle time with better scheduling
- Using waterless techniques for process
- Opportunities for recycle and reuse



Process Equipment

Have you installed equipment (e.g., timers, solenoids, level/pressure switches) to automatically shut off water flow when water is not required, such as at the end of a production cycle?

Are solenoids and automatic shutoff mechanisms checked regularly to ensure that they are working properly?

Is equipment set to the minimum flow rates recommended by the manufacturer?

Have pressure-reducing devices been installed on equipment that does not require high pressure?

Does process equipment reuse water (i.e., closed loop) or use reclaimed water from other parts of the facility?

Have you replaced water-based transportation with either waterless techniques or recycled water?

Are signs posted near equipment encouraging employee awareness of water use and discouraging tampering with equipment flow rate?

Are all hoses equipped with an automatic shutoff nozzle?

Has process cleaning or facility cleaning been replaced with or supplemented by waterless techniques (e.g., burnout ovens, ultrasonic cleaning) where possible?

Are improved rinsing techniques used and optimized: counter-current systems?

Are improved rinsing techniques used and optimized: sequential use from high to lower quality needs?

Are improved rinsing techniques used and optimized: conductivity flow controls?

Are improved rinsing techniques used and optimized: improved spray nozzles/pressure rinsing?

Are improved rinsing techniques used and optimized: fog rinsing?

Is spent rinse water reclaimed and reused for lower grade processes or for other facility applications?

Have steps been taken to reduce the water used by open steam sterilizers (e.g., utilizing jacket and chamber)?

Are you using detergents that can easily be removed with little water?

Is water used for cleaning submetered?

Are the flow parameters for cleaning systems monitored periodically?

Are employees aware of deionized/reverse osmosis (or other specially treated) water use?

Are conductivity controllers used in rinses?

At wash station, are booster pumps used with low-pressure water instead of high-pressure water?

Cooling and Boiler Systems

Has once-through cooling water been eliminated with the use of chillers, cooling towers, or air-cooled equipment?
Has blowdown/bleed-off control on cooling towers and boilers been optimized?
Is treated wastewater (or other sources of water for cooling tower makeup) reused where possible?
Are cycles of concentration for cooling towers maximized through efficient water treatment?
Has a conductivity controller been installed on each cooling tower?
Have cooling towers been equipped with overflow alarms?
Have the ball float valves been set correctly?
Do condenser water pipes run above the height of the tower spray heads?
Have maintenance programs been implemented to ensure leaks are routinely checked and fixed as needed?
Are antisplash louvers installed?
Are drift eliminators inspected and assessed by a specialist?
Have flow meters been installed on makeup and blowdown lines?
Are conductivity meters installed on blowdown lines?
Are blowdown lines operated in continuous mode?
Has side stream filtration been installed?
Has an automatic shutdown unit been installed for the unit?
Has sulphuric acid been added to adjust pH?
Are high-efficiency drift eliminators in use?

Is condensate return for reuse optimized?
Are steam traps properly located?
Are automatic blowdown control installed?
Is a conductivity sensor installed on boiler?
Is a boiler blowdown flash tank installed?

Data Collection

In addition to identifying opportunities, quantifying its savings is also important → Try to collect initial information about the opportunity during the facility walkthrough

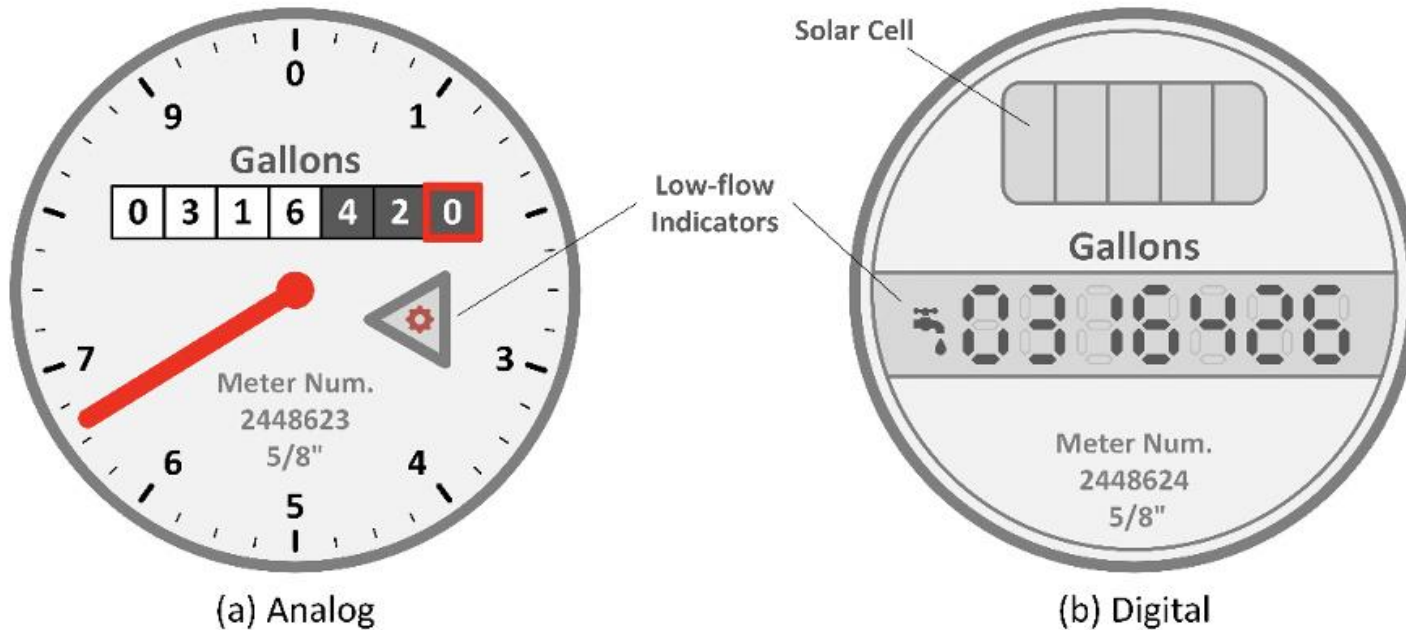
- Number of nozzles that can be reduced
- Nameplate data
- Water flow if easily estimated
- Cooling Towers and Boilers
 - Cycles of concentration; conductivity measurements

Resource for Data Collection – Diagnostic Equipment

- Instruments and data loggers for onsite data collection



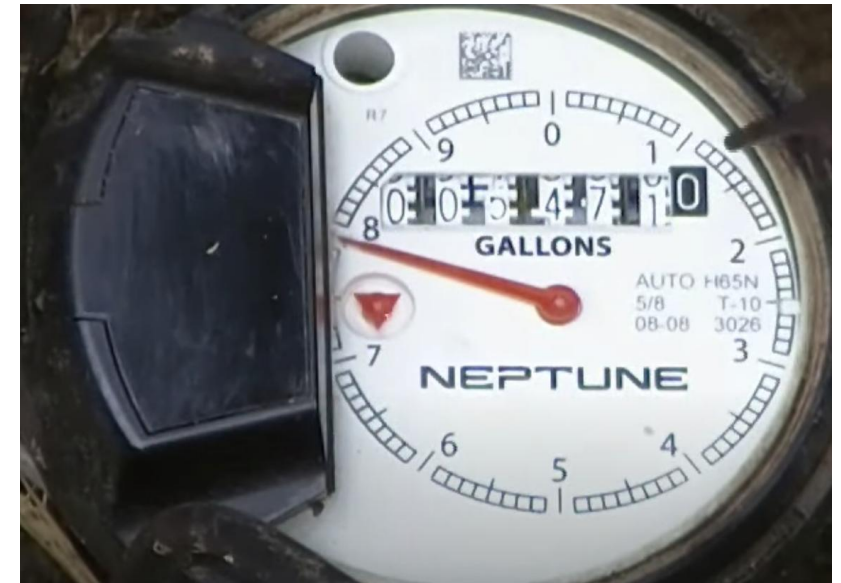
Existing Meters



Both reading 316,426 gallons

Analog meters are read by reading the rolling tick dial which records to the tens place.

The value in the red box fixed and the last whole digit is read by reading the sweeping hand



Bucket and Timer



$$GPM = \frac{60}{\text{Time to fill in Sec}} \times \text{Volume of Bucket in Gallons}$$

Specification Sheets or Cutsheets

NC8413N-1	604	647	10	41955	19586	11'-10¾"	12'-2¼"
NC8413P-1	680	735	15				
NC8413Q-1	739	788	20				
NC8413R-1	791	845	25				
NC8413S-1	834	890	30				
NC8413T-1	905	970	40				
NC8413U-1	961	1023	50				
NC8413V-1	1012	1076	60				
NC8413W-1	1073	1140	75				
NC8413X-1	1149	1219	100				
NC8414P-1	761	806	15	48355	22096	13'-10¾"	14'-2¼"
NC8414Q-1	827	876	20				
NC8414R-1	883	933	25				
NC8414S-1	929	983	30				
NC8414T-1	1011	1078	40				
NC8414U-1	1101	1161	50				
NC8414V-1	1154	1215	60				

Cooling Tower

SPECIFICATIONS

Model No**	Flow Rate Specifications GPM Nominal (m³/hr)			Vessel Staging	Membrane Vessel	Membrane Quantity	Customer Connection Specifications			Utility Requirements***			Approx Shipping Weight lb (kg)
	Product*	Feed	Reject				Feed	Product	Reject	High Voltage Service	High Voltage FLA	Pump HP	
M84R024	107 (24.3)	143 (32.5)	36 (8.7)	3:2:1	4	24	3"	3"	2"	480 VAC 3ph	67	50	5576 (2529)
M84R036	160 (36.3)	215 (48.8)	53 (12.0)	4:3:2	4	36	4"	4"	2"	480 VAC 3ph	79	60	6115 (2774)
M84R048	214 (48.6)	285 (64.7)	71 (16.1)	6:4:2	4	48	4"	4"	2"	480 VAC 3ph	79	60	6465 (2932)

* Product flow rates are based on a flux rate of 16 GFD and equipment design parameters listed below. Product flow rates may not be appropriate for other feed waters.

** The 8 designates 8" housing, the 4 designates 4 elements in length, and the -R0XX designates the number of membranes.

*** Additional voltage options are available. Refer to equipment specifications.

RO System

M-159TG

Strahman M-159 (bronze) and M-750 (stainless steel) Mixing Units-Hose Stations are designed to thoroughly mix hot and cold water in any desired proportion.

Our Temperature Indicating (TG) models are equipped with a blending chamber and quick acting dial-type dual Fahrenheit and Centigrade temperature gauge, which accurately indicates the water's temperature exiting a specially designed blending chamber.

NOTE: Not suitable for steam service

M-159TG-Globe Series Mixing Unit-Hose Stations

- Simple visual recognition of valve position
- Flow rates adjustable from low to high

M-159TG-Ball Series Mixing Unit-with Ball Valves

- Single ¼ turn to On/Off position
- Simple visual recognition of valve position
- Easy to maintain and replace ball valves
- Flow rates adjustable from low to high
- Less wrist fatigue in turning valves to On/Off position

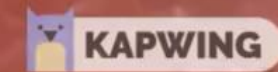


Water Mixing Sprays

Max. Pressure (BAR)	Max. Flow (LPM)	Max. Temperature
10	38	93° C

Virtual Treasure Hunt

Virtual TH Scenario 1 - Fiberglass manufacturing



Scenario 1 – What did you see?

What are the water users?

What opportunities did you find?

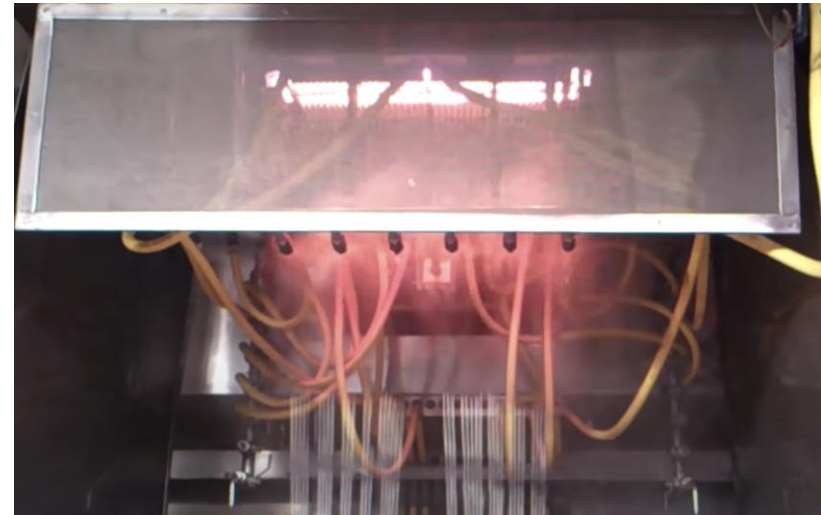
Points of interest to investigate further

Others

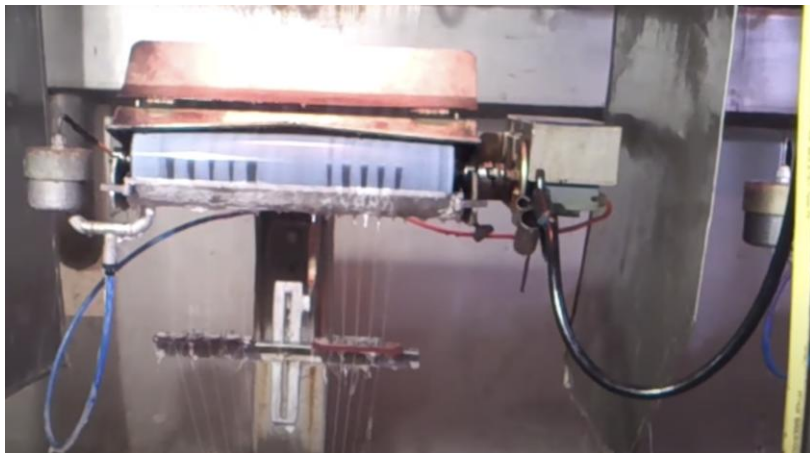
Scenario 1 – Water Users



2 hand guns per unit



Automated water nozzles



Roller (water cooled?)



Multiple units with same configuration

Scenario 1 – Opportunities / Things to investigate

- Are the automated water nozzles optimized?
 - Can the number of nozzles be reduced?
 - Can the configuration of the nozzles be changed to optimize operations
 - Is the nozzle configuration in all the lines the same?
 - Do the different units have the same nozzle configuration?
- Can water be cut out automatically when there is no product to be cooled?
- Is there room for water recycling in this process?
 - What is the type of contaminants in wastewater?
 - What is the quality of water needed for the process?
 - Is it possible to economically treat the water to be used back in the product?
- Can the use water handguns be reduced/optimized?

Virtual TH Scenario 2 – Cooling Tower



Source: <https://www.youtube.com/watch?v=mG1k6LzwqkE> ; https://www.youtube.com/watch?v=wB7RQOiBC_4

Scenario 2 – What did you see?

What opportunities did you find?

Points of interest to investigate further

Others

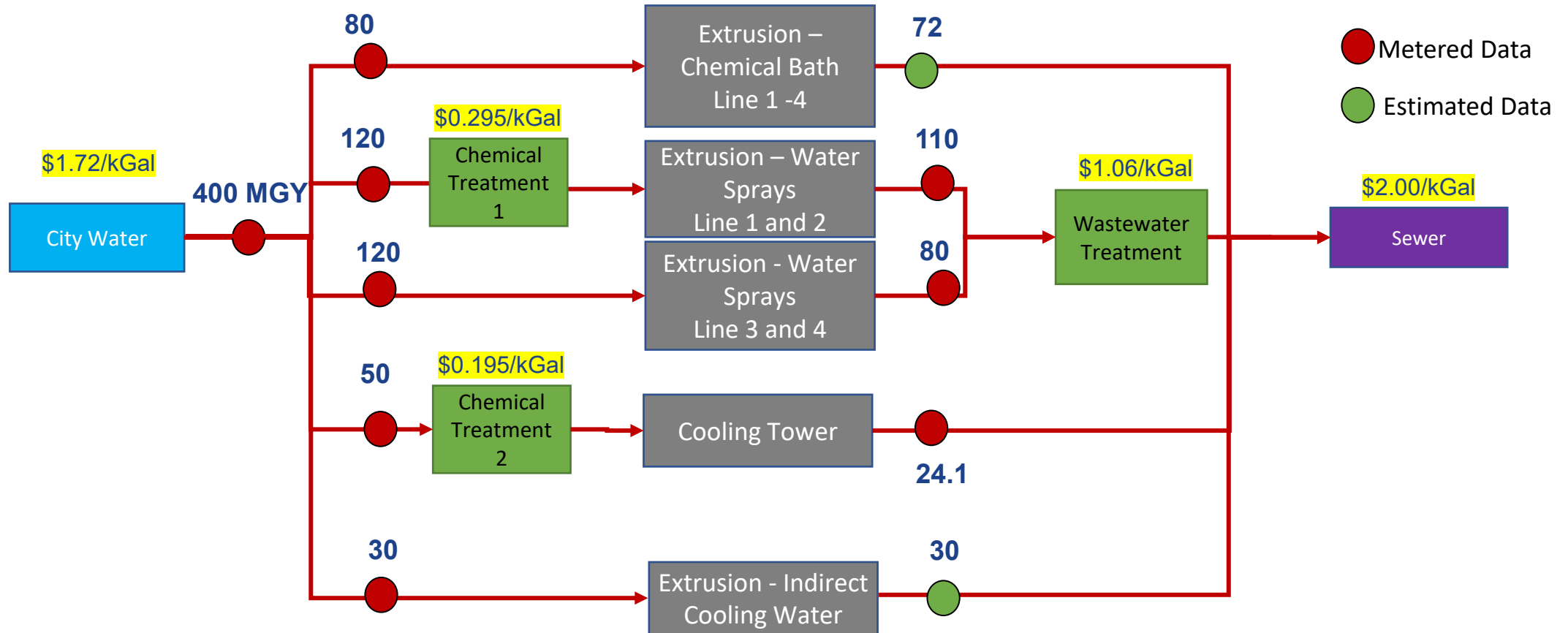
Scenario 2 - Opportunities / Things to investigate

- Is the flow through the cooling tower appropriate?
 - Spray nozzles may be clogged
 - Fill material maybe damaged or not properly installed
- Is there any splash out or leaks from the sides of the cooling tower
- Why is the blowdown leaking to the drain continuously?

To Check

- Blowdown meter reading
- Conductivity setting on the controller
- Is the bypass completely shut after maintenance

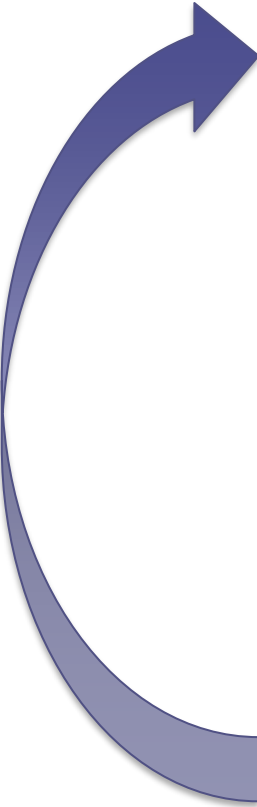
Virtual TH Scenario 3 – Water Flow Diagram



Scenario 3 - Opportunities / Things to investigate

- Recycling opportunity with wastewater effluent
- Opportunity to claim evaporative credits
- Optimize cooling tower, cycles is low
- Optimize line 3 and 4 ; losses are high compared to line 1 and 2
- Can water treatment in line 1 and 2 be eliminated
- Eliminate once through cooling

Summary



1. Walkthrough the facility and observe operations

2. Identify opportunities

3. Collect relevant data

4. Quantify Savings

5. Create Opportunity Sheet

} Leverage available
Resources

Tips for Facility Walkthrough

- Review your water assessment results for insights into water use
- Walkthrough your facility with your team
- Talk to the operators, vendors and understand the water use
 - Does water usage meet the demand optimally?
- Note down all opportunities that was identified ; best opportunities can be identified later – **No opportunity is too small**
- Take pictures of opportunities
- Collect initial data that is available of the process
- At the end of each walkthrough the teams can brief internally
- At end of each day or session the teams brief other teams on what they will pursue

Gather your
teammates and
head out !

Thank You all for attending today's webinar.

See you on Thursday– July 23rd – 3 pm ET

If you have specific questions, please stay online and we will try and answer them.

**Alternately, you can email questions to me at
thirumarank@ornl.gov**