



**DOW™ Specialty Membrane XUS180804 and XUS180802 Reverse Osmosis Elements**

Ultra-High Pressure, High-Rejection, Reverse Osmosis Elements for Industrial Water Purification

**Description**

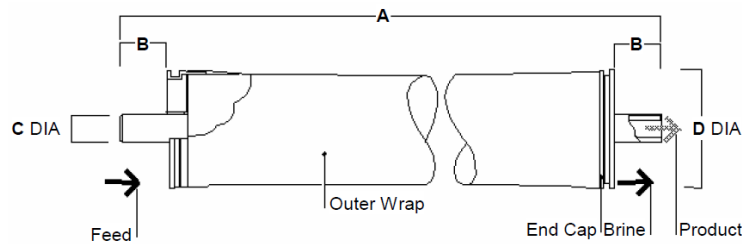
The XUS180804 and XUS180802 Reverse Osmosis Elements are ultra-high pressure elements offering an industry wide distinct combination of features:

- Up to 120 bar (1,740 psi), ultra-high feed pressure capability due to distinct element and membrane design
- Increasing the overall efficiency of Zero-Liquid-Discharge (ZLD) by achieving very high solute concentrations thus helping to reduce the size of downstream thermal treatment
- Excellent for recovery of salts in process streams
- Robust DOW FILMTEC™ reverse osmosis (RO) membrane sheet;
- 34 mil feed spacer to lessen the impact of fouling on the pressure drop across a vessel and to enhance cleaning effectiveness.

**Product Specifications**

DOW™ Specialty Membrane	Active Area		Feed Spacer Thickness	Minimum ATD OD	ATD included
	(ft <sup>2</sup> )	(m <sup>2</sup> )	(mil)	(in.)	
DOW XUS180804	60	5.6	34	3.9	Yes
DOW XUS180802	18	1.7	34	2.4	Yes

**Element Dimensions**



DOW™ Specialty Membranes	A		B		C		D	
	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)	(in.)	(mm)
XUS180804	40.0	1,016	1.03	26	0.75 OD	19 OD	3.9	99
XUS180802	40.0	1,016	1.03	26	0.75 OD	19 OD	2.5	63.5

## Operating Limits

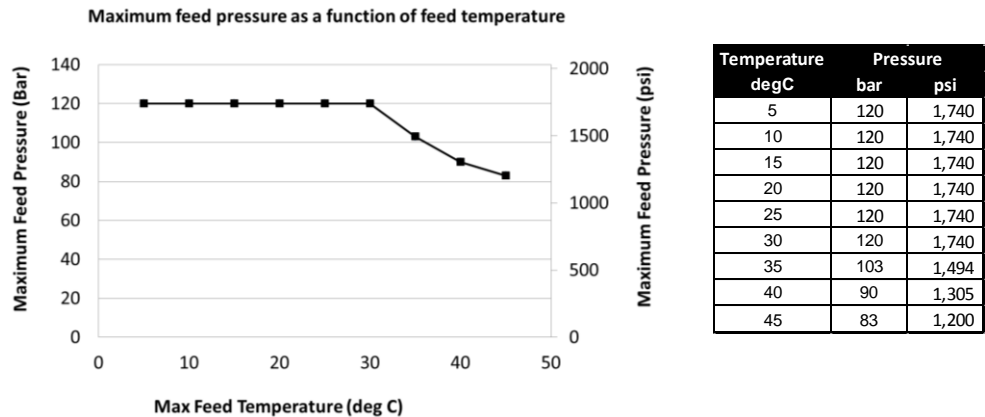
Maximum Operating Temperature <sup>a, d</sup>	113°F (45°C)
Maximum Operating Pressure at 30°C <sup>d</sup>	1,740 psig (120 bar)
Maximum Element Pressure Drop	15 psig (1.0bar)
pH Range, Continuous Operation <sup>a</sup>	2 – 11
pH Range, Short-Term Cleaning (30 min.) <sup>b</sup>	1 – 13
Maximum Feed Silt Density Index (SDI)	SDI 5
Free Chlorine Tolerance <sup>c</sup>	< 0.1 ppm

<sup>a</sup> Maximum temperature for continuous operation above pH 10 is 95°F (35°C).

<sup>b</sup> Refer to guidelines in specification [sheet 609-23010](#) for more information.

<sup>c</sup> Under certain conditions, the presence of free chlorine and other oxidizing agents will cause premature membrane failure. Since oxidation damage is not covered under warranty, Dow Water & Process Solutions recommends removing residual free chlorine by pretreatment prior to membrane exposure. Please refer to [technical bulletin 609-22010](#) for more information.

<sup>d</sup> Relation between maximum allowed feed pressure and maximum feed temperature see below



## Clean in Place (CIP) Parameters

Maximum CIP Pressure	15 to 75 psi (1 to 5 bar)
pH Range, Cleaning (< 45°C)	pH1 – pH13
Hydrogen Peroxide Limit, Short-Term Cleaning	1,000 ppm

<sup>a</sup> Refer to Cleaning Guidelines in specification sheet 609-23010.

<sup>b</sup> Under certain conditions, the presence of free chlorine and other oxidizing agents will cause premature membrane failure. Since oxidation damage is not covered under warranty, FilmTec recommends removing residual free chlorine by pretreatment prior to membrane exposure. Please refer to technical bulletin 609-22010 for more information.

## Important Start-Up Information

Normally, new elements are cleaned prior to initial use. The cleaning procedure should be based on the application for which the elements are to be used. If cleaning with formulated agents is not available, an alkaline wash with a wetting agent is recommended prior to initial use. Please refer to FILMTEC™ Technical Manual for more information.

Avoid any abrupt pressure or cross flow variations on the spiral elements during start-up, shutdown, cleaning or other sequences to prevent possible membrane damage. During startup, a gradual change from a standstill to operating state is recommended as follows:

- Feed pressure should be increased gradually over a 30-60 second time frame.
- Before initiating cross-flow at high permeate flux conditions (e.g., start-up with high temperature water), the set operating pressure should be maintained for 5-10 minutes.
- Cross-flow velocity at set operating point should be achieved gradually over 15-20 seconds.

- Avoid permeate-side backpressure at all times.
- Any concentrate or permeate obtained from the first hour of operation should be discarded.

**General Information :**

- Keep elements moist at all times after initial wetting.
- To control the spread of biological growth during system shutdowns, it is recommended that elements be immersed in a preservative solution.

**Warranty Information :**

Reference warranty document: Dow Specialty Membrane Prorated Element Warranty.  
 Before use or storage, review these additional resources for important information:

**Regulatory Note**

These membranes may be subject to drinking water application restrictions in some countries; please check the application status before use and sale.

**Product Stewardship**

Dow has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with Dow products—from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

**Customer Notice**

Dow strongly encourages its customers to review both their manufacturing processes and their applications of Dow products from the standpoint of human health and environmental quality to ensure that Dow products are not used in ways for which they are not intended or tested. Dow personnel are available to answer your questions and to provide reasonable technical support.

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