# Condensate Management Drains, Separators and Compliance Strategies

Peter Vinck
Inflow Corporation
*Keynote Speaker*


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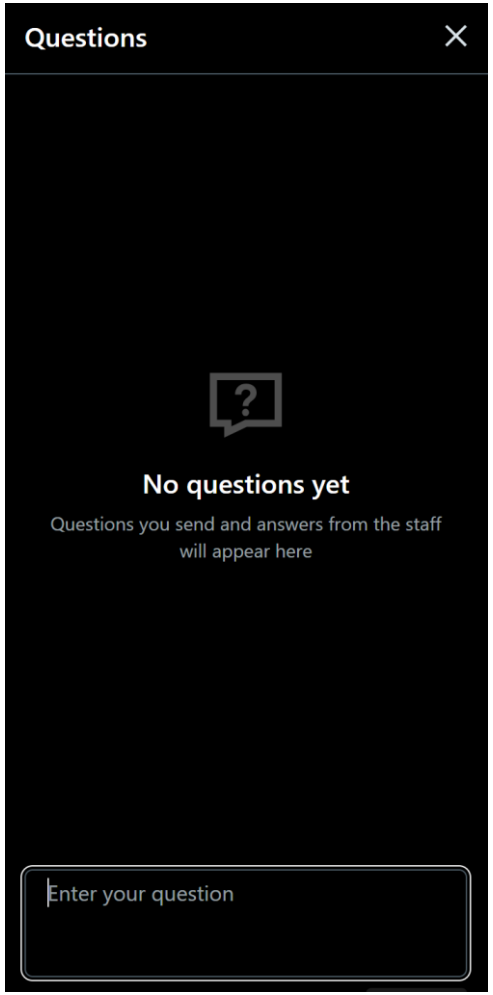


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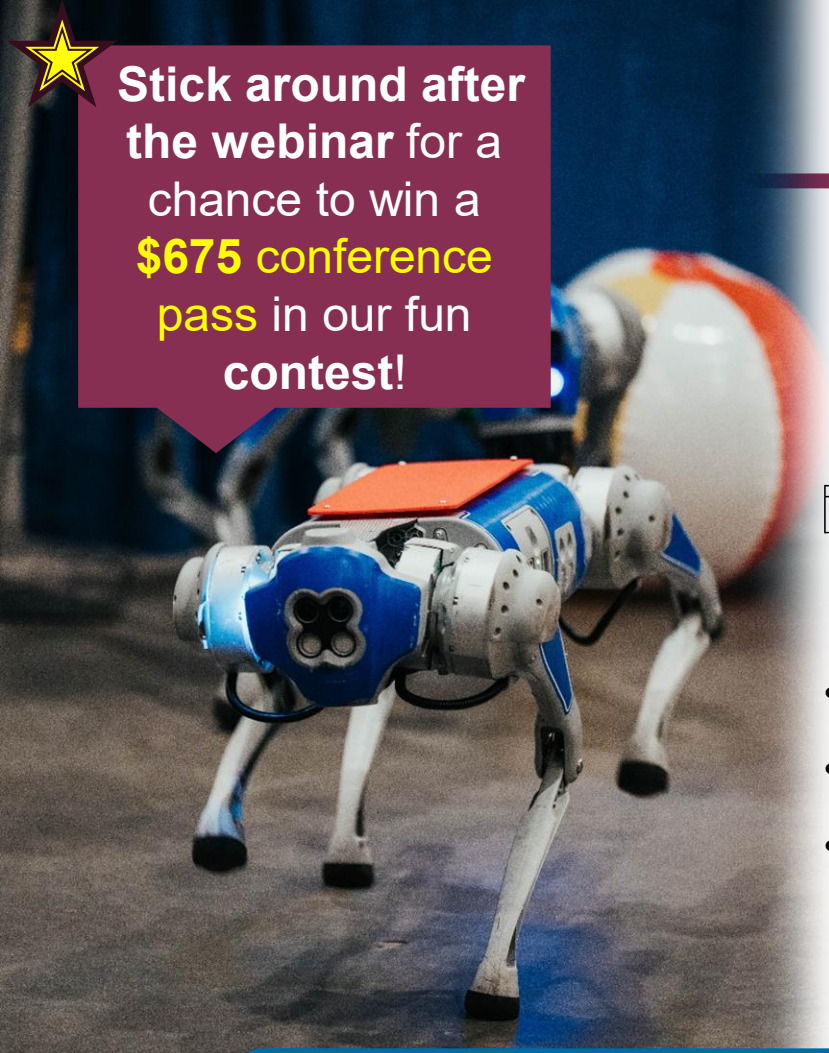

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# Condensate Management Drains, Separators and Compliance Strategies

Introduction by

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# About the Speaker

**Peter Vinck**
Inflow Corporation

- Founder & Senior Engineering Consultant, Inflow Corporation
- 18 years improving industrial compressed air systems
- Previous roles in utility energy efficiency, system design, auditing, and application/sales engineering for top manufacturers and vendors

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# Condensate Management for Compressed Air Systems

*Drains, Installation, Maintenance & Separators — Best Practices, Tricks & Traps*


## Peter Vinck

Senior Engineering Consultant
Inflow Corporation
20+ years of field experience — actionable advice


**Compressed Air Best Practices® Magazine Webinar**
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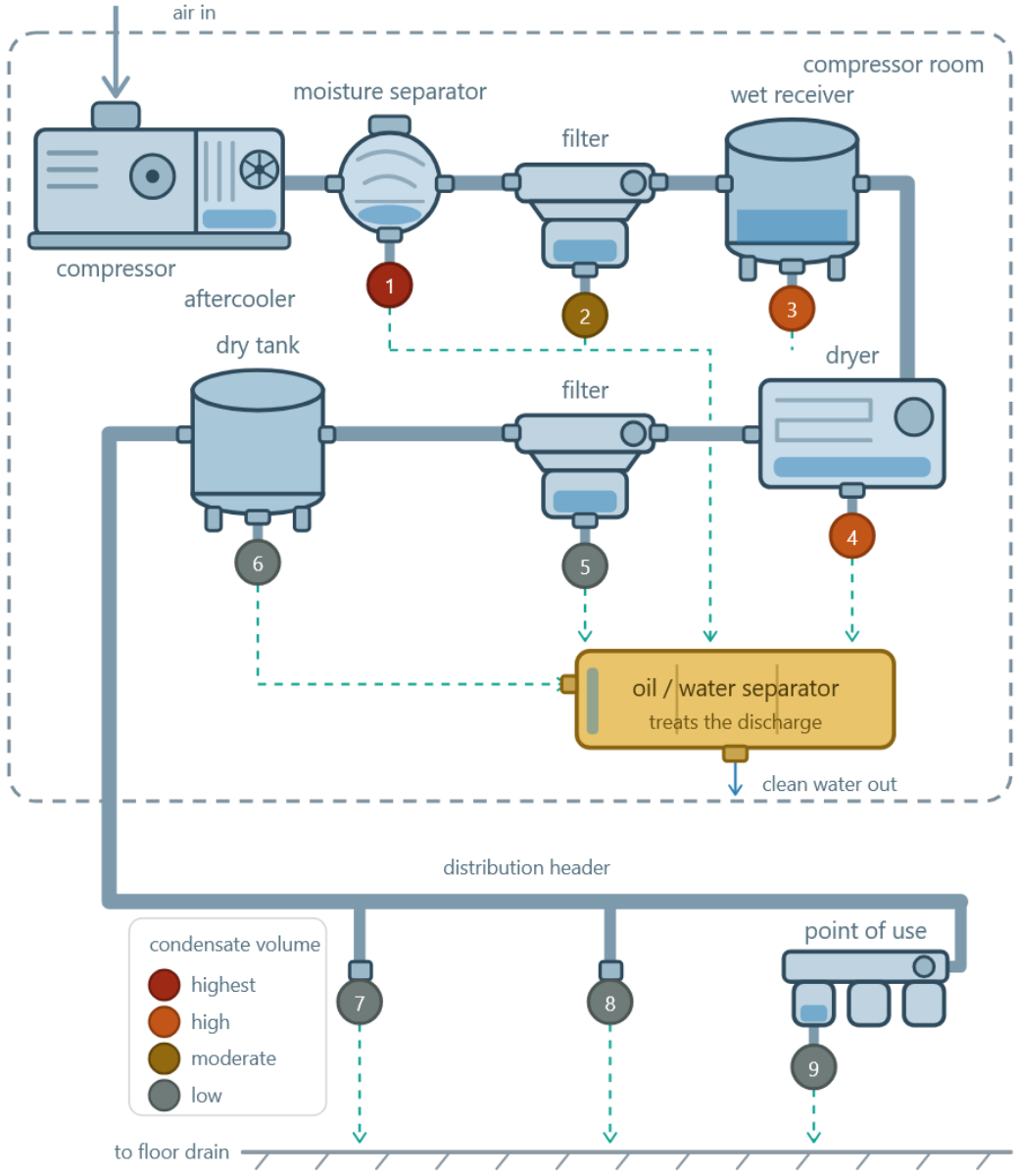
# Agenda

1. Why condensate management matters
2. What's in the condensate — and what it wrecks
3. The four types of condensate drains
4. Where drains belong — walking the low points
5. Installation best practices — drains & separators
6. Maintenance & monitoring
7. Separators — treating the discharge
8. Tricks & traps from the field
9. Case studies — timer costs & “no-loss” that wasn't
10. System design best practices & selection checklist
11. Resources & references + Q & A

# Compressed Air Systems and Condensate Drain Locations




## Condensate Drain I.D.

1. moisture separator
2. filter — before receiver
3. wet receiver
4. dryer
5. filter — after dryer
6. dry tank
7. drip leg — mid header
8. drip leg — header end
9. point-of-use bowl

**1–9 = drain points on even a simple system**

- *color = condensate share (red = most water)*
- *every discharge → oil/water separator → clean water out*

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# Why Condensate Management Matters

- **Every compressed air system makes condensate — it is unavoidable physics**
  - Compress & cool air below its dew point and water drops out; oil-lubricated compressors add an oil aerosol on top
  - A 100 HP compressor can shed ~20–30 gallons of condensate per day (more in hot, humid weather)
- The drain is doing more work than most people realize
  - Fails OPEN → blows compressed air 24/7 — money straight out the exhaust
  - Fails CLOSED → water & oil carry downstream into dryers, filters, tools and product
- Failure is silent — nobody notices until there's water at the tool or the air bill jumps

*A dryer draining straight to a floor drain — note the oil staining around it*



**KEY TAKEAWAY:** *A $900 drain protects a six-figure air system — and every product that air touches.*

# What's in the Condensate — and What It Ruins

- **It is not just water**
  - Water + compressor lubricant (oil aerosol) + rust & pipe scale + atmospheric particulate
  - Typically acidic, pH ~4–5 — corrosive to carbon steel and fittings
  - An oil/water emulsion — cannot legally go down the drain untreated
  - Oil-free compressors: no lubricant — but even more acidic (pH can reach ~3–4), still carries intake hydrocarbons & dirt — test before assuming it's sewer-safe
- Downstream damage when it escapes:
  - Desiccant dryers — oil fouls the beds and destroys dew point
  - Filters — flooded elements, high pressure drop, wasted energy
  - Tools & valves — rust, sticking, premature wear
  - Product — rejected parts, contaminated coatings, food & pharma risk

*Real condensate: rusty, oily sludge — note the corroded copper*



**KEY TAKEAWAY:** *Condensate is oily, acidic, and regulated — treat it like the waste stream it is.*

# The Four Types of Condensate Drains

| Drain type | How it works | Air loss | Reliability | Best use |
|---|---|---|---|---|
| **Manual valve** | Operator opens it periodically | High (if left open) | Depends on the human | Backup / secondary only |
| **Timer / solenoid** | Solenoid opens on a fixed time cycle | High — dumps air every cycle | Moderate; orifice clogs | Budget installs; sized backup |
| **Mechanical float** | Float rises with liquid, opens a valve | Low (when clean) | Fouls with oil & sludge | Clean, light-duty points |
| **Zero-loss electronic** | Level sensor opens only when full, then reseals | ≈ Zero | High (with maintenance) | Best practice where air = money |

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**KEY TAKEAWAY:** *Match the drain to the point — but default to zero-loss wherever compressed air is money.*

# Manual & Timer / Solenoid Drains

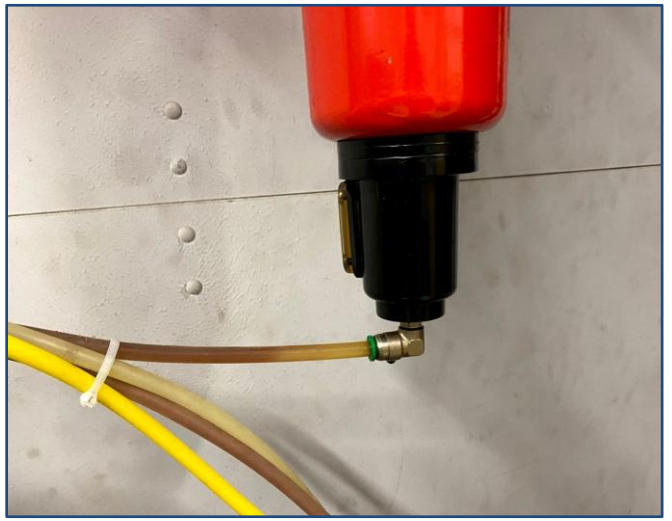
- **Manual valves**
  - Cheapest option, but relies on someone remembering
  - Left cracked open = a continuous air leak — acceptable only as a backup
- **Timer (solenoid) drains**
  - Open for a set number of seconds every few minutes — whether or not there's water
  - TRAP: every dump blows compressed air; a factory-default or over-set timer can waste thousands of $/yr
  - TRAP: the small orifice clogs with oil & scale → fails closed, no discharge
  - Where they fit: budget installs or a timed backup — set the interval to the actual load


*Timer / solenoid drain — note the MIN & SEC dials (and the cobwebs)*

**KEY TAKEAWAY:** *A timer drain wastes air on purpose — size the interval to the water, not the clock.*

# Mechanical Float Drains

- **How it works**
  - Rising condensate lifts a float that opens the valve — no air loss in principle
- **Pros**
  - No power needed, no air waste when working, mechanically simple
- **Cons & traps**
  - Oil and sludge gum up the float and seat → sticks OPEN (air leak) or CLOSED (carryover)
  - Sensitive to orientation and back-pressure; small orifices clog
  - Needs regular cleaning to stay reliable
- Best use: relatively clean, low-oil points — not ideal right after an oil-flooded screw



*Top: field install on a coalescing filter — note the oil-stained tubing. Bottom: mechanical no-loss float drain (Clean Resources)*

**KEY TAKEAWAY:** *Float drains are cheap and air-tight — until oil sludge freezes the float. Inspect them.*

# Zero-Loss / Pneumatic & Electronic Drains (Best Practice)

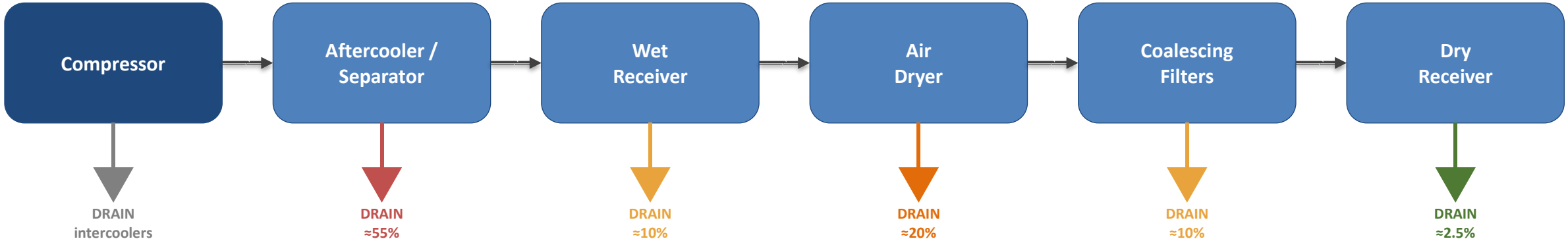
- **How it works**
  - A chamber fills; a level sensor detects liquid and opens the valve only long enough to expel condensate, then reseals before air escapes
- Why it's best practice
  - Essentially zero compressed-air loss + reliable, demand-based discharge
- **Features to look for**
  - Level-sensed (not timed) · fault / alarm output · test button · large clear orifice
- The catch
  - Needs power or air power, higher up-front cost, still needs annual service
  - Wire the fault contact to your alarm / BMS — know about carryover before your product does

*Zero-loss electronic drains on a receiver — note the individual lines & isolation valves – Pneumatic Powered Drains*



**KEY TAKEAWAY:** *Zero-loss drains pay for themselves in saved air — and tell you when they're unhappy.*

# Where Drains Belong — Walk the Low Points




**Every place air cools and water drops out is a drain point:**

- Aftercooler / moisture separator — the biggest volume, right at the compressor
- Multi-stage machines: every intercooler is a drain point too — verify the package's interstage drains & route them to the OWS
- Wet receiver bottom · air dryer · every pre- and coalescing-filter bowl
- Dry receiver and downstream low points
- Drip legs at header ends and every drop to a machine

*Drain color & % = typical share of system condensate (red = most water) — size each drain point for its share*



**KEY TAKEAWAY:** *Water collects at every low point — so does your risk. Drain them all, then treat what they discharge.*

# Installation Best Practices — Drains

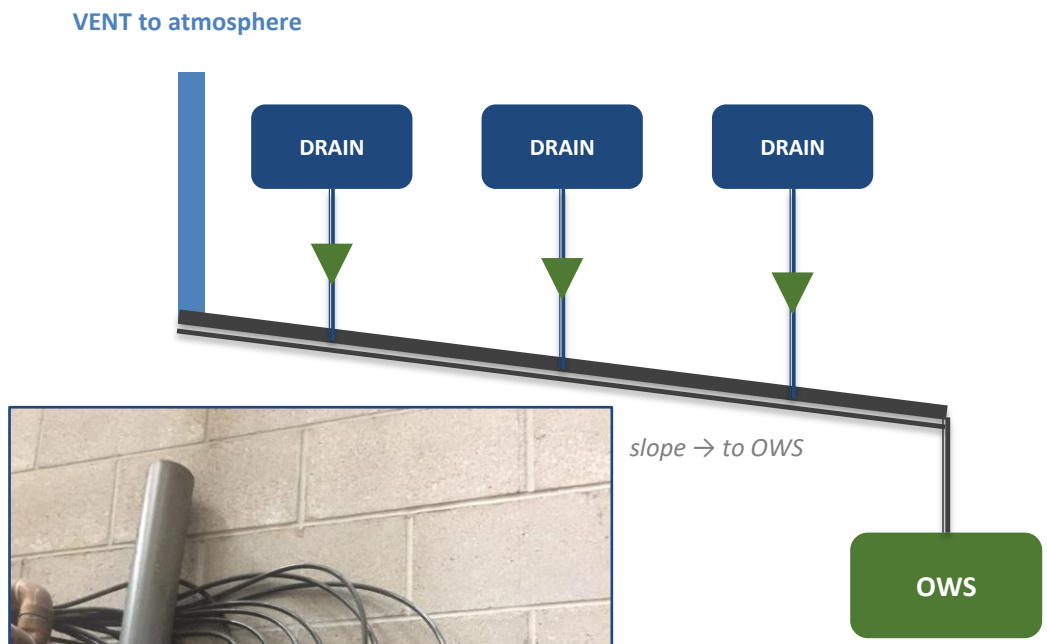
- **One drain → one line → one isolation valve (service it without shutting down)**
  - Never manifold drains into a shared header — back-pressure makes upstream drains fail & carry over
- **Treat drain lines like plumbing — let gravity work: slope down, short runs, no lifts**
  - Don't push condensate up-and-over to a remote drain under air pressure — it kills zero-loss savings
- **Specify drains you can test and see working**
  - Test button + sight glass / air-gap discharge → confirm operation at a glance
  - Failure & set-point indicators are usually poor — pick drains with a fault output
- Know your real condensate load — time how fast the discharge fills a bucket or refills a 55-gal drum; it sizes timer settings & flags a failing drain
- Route the discharge to an oil/water separator — never a bare floor drain


*The compressor OEM's own warning: drain lines cannot share a common header*

**KEY TAKEAWAY:** *Treat drains like plumbing you can test — gravity, an isolation valve, and a way to see it working.*

# Drain Manifolds — If You Must, Do It Right

- **The default is still one drain → one line → the separator**
- **A shared manifold is acceptable ONLY when it's engineered:**
  - OVERSIZE it — ≥ 2" pipe for a handful of drains (not ½" tube)
  - VENT it to atmosphere — an unpressurized manifold = zero back-pressure on every drain
  - SLOPE it continuously to the OWS — no traps, no uphill lifts
  - Enter from the TOP — each drain through its own fitting
  - Keep each drain's isolation valve so it can be serviced live
- Never tee pressurized drain discharges into a small common tube — back-pressure can hold the upstream drains shut




**KEY TAKEAWAY:** *A manifold isn't a tee'd tube — it's an oversized, vented, sloped gravity header.*

# Installation Best Practices — Separators (OWS)

- **Oil-free ≠ drain-safe — test before you assume**
  - Oil-free compressors still carry ambient hydrocarbons & intake dust — it's still wastewater
  - Sample it; meet local POTW limits (often 10–15 ppm; EPA 40 CFR 279 caps oil at 40 ppm) — treat if it exceeds
  - EPA 40 CFR 403.5(b)(2): discharge below pH 5.0 is prohibited — oil-free condensate can fail on acidity alone (ref: CABP, "Achieving Technically Oil-Free Compressed Air")
- **Feed the separator by gravity — below the drain points, sloped inlet, properly vented**
  - Never push condensate uphill into the OWS under compressed-air pressure
- Contain it: leaky OWS housings are common — set the unit in secondary containment / a drip tray
- Alarm it: most OWS have NO overfull alarm — add a high-level float so a plugged bed can't overflow oil
- Add an outlet sample / test port — verify effluent ppm on a schedule and keep the results

*Untreated condensate dumped outdoors — a discharge violation waiting to happen*

**KEY TAKEAWAY:** *Gravity-fed, contained, alarmed, and sampled — an OWS you can trust and prove is compliant.*

# Maintenance & Monitoring

- **Drains are wear items — not "install and forget"**
- **Monthly: press the test button**
  - Confirm a short puff then a clean reseal; look & listen for a continuous air leak
- Quarterly / annual:
  - Clean strainers & chambers · rebuild or replace seals · verify float action
- **Know the failure signs**
  - Continuous hiss = failed open = wasted air
  - Water at tools or rising dryer dew point = failed closed = carryover
- Three alarms cover the whole train: drain fault → BMS · OWS high-level float · dryer dew-point rise — keep rebuild kits on hand


*The TEST button + interval dials — a monthly press confirms it still puffs and reseals*

**KEY TAKEAWAY:** *Test the button monthly. A silent drain is either perfect or failed — go check which.*

# Separators — Treating the Discharge

- The discharge is an oil/water emulsion — illegal to send to the sewer untreated
  - Clean Water Act & local POTW limits — commonly ≤10 mg/L (ppm) oil & grease
- **Oil/water separator: condensate flows through adsorption media (alumina-silicate) that grabs the oil and passes clean water**
  - Guaranteed to ≤10 ppm when properly sized, installed & registered (EPA methods 1664b, etc.)
- **Size by compressor CFM / HP and oil type — under sizing = oil breakthrough**
  - e.g. Clean Resources CRP-500 → 30–250 HP · CRP-2000 → up to ~800 HP
- Maintain: change media on schedule; dispose of spent media & oil per regs; keep the registration paperwork

*Clean Resources oil/water separator line (session sponsor)*

**KEY TAKEAWAY:** *Separators turn a hazardous emulsion into sewer-safe water — size them right and keep the paperwork.*

# Sizing & Spec'ing — the Drain and the OWS

- **Pressure rating**
  - Rate the drain for maximum system pressure — standard bodies to ~250 psi; high-pressure versions to 4,000 psi
  - Zero-loss drains also list a MINIMUM pressure needed to eject condensate — check both ends of the spec
- **Orifice & valve size**
  - Small orifices are what clog with oil & scale — bigger is more forgiving; pilot-operated valves (~11 mm orifice) for high-load, dirty service
  - Know where the water is: aftercooler ≈ 55% of system condensate · refrigerated dryer ≈ 20% · wet receiver & pre-filter ≈ 10% each — size each point for its share
- **Drain settings**
  - Timers: ON just long enough to clear the water, OFF matched to season & load — summer can make 5× winter's condensate
  - Zero-loss: no settings to get wrong — but wire the fault output
- **Oil/Water Separator**
  - Size by total CFM/HP AND climate AND lubricant type — polyglycol vs. mineral vs. synthetic need different media; confirm with the OWS maker
  - The OWS is an UNPRESSURIZED vessel — feed it through its depressurization/vent chamber; never dead-head a pressurized drain line into it



**KEY TAKEAWAY:** *Spec the drain for the pressure, the orifice for the dirt, the settings for the season — and the OWS for the oil.*

# Tricks & Traps from the Field

- Manifolded drains — four into one ½" line: back-pressure held the receiver drain shut → carryover to the dryer
- Factory-default timer (5 s / 1 min) on a dry plant → thousands of $/yr of air wasted
- Float drain after an oil-flooded screw: sludge locked it open → a continuous leak no one heard
- Zero-loss drain with no isolation valve → servicing meant shutting the plant, so it never got serviced
- Separator undersized / media never changed → oil breakthrough to the city sewer (a compliance problem)

*Field finds: a manual valve bypassing the drain to a bucket (top) · a bypass teed around a drain — one cracked valve from a 24/7 leak (bottom)*

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**KEY TAKEAWAY:** *Most drain failures are install & maintenance sins — not bad hardware.*

# Case Study 1 — What a Timer Drain Really Costs

*Annual cost of blown air, per drain — 125 psig · ¼" orifice ≈ 98 CFM while open · $0.35 / 1,000 ft³*

| OFF (min) \ ON (sec) | 0.5 s | 1 s | 2 s | 5 s | 10 s |
|---|---|---|---|---|---|
| **0.5 min** | $296 | $582 | $1,127 | $2,575 | $4,507 |
| **1 min** | $149 | $296 | $582 | **$1,387** | $2,575 |
| **2 min** | $75 | $149 | $296 | $721 | $1,387 |
| **5 min** | $30 | $60 | **$119** | $296 | $582 |
| **10 min** | $15 | $30 | $60 | $149 | $296 |

- **Factory default — 5 s ON / 1 min OFF: $1,387 per drain, per year**
- **Tuned to the actual load — 2 s ON / 5 min OFF: $119 / yr**
- **Zero-loss drain: ≈ $0 — and multiply the difference by every timer drain in the plant**

**RESULT:** *Against a default-set timer, a zero-loss drain pays for itself in months — go check every timer dial in the plant.*

# Case Study 2 — “No-Loss” Drains That Weren't

## The Assumption

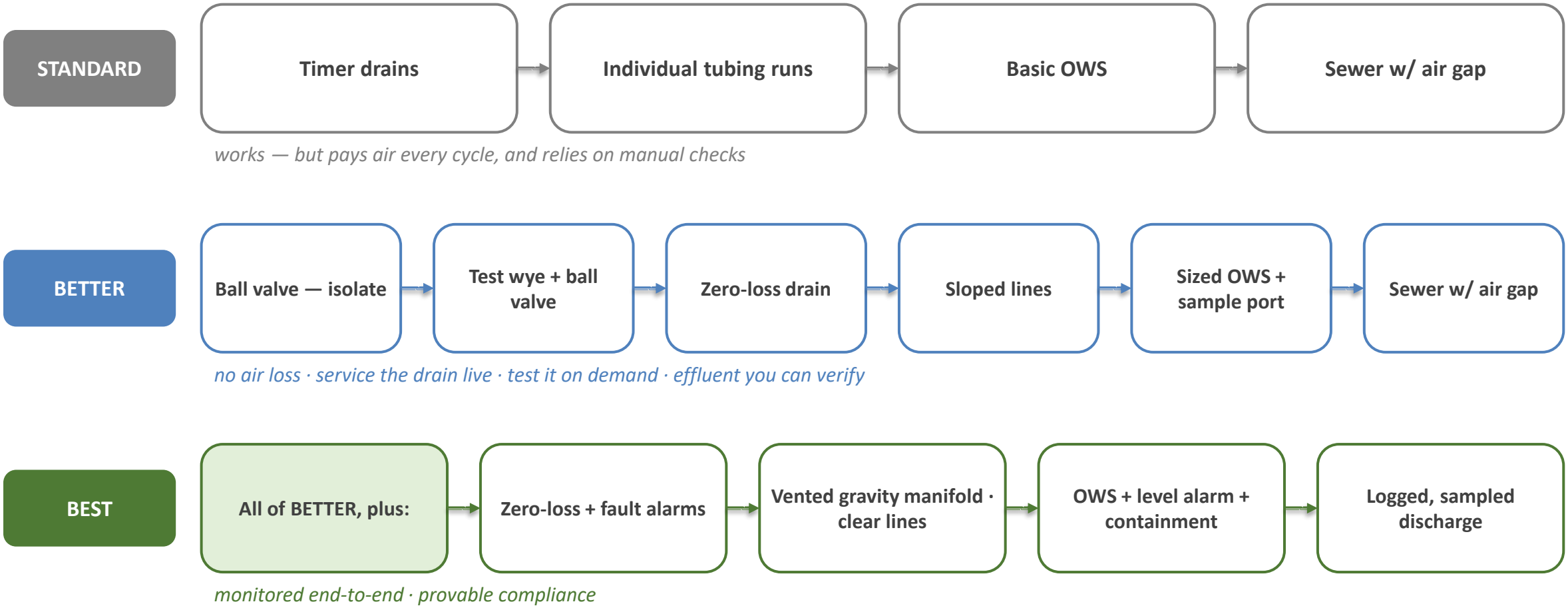
- Real audit: glass plant — 35 drains across 7 compressors & dryers
- Plant standardized on “no-loss” (NLAD) drains — air loss booked as $0
- Drains “didn’t work well” → balance lines left open to atmosphere = continuous purge
- Two “drains” were nothing but open pipe

## What the Audit Found

- 32 of 35 “no-loss” drains bleeding air 24/7 — ≈ 4,330 kWh ≈ $270 / yr each
- Plant total: 15.8 kW · 138,588 kWh / yr ≈ $10,800 / yr
- Fix: true no-loss drains — 29 × $400 = $11,600, minus $200/drain utility rebate
- Payback: 1.07 years

**RESULT:** *“No-loss” on the nameplate isn’t no-loss in the field — walk your drains and check where the balance line goes.*

# Condensate Architecture — Standard → Better → Best




**KEY TAKEAWAY:** *Climb one tier at a time — each step pays for itself in air, uptime, and compliance.*

# System Design Best Practices

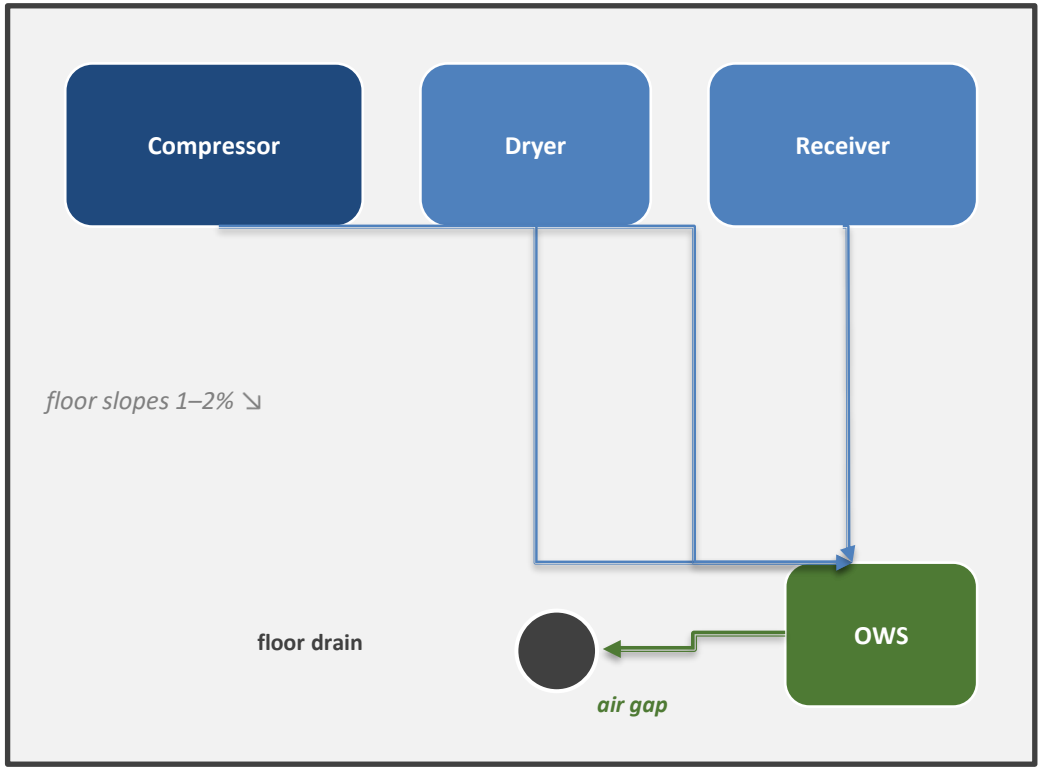
- **Take air off the TOP of the header — swan-neck / gooseneck takeoffs keep condensate in the main, out of the drops**
  - Bottom takeoffs feed water and oil straight down to the tool; an upside-down plumbing trap
- **Slope every main ~1% (≈1/8" per ft) toward designated low points — in a looped system, make the corners the low points**
- **Full-size drip legs at every low point — header ends, loop corners, before & after the dryer — each with a zero-loss drain**
- Knock out the bulk at the compressor — intercoolers, aftercooler + moisture separator before condensate reaches the distribution system
- Design a gravity path to a correctly-sized oil/water separator — no lifts, no pushing uphill under air pressure
- Size dry storage so drains aren't overwhelmed during big demand events; default to zero-loss drains



**KEY TAKEAWAY:** *Good condensate design starts at the pipe — top takeoffs, sloped mains, drip legs at every low point — then drain it and treat it.*

# Compressor Room Design — Plan the Floor Drain

- **Put a floor drain (or trench) in the room at design time**
  - Retrofitting one later means saw-cutting concrete — cheapest insurance you'll ever pour
- **Slope the floor 1–2% to the drain · set equipment on housekeeping pads**
- Condensate NEVER goes to the floor drain directly
  - Every drain point → OWS → then the floor drain, through an AIR GAP
- Locate the OWS low, next to the drain, with service clearance
  - Containment under the OWS — the sloped floor + drain become your spill protection
- Verify with local POTW / plumbing code: sample port, backflow, permit




*Compressor room — plan view*

**KEY TAKEAWAY:** *The best condensate decision costs nothing at design time: a sloped floor and a drain in the room.*

# Design & Selection Checklist

- Identify every low point — put a drain at each one
- Default to zero-loss electronic where air cost matters
  - Float for clean, light-duty points · timer only as a sized backup
- **Individual drain lines + isolation valves — no shared headers**
- Relieve pressure first — vented manifold or the OWS's depressurization chamber — then into a correctly-sized oil/water separator
- Wire fault outputs to an alarm / BMS
- Put drains on the PM schedule; stock rebuild kits
- Keep separator sizing & EPA registration documentation on file



**KEY TAKEAWAY:** *Design for access and monitoring — the drain you can test is the drain that gets tested.*

# Resources & References

- **CAGI — Compressed Air & Gas Institute — cagi.org**
  - Industry standards, CAGI performance data sheets, Compressed Air & Gas Handbook
- **Compressed Air Challenge (CAGI Education Foundation) — compressedairchallenge.org**
  - Fundamentals & Advanced training; "Improving Compressed Air System Performance" sourcebook
- **U.S. DOE — Compressed Air Systems — energy.gov/cmei**
  - Free tip sheets: "Remove Condensate with Minimal Air Loss," "Maintaining System Air Quality"; AIRMaster+ / MEASUR tools
- **Compressed Air Best Practices Magazine — airbestpractices.com**
  - Trade articles & case studies on condensate, drains, oil/water separators & air treatment
- **ASHRAE — ashrae.org**
  - Psychometrics, dew point & refrigeration standards behind dryer and condensate design



**KEY TAKEAWAY:** *Vendor-neutral authorities — start with the CAGI data sheets and the DOE "Remove Condensate with Minimal Air Loss" tip sheet.*

# Summary & Contact

- Condensate is unavoidable — the drain is a small part doing a big job
  - Failed open = wasted air · failed closed = water & oil downstream
- Drain types, worst → best: manual < timer < float < zero-loss
- **Install for access: isolate, don't manifold, separate before discharge**
- Maintain & monitor — test buttons and fault alarms catch failures early

*Scan to connect*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**KEY TAKEAWAY:** *Right drain, right install, treated discharge, monitored — that's condensate you never have to think about.*

# Thank You!

Thank you to **CABP** for hosting — and to **Clean Resources** for sponsoring this session

*cleanresources.com — oil/water separators for compressor condensate*

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Contact me with any questions or support needs:

**Peter Vinck · Inflow Corporation · peter.vinck@inflowco.com · www.inflowco.com**

# About the Speaker

**Chad Timmer**
Clean Resources

- Vice President of Sales, Clean Resources
- In compressed air since 2011
- Started with a Quincy distributor in Michigan
- Hands-on background from his father's tool and die shop

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# Do You Know...

What an Oil-Water Separator actually does?
The EPA mandate on condensate discharge levels?
How much condensate your compressor produces?

Chad Timmer — **Vice President of Sales**

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# Today's Discussion

- Purpose of the Oil-Water Separator
- EPA mandate
- How much condensate does my compressor produce?
- Food manufacturing company
- Oil-Water Separator — an insurance policy
- Small manufacturing company and OSHA
- ISO audit in Detroit
- Local code enforcement

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# Purpose of the Oil-Water Separator

Condensate Management and the EPA Mandate

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## Oil Carryover = Oil-to-Air Ratio

Concentration of oil in the compressed air

## 1 – 2 ppm Oil in Air = 300 – 600 ppm in Condensate

COMPRESSOR CONDENSATE

## EPA has mandated

Condensate cannot exceed 50 ppm

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# How much condensate does my compressor produce?

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# Food Manufacturing Company

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# Who am I at risk from?

- EPA
- Local Code Enforcement
- OSHA
- ISO/TS Audits

# Oil-Water Separator an insurance policy


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# Small manufacturing company and OSHA

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# ISO audit in Detroit

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# Local code enforcement

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Submit your poll answer to qualify. Winners notified tomorrow!

**What does a failed-closed condensate drain cause?**

| | |
|---|---|
| A | • Wasted air |
| B | • Water & oil carryover |
| C | • Noise increase |

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*By entering you are giving permission to announce your name if you are a winner

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# Condensate Management Drains, Separators and Compliance Strategies

## Q&A

Please submit any questions through the Question Window on your GoToWebinar interface, directing them to Best Practices Magazine. Our panelists will do their best to address your questions and will follow up with you on anything that goes unanswered during this session.

**Thank you for attending!**

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## August 2026 Webinar

# How to Maintain Cooling System Efficiency Over Time

**Clayton Penhallegon, Jr., PE**
Integrated Services Group
*Keynote Speaker*

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