

# COMPRESSED AIR LEAK CORRECTION

REBATE PROGRAM

**DID YOU KNOW  
THIS HOLE**



**COULD BE COSTING  
YOUR COMPANY MORE THAN  
\$12,000  
ANNUALLY?**

**TEAMING UP TO SAVE YOU MONEY**






**CONSERVE & \$AVE**



# HOW MUCH ARE COMPRESSED AIR LEAKS COSTING YOU?

Compressed air isn't free! It may be looked upon as a utility much like water, electricity, or gas. According to the U.S. Department of Energy, compressed air is the most costly utility in plants today. It is estimated that average industrial customers waste 20% to 30% of their compressed air to leaks. Look at how much compressed air leaks may be costing you:

Air Loss (cfm)	Equivalent Orifice Size	Annual Cost*
16	 1/8"	\$1,432
63	 1/4"	\$5,640
143	 3/8"	\$12,801

By routinely detecting and fixing air leaks, most companies can reduce leakage to 10% or less and realize large cost savings and almost immediate payback. Any company committed to reducing operating costs should conduct a compressed air leak survey.

## Major air leak sources include:

- Hose leaks, fittings, worn disconnect plugs, and tools
- Mechanical failures on valves, cylinders, and controls such as seals, seats, gaskets, and O-rings
- Condensate traps and pressure regulators
- Pipe connections and stem valve packing in shut-off valves
- Abandoned equipment with the air left on

*\*Note: Annual Costs were calculated using 100 psig air, an average energy rate of \$0.08/kWh, and assuming 6,000 annual operating hours and 4.0 cfm/bhp.*

# LET YOUR UTILITY HELP YOUR BUSINESS

If you are a customer that has at least 10 horsepower of air compressors that operate at least 2,000 hours per year, we can provide you the use of an ultrasonic leak detector for **FREE** to locate your leaks without shutting down your processes. The Ultraprobe® 3000 leak detector is easy to use and comes with instructions that show you how to use the detector to locate leaks. Most air leaks can be corrected as they are located, so you can begin saving energy and money immediately. After locating your leaks, the software (included) will provide a detailed report showing how much you can save by fixing each leak.

If you prefer not to perform your own leak survey, you can hire a contractor to perform a survey to identify the locations of your compressed air leaks and provide a detailed leak report.

We recommend implementing a correction maintenance program, at least annually, to minimize waste due to leaks in your compressed air system.





# CONSERVE & \$AVE REBATES

Rebates are available to our customers who document and verify that they have fixed at least 50% of the compressed air leaks identified during a leak survey (self-survey or third-party survey).

The rebate is \$4 per horsepower of air compressor (excluding backup compressors). For example, if you have 50 hp of air compressors that operate more than 2,000 hours per year, the rebate for repairing at least half of the air leaks identified in a survey would be \$200. When combined with the energy savings, the typical payback for surveying and repairing compressed air leaks is only a few months.\*

**Rebate applications are available on your utility's website, or call your utility representative.** Rebate verification will be determined based on comparison of pre and post data downloaded from leak detection equipment showing a reduction in air leaks of 50% or more.

## REQUIREMENTS TO PARTICIPATE

- Program is available to electric customers of Austin, Owatonna, and Rochester Public Utilities.
- Customers must have at least 10 horsepower of air compressors (excluding backup) that operate at least 2,000 hours per year.
- Customers must document and verify they have repaired at least 50% of the compressed air leaks identified during their survey.
- Customers must complete repairs and perform follow-up test within 60 days of initial compressed air leak survey.

*\*Note: Annual Costs were calculated using 100 psig air, an average energy rate of \$0.08/kWh, and assuming 6,000 annual operating hours and 4.0 cfm/bhp.*

# A STEP-BY-STEP GUIDE TO AIR LEAK CORRECTION

- 1 Reserve the Ultraprobe® 3000 leak detector.**  
*Use the reservation form on the following page. Submit your request at least two weeks before your leak survey is scheduled.*
- 2 Perform your initial leak survey.**
- 3 Create leak report using downloaded data.**  
*You may install the included software on your company computer or return the equipment to your utility to download the data and create the report for you.*
- 4 Perform repairs within 60 days of initial compressed air leak survey.**
- 5 Request the Ultraprobe® 3000 leak detector to perform your follow-up survey.**
- 6 Create a follow-up report using downloaded data.**  
*See Step 3.*
- 7 Apply for your **CONSERVE & \$SAVE** rebates.**



# LEAK DETECTOR RESERVATION

To reserve the Ultraprobe® 3000 leak detector, ***make a copy of this form***, fill out the information, and return it to your utility as listed below. An account representative will contact you. ***Keep this form to make copies for your follow-up survey request, as well as for future reservations; we recommend annual inspections.***

Commercial customers with at least 10 hp of air compressors that operate at least 2,000 hours per year may borrow the leak detector **FREE** for one week to locate air leaks (**INITIAL SURVEY**), and then again to verify repairs (**FOLLOW-UP SURVEY**).

**I am a customer of:**

Austin Utilities     Owatonna Public Utilities     Rochester Public Utilities

**FOR INITIAL SURVEY:**

\_\_\_\_\_  
Today's Date

\_\_\_\_\_  
Requested Date for Leak Detector

**FOR FOLLOW-UP SURVEY:**

\_\_\_\_\_  
Today's Date

\_\_\_\_\_  
Requested Date for Leak Detector

\_\_\_\_\_  
Company Name

\_\_\_\_\_  
Utility Account Number

\_\_\_\_\_  
Contact Name

\_\_\_\_\_  
Address

\_\_\_\_\_  
City

\_\_\_\_\_  
State

\_\_\_\_\_  
Zip

\_\_\_\_\_  
Daytime Phone

\_\_\_\_\_  
E-mail

**FAX, MAIL, OR E-MAIL A SCANNED COPY OF YOUR COMPLETED FORM TO:**

**Austin Utilities**

Attn: Commercial Acct Rep  
400 - 4th Street NE  
Austin, MN 55912  
507.433.5045 fax  
[KellyL@austinutilities.com](mailto:KellyL@austinutilities.com)

**Owatonna Public Utilities**

Attn: Commercial Acct Rep  
P.O. Box 800  
Owatonna, MN 55060  
507.451.4940 fax  
[GreenJ@owatonnautilities.com](mailto:GreenJ@owatonnautilities.com)

**Rochester Public Utilities**

Attn: Commercial Acct Rep  
4000 East River Road NE  
Rochester, MN 55906-2813  
507.280.1542 fax  
[TDeBoer@rpu.org](mailto:TDeBoer@rpu.org)

# ADDITIONAL WAYS TO IMPROVE THE PERFORMANCE OF YOUR COMPRESSED AIR SYSTEM

- **Intake air temperature** – For every 6°F that the inlet temperature is above the manufacturer’s rating conditions, the capacity of the compressor drops 1%. Thus, intake air should be supplied by outside air.
- **Reduce system pressure** – The system should deliver compressed air at the lowest possible pressure. Ideally, the pressure at the compressor should be no more than 10 psi higher than that required by the tools. Every 1 psi of pressure reduction equals 0.5% reduction in power requirements.
- **Maintain air filters regularly** to prevent air restrictions to the compressor.
- **Consider using a smaller compressor** – The existing compressor is probably oversized if it operates below 50% capacity for long periods of time.
- **Shut off air compressors when not needed** such as nights and weekends.
- **Use energy-efficient nozzles** – Efficient nozzles use about half the CFM as standard nozzles.



**Austin Utilities**  
400 - 4th Street NE  
Austin, MN 55912  
507.433.8886  
507.433.5045 fax  
[www.austinutilities.com](http://www.austinutilities.com)

**Owatonna Public Utilities**  
P.O. Box 800  
Owatonna, MN 55060  
507.451.2480  
507.451.4940 fax  
[www.owatonnautilities.com](http://www.owatonnautilities.com)

**Rochester Public Utilities**  
4000 East River Road NE  
Rochester, MN 55906-2813  
507.280.1500  
507.280.1542 fax  
[www.rpu.org](http://www.rpu.org)