



eleXion

ioniX Filling Station

Filling station installation instructions



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IONIX FS 2026

1. Overview.

Chemical free water treatment systems from eleXion have been specially designed to combat corrosion in modern sealed systems.

ioniX filling stations from eleXion are an industry leading range of ion exchange resin vessels designed for technical water treatment applications.

The range is designed to achieve compliance with VDI 2035, VDI 6044, BSRIA BG89, BG29 & BG50.

Chemical free water treatment and VDI 2035 is the preferred method of water treatment for the vast majority of HVAC manufacturers.

ioniX filling stations ensure system top ups and initial system filling are compliant with low saline requirements which is also referred to as “depleted” or “conditioned water” in UK guidance.

ioniX filling stations have been developed to ensure all future top-up water is conditioned prior to entering the system, providing demineralised water at point of fill, ensuring the circulation water remains within design parameters and preventing corrosion.

Raw water top-ups can seriously impact the life expectancy of all modern heating and cooling systems, whilst dramatically reducing the efficiency as a result of scale build formation and system fouling.

ioniX filling stations combat the root cause of scale and corrosion within modern sealed systems.

ioniX filling stations are utilised as pretreatment devices for systems which incorporate an automatic pressure maintenance device and also which incorporate manual quick fill connection.

For standard pumped pressurisation devices, the ioniX FS is located on the outlet of the device, whereas with fill & spill or vacuum degassing type units, the ioniX is located on the mains feed supply to the pressure maintenance device.

ioniX FS have been designed to be used alongside our Xi+ ion exchange resin.

Xi+ is our pH regulated ion exchange resin designed to condition the fill water and existing circulating water in accordance with known chemical free guidance documents.

Regulating the pH & electrical conductivity at point of fill puts the system water in a non-corrosive state from the outset, while removing hardness forming salts at the same time.

The special blend of anion and cation resin not only targets minerals in the water but provides a significantly better exchange capacity towards acids and aggressive salts over standard resins available.

ioniX FS are typically sized on estimated annual system top ups and losses through general maintenance &/or system leaks.

Each filling station is supplied with a combined electrical conductivity and water meter, which allows for real time monitoring of the outlet conductivity and system fill volume.

The internal meter is available in two options, AA battery powered or 240v (3 pin UK plug). The 240v option is compatible with a BMS system, via volt free alarm output. When the resin outlet setpoint has been exceeded, the internal contact breaks.

A separate Modbus/pulse water meter can also be supplied for monitoring annual fill rates via a BMS panel. Initial system fills should also be accounted for when selecting the appropriate size filling station.

System top up water and circulation water can be treated to known chemical free guidelines such as VDI 2035.

2. System identification.

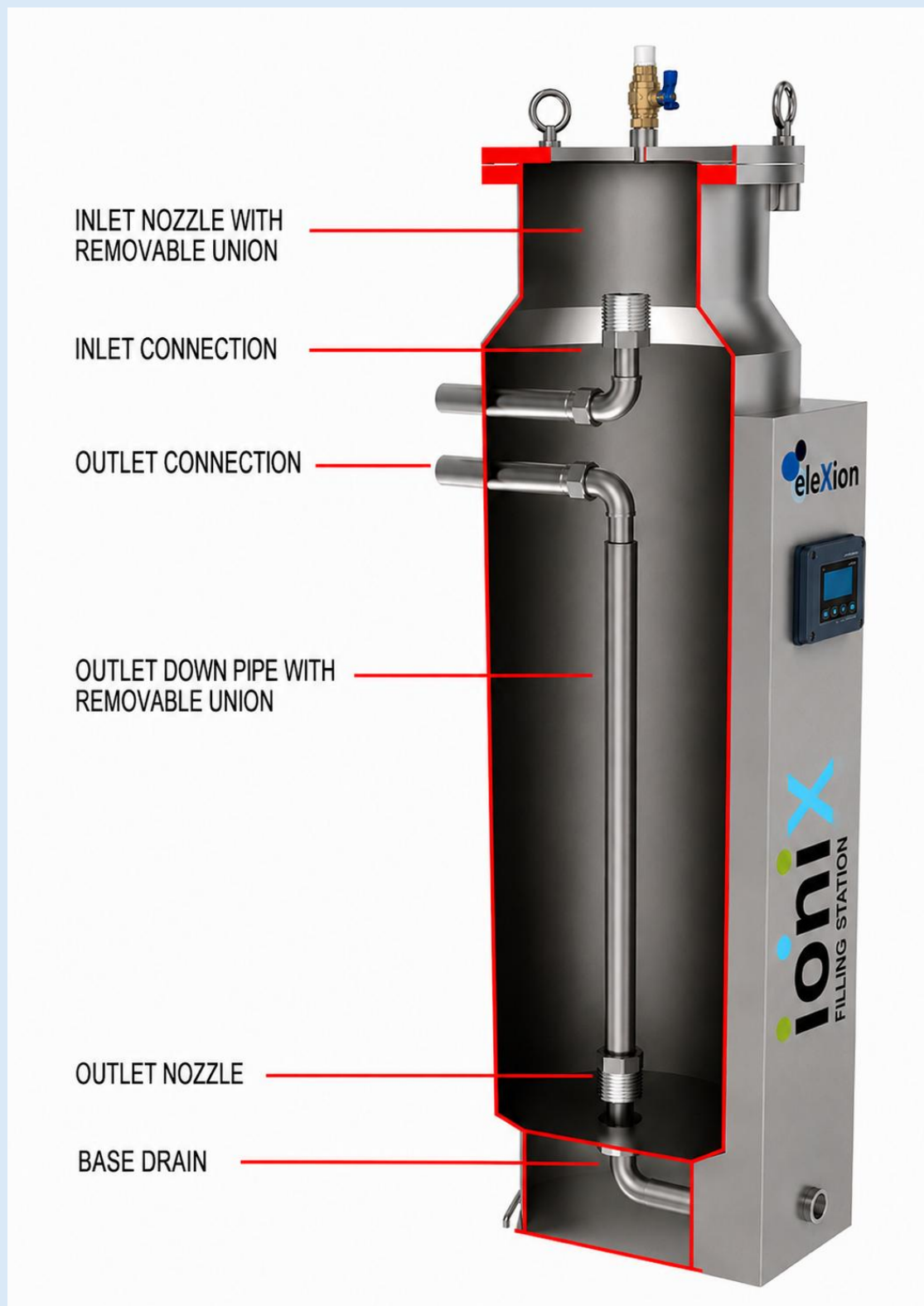
IoniX 15-100

External



IoniX 15-100

Internal



3. General safety information.

The ioniX filling station should only be installed and operated in accordance with this instruction manual and should only be operated by suitably trained personnel.

Each filling station is manufactured from high grade 316 stainless steel.

Only the supplied Xi+ resin, valves, sensors and electrical conductivity meter should be used when operating the ioniX FS.

The ioniX FS lid has been manufactured to withstand pressures of up to 10 bar, with the supplied gasket being designed to withstand temperatures of up to 90 degrees with a long service life. All filling stations are pressure tested at the factory to ensure they are compliant with the information in this manual.

All filling stations are pressure tested at the factory to ensure they are compliant with the information in this manual. Testing of each unit is compliant with PED 2014/68/EU.

The lid must be secured as per the instructions found within this manual, failure to do so may result in water leakage, which could potentially result in property damage. Any property damage as a result of leakage due to incorrect securing of the lid or accompanying accessories is not covered by the product liability insurance.

A pressure test of the filling station and associated equipment should be confirmed before use and before being left to operate unattended.

The devices should never be exposed to higher temperatures or pressures than listed in the technical data below.

ioniX FS should only be operated on a solid, stable and level platform, capable of supporting the weight of the unit when in operation.

ioniX FS can be operated under high temperatures and pressures, so precautions should be taken when handling or servicing the filling station.

Onsite risk assessments should be completed and appropriate PPE should be worn before working on any eleXion system.

ioniX FS should never be worked on until the filling station is electrically isolated from the power supply (combo meter ES099V), hydraulically isolated from the mains supply and/or system pipework, the pressure has been drained from the vessel and once the filling station is at a temperature where it is safe to handle.

Di water produced is intended only for technical use and not human consumption.

Personal injury and property damage resulting from the failure to comply with these instructions are not covered by the Product Liability. The manufacturer also assumes no liability for any other damage caused by the failure to comply with these instructions.

Please read these instructions carefully before using the device. For your own safety and others, it is essential to follow the safety instructions in this instruction manual.

You must always adhere to the relevant local safety regulations and water regulations.

It is the installer's/operator's responsibility to comply with the local regulations that apply to them and to keep up to date with the latest regulations.

4. Application:

ioniX filling stations from eleXion have been specially designed for use in both heating and cooling systems, allowing them to become compliant with “chemical free guidelines” and in line with many of the world’s leading HVAC manufacturers’ technical instructions and their requirements for water treatment.

Compatible guidelines:

- VDI 2035 & 6044
- ÖNORM 5195-1
- EN12828
- CIBSE CP1
- SWKI BT 102-01
- DIN50930
- BSRIA BG50
- HNTAS TS1

ioniX filling stations are designed to be used with ion exchange resins for the complete desalination of the fill water or softening of the fill water, depending on application.

When used with Xi+ resin (our in house mixed bed ion exchange resin), the Di water produced will be suitably conditioned for use in both heating and cooling systems.

Caution should be taken with third party resins, as they may not be suitable for use in HVAC systems.

Other technical applications and industries can also utilise the Di water produced from ioniX filling stations.

5. Product data sheet.

IoniX model	15	25	50	100
Dimensions				
Tank height (mm)	1020	1100	1230	1400
Tank width (mm)	405.40			
Tank width with computer housing (mm)	485.40			
Weight empty (kg)	115	125	135	155
Vessel information				
Design code	PED 2014/68/EU			
Wet side material	316 SS			
Tank finish	Pickled & passivated			
Test pressure (bar)	16			
Maximum operating pressure (bar)	10			
	UP TO 24 BAR AVAILABLE ON REQUEST			
Maximum operating temperature (°C)	60			
Effective capacity (Litres)	15	25	50	100
Recommended flow rate (lpm)	<15	<25	<50	<100
Connection sizes				
Air vent	1/2“			
*Inlet/outlet	3/4”			1”
Drain	3/4”			
Lid access	Removable top flange with M16 wing nuts			
Combined electrical conductivity & water meter				
ES099	Battery powered option (AA battery)			
ES099V	240v option (230V 3 pin plug with alarm output)			
Combo meter flow rate (lpm)	3-100			
Combo meter maximum temperature (°C)	80			
Estimated Capacity				
Estimated capacity @ 600 uS/cm	1,995	3,350	6,700	13,400
Estimated capacity @ 300 uS/cm	997.5	1,675	3,350	6,700

6. Estimated capacity limits.

To estimate the total volume of water that can be conditioned with an ioniX filling station using Xi+ resin the following estimates can be applied.

Xi+ resin treated volume based on inlet feed electrical conductivity (1 litre of resin)				
Cond	TDS	TDS	Conversion Factor	OBR
µS/cm	mg/l or ppm	meq/l as CaCO ₃		BV*
10	5	0.10	400	4000
50	25	0.50	400	800
100	50	1.00	400	400
150	75	1.50	400	267
200	100	2.00	400	200
250	125	2.50	400	160
300	150	3.00	400	133
350	175	3.50	400	114
400	200	4.00	400	100
450	225	4.50	400	89
500	250	5.00	400	80
550	275	5.50	400	73
600	300	6.00	400	67
650	325	6.50	400	62
700	350	7.00	400	57
750	375	7.50	400	53
800	400	8.00	400	50

*BV = L/L means volume of treated water per litre of resin.

- To calculate ioniX FS - BV x ioniX FS capacity (model)

Example: the local tap water has an electrical conductivity of 400 µS/cm.

Using the ioniX FS 50 it is possible to treat 5000 litres of water (50 x BV 100).

A critical factor is knowing the incoming conductivity supply of the raw water supply or the electrical conductivity of the circulating water if completing inline conditioning.

It is always preferable to have completed an onsite analysis of the fill or circulation water. However, if this is not available you can search the local water supplier's website to find their latest reports for the area in question. Please note, this is only useful information for initial filling and not inline circulation where contamination could affect the estimated capacity of Xi+ resin.

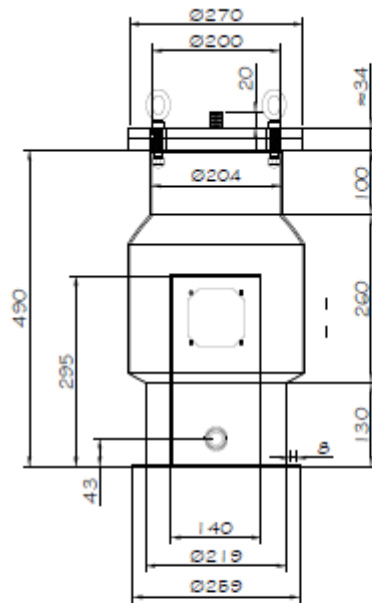
If the water supplier's details are unknown, you can visit www.water.org.uk/customers/find-your-supplier where you will be able to identify the local water supplier (providing they are not supplied privately).

The above calculations are an estimation tool only; these figures are based on natural water while performing treatment at the recommended flow rates. Chemically treated water or water which contains undesirable solids will have a negative effect on resin output.

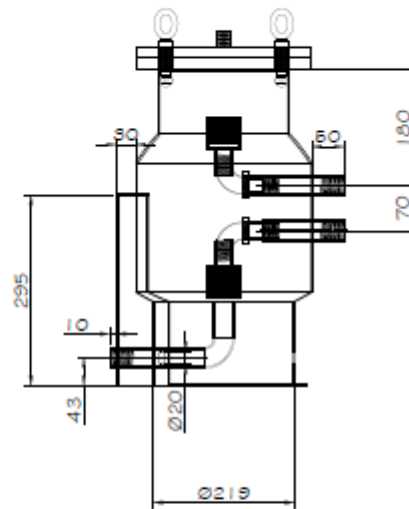
7. Drawings

IoniX 15

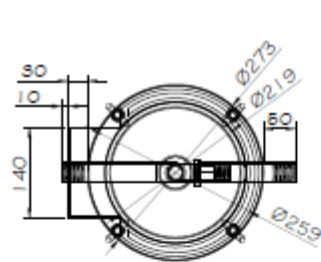
Dimensions



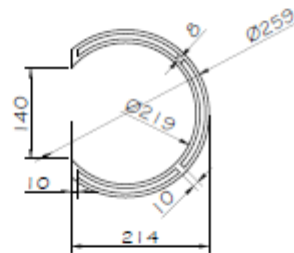
FRONT ELEVATION



SIDE ELEVATION

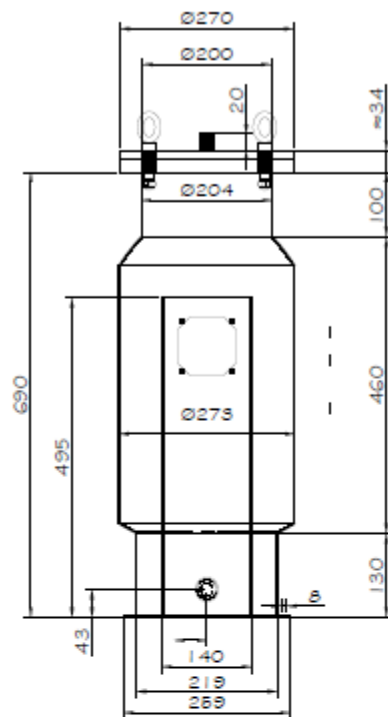


PLAN

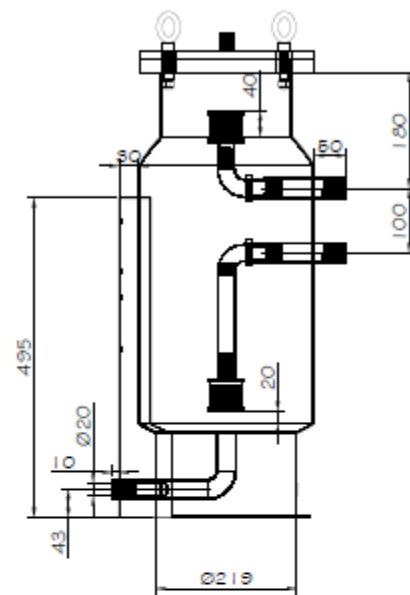


IoniX 25

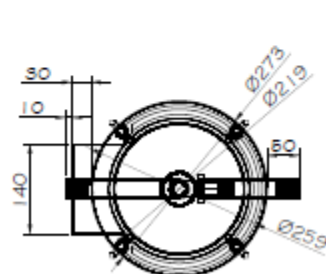
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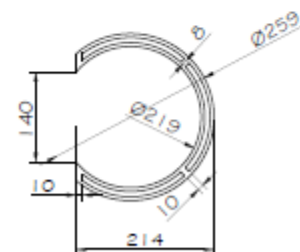
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SIDE ELEVATION

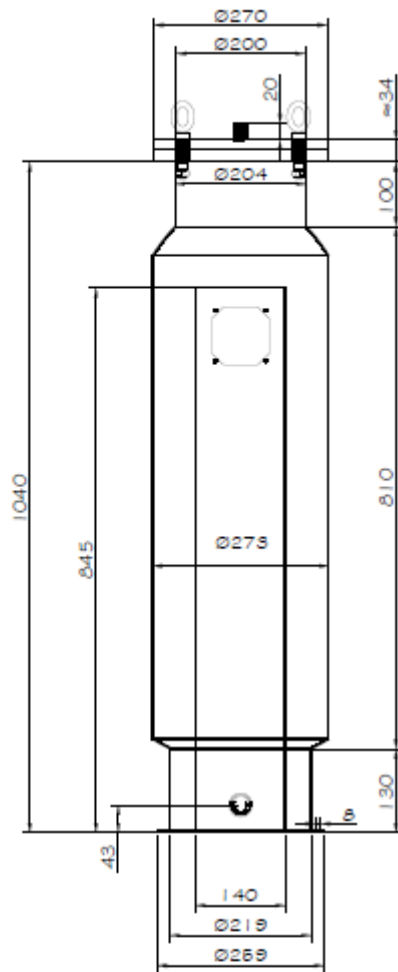


PLAN

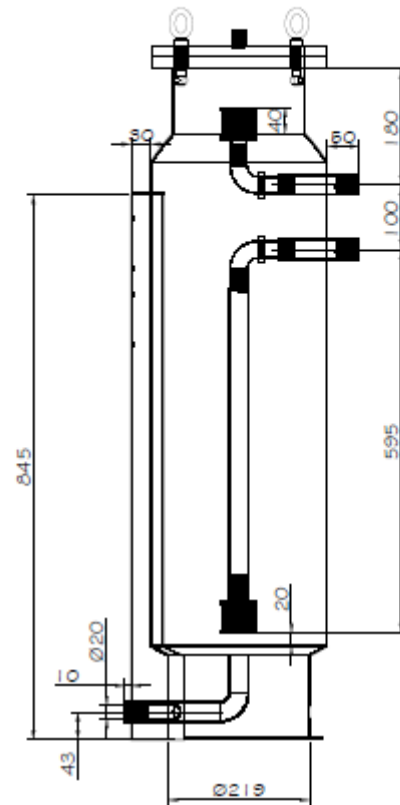


IonIX 50

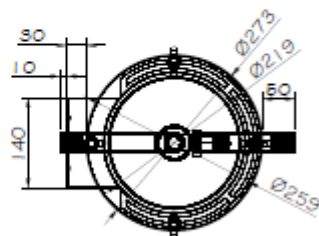
Dimensions



FRONT ELEVATION



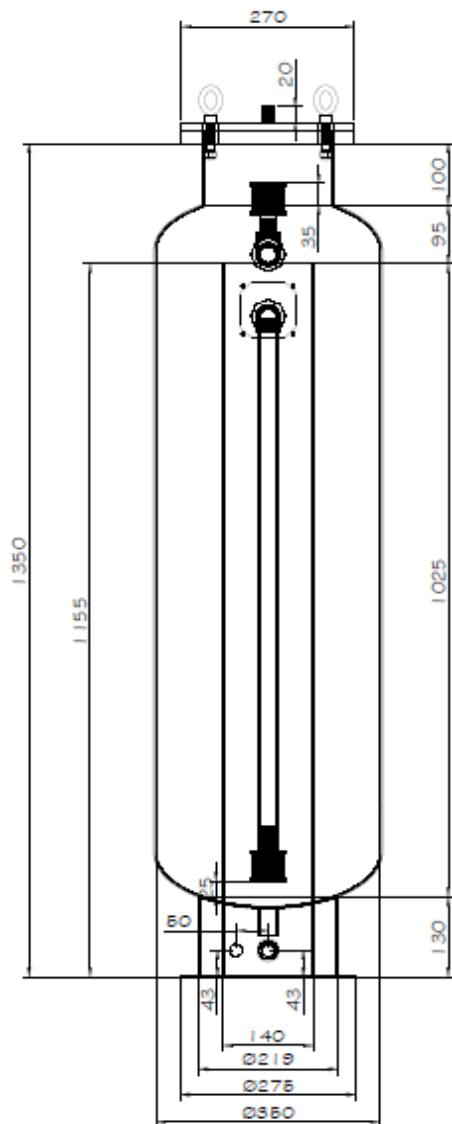
SIDE ELEVATION



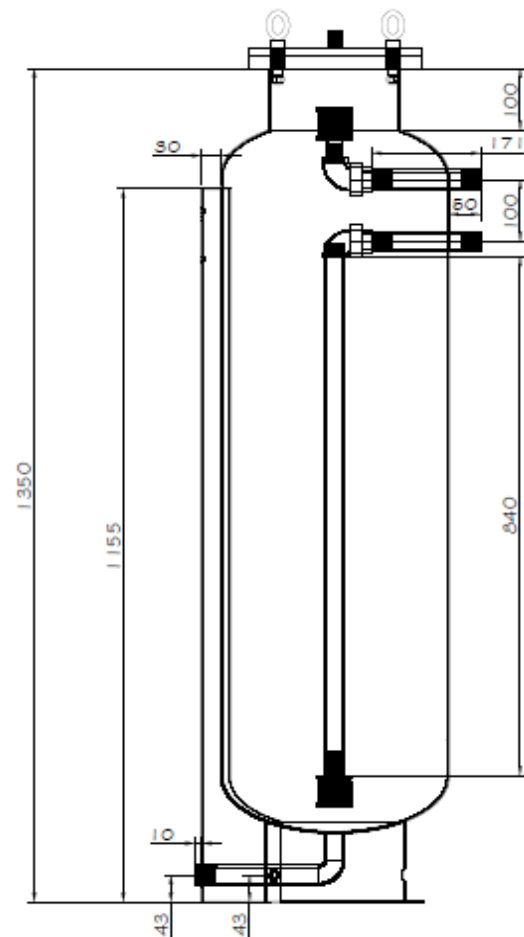
PLAN

IonIX 100

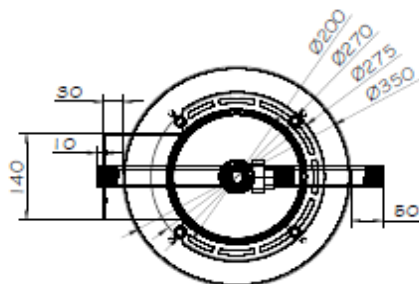
Dimensions



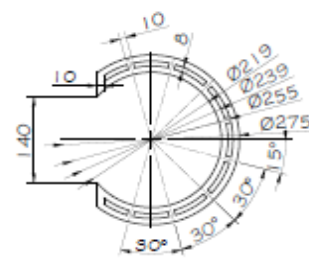
FRONT ELEVATION



SIDE ELEVATION



PLAN



8. IoniX sizing for permanent installation

The IoniX filling station should be sized on the following parameters:

- System volume.
- Yearly estimated top up volume.
- Fill rate required.

Typically, a maximum annual system top up should be limited to 5%.

VDI 2035 “During the lifetime of the system the quantity of filling and make-up water should not exceed three times the water content of the system”.

If the system volume and quality of the local water is known, it is possible to calculate the volume of resin required to meet the recommended annual top up rate. This information will help size the IoniX FS required to meet the demands of the system.

It is always recommended to work some contingency into the system to help manage unplanned works and potential system leaks.

For large industrial systems or heat networks multiple IoniX filling stations can be installed in parallel to achieve higher flow rates and capacity limits.

9. Connection to water supply

The IoniX system can be utilised for permanent connection to any sealed system.

Installation of the IoniX filling station should be compliant with this instruction manual and local building regulations.

A permanent connection can be subject to technical requirements depending on national or local regulations.

A break tank or device with a minimum CAT 4 protection is usually required when connecting to a commercial system.

A suitably approved backflow protection device, compliant with DIN EN 1717 may be required when connecting the IoniX filling station to a fill & spill type pressurisation unit.

When directly connecting to the mains supply or a system without the appropriate category of fluid protection it is recommended that the system incorporates an RPZ valve (BA separator part number 570005).

Where an IoniX filling station is installed direct to the mains and there is a hydraulic break between the heating/chilled system then a suitable CAT 3 double check valve will need to be installed.

Please check with your local water board to ensure the protection provided is sufficient and in line with building regulations/local water bylaws.

eleXion holds no responsibility for the incorrect use or classification of back flow prevention and it is the responsibility of the installer to ensure compliance.

ioniX filling stations should be positioned so that all future top up water passes through the filling station, ensuring all future top up/initial fill water is conditioned and in line with required guidelines.

Both manual fill and automatic top up device positions should be considered when positioning an ioniX filling station.

Where the inlet pressure exceeds 10 bar a suitable pressure reducing valve should be fitted to prevent exceeding the maximum recommended pressure.

The valve kit supplied allows for a flexible installation onsite where any orientation of the pipework can be achieved.

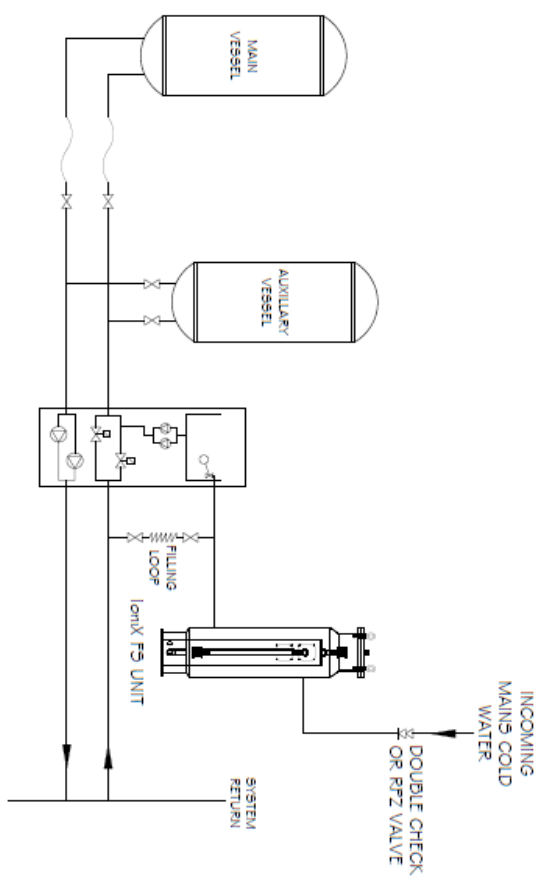
The filling station should be installed on a secure and level base, suitable to take the weight of the filling station when at full capacity and weight.

Please refer to the schematics on page 14 for installation assistance.

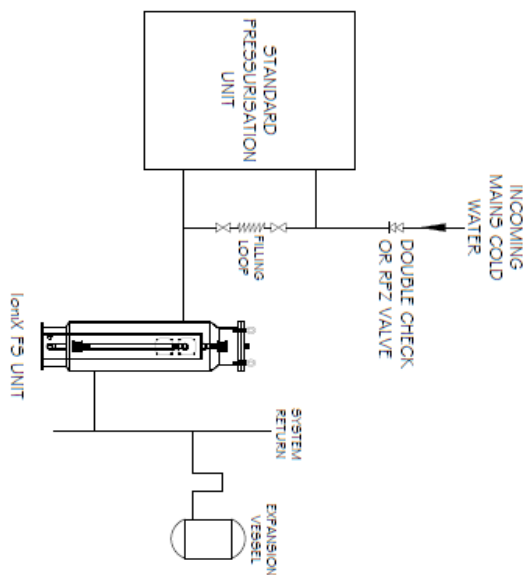
10. Installation examples

Ionix 15-100

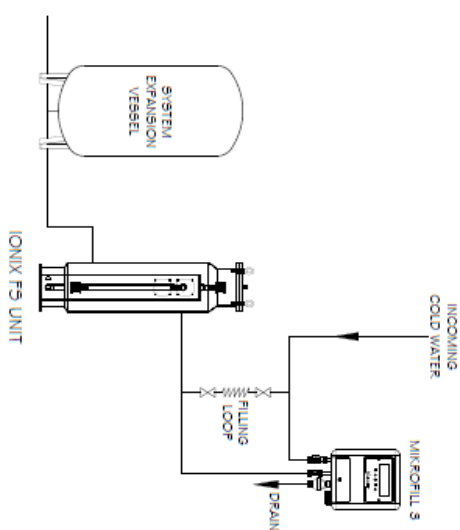
Typical installation layout



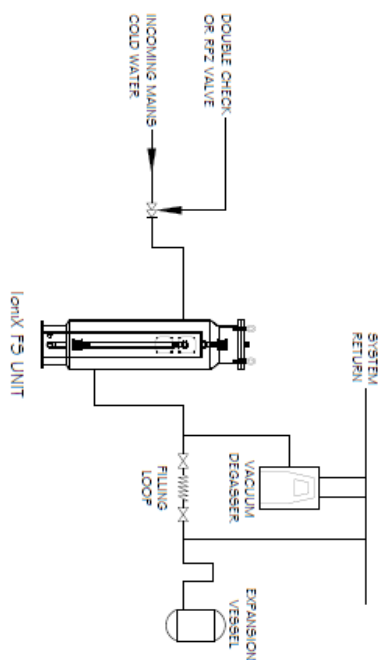
FILL & SPILL TYPE PRESSURISATION UNIT
IONIX FS CONNECTED TO THE INLET OF THE PU



STANDARD PRESSURISATION UNIT
IONIX FS CONNECTED TO THE OUTLET OF THE PU



TANK & PUMPLESS PRESSURISATION UNIT
IONIX FS CONNECTED TO MAINS OR
OUTLET OF DEVICE



VACUUM DEGASSER
IONIX FS CONNECTED TO MAINS INLET

11. Installation

11.1 Mounting the Filling station

The ionix FS is supplied with a multi-hole fixing ring for flexibility when mounting onsite.

The ring ensures there are ample fixing points available for the installer to securely mount the vessel no matter what surface they are using.

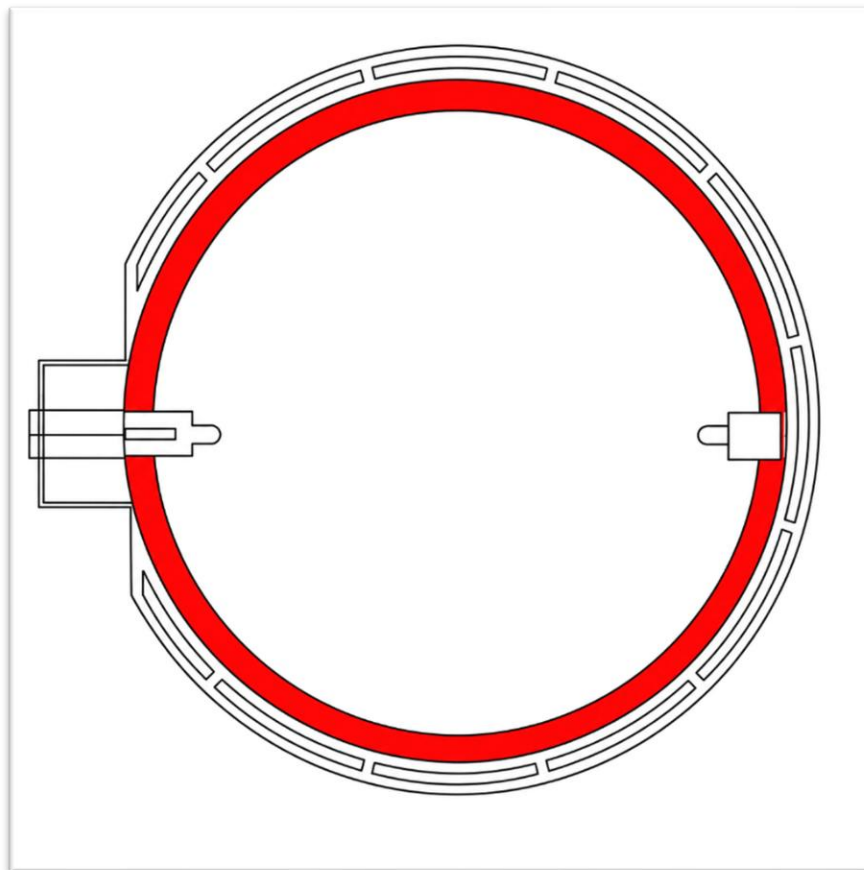
eleXion recommends that a minimum of four fixings are used, however depending on the installation environment and surface additional fixings may be required.

The installer must install the vessel on a suitable platform (direct to the floor/plinth/frame etc) which is capable of taking the weight of the vessel when full.

The platform must be sturdy and level to prevent the vessel from moving.

The installer will need to use appropriate fixings depending on the surface in which they plan to mount the vessel.

The vessel must be level and secured firmly to the floor.



11.2 Assembling the valve kit

The ioniX filling station has been designed to allow for a multitude of possible orientations.

It is possible to have the inlet and outlet connections fitted at any angle or orientation to assist with connecting onto the system.

The valve kit supplied has been pre-formed to show the installer how the valves and connections need to be fitted.

Where the valves and connections have been made hand tight with no sealant, the purpose is purely to show the formation of the valve set up.

The installer must provide a suitable jointing method to suit their preference.

eleXion permits the use of LOCTITE 55 or PTFE tape (or similar), for use on threaded fittings.

It is a requirement that the male threads of each item are “roughened or scratched” before applying the sealing thread.

Alternatively sealing compounds are permitted for use such as LOCTITE 557 or Rapid blue gel (or similar).

Before applying the selected sealing method, please refer to the selected product manufacturer’s instructions to ensure that the product is suitable for use and you are familiar with the necessary steps in making a watertight seal.

Any leak to the installed valve kit is the responsibility of the installer and will not be covered under the product guarantee, unless an item is faulty through manufacturing issues.



FILTER GASKET BASKET TO POINT TOWARDS
THE BRASS METER UNION



SAMPLE POINT MUST BE DOWN STREAM
OF ISOLATION VALVE HANDLE

12. Combo meters.

IonIX filling stations are supplied with a combined electrical conductivity and flow rate meter.

The standard Combo meter ES099 requires 3 x AA alkaline batteries.

The advanced combo meter ES099V requires a 240v plug supply.

The combination meter has been designed to register the outlet of the filling station. When water passes through the filling station the flow rate, total volume passed and electrical conductivity of the water are recorded.

It is recommended that the combo meter is set to AUTO with the alarm being set to 15 uS/cm.

Once this limit has been exceeded an audible alarm will be heard and if using the ES099V model a volt free contact will be made which can be connected to a BMS system.

The annual fill rate should be recorded.



To replace the batteries, simply unscrew the 4 machine screws so the meter head can be removed from the panel.

Carefully remove the meter connection.

Then unscrew the 4 small screws holding the back plate of the meter.

You will then be able to access the battery compartment.

Insert the batteries and then reassemble the meter and screw securely ensuring the black rubber gasket is correctly located in the recess.

13. Setting the combo meters.

Visual display of inlet & outlet meters, indicating correctly set meters.

The screen must display the **AUTO** symbol.

1. Turn the meter on using the  button; press and hold for 3 seconds.
2. The unit must be set to read $\mu\text{S}/\text{cm}$, should the device read PPM, a single short press of the  button will switch between the two possible readings.
3. To set the meter to **AUTO** press and hold the  button for 3 seconds, the red led will illuminate, release the  button and then press again for one short press, **AUTO** will now appear on the screen.
4. To set the conductivity limit press the  button, the limit counter will change, it is recommended that the meter is set to $15 \mu\text{S}/\text{cm}$.
5. To reset the limit values, hold down the  button for 3 seconds.
6. To reset the total volume meter, hold down the  button for 3 seconds, the total volume calculator will then reset.
7. The system takes an electrical conductivity reading every time 10 litres of water passes through the filling station. Once the capacity limit has been exceeded (eg $15 \mu\text{S}/\text{cm}$) the audible alarm can be heard and the volt free alarm contact will be closed (ES099V only) indicating the resin has expired.
8. Replacing the batteries (ES099 only), when the screen displays  this indicates the batteries need replacing. Unscrew the display screen from the ionix FS using a suitable Allen key, then remove the protective back cover of the meter display using a suitable Phillips screwdriver. Replace the AA batteries (3) using only alkaline batteries.
9. It is possible for the meter to record in both litres and gallons.
To switch between the two, with the batteries removed press and hold down the  button, insert the final battery, when you hear the audible “beep” release the  button and the screen will now show “gal/min”.



14. Pre operation safety checklist.

Before connecting or servicing the ioniX FS, the following checks should be undertaken by the onsite engineer.

IoniX filling station	
Safety check list	
Ensure the ioniX FS is in good condition.	
Check all seals and gaskets are in a good condition.	
Ensure the lid, bolts, metal washer and wing nut are in a good condition.	
Check that the operating pressure and temperature of the system do not exceed the maximum operating pressure or temperature of the filter.	
Check all supplied accessories have been fitted correctly and are in good working order.	
Check the combo meter connections/cables are in a good condition with no visible damage.	
Ensure the filling station is installed on a flat stable surface.	
Ensure that the system is fully depressurized before opening the lid.	
Ensure the system is electrically isolated (ES099V ONLY) before working on the unit.	

15. Securing the ioniX FS lid.

It is essential for the safe operation of the ioniX FS that the lid is secured correctly.

Failure to correctly secure the lid and gasket will result in leakage and potentially property damage.

Inspect the rubber seal before attempting to secure the lid. If the seal is damaged or worn it must be replaced. Using worn seals or having resin beads on the surface of either the lid, lid seat or gasket will compromise the integrity of the seal causing the lid to leak.

The supplied rubber seal should be located within the groove found on the filling station top flange.

The groove secures the rubber seal in place making it lock into position.

It is essential the seal is located correctly within the groove supplied on the filling station.
Failure to do so may result in the lid leaking.

The lid should sit flat on to the rubber seal.

Ensure the lid is firmly secured by tightening the 4 x M16 ring bolts.

The M16 ring bolts should be secured using an appropriate tool such as a spanner or pipe grips, do not use automatic tools or impact drivers. The lid must be closed so that the clamp is very tight, providing a watertight seal.



16. Replacing the resin

Before initial use and after the resin has been exhausted (indicated via the outlet computer) the resin will require changing.

After replacing the resin, it is always advisable to flush through the resin with raw water. It is not advisable to transfer resin from site to site when using an ioniX mobile filling station. If the resin is transferred, please thoroughly flush this through before using.

The filling station should be flushed through with a quantity of water corresponding to twice the filter volume before use.

1. Isolate the power supply if using combo meter ES099V.
2. Ensure the filling station is isolated from the system by closing the inlet and outlet isolation valves supplied.
3. On existing installations and/or after inline treatment the existing resin will need removing (not the case for first time fills).
4. Connect a suitable 3/4" full bore hose to the base drain of the ioniX filling station.
5. The system is subject to high pressures and the drain hose must be made secure when draining the filling station.
6. The drain hose should be positioned into the supplied woven bag.
7. The bag should be positioned on top of a drain or within a bucket large enough to take the water volume of the filling station.
8. Open the drain valve to release the pressure from the filling station.
9. Resin should start to flow into the woven bag with the water being expelled into the drain/bucket.
10. Open the inlet isolation valve to the ioniX filling station slowly. This aids in rinsing the vessel of any resin stuck within the vessel.
11. Continue the process until the water runs clear and no resin is seen entering the woven bag.
12. Once all water has been drained from the ioniX filling station, carefully open the top of the filling station, using the quick release lid system.
13. Looking inside the filling station, ensure all the resin has been removed.
14. On confirmation that all resin has been removed from the base, the drain can now be closed.
15. Open the vacuum-packed ion exchange resin Xi+ and carefully pour into the ioniX filling station.
16. Inspect the rubber gasket before closing the lid, if the rubber is damaged or worn, please replace it before the next use.

17. Once the lid is closed, the filling station can be filled by opening the inlet isolation valve slowly.
18. Slowly open the air vent connection located on the lid of the ioniX filling station, once this has stopped venting, close the air vent.
19. Then fully open the inlet isolation valve and slowly start to open the outlet isolation valve.
20. Check all connections are watertight.
21. Reinstall the power supply to the filling station if required.
22. Take note of the water meter fill rate and log for future diagnostics.

17. Removing the nozzles.

Over the lifetime of the installation, it may be a requirement to remove the nozzles for cleaning or replacing.

In the event the flow rate through the unit is reduced and/or the screen washer has become blocked the nozzle will need to be removed.

If the flow rate through the unit is reduced only, the nozzle can be cleaned.

If the nozzle has become damaged or perished, then it will need to be replaced.

The nozzles can be removed from the ioniX FS by undoing the removable union.

When removing be careful not to drop the sealing washer.

Once removed the nozzle can be cleaned or replaced.

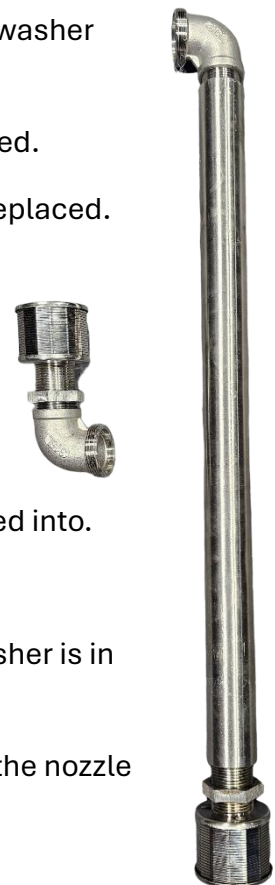
The nozzle can be removed by unscrewing it from the socket it is screwed into.

The nozzles have been secured in place using pipe sealant.

When reinstating the nozzles inside the ioniX FS, ensure the sealing washer is in place.

Start with the outlet down pipe, when securing ensure it is held so that the nozzle faces the centre of the vessel.

Complete the same process with the inlet nozzle.



18. Replacement parts list.

Image	Description	Part number
	Conductivity meter (Battery) Supplied with meter body	
	Conductivity meter (Mains powered) Supplied with meter body	
	Manual air vent	
	3/4" isolation valve With sample point	
	Inlet/outlet isolation valve with union	
	Drain	
	Water meter union	
	Screen washer	
	Sample point	
	Nozzle	
	Lid gasket	

19. Water treatment log.

[illegible]

20. Practice (SEP) Statement.

Pressure Equipment Directive (PED) 2014/68/EU:

Sound Engineering Practice (SEP) Statement:

The pressure vessels supplied by eleXion water treatment Ltd are designed and manufactured for use within sealed heating and water treatment systems containing water (Group 2 fluid) with the following maximum operating conditions:

Maximum allowable pressure (PS): 10 bar
Maximum operating temperature: 95 °C
Maximum vessel volume: 300 litres

The vessels contain non-hazardous water-based fluid classified as a Group 2 liquid under the Pressure Equipment Directive 2014/68/EU.

In accordance with Article 4 and the classification tables of Directive 2014/68/EU, vessels containing Group 2 liquids are only subject to categorised conformity assessment and CE marking requirements where the applicable pressure and volume thresholds are exceeded.

For the equipment supplied:

PS = 10 bar

V = 300 litres

PS × V = 3000 bar – litres

The equipment does not exceed the applicable threshold limits for categorised pressure equipment under PED 2014/68/EU for vessels containing Group 2 liquids.

Accordingly, the vessels fall within the scope of:

Article 4(3) – Sound Engineering Practice (SEP) and therefore:

- are not subject to PED Categories I, II, III, or IV,
- do not require involvement of a Notified Body,
- and are not required to bear the CE marking in respect of PED 2014/68/EU.

The equipment is nevertheless designed and manufactured in accordance with recognised Sound Engineering Practice applicable within the European Union, including appropriate consideration of:

- material suitability
- pressure containment integrity
- weld quality
- hydrostatic pressure testing
- temperature and pressure design limits
- and safe operation within intended service conditions.

Hydrostatic pressure testing is conducted at an appropriate test pressure exceeding the maximum allowable operating pressure.

This statement applies solely to conformity assessment under PED 2014/68/EU and does not remove obligations arising under any other applicable legislation, directives, or national regulations.

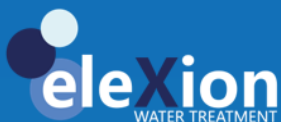
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