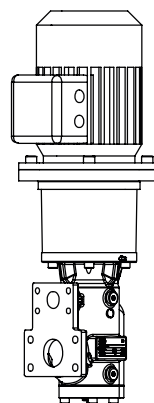
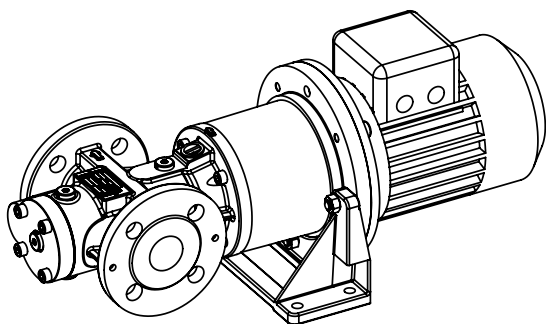
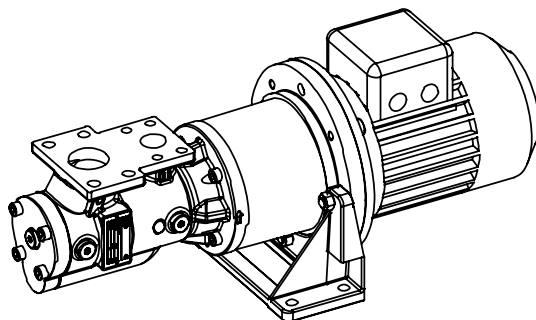
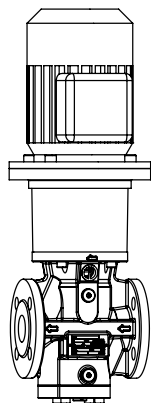




Operating instructions

KRAL



KRAL screw pumps.

Series R

Magnetic coupling



Observe safety instructions for persons with cardiac pacemakers, metallic implants or neurostimulators.

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Original instructions

www.kral.at

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1 About this document

1.1 General information

These instructions form part of the product and must be kept for future reference. Furthermore please observe the associated documents.

1.2 Associated documents

- ☐ Declaration of conformity according to EU Directive 2006/42/EC
- ☐ Manufacturer's declaration according to EU Directive 2014/68/EU
- ☐ Data sheet of the pump
- ☐ Technical documentation of the supplied components

1.3 Target groups

The instructions are intended for the following persons:

- ☐ Persons who work with the product
- ☐ Operator-owners who are responsible for the use of the product

Persons who work with the product must be qualified. The qualification ensures that possible dangers and material damage that are connected to the activity are detected and avoided. These persons are qualified personnel who carry out the work properly due to their training, knowledge and experience and on the basis of the relevant provisions.


Information on the required qualification of the personnel is provided separately at the beginning of the individual chapters in these instructions. The following table provides an overview.

Target group	Activity	Qualification
Transport personnel	Transporting, unloading, setting up	Qualified personnel for transport, mobile crane operators, crane operators, forklift operators
Fitter	Mounting, connection	Qualified personnel for mounting
Electrician	Electrical connection	Qualified personnel for electric installation
Trained personnel	Delegated task	Personnel trained by the operator-owner who know the task delegated to them and the possible dangers arising through improper behaviour.

Tab. 1: Target groups

1.4 Symbols








1.4.1 Danger levels

	Signal word	Danger level	Consequences of non-observance
	DANGER	Immediate threat of danger	Serious personal injury, death
	WARNING	Possible threat of danger	Serious personal injury, invalidity
	CAUTION	Potentially dangerous situation	Slight personal injury
	ATTENTION	Potentially dangerous situation	Material damage





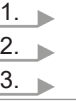


2 Safety

2.1 Proper use

1.4.2 Danger signs

	Meaning	Source and possible consequences of non-observance
	Electrical voltage	Electrical voltage causes serious physical injury or death.
	Magnetic field	Magnetic field can cause serious physical injury or death.
	Raised load	Falling objects can result in serious physical injury or death.
	Heavy load	Heavy loads can result in serious back problems.
	Risk of slipping	Discharging pumped liquid and oils on the foundation or tread surfaces can cause falls with serious physical injury or death.
	Flammable substances	Discharging pumped liquid and oils can be easily inflammable and can result in serious burns.
	Hot surface	Hot surfaces of the pump unit can cause burns.

1.4.3 Symbols in this document

	Meaning
	Warning personal injury
	Safety instruction
	Prohibition sign cardiac pacemaker
	Request for action
	Multi-step instructions for actions
	Action result
	Cross-reference

2 Safety

2.1 Proper use

- ☐ Use the pump solely for transporting lubricating liquids that are chemically neutral and that do not contain gas or solid components.
- ☐ Use the pump only within the operating limits specified on the rating plate and in the chapter "Technical data". In the case of operating data that do not agree with the specifications on the rating plate, please contact the manufacturer.
- ☐ The pump is designed specially for the operating pressure named by the customer. If the actual operating pressure deviates notably from this design pressure, damage to the pump can also arise within the specified operating limits. This applies both to notably higher as well as to notably lower operating pressures. Under no circumstances may the minimum pressure lie below 2 bar. In case of any doubt, please contact the manufacturer.

2.2 Foreseeable misuse

- ☐ Any use that extends beyond the proper use or any other use is misuse.
- ☐ The product is not suitable for pumping liquids outside the operational limits.
- ☐ Any bypassing or deactivation of safety equipment during operation is prohibited.

2.3 Obligations of the operator-owner

The operator-owner is the person who operates the product commercially or permits a third party to use it and who bears the legal responsibility for the product, the protection of the personnel and third parties during its operation.

The product is used in industrial applications. The operator-owner is therefore subject to the statutory obligations concerning occupational health and safety.

In addition to the safety instructions in these instructions, the regulations on safety, accident prevention and environmental protection respectively valid for the range of application of the product are to be observed.

2.4 Safety instructions

2.4.1 Fundamental safety instructions



The following safety instructions must be observed strictly:

- ☐ Read these operating instructions carefully and observe them.
- ☐ Read the operating instructions of the components carefully and observe them.
- ☐ Have work only carried out by qualified personnel/trained personnel.
- ☐ Wear personal protective equipment and work carefully.
- ☐ Pumped liquids can be subject to high pressure and can result in personal injury and damage to property in case of incorrect operation or damaged components.
- ☐ Pumped liquids can be hot, poisonous, combustible and caustic. Use corresponding protective equipment.
- ☐ Observe the associated data sheets and safety regulations when handling dangerous materials.
- ☐ Avoid skin contact with system parts carrying liquids at operating temperatures exceeding 60 °C.
- ☐ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations. Neutralize residues.
- ☐ Keep the mounting surfaces, scaffolding, ladders, lifting platforms and tools clean in order to prevent slipping or stumbling.
- ☐ If pressurized or energized components are damaged, shut down the pump immediately. Replace the components or pump.

2.4.2 Dangers at magnetic coupling systems

Magnetic fields from magnetic coupling systems (MCS) can influence the function and operational safety of electrical and electronic devices. The following safety instructions must be observed.



The following safety instructions must be observed:

- ☐ Keep the MCS away from cardiac pacemakers. There is a danger to life!
 - Under no circumstances may persons with cardiac pacemakers perform installation, dismantling or maintenance work.
- ☐ Persons with cardiac pacemakers must comply with the following safe distances to the MCS:
 - 3 m distance to the openly accessible MCS
 - 1 m distance to pump units with installed MCS
- ☐ Do not bring the MCS in the immediate area of PCs, data carriers and other electronic components.
- ☐ Keep the MCS away from clocks, magnetized tools and measuring equipment as well as all magnetizable parts.
- ☐ Do not bring both the MCS parts together, as this can destroy the magnetic coupling system.

3 Identification

3.1 Type code

3 Identification

3.1 Type code

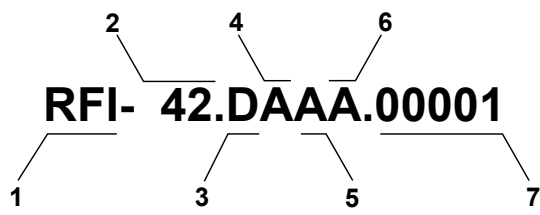


Fig. 1: Type code

Item	Classification	Description
1	Type	RFI <input type="checkbox"/> Pump with mounted inner rotor and containment can <input type="checkbox"/> Pump with inline flanges PN16 <input type="checkbox"/> Pump unit with pump bracket foot
		RVI <input type="checkbox"/> Pump with mounted inner rotor and containment can on pedestal for vertical mounting <input type="checkbox"/> Pump with inline flanges PN16 for vertical mounting <input type="checkbox"/> Pump unit on pedestal for vertical mounting
		RFT <input type="checkbox"/> Pump with mounted inner rotor and containment can <input type="checkbox"/> Pump with overhead flanges PN16 according to marine industry standards <input type="checkbox"/> Pump unit with pump bracket foot
		RVT <input type="checkbox"/> Pump with mounted inner rotor and containment can on pedestal for vertical mounting <input type="checkbox"/> Pump with overhead flanges PN16 according to marine industry standards for vertical mounting <input type="checkbox"/> Pump unit on pedestal for vertical mounting
2	Size	Corresponds to delivery rate in [l/min] at 1450 min ⁻¹
3	Shaft seal	B Mechanical seal of hard material
		D Magnetic coupling
4	Pressure stage overflow valve	A Pressure stage 6 bar ± 10 %
		B Pressure stage 10 bar ± 10 %
5	Variant	A Not assigned
6	Completion	A Pump with mounted inner rotor and containment can
		B Pump with pump bracket
		C Pump with pump bracket and motor
7	Version index	For internal administration

Tab. 2: Type code

3.2 Rating plate

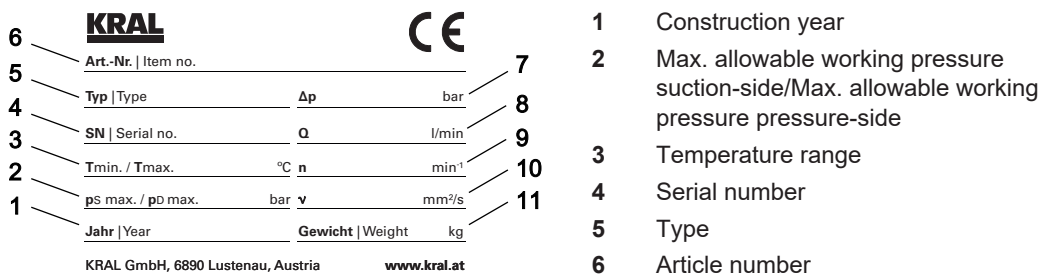


Fig. 2: Rating plate

4 Technical data

4.1 Operating limits

		Size				
Parameter	Unit	15–20	32–42	55–85	105–118	160–210
Max. allowable working pressure						
<input type="checkbox"/> Pump housing	[bar]	16				
Max. temperature of the pumped liquid						
<input type="checkbox"/> Magnetic coupling	[°C]	180				
Ambient temperature min. - max.		[°C]	-10 ... 50			
Min. – max. viscosity		[mm²/s]	1.4–10 000			
Speed max.						
<input type="checkbox"/> At 50 Hz	[min⁻¹]	2900			1450	
<input type="checkbox"/> At 60 Hz	[min⁻¹]	3500			1750	
Inlet pressure						
<input type="checkbox"/> Magnetic coupling	[bar]	16				

Tab. 3: Operating limits

4.2 Short-circuit pressure of the overflow valve

Size	Short-circuit pressure [bar] at speed [min ⁻¹]							
	Overflow valve A				Overflow valve B			
	1450	1750	2900	3500	1450	1750	2900	3500
15–20	6.5	7.0	7.5	8.0	10.5	11.0	12.0	12.5
32–42	6.5	7.0	7.5	8.5	10.5	11.5	12.5	14.0
55–85	7.5	8.0	9.0	10.0	13.0	13.5	14.0	15.0
105–118	7.5	8.0	9.0	10.0	12.0	12.5	13.0	14.0
160–210	8.0	8.5	10.0	11.0	13.0	13.5	15.0	16.0

Tab. 4: Short-circuit pressure of the overflow valve

4.3 Required NPSH values

The required NPSH values of the pump depend on the size, the viscosity of the pumped liquid and the speed.

The NPSH values are available on the website of the manufacturer:

www.kral.at/en/screw-pumps

4.4 Sound pressure level

Guide values at 1 m distance, 1450 min⁻¹, 20 bar, 21 mm²/s

	Size				
	15–20	32–42	55–85	105–118	160–210
Max. sound pressure level ±3 [dB(A)]					
Pump	56.0	59.0	65.0	65.0	71.0
Motor	65.0	66.0	77.0	77.0	79.0
Pump unit	66.0	67.0	78.0	78.0	80.0

Tab. 5: Sound pressure level

4.5 Weights

The weight is specified on the rating plate.

5 Function description

5.1 Pump structure

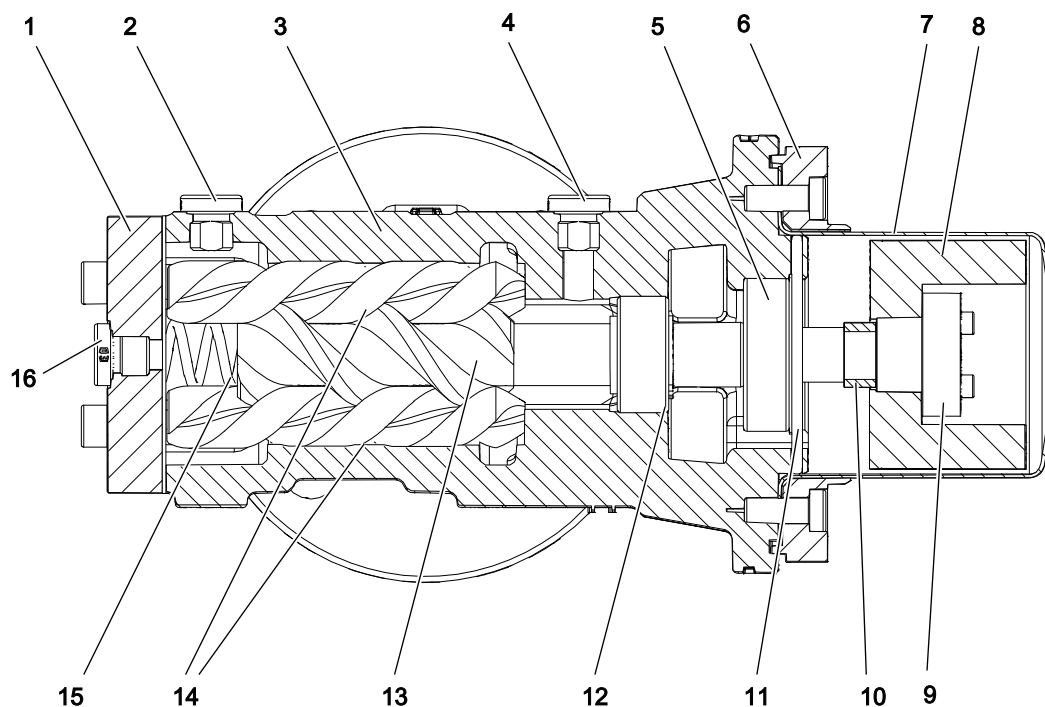


Fig. 3: Pump structure

- | | | | |
|---|-----------------|----|--------------------|
| 1 | End cover | 9 | Tensioning element |
| 2 | Screw plug | 10 | Distance sleeve |
| 3 | Pump housing | 11 | O-ring |
| 4 | Screw plug | 12 | Balancing cylinder |
| 5 | Ball bearing | 13 | Main screw |
| 6 | Center flange | 14 | Idle screw |
| 7 | Containment can | 15 | Overflow valve |
| 8 | Inner rotor | 16 | Screw plug |

5.2 Pump unit structure

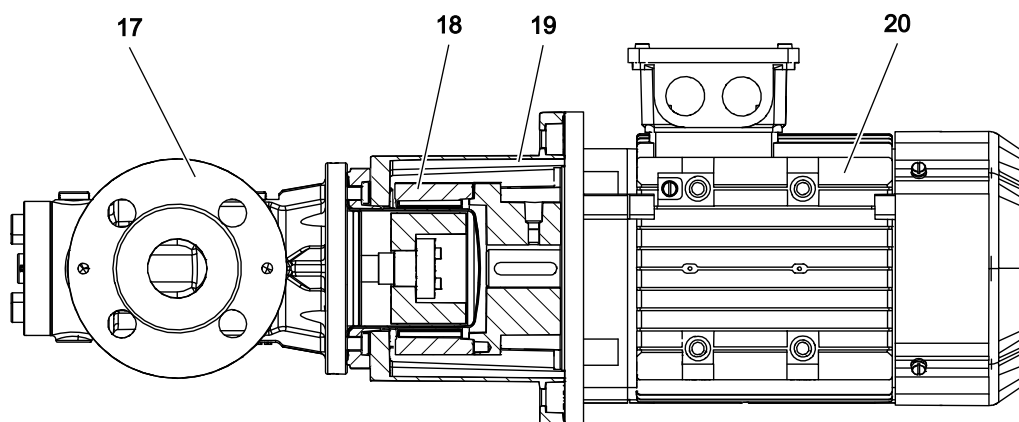


Fig. 4: Pump unit structure

- | | | | |
|----|-------------|----|--------------|
| 17 | Pump | 19 | Pump bracket |
| 18 | Outer rotor | 20 | Motor |

5.3 Functional principle

Screw pumps are rotating displacement pumps. Their displacement effect results from three rotating screws **13** and **14** and the enclosing pump housing **3**.

Radial support of the screw set is provided through the sliding contact in the pump housing that depends on lubrication by the pumped liquid. Screw pumps are therefore not suitable for dry running and can only be used up to specific pressure limits and viscosity limits. Due to the narrow tolerances, suspended solids cannot be pumped.

Axial support of the main screw is provided by a deep-groove ball bearing **5**. In order to reduce the pressure, a balancing cylinder **12** is mounted at the main screw. An integrated overflow valve **15** protects against excessive pressure that could cause housing parts to burst.

The default direction of the rotation of the screw set is clockwise viewed from the motor and is marked on the pump flange by an arrow.

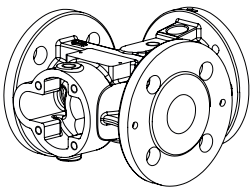
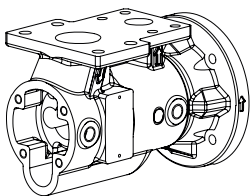
The flow direction is marked on the pump housing by two arrows.

5.4 Magnetic coupling

The shaft end of the pump is enclosed by a containment can **7** which is hermetically sealed to the motor-side flange of the pump via a center flange **6**. Therefore, it is not necessary to seal a rotating free shaft end against a stationary seal housing. Special rotors equipped with powerful permanent magnets are used to transfer the torque from the motor to the pump. The inner rotor **8** is fixed at the shaft end and driven by the outer rotor **18**, which in turn is fixed to the shaft of the motor. The torque is thus transferred contact-free by means of the magnetic field between the outer rotor and inner rotor.

The containment can is made of amagnetic Hastelloy which does not impede the forming of magnetic flux lines between the rotors. The pressure discharge of the containment can is provided via a core drilled hole in the main screw. Therefore, it can be assumed that the pressure in the containment can approximately corresponds to the pressure on the suction side of the pump.

5.5 Housing variants

Housing	Type	Description
	RFI/RVI	Flange arrangement: Inline flange PN16
	RFT/RVT	Flange arrangement: Overhead flange PN16 according to marine industry standards

Tab. 6: Housing variants

5.6 Overflow valve

The integrated overflow valve ensures that very high pressures that could result in housing parts bursting do not arise.

The overflow valve is purely there as a safety element for the pump and should not be used for control or regulation purposes such as maintaining pressure. Circulation through the overflow valve for too long furthermore heats the pump to excess. This reduces viscosity and can ultimately lead to pump failure.

It therefore has to be ensured through a safety valve at the system that the maximum allowable working pressure always lies under the opening pressure of the overflow valve.

6 Transportation, storage

6.1 Dangers during transportation

Two variants of the overflow valve are available. The valve spring is pretensioned to the respective opening pressure:

Parameter	Unit	Overflow valve A	Overflow valve B
Pretension Δp	[bar]	$6 \pm 10 \%$	$10 \pm 10 \%$

Tab. 7: Pretension valve spring

Short-circuit pressure of the overflow valve ↪ Technical data, Page 7.

- Note**
- ☐ A function test of the overflow valve at least every 5 years is essential for the safe operation ↪ During operation, Page 24.
 - ☐ Scope and if necessary shorter test intervals must be specified by the operator-owner in accordance with the requirements and national provisions (for example Austrian Ordinance of Safety and Health (BetrSichV)).
 - ☐ The first function test must take place directly after the commissioning.
 - ☐ After longer downtimes (> 4 weeks) the function of the overflow valve must be tested again.

6 Transportation, storage

6.1 Dangers during transportation



The following safety instructions must be observed:

- ☐ Have all work only carried out by authorized transport personnel.
- ☐ Use intact and correctly dimensioned hoisting equipment.
- ☐ Ensure that the means of transport is in a flawless state.
- ☐ Ensure that the centre of gravity of the load is taken into consideration.
- ☐ Do not stand under raised loads.

6.2 Dangers during storage



The following safety instructions must be observed:

- ☐ Observe the storage conditions.

6.3 Unpacking and checking the state of delivery

Personnel qualification:	<input type="checkbox"/> Trained personnel
--------------------------	--



! DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

1. ► Upon delivery check the pump/pump unit for damage during transportation.
2. ► Report damage during transportation immediately to the manufacturer.
3. ► Dispose of packaging material in accordance with the locally applicable regulations.

6.4 Transporting the pump/pump unit

Personnel qualification:	<input type="checkbox"/> Transport personnel
Personal protective equipment:	<input type="checkbox"/> Protective helmet <input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Mobile crane, forklift, hoisting equipment



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



⚠ WARNING

Risk of injury and damage to equipment through falling and toppling parts.

- ▶ Use intact and correctly dimensioned hoisting equipment in accordance with the total weight to be transported.
- ▶ Select the lift points for the hoisting equipment in accordance with the centre of gravity and the weight distribution.
- ▶ Use at least two load ropes.
- ▶ In the case of vertical transportation secure the motor against tipping.
- ▶ Do not stand under raised loads.

ATTENTION

Damage to equipment through improper transportation.

- ▶ Protect the pump against damage, heat, sunlight, dust and moisture.

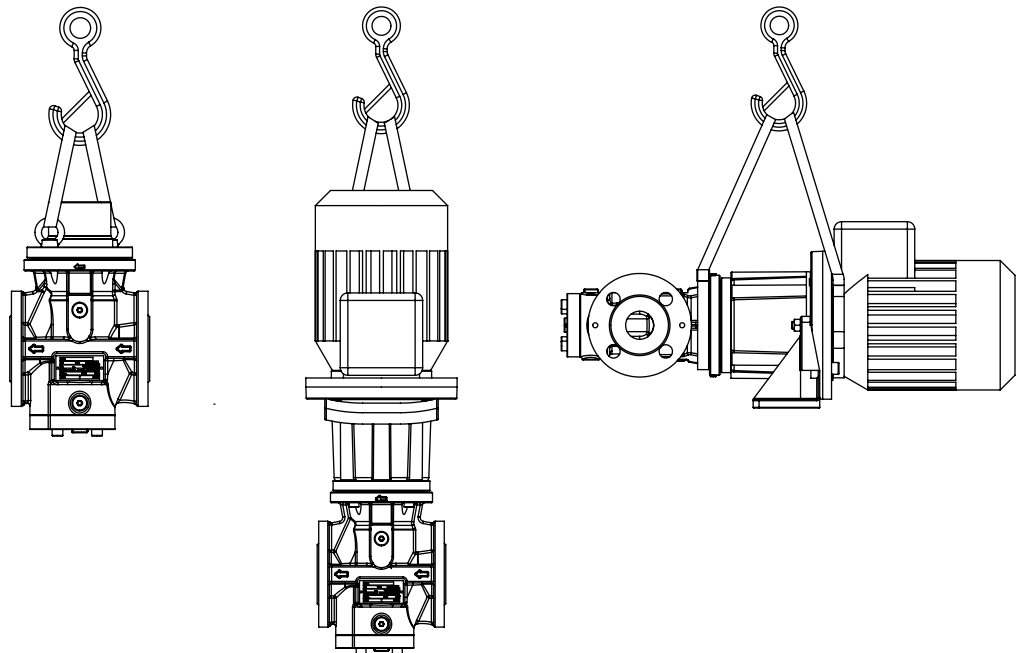


Fig. 5: Fastening of hoisting equipment - principle diagrams

1. ▶ Attach the hoisting equipment to the pump/pump unit and tighten. Ensure that the centre of gravity lies exactly under the crane hook.
2. ▶ Lift the pump/pump unit carefully and put it down shock-free.
3. ▶ Before loosening the transport belts ensure that the pump/pump unit is secured against tilting.

7 Preservation

6.5 Storing the pump

6.5 Storing the pump

During the test run, the internal components of the pump are wetted with test oil, which has a preservative effect. Pressure connection and suction connection are closed with protective caps. Unless otherwise specified, the outer surfaces of the pump are preserved with a single-coat PU-based two-component paint.

The preservative applied at the factory will protect the pump for about six weeks, if it is stored in a dry and clean location.

The manufacturer offers a long-term preservation for storage times of up to 60 months. The pump is additionally packed in hermetically sealing anti-corrosion paper.

Personnel qualification:	<input type="checkbox"/> Transport personnel
Aids:	<input type="checkbox"/> Mobile crane, forklift, hoisting equipment



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

ATTENTION

Damage to equipment and corrosion if stored improperly and during longer standstills.

- Protect the pump against damage, heat, sunlight, dust and moisture.
- Protect against corrosion during longer standstill.
- Observe measures for storing and preservation.

1. ► Store cool and dry and protect against sunlight.
2. ► Ensure that the anti-corrosion paper is not damaged.
3. ► Observe the intervals for preservation → Preservation, Page 12.

7 Preservation

7.1 Preservation table

Preservation has to be carried out additionally under the following conditions:

Type of delivery	Condition
Standard delivery	<input type="checkbox"/> Storage time exceeding six weeks <input type="checkbox"/> Unfavourable storage conditions such as high humidity, salty air, etc.
Delivery with long-term preservation	<input type="checkbox"/> Opened or damaged packaging

Tab. 8: Conditions for additional preservation

7.2 Preserving the inner surfaces

Personnel qualification:	<input type="checkbox"/> Trained personnel
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Preservative (acid-free and resin-free oil)



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

1. ► Open the packaging carefully. If the pump is protected additionally by anti-corrosion paper, ensure that it is not damaged.
2. ► Close the suction connection of the pump with a blind flange.
3. ► Pour the preservative into the pressure connection until it reaches approx. 2 cm under the rim, while slowly turning the main screw against the direction of rotation.
4. ► Close the pressure connection of the pump with a new blind flange.
5. ► Close the packaging carefully.
6. ► After about six months storage check the filling level of the preservative and if necessary top up.

7.3 Preserving the outer surfaces

Personnel qualification:	<input type="checkbox"/> Trained personnel
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Face protection <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Calcium complex grease (for example TEVI-ER® GREASE WAVE 100 with adhesive additive) <input type="checkbox"/> Castrol Rustilo DWX 33 or other preservative offering comparable protection



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

1. ► Brush calcium complex grease corrosion protection (for example TEVIER® FETT WAVE 100 with adhesive additive) to the mounting surfaces.
2. ► Brush or spray preservative (for example Castrol Rustilo DWX 33) onto the process connections and remaining plain and unpainted parts.
3. ► At intervals of about six months check the preservation and if necessary repeat.

7.4 Removing the preservation

Personnel qualification:	<input type="checkbox"/> Trained personnel
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Face protection <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Solvent <input type="checkbox"/> Collection tank <input type="checkbox"/> Steam-jet cleaning device with wax-dissolving additives

8 Installation, removal

8.1 Dangers during installation



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



CAUTION

Risk of injury through discharging preservative.

- Wear personal protective equipment during all the work.
- Collect any discharging preservative safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.

1. ► Clean the outside of the pump with solvents, if necessary using a steam-jet cleaning device.
2. ► Remove the pressure-side blind flange carefully in order to reduce any pressure that may exist in the pump.
3. ► Drain the pump, collecting the preservative in a suitable vessel.
4. ► Remove the blind flange on the suction side.
5. ► To remove the residual preservative, flush the pump with the pumped liquid.

8 Installation, removal

8.1 Dangers during installation



The following safety instructions must be observed strictly:

- ☐ Have all work carried out only by authorized qualified personnel.
- ☐ Before installation ensure that the operating limits, NPSH values and ambient conditions are observed.
- ☐ Observe the tightening torques ↗ Appendix, Page 44.
- ☐ Ensure that all the components can be accessed and that maintenance work can be carried out easily.

8.2 Dangers during removing



The following safety instructions must be observed strictly:

- ☐ Have all work carried out only by authorized qualified personnel.
- ☐ Before beginning work, let the pump unit cool down to the ambient temperature.
- ☐ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.
- ☐ Ensure that the collection tank for discharging pumped liquid is sufficiently large.

8.3 Installing the pump

The pumps can be operated in horizontal and vertical installation position.

Note Soiling in the pipe system impair the service life of the pump. If the pipe system is flushed using the pump during the initial commissioning, an additional commissioning filter has to be installed temporarily before the pump at the system (mesh width: 0.02 mm).

Personnel qualification:	<input type="checkbox"/> Transport personnel <input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective helmet <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Mobile crane, forklift, hoisting equipment



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



⚠ WARNING

Risk of injury and damage to equipment through falling and toppling parts.

- ▶ Only fasten the pump on a stable load-bearing underground or stable load-bearing load support.
- ▶ Ensure that fastening elements and pipings are fastened sufficiently.

ATTENTION

Damage to motor through discharging pumped liquid.

- ▶ Do not install the pump above the motor.

ATTENTION

Damage to device through impurity in the pipe system.

- ▶ During welding work attach protective covers in front of the connecting flanges.
- ▶ Ensure when welding that welding beads and abrasive dust cannot get into the pipe system and the pump.
- ▶ Ensure that a commissioning filter is installed when the pipe system is flushed and cleaned using the pump.

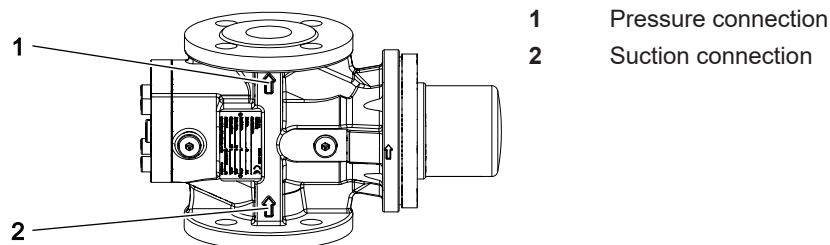


Fig. 6: Flow direction

Requirement:

- ✓ Pump protection: Integrated overflow valve or system-side overflow valve/safety valve installed.
 - ✓ Pump connections protected against soiling, for example by using the protective cover mounted in the factory
 - ✓ If required, hoisting equipment prepared
1. ▶ Bring the pump in the installation position, while observing the position of the motor and the arrows for the flow direction on the pump housing (1 pressure connection, 2 suction connection).
 2. ▶ Fasten the pump with fastening elements securely on the underground.

8.4 Removing the pump

Personnel qualification:	<input type="checkbox"/> Transport personnel <input type="checkbox"/> Fitter <input type="checkbox"/> Electrician
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective helmet <input type="checkbox"/> Face protection <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Mobile crane, forklift, hoisting equipment <input type="checkbox"/> Collection tank



DANGER

Risk of death resulting from electric shock.

- ▶ Ensure that the electrical power supply is de-energized and is secured against being switched back on.
- ▶ Observe the operating instructions of the electrical components.



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



DANGER

Risk of death through emitted pumped liquid.

Pumped liquids can be hot, poisonous, combustible and caustic and can spray out under high pressure.

- ▶ Wear personal protective clothing during all the work. Ensure face protection.
- ▶ Before beginning work, let the pump unit cool down to the ambient temperature.
- ▶ Ensure that the pump is depressurized.
- ▶ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.

Requirement:

- ✓ Pump unit cooled down to the ambient temperature
 - ✓ Pump unit disconnected from the electrical power supply, deenergized and secured against being switched back on
1. ➤ Close the pressure-side and suction-side shut-off devices.
 2. ➤ Empty the pump at the lowest point. Collect the discharging pumped liquid in a collection tank.
 3. ➤ Dismantle the pressure-side and suction-side connecting flanges.
 4. ➤ Disconnect the pump unit from the pipe system and empty it. Collect any discharging pumped liquid.
 5. ➤ Screw out the fastening elements used to fasten the pump.
 6. ➤ Dismantle the pump unit on site or transport it to a suitable location ➤ Transportation, storage, Page 10.

9 Connection

9.1 Dangers during connection work



The following safety instructions must be observed strictly:

- ☐ Have all work on the pump and pipe system only carried out by authorized qualified personnel.
- ☐ Ensure that impurities cannot get into the pump and pipe system.
- ☐ Ensure that mechanical connections are mounted stress-free.
- ☐ Observe the tightening torques ↗ Appendix, Page 44.
- ☐ Have all the work on the electrical equipment only carried out by electricians.
- ☐ Before beginning work on the pump ensure that the electrical power supply is deenergized and is secured against being switched back on.
- ☐ If the insulation of the electrical cables or wires is damaged, disconnect the power supply immediately.

9.2 Connecting the pump to the pipe system

Personnel qualification:	<input type="checkbox"/> Transport personnel <input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Protective helmet <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Mobile crane, forklift, hoisting equipment



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

ATTENTION

Damage to device through impurity in the pipe system.

- ▶ During welding work attach protective covers in front of the connecting flanges.
- ▶ Ensure when welding that welding beads and abrasive dust cannot get into the pipe system and the pump.
- ▶ Ensure that a commissioning filter is installed when the pipe system is flushed and cleaned using the pump.

ATTENTION

Damage to device through mechanical stress.

- ▶ Ensure that the pump is mounted free of mechanical stresses in the pipe system.
- ▶ Observe the tightening torques.

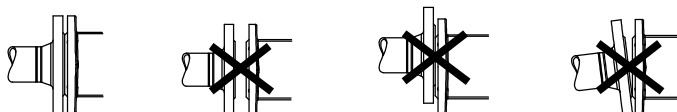


Fig. 7: Connection to pipe system

1. ➡ Turn the pump shaft or the fan impeller of the motor. This tests that the pump runs smoothly. If the pump shaft cannot be turned by hand, remedy the fault before installing the pump ↗ Troubleshooting, Page 40.

9 Connection

9.3 Insulating the pump

2. ➤ Before carrying out welding work mount a protective cover on the suction connection and pressure connection.
3. ➤ Place the piping in position and support the weight of the piping.
4. ➤ Check the linear, height and angular offset and correct if necessary.
⇒ If the screws tighten easily, this is a sure sign that the installation is stress-free.
5. ➤ Tighten the connecting screws crosswise with torque, Table of tightening torques ➤ Appendix, Page 44.

9.3 Insulating the pump

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Insulation material



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump station.



WARNING

Hot surface.

Touching of uninsulated hot surfaces results in burns.

- ▶ Insulate components and pipings in which hot liquids (> 60 °C) flow before commissioning.

➤ Before commissioning, carefully insulate all potentially hot surfaces of the pump and the connected piping or provide suitable protection against accidental contact.

9.4 Connecting the pump unit to the power supply

Personnel qualification:	<input type="checkbox"/> Electrician
Aids:	<input type="checkbox"/> Operating instructions of the motor <input type="checkbox"/> Motor circuit diagram



DANGER

Risk of death resulting from electric shock.

- ▶ Ensure that the electrical power supply is de-energized and is secured against being switched back on.
- ▶ Before commissioning ensure correct grounding and equipotential bonding.
- ▶ Observe the operating instructions of the electrical components.



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

1. ➤ Ensure that the operating data on the rating plate of the motor agree with the operating data of the pump and with the local power supply.
2. ➤ Carefully earth the pump bracket foot, base frame or pedestal via the screwing.
3. ➤ Connect the motor in accordance with the operating instructions and circuit diagram in the motor terminal block.
4. ➤ When connecting the pump unit to the complete system continue equipotential bonding.

10 Operation

10.1 Dangers during operation



The following safety instructions must be observed strictly:

- ☐ Have all work carried out only by authorized qualified personnel.
- ☐ Before commissioning ensure that a safety valve has been installed in the pipe system on the pressure side before the first shut-off device.
- ☐ Before commissioning, make sure that the suction line and pump are filled.
- ☐ Pumped liquids can be hot, poisonous, combustible and caustic. Use corresponding protective equipment.
- ☐ Ensure that the pump station is only operated within the operating limits.
- ☐ Wear hearing protection if you work for a longer time directly at the pump.
- ☐ Ensure that the maximum permissible system pressure is not exceeded.
- ☐ Ensure that during cooling down or heating up the pump is only subjected to slow temperature changes.
- ☐ Ensure that existing safety equipment is not bypassed or activated during operation.
- ☐ Before decommissioning ensure that the electrical power supply is deenergized and is secured against being switched back on.

10.2 Commissioning

10.2.1 Cleaning the pipe system

Note Soiling in the pipe system impair the service life of the pump. If the pipe system is flushed using the pump during the initial commissioning, an additional commissioning filter has to be installed temporarily before the pump at the system.

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump station.

ATTENTION

Damage to equipment through additional pressure loss in the commissioning filter/commissioning strainer.

- ▶ Calculate the flow resistance and determine the remaining pump intake.
- ▶ Monitor the suction-side pressure.
- ▶ Check the commissioning filter/commissioning strainer regularly.

Requirement:

- ✓ If required, commissioning filter installed (mesh width 0.02 mm)

1. ➤ Clean the complete pipe system before commissioning in order to protect the pump.
2. ➤ Flush the pipe system at least 50 – 100 hours.

10.2.2 Filling and venting the pump

Possibilities

There are two possible ways to fill the pump:

- ☐ Via the suction connection or pressure connection
- ☐ Via the vent holes

Filling and venting the pump via the suction connection or pressure connection

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Protective helmet <input type="checkbox"/> Safety boots <input type="checkbox"/> Face protection



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

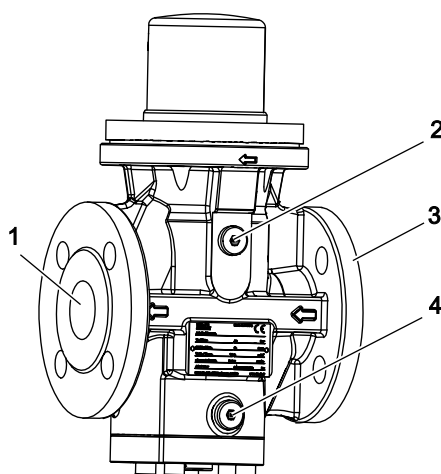


⚠ DANGER

Risk of death through discharging pumped liquid.

Pumped liquids can be hot, poisonous, combustible and caustic and can spray out under high pressure.

- ▶ Wear personal protective equipment during all the work. Ensure face protection.
- ▶ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.



- 1 Pressure connection
- 2 Pressure-side vent hole
- 3 Suction connection
- 4 Suction-side vent hole

1. ➡ Open the screw plug of the vent hole **2** or **4** by a max. of two rotations so that air can escape during the filling process.
2. ➡ Open the suction-side or pressure-side shut-off device and fill the pump via the suction connection **3** or pressure connection **1** until pumped liquid is emitted at the vent hole **2** or **4**.
3. ➡ During the filling process turn the fan impeller of the motor by hand to speed up the filling process:
 Filling via suction connection: Turn the fan impeller in the direction of the arrow of the pump flange.
 Filling via the pressure connection: Turn the fan impeller against the direction of the arrow on the pump flange.
4. ➡ Retighten the screw plug of the vent hole **2** or **4**.

Filling and venting the pump via the vent hole

Note Filling the pump via the vent hole only makes sense in the horizontal mounting position.

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Protective helmet <input type="checkbox"/> Safety boots <input type="checkbox"/> Face protection



! DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

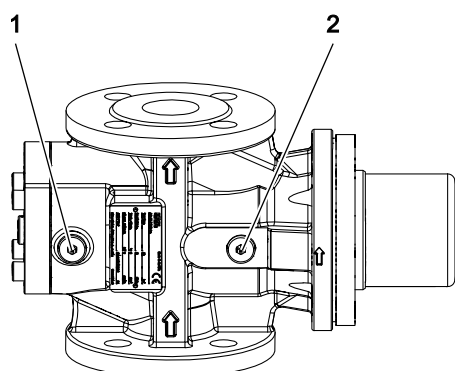


! WARNING

Risk of injury through emitted pumped liquid.

Pumped liquids can be hot, poisonous, combustible and caustic.

- Wear personal protective clothing during all the work. Ensure face protection.
- Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.



- 1 Suction-side vent hole
- 2 Pressure-side vent hole

Requirement:

- ✓ Shut-off devices in the suction line and pressure line closed

1. ► Remove the screw plug of the vent hole **1** and **2** so that the air can escape during the filling process.
2. ► Fill the pump via one of the vent holes until pumped liquid is emitted at the second vent hole.
3. ► During the filling process turn the fan impeller of the motor by hand to speed up the filling process:
 Filling via the suction-side vent hole: Turn the fan impeller in the direction of the arrow on the pump flange.
 Filling via the pressure-side vent hole: Turn the fan impeller against the direction of the arrow on the pump flange.
4. ► Retighten the screw plugs of the vent hole **1** and **2**.

10.2.3 Checking the direction of rotation

The direction of rotation is indicated by an arrow on the pump flange/pump housing. The direction of rotation of the motor specifies the direction of rotation of the pump. The fan impeller of the motor must rotate in the same direction in which the arrow for the direction of rotation on the pump flange points.

Note Standard direction of rotation: clockwise (viewed from the motor)

Personnel qualification:	<input type="checkbox"/> Fitter
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DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

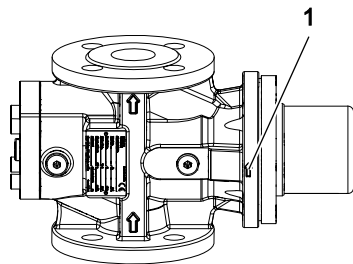
- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

ATTENTION

Dry running can damage pump equipment.

- ▶ Ensure that the pump is filled properly.
- ▶ Switch the pump on for a maximum of one second and then off again immediately.

1. ▶ Switch on the power supply and then turn it off again immediately.



2. ▶ Compare the direction of rotation of the fan impeller with the arrow for the direction of rotation 1.
3. ▶ If the directions do not match, swap the two electrical connection phases. Repeat Steps 1 and 2.

10.2.4 Commissioning the pump

Personnel qualification:	<input type="checkbox"/> Fitter <input type="checkbox"/> Electrician
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Face protection <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Collection tank



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



DANGER

Risk of death resulting from bursting components and discharging pumped liquid.

As a result of impermissibly high pressure, components can burst with high energy, for example through the pressure-side pipe system being shut off.

- ▶ Wear personal protective equipment during all the work.
- ▶ System protection: Before carrying out commissioning ensure that a safety valve is installed in the pressure-side pipe system at the system end.
- ▶ Pump protection: Ensure before commissioning that an integrated overflow valve or system-side overflow valve/safety valve is installed.



WARNING

Risk of injury through emitted pumped liquid.

Pumped liquids can be hot, poisonous, combustible and caustic.

- ▶ Wear personal protective clothing during all the work. Ensure face protection.
- ▶ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.



WARNING

Hot surface.

Touching of uninsulated hot surfaces results in burns.

- ▶ Insulate components and pipings in which hot liquids (> 60 °C) flow before commissioning.



WARNING

Risk of injury through emitted pumped liquid.

Bursting of the containment can due to damage by iron particles in the medium.

- ▶ Install filter/strainer with magnetic separator on suction side.



ATTENTION

Dry running can damage pump equipment.

- ▶ Ensure that the pump and the connected pipe system are filled properly.
- ▶ If the pump does not deliver after 10 – 15 seconds, abort commissioning.

Requirement:

- ✓ Pump unit set up correctly
- ✓ Connections connected sealingly
- ✓ Motor connected correctly
- ✓ Pipe system is free of impurities
- ✓ System protection: Safety valve in accordance with EN ISO 4126-1 installed in the pressure-side pipe system before the first shut-off device
- ✓ Pump protection: Integrated overflow valve or system-side overflow valve/safety valve installed.
- ✓ Filter/strainer with magnetic separator installed on suction side
- ✓ Pump filled with pumped liquid
- ✓ Shut-off devices in the suction line and pressure line opened

1.  Switch on the pump unit.
⇒ The pump delivers when the pressure on the pressure side of the pump rises or a flow indicator at the system side triggers.
2.  If the pump does not deliver after 10 – 15 seconds of operation, abort commissioning. Eliminate the cause of the fault and only then continue with commissioning. Take the information from the troubleshooting table into account ➔ Troubleshooting, Page 40.

3. ➤ Run the pump for a few minutes to allow the pipe system to vent fully.
⇒ The pipe system is fully vented when the pump operating noise is smooth and a pressure gauge on the pressure side shows no more fluctuations.
4. ➤ Checking overflow valve functions ➤ During operation, Page 24.

10.3 During operation

10.3.1 Checking the operating pressure

Personnel qualification: ☐ Trained personnel

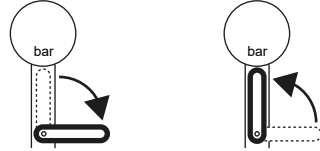


Fig. 8: Pressure gauge shut-off valves closed/open - principle diagram



! DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump station.

ATTENTION

Leak in the pressure gauge through permanently opened pressure gauge shut-off valve.

- Close the pressure gauge shut-off valve immediately after completing reading.

1. ➤ Open the pressure gauge shut-off valve.
2. ➤ Read the operating pressure and close the pressure gauge shut-off valve.

10.3.2 Monitoring the filter and/or strainer

Note The manufacturer recommends protecting the pump against soiling by means of a filter and/or strainer installed at the system end (mesh width 0.5 mm). The degree of soiling of the filter and/or the strainer can be monitored by means of a suction-side pressure gauge or a differential pressure indicator.

Personnel qualification: ☐ Trained personnel



! DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump station.



! WARNING

Risk of injury through emitted pumped liquid.

Bursting of the containment can due to damage by iron particles in the medium.

- Install filter/strainer with magnetic separator on suction side.

1. ➤ After commissioning monitor the degree of soiling of the filter and/or strainer by means of a suction-side pressure gauge or a differential pressure indication.
2. ➤ Also check the filters/strainers in the event of a pressure drop on the suction side. Observe the dimensioning data of the manufacturer of the filters and/or strainers.

3. ➤ Check the suction-side pressure every two weeks during operation.
4. ➤ Regularly check the magnetic separator in the filter/strainer during operation and clean it if necessary.

10.3.3 Switching off the pump unit

Personnel qualification:	<input type="checkbox"/> Trained personnel
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ATTENTION

Seal damage through pressurizing during standstill.

- ▶ Ensure that the maximum permissible system pressure is not exceeded.

1. ➤ Switch off the motor.
2. ➤ Close the pressure-side shut-off device.

10.4 Decommissioning

10.4.1 Decommissioning the pump

Decommissioning is an operation interruption that requires different measures depending on the scope and duration of the interruption as well as the properties of the pumped liquid.

Personnel qualification:	<input type="checkbox"/> Fitter <input type="checkbox"/> Electrician
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Collection tank



DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



WARNING

Risk of injury through emitted pumped liquid.

Pumped liquids can be hot, poisonous, combustible and caustic.

- ▶ Wear personal protective clothing during all the work. Ensure face protection.
- ▶ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.

ATTENTION

Damage to equipment through excessively fast temperature change.

- ▶ Subject the pump only to slow temperature changes.
- ▶ Under no circumstances heat the pump with an open flame.

➤ Carry out the following measures during operation interruptions:

Scope of the operation interruption	Measure
<input type="checkbox"/> Shutting down the pump for a longer period	➤ Depending on the pumped liquid

11 Maintenance

10.5 Recommissioning

Scope of the operation interruption	Measure
<input type="checkbox"/> Draining the pump	—> Close the pressure-side and suction-side shut-off devices.
<input type="checkbox"/> Dismantling the pump	—> Disconnect the motors from the power supply and secure against being switched back on.
<input type="checkbox"/> Storing the pump	—> Observe measures for storing and preservation ↗ Transportation, storage, Page 10.

Tab. 9: Measures during operation interruptions

Behaviour of the pumped liquid	Duration of the operation interruption	
	Short	Long
<input type="checkbox"/> Solids sediment	—> Rinse the pump.	—> Rinse the pump.
<input type="checkbox"/> Congealed/frozen <input type="checkbox"/> No corrosive burden	—> Heat or drain the pump.	—> Drain the pump.
<input type="checkbox"/> Congealed/frozen <input type="checkbox"/> Corrosive burden	—> Heat or drain the pump.	1. —> Drain the pump. 2. —> Preserve the pump.
<input type="checkbox"/> Remains liquid <input type="checkbox"/> No corrosive burden	—	—
<input type="checkbox"/> Remains liquid <input type="checkbox"/> Corrosive burden	—	1. —> Drain the pump. 2. —> Preserve the pump.

Tab. 10: Measures depending on the behaviour of the pumped liquid

—> Drain the pump via the pressure line, suction line, vent screws and screw plugs.

10.5 Recommissioning

10.5.1 Recommissioning the pump

—> Depending on the extent and duration of the interruption of operation, carry out steps as for commissioning ↗ Commissioning, Page 19.

11 Maintenance

11.1 Dangers during maintenance



The following safety instructions must be observed strictly:

- ☐ Have all work carried out only by authorized qualified personnel.
- ☐ Before beginning work, let the pump unit cool down slowly to the ambient temperature. Avoid rapid temperature changes.
- ☐ Pumped liquids can be hot, poisonous, combustible and caustic. Use corresponding protective equipment.
- ☐ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.
- ☐ Ensure that the collection tank for discharging pumped liquid is sufficiently large.
- ☐ Observe the operating instructions and data sheets of the components.

11.2 Required maintenance

The service life depends on the observance of the operating conditions of the pump and the requirements from the operating instructions of the components.

Component	Required maintenance	Cycle
Pump	<input type="checkbox"/> Visual inspection <input type="checkbox"/> Acoustic inspection	4 weeks
Filter/strainer with magnetic separator	<input type="checkbox"/> Cleaning the magnetic separator	Depending on the pumped liquid

Component	Required maintenance	Cycle
Filter/strainer (system side)	<input type="checkbox"/> Check of the suction-side pressure	2 weeks
Magnetic coupling	<input type="checkbox"/> Checking the tightening torques <input type="checkbox"/> Checking the inside of the containment can for wear/scoring <input type="checkbox"/> Check for accumulated iron particles on the inner rotor <input type="checkbox"/> Check for accumulated iron particles on the outer rotor	1 year
Overflow valve	<input type="checkbox"/> Function test	≤ 5 years

Tab. 11: Required maintenance

11.3 Ball bearing

When using the pump in lubrication oil applications with a minimum purity class of 21/18/13 according to ISO 4406, a bearings replacement at the latest after 5 years (40000 h) is sufficient.

11.4 Maintaining the pump

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots <input type="checkbox"/> Face protection



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



⚠ WARNING

Risk of injury through emitted pumped liquid.

Pumped liquids can be hot, poisonous, combustible and caustic.

- ▶ Wear personal protective clothing during all the work. Ensure face protection.
- ▶ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.

- ▶ Check the pump visually and acoustically every four weeks.
- ▶ If there are signs of wear, eliminate the cause ➔ Servicing, Page 31.

11.5 Maintaining the magnetic coupling

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots <input type="checkbox"/> Face protection



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



⚠ WARNING

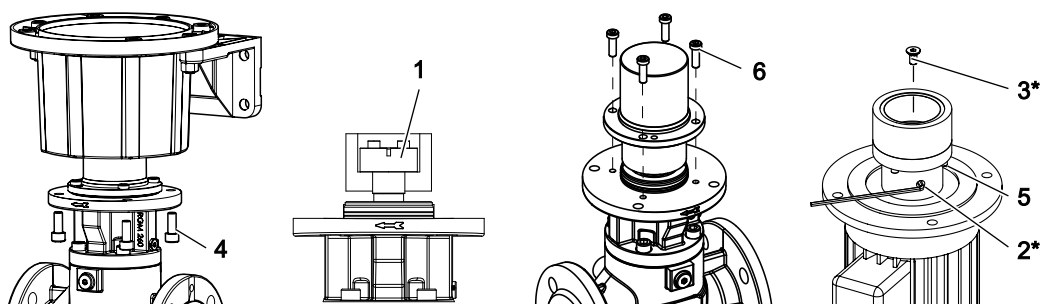
Hot surface.

Components of the magnetic coupling heat up more than the pump during operation. Touching the magnetic coupling will result in burns.

- ▶ Before working on the magnetic coupling, allow the pump including the magnetic coupling to cool down to ambient temperature.
- ▶ Wear personal protective equipment at all times during operation. Be sure to wear protective gloves.

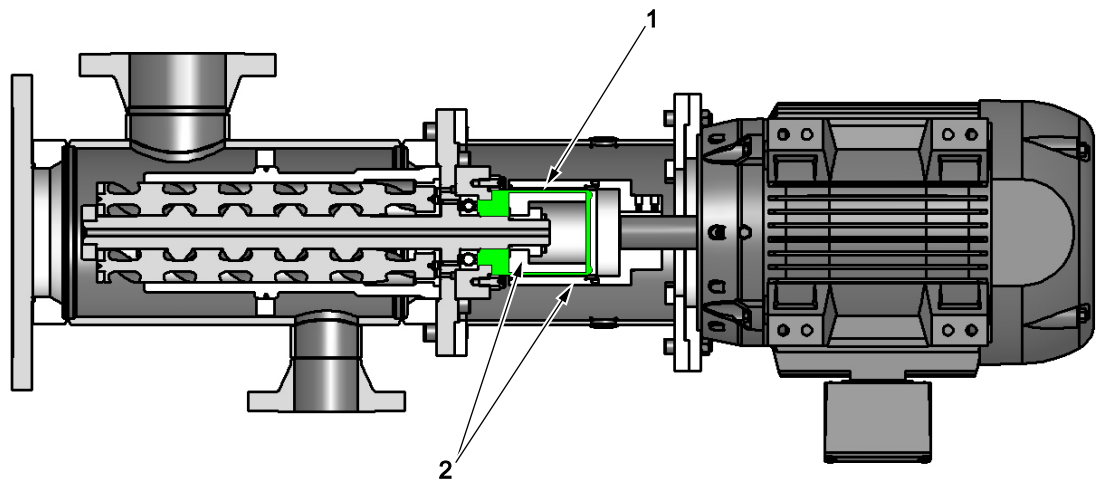
1. ▶ Check tightening torques of parts of the magnetic coupling annually in accordance with the table below. See also replacing the magnetic coupling ↪ Servicing, Page 31, tightening torques to be observed ↪ Appendix, Page 44.
2. ▶ Carefully clean outer surfaces of the inner rotor, outer rotor and containment can from metallic solids and other adherences ↪ Servicing, Page 31.
3. ▶ Check axial play of the ball bearing through manual movement of the shaft, see below. Replace in case of an noticeable play of more than 0.5 mm ball bearing ↪ Servicing, Page 31.

Check tightening torques



Item No.	Part
1	Tensioning element
2*	Threaded pin outer rotor support
3*	Countersunk screw outer rotor support
4	Socket screws pump bracket – pump
5	Socket screws outer rotor support – outer rotor
6	Socket screws containment can – pump
*	Depending on motor size

Tab. 12: Magnetic coupling: Parts to be maintained

Check inner rotor, outer rotor and containment can

1. ➤ Check containment can (green) 1 inside and outside for scratches, scores or other damage.
2. ➤ Check the inner rotor and the inside of the outer rotor 2 for cleanliness (no particles or chips) and damage.
3. ➤ Clean all surfaces completely of solids or ferrous build-up, see below.



*Fig. 9: Containment can
Left: Outer surface free from grooves
Right: Inside free from grooves*

11 Maintenance

11.5 Maintaining the magnetic coupling



Fig. 10: Containment can
Left: Groove extends over the entire wall thickness
Right: several deep grooves in succession

4. ➤ Containment can
Check the condition of the can, especially the inside.
⇒ If the grooves are deeper than 0.5 mm, the containment can must be replaced, as the compressive strength of the thin-walled containment can may be considerably reduced.



Fig. 11: Inner rotor
Left: Inner rotor without adhesions
Right: Large amount of iron particles accumulated on the inner rotor

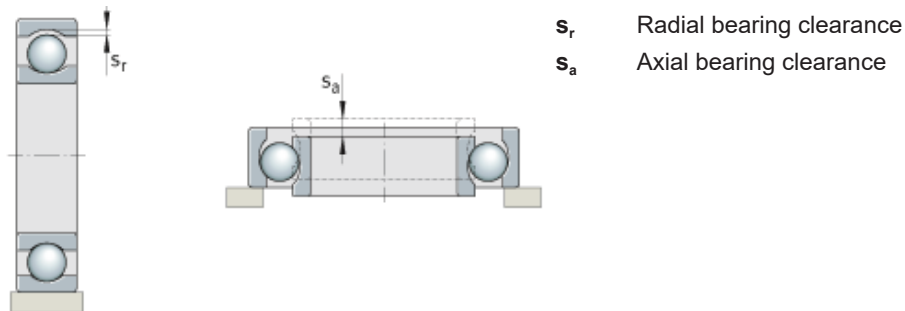
5. ➤ Inner rotor
If iron particles adhere to the surface, degrease the inner rotor with a solvent (acetone) and compressed air to remove the particles. Wipe off any remaining particles with a clean cloth over the edge of the inner rotor.

Check ball bearing**Fig. 12: Bearing**

Left: Worn bearing with missing cage and several rolling elements

Right: running surface of bearing inner ring with embedded deposits

1. ➔ Check the condition of the bearing for completeness of the rolling elements and their surface condition.
2. ➔ Check bearing clearance and condition of bearing cage.

**Fig. 13: Bearing clearance**

- ⇒ The ball bearing must be replaced when the limits of the radial and axial play (bearing clearance) are exceeded.
- The limits of the radial bearing clearance for non-installed bearings are specified in DIN 620-4 or ISO 5753-1. The limits of the axial bearing clearance depend on the radial bearing clearance and the concrete installation conditions so that no generally valid limits can be specified for this.
- The value of 0.5 mm specified above is an empirical value tested in practice.

12 Servicing**12.1 Dangers during servicing****The following safety instructions must be observed strictly:**

- ☐ Have all work carried out only by authorized qualified personnel.
- ☐ Before beginning work on the pump ensure that the electrical power supply is deenergized and is secured against being switched back on.
- ☐ Before beginning work, let the pump unit cool down slowly to the ambient temperature. Avoid rapid temperature changes.
- ☐ Pumped liquids can be hot, poisonous, combustible and caustic. Use corresponding protective equipment.
- ☐ Ensure that the pump is depressurized and that shut-off devices are not operated uncontrolled.
- ☐ Collect any discharging pumped liquid safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.
- ☐ Ensure that the collection tank for discharging pumped liquid is sufficiently large.
- ☐ Observe the tightening torques ➔ Appendix, Page 44.
- ☐ Observe the operating instructions and data sheets of the components.

12.2 Wear

12.2.1 Signs of wear

The following table lists signs of progressive wear of individual pump elements:

Finding	Cause	Elimination
Increased running noises	Incipient damage to bearing	➔ Replace the ball bearing.
Reduction in the delivery rate or pressure under constant operating conditions	Advanced wear of screws and housing	➔ Replace the pump.

Tab. 13: Signs of wear

12.2.2 Magnetic coupling

When using the pump in lubrication oil applications with a minimum purity class of 21/18/13 according to ISO 4406, an inspection at the latest after 5 years (40000 h) is sufficient.

Especially for pump systems where the containment can is exposed to an inlet pressure > 0.5 barg (14.5 psig), in combination with the risk of iron particles in the lubricating oil system and no possibility of fine filtration directly upstream of the pump, we strongly recommend an annual inspection.

Magnetic filter systems

If iron particles accumulate and deposit on the inner rotor and containment can, regular inspection and cleaning of the magnetic coupling is required. In this case, the manufacturer recommends installing a filter/strainer with magnetic separator or a similar device to catch ferrous particles upstream of the pump.

12.3 Replacing the magnetic coupling

12.3.1 Removing the outer rotor

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Open-end spanner <input type="checkbox"/> Mounting lever <input type="checkbox"/> Hoisting equipment <input type="checkbox"/> Positive guide



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



⚠ WARNING

Risk of injury and damage to equipment through falling and toppling parts.

- ▶ Use intact and correctly dimensioned hoisting equipment in accordance with the total weight to be transported.
- ▶ Select the lift points for the hoisting equipment in accordance with the centre of gravity and the weight distribution.
- ▶ Use at least two load ropes.
- ▶ In the case of vertical transportation secure the motor against tipping.
- ▶ Do not stand under raised loads.



⚠ WARNING

Danger of crushing between motor and pump.

When dismantling/assembling the motor with the pump, the strong magnetic forces can cause sudden collision and therefore injuries to hands or fingers.

- ▶ Use positive guide for disassembly/assembly.
- ▶ Two people are required.
- ▶ Use suitable hoisting equipment (for example chain hoist).
- ▶ Carry out disassembly/assembly in a vertical position if possible.
- ▶ Fix the pump with suitable measures.
- ▶ When the motor is disassembled/assembled, ensure that hands/fingers are not positioned between motor and pump.



⚠ WARNING

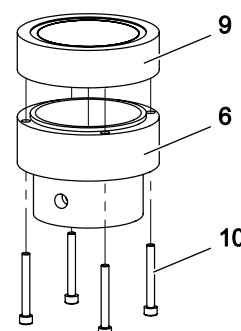
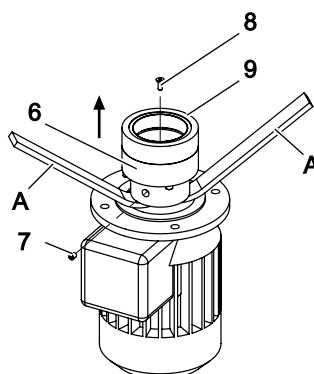
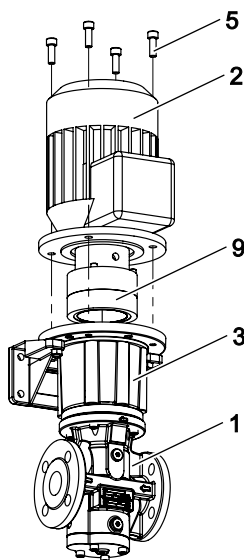
Hot surface.

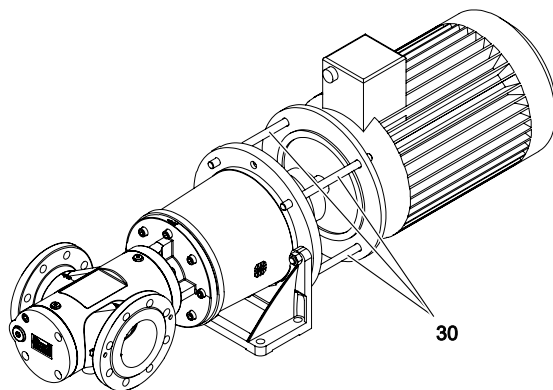
Components of the magnetic coupling heat up more than the pump during operation. Touching the magnetic coupling will result in burns.

- ▶ Before working on the magnetic coupling, allow the pump including the magnetic coupling to cool down to ambient temperature.
- ▶ Wear personal protective equipment at all times during operation. Be sure to wear protective gloves.

Requirement:

- ✓ Pump unit disconnected from the electrical power supply, deenergized and secured against being switched back on
1. ▶ Before dismantling, close the suction connection and pressure connection of the pump with protective covers.
 2. ▶ Fix the pump unit with suitable means so that the pump cannot tilt after dismantling the motor.





3. ➤ Attach the hoisting equipment to the motor 2.
4. ➤ Loosen the cap screws 5 between motor 2 and pump bracket 3 and replace with positive guide 30.
5. ➤ Lift the motor 2 off the pump bracket 3 via the positive guide.
6. ➤ Depending on the motor size remove the threaded pin 7 or the countersunk screw 8.
7. ➤ Pull the outer rotor support 6 and outer rotor 9 off from the motor shaft using mounting levers A.
8. ➤ Remove the socket screws 10 between the outer rotor support 6 and the outer rotor 9.

12.3.2 Removing the inner rotor

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Allen key <input type="checkbox"/> Strap spanner

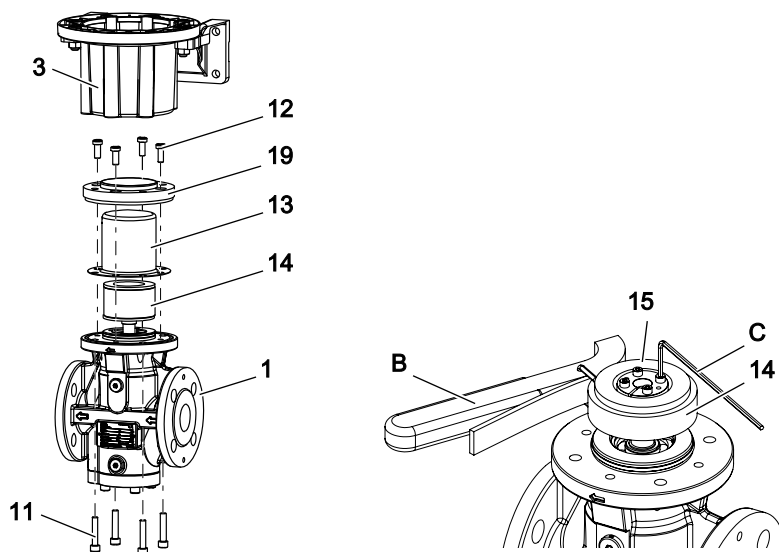


⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



1. ➤ Remove the socket screws 11 between the pump 1 and pump bracket 3 and remove the pump bracket.

2. ➤ Remove the socket screws **12** between the center flange **19** and the pump **1**, take off the containment can **13** and center flange **19**.
3. ➤ Fix the inner rotor **14** with a strap spanner **B**. Loosen the fixing screws of the tensioning elements **15** with Allen key **C** and remove the inner rotor from the shaft.

12.3.3 Installing the inner rotor

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Oil without molybdenum sulphide additive (e.g. multifunction spray WD-40)

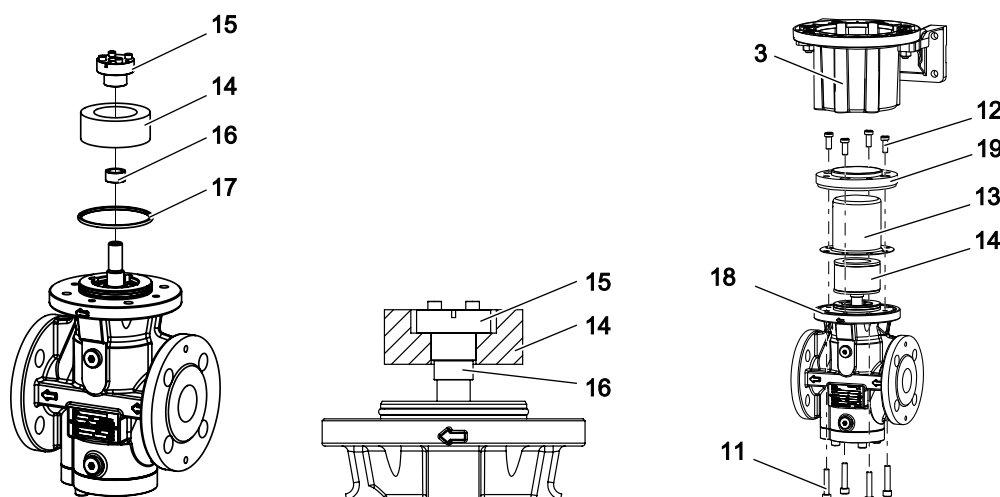


⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



1. ➤ Carefully clean the contact surfaces of the inner rotor **14**, oil the tensioning element **15** lightly.
2. ➤ Manually loosen the screws of the tensioning element by a few turns and insert the tensioning element in the inner rotor.
3. ➤ Carefully clean the sealing surfaces.
4. ➤ Clean and lightly grease the O-ring **17**. Insert the O-ring and slide the distance sleeve **16** onto the pump shaft.
5. ➤ Place the inner rotor with the pre-assembled tensioning element onto the pump shaft and tighten the screws of the tensioning element crosswise by hand.
6. ➤ Check the position of the tensioning element: The tensioning element should lie flat on the distance sleeve and inner rotor. Otherwise loosen the screws and reposition the tensioning element.
7. ➤ When the position is correct, first tighten the screws of the tensioning element with half the torque crosswise. Subsequently tighten several times crosswise with the full tightening torque ➤ Appendix, Page 44.
8. ➤ Press the containment can **13** and center flange **19** onto the pump flange **18** and tighten the socket screws **12** with torque.
9. ➤ Place the pump bracket **3** on the pump and tighten the socket screws **11** with torque.

12.3.4 Installing the outer rotor

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Hoisting equipment <input type="checkbox"/> Torque wrench <input type="checkbox"/> Positive guide



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

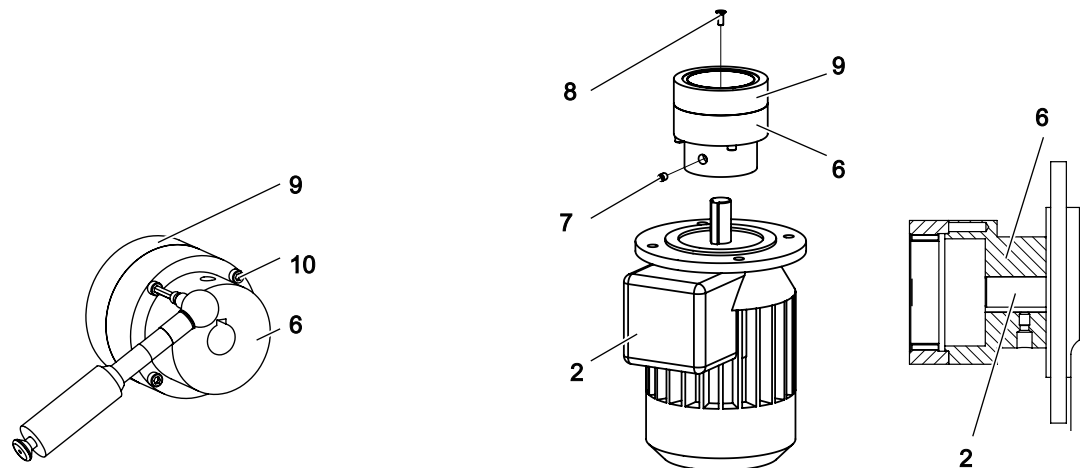


⚠ WARNING

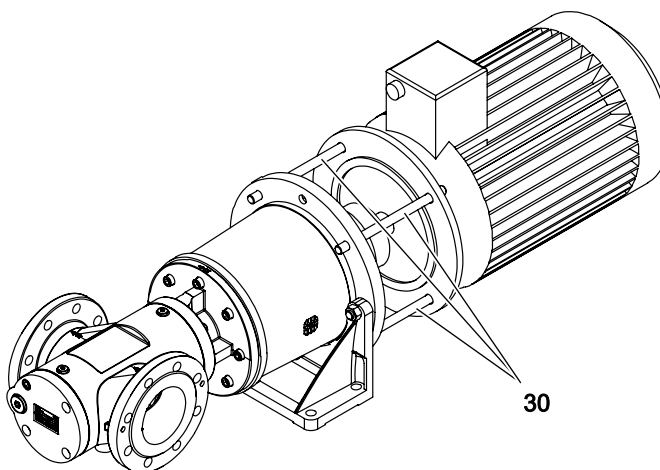
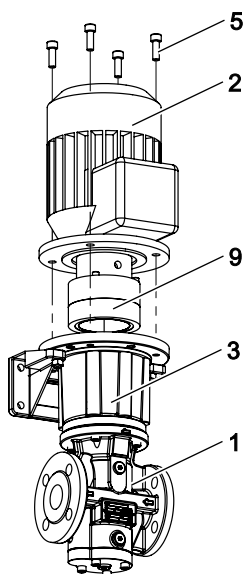
Danger of crushing between motor and pump.

When dismantling/assembling the motor with the pump, the strong magnetic forces can cause sudden collision and therefore injuries to hands or fingers.

- ▶ Use positive guide for disassembly/assembly.
- ▶ Two people are required.
- ▶ Use suitable hoisting equipment (for example chain hoist).
- ▶ Carry out disassembly/assembly in a vertical position if possible.
- ▶ Fix the pump with suitable measures.
- ▶ When the motor is disassembled/assembled, ensure that hands/fingers are not positioned between motor and pump.



1. ▶ Clean the outer rotor **9** carefully with compressed air. Tighten the socket screws **10** between the outer rotor and outer rotor support **6** with torque.
2. ▶ Clean and grease the shaft end of the motor **2**.
3. ▶ Place the outer rotor support with outer rotor on the shaft end of the motor.
4. ▶ Ensure that the shaft end of the motor is flush with the front surface of the outer rotor support.
5. ▶ Depending on the motor size tighten the threaded pin **7** or the countersunk screw **8**.



6. ➤ Fix the pump **1** with suitable means, so that the pump cannot tilt when the motor is mounted.
7. ➤ Attach the hoisting equipment to the motor and position it above the pump.
8. ➤ Insert the positive guide **30** between the motor and the pump bracket **3**.
9. ➤ Place the motor slowly on the pump bracket **3** of the pump via the positive guide. Ensure that the outer rotor does not strike the containment can.
10. ➤ Remove the positive guide.
11. ➤ Screw in the cap screws between the pump bracket and the motor and tighten them with torque.
12. ➤ Make sure that the outer rotor does not rub against the containment can by turning the fan wheel of the motor.
13. ➤ Do not remove the protective cover until just before reconnecting the pump to the pipe system.

12.4 Replacing the ball bearing

12.4.1 Removing the ball bearing

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Disassembly tool <input type="checkbox"/> Open-end spanner <input type="checkbox"/> Extractor



⚠ DANGER

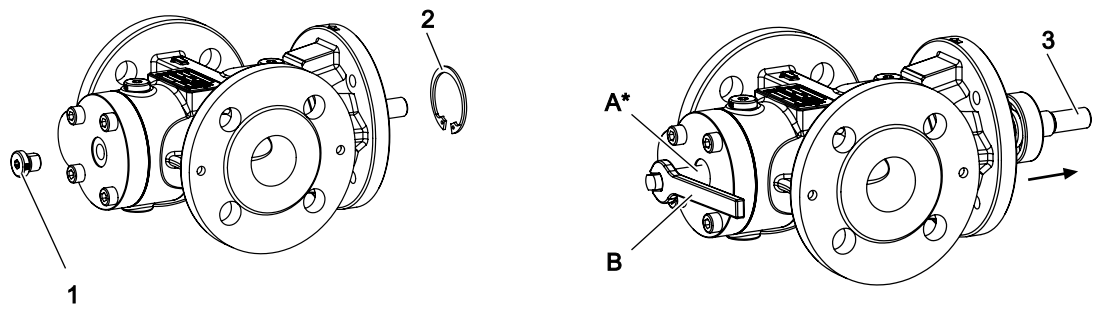
Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

12 Servicing

12.4 Replacing the ball bearing



* Part of the maintenance kit → Spare parts, Page 41

1. ➤ Remove the circlip **2** and screw plug **1**.
2. ➤ Screw in the disassembly tool **A*** with open-end spanner **B**.
→ The main screw **3** is pressed out of the pump housing.
3. ➤ Pull the main screw out of the pump housing.



4. ➤ Remove the circlip **6** and supporting ring **5** from the main screw.
5. ➤ Pull off the ball bearing **7** with a suitable extractor **C** from the main screw.
6. ➤ **Size 15 – 20:** Remove the supporting ring **4**.

12.4.2 Installing the ball bearing

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots



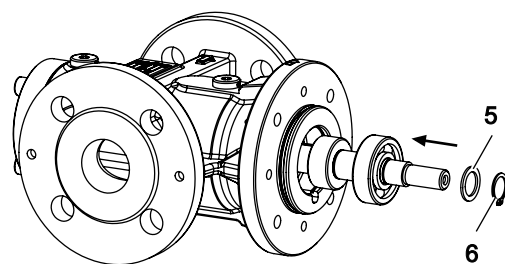
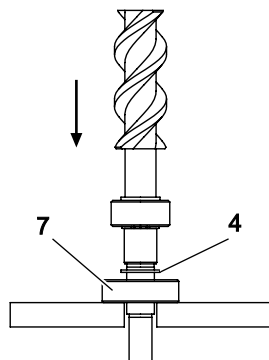
⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

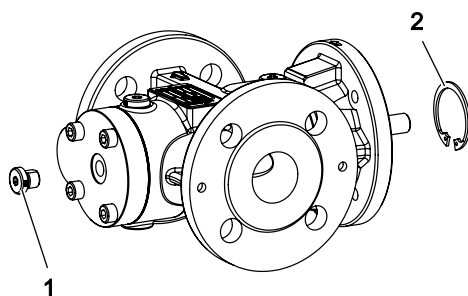
- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.

1. ➤ Clean the fitting surfaces and main screw. Grease the main screw slightly.



2. ➤ **Size 15 – 20:** Slide the supporting ring **4** onto the main screw.
3. ➤ Press the ball bearing **7** onto main screw.

4. ➤ Mount the supporting ring **5** and circlip **6**.
5. ➤ Slide the main screw with premounted ball bearing into the pump housing until the main screw engages into the idle screws. Turn the main screw in the process.



6. ➤ Mount the screw plug **1** and circlip **2**.

13 Disposal

13.1 Dismantling and disposing of the pump

Personnel qualification:	<input type="checkbox"/> Fitter
Personal protective equipment:	<input type="checkbox"/> Work clothing <input type="checkbox"/> Face protection <input type="checkbox"/> Protective gloves <input type="checkbox"/> Safety boots
Aids:	<input type="checkbox"/> Solvents or industrial cleaners suitable for the pumped liquid <input type="checkbox"/> Collection tank



⚠ DANGER

Magnetic field.

Risk of death for persons with cardiac pacemaker, metallic implant or neurostimulator.

- ▶ Under no circumstances may persons with cardiac pacemakers, metallic implant or neurostimulator perform work on the pump/pump unit.



⚠ WARNING

Danger of poisoning and environmental damage through residues.

- ▶ Wear personal protective clothing during all the work. Ensure face protection.
- ▶ Before disposal collect any pumped liquid still present safely and dispose of it in an environmentally compatible manner in accordance with the applicable local regulations.
- ▶ Before disposing neutralize the residues.

Requirement:

- ✓ Disconnect the pump unit from the power supply and secure it against being switched back on
- ✓ Pump unit cooled down to the ambient temperature and disconnected from the pipe system
- ✓ Pump emptied completely
- ✓ Pump placed at a location suitable for dismantling

1. ➤ Dismantle the pump and disassemble it into its individual parts.
2. ➤ Clean residues of the pumped liquid from the individual parts.
3. ➤ Separate sealing elements made of elastomers and ceramics (SiC) from the pump and dispose of them in separately.
4. ➤ Recycle iron parts.

14 Troubleshooting

14.1 Possible faults

14 Troubleshooting

14.1 Possible faults

Faults can have different causes. The following tables list the symptoms of a fault, the possible causes and measures for troubleshooting.

Identification	Fault
1	No pump suction
2	Delivery rate too low
3	Pump too loud
4	Motor overload
5	Uneven delivery rate
6	Pump has seized
7	Magnetic coupling leaks

14.2 Troubleshooting

Fault identification							Cause	Remedy
1	–	–	–	–	–	–	Pump suction line closed	<div> <div></div> <div>Check the shut-off devices. If required, open.</div> </div>
1	2	3	–	5	–	–	Parts soiled (filter, suction line, suction valve, strainer)	<div> <div></div> <div>Clean parts.</div> </div>
1	2	3	–	5	–	–	Suction head too high	<div> <div></div> <div> <div>Reduce the level difference.</div> <div>-or-</div> <div>Reduce the line length.</div> <div>-or-</div> <div>Increase the line cross-section.</div> <div>-or-</div> <div>Heat up the pumped liquid.</div> <div>-or-</div> <div>Install a filter / strainer with a larger mesh width. Ensure that the permissible mesh width is not exceeded.</div> </div> </div>
1	–	3	–	–	–	–	Level in the intake container too low	<div> <div></div> <div>Fill the intake container.</div> </div>
1	–	–	–	–	–	–	Too little pumped liquid in the pump	<div> <div></div> <div>Fill the pump with pumped liquid.</div> </div>
1	–	–	–	–	–	–	Incorrect pump direction of rotation	<div> <div></div> <div>Swop the two electrical connection phases ↻ Connection, Page 17.</div> </div>
–	–	–	4	–	–	–	Differential pressure too high	<div> <div></div> <div>Reduce the differential pressure.</div> </div>
1	–	3	4	5	–	–	Viscosity of the pumped liquid too high	<div> <div></div> <div> <div>Increase the temperature of the pumped liquid.</div> <div>-or-</div> <div>Decrease the speed.</div> </div> </div>
–	2	–	–	–	–	–	Viscosity of the pumped liquid too low	<div> <div></div> <div> <div>Reduce the temperature of the pumped liquid.</div> <div>-or-</div> <div>Increase the speed.</div> </div> </div>
–	2	3	–	5	–	–	Airlock/gas in the pumped liquid	<div> <div> <div>1. Test the pipe system for air admission, replace leaking parts.</div> <div>2. Reduce the suction head.</div> </div> <div> <div>-or-</div> <div>Increase the inlet pressure.</div> </div> </div>

Fault identification							Cause	Remedy
–	2	–	4	–	–	–	Speed/frequency/voltage of the motor false	<ol style="list-style-type: none"> ➤ Ensure that the motor frequency and voltage match the operating voltage. ➤ Ensure that the speed of the motor matches the rating plate of the pump. If necessary adjust the speed.
–	2	3	–	5	–	–	Overflow valve opens during normal operation	➤ Set the opening pressure to 110% of the differential pressure ↗ During operation, Page 24.
–	2	–	–	5	–	–	Overflow valve leaks	➤ Contact the manufacturer.
–	2	–	–	–	–	–	Advanced wear of the housing/screw set	➤ Contact the manufacturer.
–	–	3	–	–	–	–	Pump subject to mechanical stress	➤ Connect the pump correctly to the pipe system ↗ Connection, Page 17.
–	–	3	–	–	–	–	Vibrations/pulsations in the system	➤ Bear the pump unit elastically. -or- Make the connections with hoses.
–	–	3	–	–	–	–	Flow speed in the pressure line or suction line too high	➤ Set the flow speed in the pressure line so that it does not exceed 3 m/s. -or- Set the flow speed in the suction line so that it does not exceed 1 m/s. -or- Contact the manufacturer.
–	–	3	4	–	–	7	Ball bearing damaged	➤ Replace the ball bearing ↗ Servicing, Page 31.
–	–	–	4	–	–	7	Foreign bodies in the pump	➤ Contact the manufacturer.
–	–	–	–	–	–	7	Differential pressure is too high and has overloaded the idle screws	➤ Contact the manufacturer.
–	–	–	–	–	–	7	Viscosity is too low and has overloaded the idle screws	➤ Contact the manufacturer.
1	2	3	4	–	–	7	Pump damaged through dry running	➤ Contact the manufacturer.
1	–	–	–	–	–	–	Pump does not vent	➤ Vent the pressure line at the highest point.
–	2	3	–	–	–	–	Magnetic coupling interrupted	<ol style="list-style-type: none"> ➤ Stop the pump immediately and restart it. ➤ Avoid excessive differential pressures. ➤ At repeated occurrence check whether pump has got stuck.
1	–	–	–	–	–	7	Containment can defective	➤ Replace the containment can ↗ Servicing, Page 31.

Tab. 14: Fault table

15 Spare parts

15.1 Overview

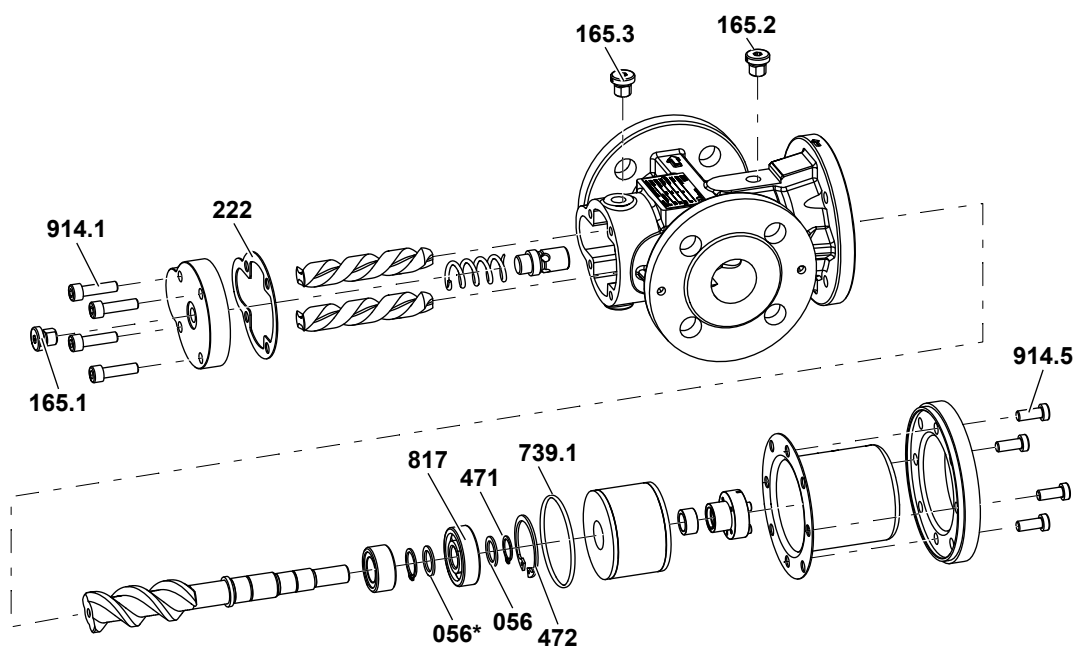
Model/Size	Type	Variant	Internal
15 – 210	Maintenance kit	Magnetic coupling	OPW 42
15 – 210	Repair kit	Magnetic coupling	OPR 12

Tab. 15: Overview of spare parts

15.2 Maintenance kits

15.2.1 Maintenance kit, magnetic coupling

Note The maintenance kit contains only the numbered parts and is only supplied complete.



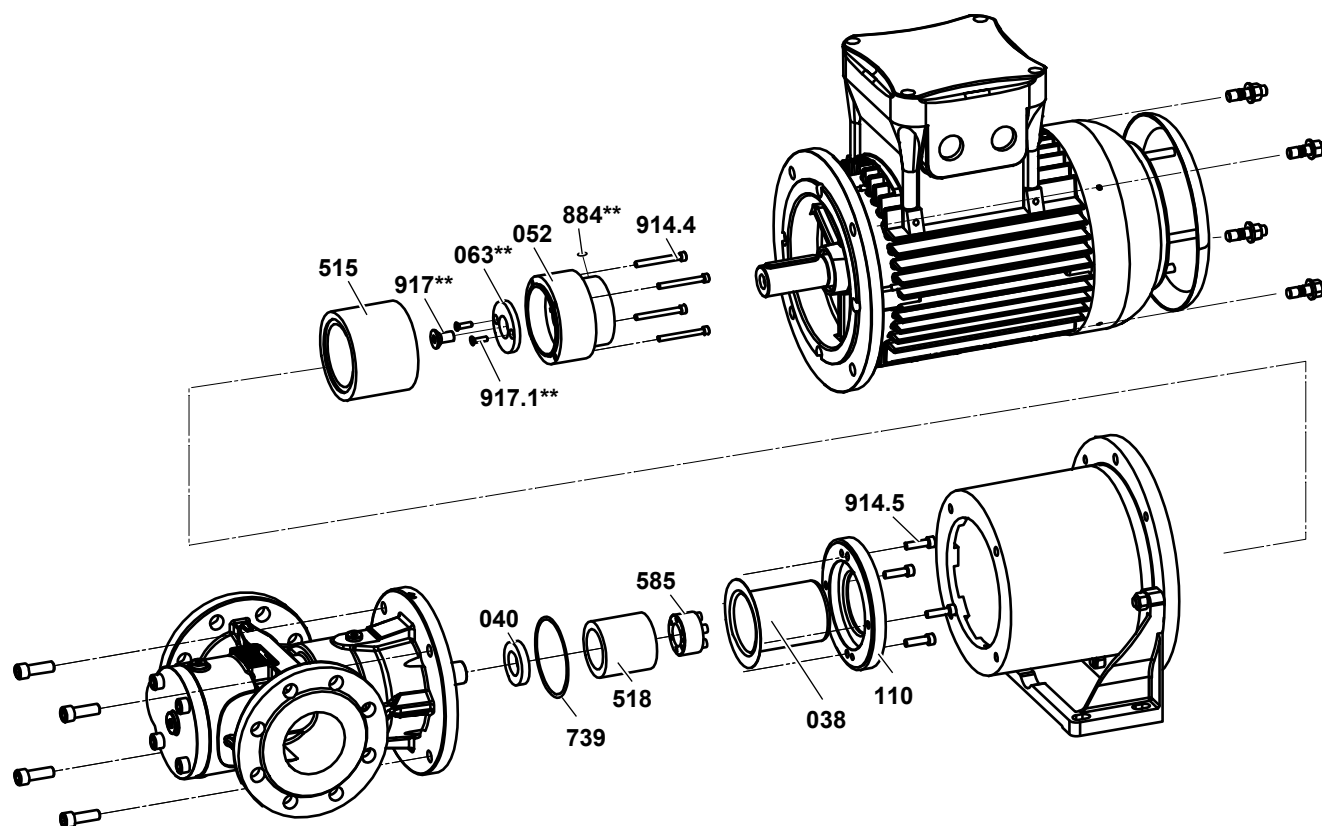
Qty.	Item no.	Part	Qty.	Item no.	Part
1 (2*)	056(*)	Supporting ring	1	739.1	O-ring
1	165.1	Screw plug	1	817	Ball bearing
1	165.2	Screw plug	4	914.1	Socket screw
1	165.3	Screw plug	4	914.5	Socket screw
1	222	Flat gasket	1		Disassembly tool
1	471	Circlip	1		Silicone grease 1 g
1	472	Circlip			
	*	Only for R 15–20			

Tab. 16: Magnetic coupling maintenance kit

15.3 Repair kits

15.3.1 Repair kit magnetic coupling

Note The repair kit contains only the numbered parts and is only supplied complete.



Qty.	Item no.	Part	Qty.	Item no.	Part
1	038	Containment can	1	585	Tensioning element
1	040	Distance sleeve	1	739	O-ring
1	052	Outer coupling hub	1 (2**)	884**	Threaded pin
1	063**	Supporting ring	4	914.4	Socket screw
1	110*	Center flange	4	914.5	Socket screw
1	515	Outer rotor	1	917**	Countersunk screw
1	518	Inner rotor	2	917.1**	Countersunk screw
	*	Only included in the current design			
	**	Depending on motor size			

Tab. 17: Magnetic coupling repair kit

16 Appendix

16.1 Tightening torques for screws with metric screw threads with and without wedge lock washers

Note In the case of galvanised screw plugs and screw plugs made of stainless steel the inner thread and outer thread have to be greased thorough before mounting in order to prevent threads from seizing.

Note The manufacturer recommends tightening screws with wedge lock washers according to the table three times after another with the same tightening torque

Tightening torque [Nm]							
Screws with head contact surface					Countersunk screws		
Thread					Stainless steel screws A2 and A4		8.8
	5.6	8.8	10.9	8.8+ Alu*	Property class 70	Property class 80	
M 3	0.6	1.5	–	1.2	1.1	1.3	1.0
M 4	1.4	3.0	4.1	2.3	2.0	2.3	2.0
M 5	2.7	6.0	8.0	4.8	3.9	4.7	5.0
M 6	4.7	10.3	14.0	7.6	6.9	8.0	9.0
M 8	11.3	25.0	34.0	18.4	17.0	22.0	14.0
M 10	23.0	47.0	68.0	36.8	33.0	43.0	36.0
M 12	39.0	84.0	117	64.0	56.0	75.0	60.0
M 14	62.0	133	186	101	89.0	–	90.0
M 16	96.0	204	285	155	136	180	100
M 18	133	284	390	224	191	–	–
M 20	187	399	558	313	267	370	135
M 24	322	687	960	540	460	605	360

Tab. 18: Tightening torques metric screw thread

*When screwing into aluminium, the tightening torque reduces by 20 % when the screw-in depth is less than double the thread diameter.

16.2 Tightening torques for screw plugs with thread measured in inches and elastomer seal

Note In the case of galvanised screw plugs and screw plugs made of stainless steel the inner thread and outer thread have to be greased thorough before mounting in order to prevent threads from seizing.

Tightening torque [Nm]	
Thread	Galvanized + stainless steel
G 1/8"	13.0
G 1/4"	30.0
G 3/8"	60.0
G 1/2"	80.0
G 3/4"	120
G 1"	200
G 1 1/4"	400
G 1 1/2"	450

Tab. 19: Tightening torques with thread measured in inches

16.3 Tightening torques for screws of tensioning elements

Tightening torque [Nm]	
Thread	12.9
M 3	2.1
M 4	5.1
M 6	17.4
M 8	42.2
M 10	83.0
M 12	144

*Tab. 20: Tightening torques tensioning elements***16.4 Contents of the Declaration of Conformity**

The products described in these instructions are machinery in the sense of the Directive 2006/42/EC. The original of the EC Declaration of Conformity is enclosed with the machinery at delivery.

The machinery fulfils all the relevant provisions of the following directives:

Number	Name	Remark
2006/42/EC	Machinery Directive	–
2014/68/EU	Pressure Equipment Directive	–
2014/30/EU	Directive on Electromagnetic Compatibility	Only for machinery with electrical components
2014/35/EU	Low Voltage Directive	Only for machinery with electrical components
2014/34/EU	Directive on Use in Potentially Explosive Areas (ATEX)	Only for machinery in ATEX version

Tab. 21: Directives observed



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