

Operating and Maintenance Instructions

VM No.: 670.0005 GB
 Edition: 02.99
 Ident No.: 550 165

Screw pumps
Series SM...ER..
 Design D, E and KA

**Retain
 for future
 use!**

Order no.:

Pump ident. no.:

Machine no.:

Pump type:

Operating data of pump as per order data sheet
 Dimensions as per technical specification VM 618/...

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These Operating and Maintenance Instructions contain information from the pump manufacturer. They may need to be supplemented by instructions of the operator company for its personnel. These instructions do not take account of specific information relating to operation and maintenance of the process plant into which the pump is integrated. Such information can only be given by the persons responsible for construction and planning of the plant (plant manufacturer).

Such specific instructions relating to operation and maintenance of the process plant into which the pump is integrated have priority over the instructions of the pump manufacturer.

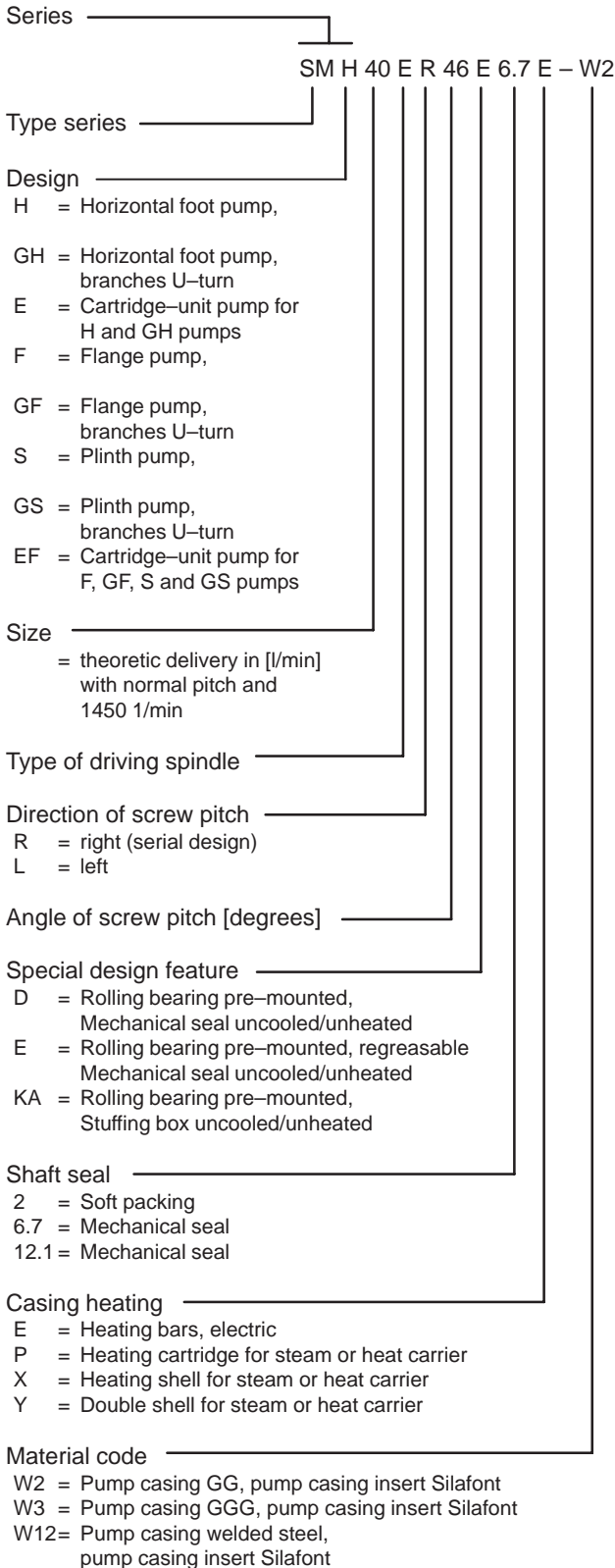
Refer to the operating instructions of the plant manufacturer!

1 General

1.1 Abbreviation

The abbreviation of the screw pump is set up according to the following schema, and is engraved on the type plate.

Example:



1.2 Application and range of utilization

The inside–bearing screw pumps of type series SM...ER.. are three–screw, rotary positive displacement pumps for lubricating liquids. The liquids must not contain any abrasive particles nor chemically attack the pump materials.

Due to a modular system, the pumps may be designed as cartridge–unit pumps, horizontal foot–mounted pumps, flange–mounted pumps as well as vertical plinth–mounted pumps.

1.3 Performance data

The exact performance data applicable to the pump can be taken from the order data sheet and/or acceptance test report, and are engraved on the name plate.

The pressure data indicated there apply only to approximated static pressure load. In the case of dynamic alternating pressure load, consult the manufacturer.

1.4 Warranty

Our warranty for shortcomings in the supply is laid down in our delivery conditions. No liability will be undertaken for damages caused by non–compliance with the operating instructions and service conditions. If at any later date the operating conditions change (e.g. different fluid conveyed, speed, viscosity, temperature or supply conditions), it must be checked by us from case to case and confirmed, if necessary, that the pump is suited for those purposes. Where no special agreements were made, pumps supplied by us may, during the warranty period, only be opened or varied by us or our authorized contract service workshops; otherwise our liability for any defects will cease.

1.5 Testing

Prior to leaving our factory, all pumps are subjected to a thorough test run and performance test on the test stand. Only properly operating pumps, achieving the performance assured by us, leave the factory. Thus, compliance with the following operating instructions ensures fault–free operation and full delivery.

1.6 Availability

As a matter of principle, we recommend stocking replacement pumps and withdrawable units (hydraulic action system) where the supplied pumps are a decisive factor in maintaining a production or delivery process. In this way downtimes can be avoided, or reduced to a minimum.

2 Safety

These operating instructions contain basic safety instructions for installation, operation and maintenance. It is therefore essential that they are read by fitters and all specialist staff and customer personnel prior to installation and start-up. They must always be kept at hand at the place of installation.

The special safety instructions contained in the other chapters must be observed in addition to the general safety instructions in this chapter.

2.1 Marking of instructions in the operating instructions

The safety instructions contained in these operating instructions which represent a danger to personnel if not complied with are specially marked by the general danger symbol:



Warning symbol
as per DIN 4844–W9

Warning of danger from electric voltage is given as follows:



Warning symbol
as per DIN 4844–W8.

Instructions which are essential to avoid endangering the machine and its functioning are marked by the word

ATTENTION

Instructions affixed directly to the machine such as

- Directional markers
- Signs for fluid connections

must always be observed and maintained in fully legible condition at all times.

2.2 Personnel qualification and training

The operating, maintenance, inspection and mounting personnel must be appropriately qualified for the duties assigned to them. The scope of their responsibilities, competency and supervisory duties must be closely controlled by the customer. If the personnel do not have the required knowledge, they must be trained and instructed. If required, this may be provided by the manufacturer/supplier on behalf of the customer. The customer must additionally ensure that personnel fully understand the content of the operating instructions.

2.3 Dangers in the event of non-compliance with safety instructions

Failure to comply with the safety instructions may result in danger to persons, and place the environment and the machine at risk. Non-compliance with the safety instructions may lead to the loss of any claims for damages.

Non-compliance may relate to the following dangers:

- Failure of important functions of the plant
- Failure of specified methods for maintenance and servicing
- Danger to persons resulting from electrical, mechanical and chemical effects
- Danger to the environment resulting from leakage of hazardous substances

2.4 Responsible working practices

The safety instructions contained in these operating instructions, current national accident prevention regulations, as well as internal working, operating and safety rules of the customer, must be observed.

2.5 Safety instructions for the user/operator

- Hot or cold parts representing a danger must be protected against accidental contact on site.
- Protection against accidental contact for moving parts (such as the coupling) must not be removed while the machine is in operation.
- When operating pump aggregates in a dust-laden environment (e.g. milling, chipboard manufacture, bakeries), the surfaces of the pumps and motors must be cleaned at regular intervals, depending on local conditions, in order to maintain the cooling effect and eliminate the possibility of spontaneous combustion. Refer also to explosion protection regulations (ZH 1/10).
- Leakage (e.g. from the shaft seal) of hazardous substances being handled, such as explosive, toxic or hot materials, must be discharged such that no danger to persons or the environment is created. Legal regulations must be observed.
- Dangers from electrical energy must be eliminated. For details in this regard, refer to VDE and local power company regulations.

2.6 Safety instructions for maintenance, inspection and mounting work

The operator company shall ensure that all maintenance, inspection and mounting work is performed by authorized and qualified specialist personnel who have thoroughly studied the operating instructions.

Work on the machine is only to be carried out when the machine is at a standstill. The means of shutdown of the machine described in the operating instructions must always be followed.

Pumps or aggregates handling fluids which are detrimental to health must be decontaminated. All safety and protective devices must immediately be refitted and made operational on completion of the work.

The instructions under Section 6.1, "Preparation for start-up", must be observed before restarting.

2.7 Unauthorized conversion and production of replacement parts

Conversion or modification of the machines is only permissible after consultation with the manufacturer. Original replacement parts and accessories approved by the manufacturer serve safety purposes. If other parts are used the manufacturer cannot be held liable for the consequences.

2.8 Impermissible modes of operation

The operating safety of the machine supplied is only ensured when it is used in accordance with *Section 1* of the operating instructions. The limit values given on the data sheet must under no circumstances be exceeded.

3 Transportation and Intermediate Storage

3.1 Packaging

Attention must be paid to the markings on the packaging.

The suction and pressure sides and all auxiliary connections must always be closed during transportation and storage. The closing plugs must be removed when the pump aggregate is installed.

3.2 Transportation

The pump or pump aggregate is to be safely transported to the place of installation, if required by means of lifting gear.



The generally applicable safety regulations for lifting loads must be observed. The crane device and cables must be adequately dimensioned. The cables must not be attached to the attachment eyes of the motor.

Complete aggregates, with a base plate-mounted horizontal foot pump and mounted, coupled motor, must be transported to the place of installation as shown in the illustration.

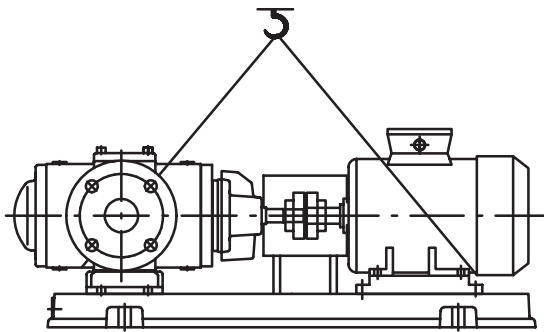


Fig. 1: Transportation of a horizontally mounted pump aggregate

In the case of vertically and horizontally mounted flanged pump aggregates, it is advisable to attach the cables to the wall/foot lantern or intermediate fitting lantern (not shown).

ATTENTION During transportation ensure that the aggregate is secured against toppling over. The attachment eyes of the motor can be used to secure it.

Transport damage

ATTENTION Check the pump for damage on receipt. Any damage detected must be notified immediately.

3.3 Preservation and storage of the screw pumps

3.3.1 Preservation

In the case of storage or prolonged standstill, the pumps must be protected against corrosion. In those cases, an outside and inside preservation is to be provided. The durability of the protection against corrosion, which is limited in time, depends on the composition of the preservative to be applied and the storage conditions.

ATTENTION Under normal circumstances the pumps have no special preservative.

At an additional charge we can, however, supply pumps and replacement parts ex factory with a preservative adequate to the planned storage period.

We will be pleased to specify suitable preservatives for you on request.

3.3.1.1 Outside preservation

The outside preservative should be applied by painting or spraying with a spray gun.

Points of preservation:

All bright and unvarnished parts (e.g. shaft ends, couplings, flange facings, valve and manometer connections).

3.3.1.2 Inside preservation

The preservative is to be applied by filling the pump. For these purposes, the suction side of the pump must first be closed with a dummy flange. During filling, the pressure flange must be on a higher level than the suction flange. During the filling process, the shaft must be slowly cranked against the direction of rotation. Filling must be continued until the preservative reaches the sealing strip of the delivery flange, bubble-free. Then the outlet side is to be closed with a dummy flange.

Note: Not required for pumps made of stainless materials.

Points of preservation:

All bright parts inside the pump (e.g. pump casing inside, screw spindles, ball bearings, pressure-relief valves).

3.3.1.3 Monitoring of preservation

In the event of prolonged storage, the preservation of the pump must be checked by the customer at regular intervals.

Every six months the pump level must be checked; if necessary, preservative must be topped up to the sealing strip on the pressure flange.

At the same time, the packing must be checked for destruction, and repaired if necessary.

Note: Liability for damages caused by improper preservation cannot be assumed by us.

3.3.1.4 Depreservation



Prior to setting the pump in motion, the preservative applied must be removed.

Environmentally compatible disposal must be ensured.

The preservative applied for inside preservation can normally be removed by flushing the pump with the fluid to be conveyed.

Alternative, suitable solvents may be applied for removing the inside and outside preservation. Appropriate solvents are for example: petroleum, benzene, Diesel fuel, spirit, alkalis (industrial cleaners) or any other wax solvents. Steam jet cleaning devices with appropriate admixtures can also be used (allow wax solvent to act beforehand).

ATTENTION Prior to start-up after prolonged storage, all elastomers (O-rings, shaft seals) must be checked for their elasticity of shape. Embrittled elastomers must be exchanged. Elastomers of ethylene-propylene rubber (EPDM) must always be replaced. The pump must be filled with fluid to prevent seizing of the components. A pressure-relief valve attached or fitted in the pipeline must be checked for passage.

Note: If on the plant side, the pipelines, (oil) tanks or other parts are wetted with paraffin-containing preservative, the entire plant must be depreserved as paraffin is detrimental to the air separating capability of oil. This may result in unsteady operation of the pump and loud noise.

3.3.2 Storage

During storage of the pump, the suction and outlet branches and all other supply and discharge branches must always be closed with dummy flanges or dummy plugs.

Storage should be in a dry, dust-free room. During storage, the pump should be cranked at least once a month. During this process, parts such as the shaft and bearings should change their position.

4 Description

4.1 Structural design

Three-screw pumps with a double-threaded driving spindle and two double-threaded idler spindles, enclosed in a housing insert with narrow running clearance.

The delivery elements are installed in a pump housing which is closed off by pump caps.

In the plinth pumps, the end-side pump cover is designed as a round foot. Cartridge-unit pumps do not have a pump casing. Depending on the installation situation, they can be installed in pump columns, submersed bodies, (hydraulic) tanks and cylinder casings etc.

4.1.1 Bearing and lubrication

By a pre-mounted, greased groove ball bearing to DIN 625.

Design D, KA: not regreasable, groove ball bearing with sealing washers on both sides and life-time grease filling.

Design E: regreasable by means of lubricating nipple. A grease flow regulator (labyrinth ring) ensures that overgreasing and thus impermissible heating of the bearing is avoided.

4.1.2 Shaft seal

- **Stuffing box (Design KA2)**

Soft packing; packing rings of teflon-impregnated mineral fibre yarn.

Note: Design KA2 has no regulating valve and should therefore not be used in suction operation. In case of doubt please contact the factory.

- **Mechanical seal (Design D... and E...)**

Uncooled, maintenance-free mechanical seal of the unbalanced type.

Material of the mechanical seal ①:

Rotating seal ring:	Hard carbon, metal-impregnated
Stationary seal ring:	Alloyed grey cast iron
Auxiliary gaskets:	Viton
Spring:	CrNiMo-steel
Metal parts	CrNiMo-steel

① Special mechanical seals and/or other material designs may be installed.

4.1.3 Connections/Branch positions/Dimensions

SMH, SMF, SMS: with symmetrically arranged opposite suction and delivery branches, offset.

SMGH, SMGF: suction and delivery branches arranged one behind the other (U-turn).
②

SMGS: suction and delivery branches arranged one above the other (U-turn).
②

Flanges on all designs

Suction side: PN 16 to EN 1092-2

Delivery side: PN 100 to DIN 2546

② These designs are only available with steel-welded casing.

4.1.4 Heating

Where heavy heating oils or other fluids which tend to solidification when cooling are to be pumped, the following equipment is available for pump heating.

Short cut	Heating			
	electrical	with steam or heat carrier		
	Heating rods	Heating shell	Heating cartridge	Heating jacket ①
–	–	–	–	–
E	x	–	–	–
X	–	x	–	–
P	–	–	x	–
Y	–	–	–	x

① Only pumps of steel-welded construction are fitted with a heating jacket.

For further details on pump heating and the necessary heating capacity, refer to our specific brochure VM 4.70/Z.–Nr. 6000002024.

4.1.5 Pressure relief valve



For safety reasons, screw pumps must generally be equipped with a pressure relief valve.

Most pumps are already equipped with a pressure relief valve when they leave the factory. The standard trigger pressure of this valve is approximately 10% above the operating pressure.



Pumps that are supplied without a pressure relief valve must be provided with a suitable safety valve by the customer. The safety valve must be fitted in the discharge pipeline between the pump and the first shut-off device.

4.1.6 Additional devices/Auxiliary systems

Any additional devices required (heating, cooling, quench, pressure relief system) are dependent on the order and the plant operating conditions.

Please refer to the order-specific documents for precise details of the construction and the operating conditions.

4.2 Mode of operation

Through the suction connection, the fluid is conveyed into the suction chamber of the pump. From there the fluid flows into the spindle chambers, which are constantly formed by the rotary motion at the spindle end on the suction side. By the translatory rotary motion, the chambers filled with the fluid move from the suction side to the outlet side. During this process the closed chamber volume does not change. At the spindle end on the outlet side the chamber opens towards the delivery chamber. The fluid is steadily pushed out into the delivery chamber from where it is transported, through the pressure connection, into the pressure pipeline.

The axial thrust acting on the faces of the profile flanks on the outlet side is hydraulically balanced by an appropriate dimensioning of the compensating piston of the driving spindles and the compensating journals of the idler spindles. Thus the bearing is relieved of the hydraulic axial thrust.

The idler spindles are hydraulically driven by means of appropriate dimensioning of the spindles. Only the torque resulting from the fluid friction is transmitted via the profile flanks. They are therefore practically stress-free, and not subject to any wear.

As a result of the constant chamber volume the medium inside the pump is transported, almost entirely free of turbulence and squeezing, from the suction side to the outlet side.

The compartment for the shaft seal is connected to the pump suction chamber. An installed stuffing box regulating valve provides for an excess pressure in the stuffing box housing during suction operation. This excess pressure is approx. 0.5 bar above the pressure in the suction chamber. Thus, during suction operation, air aspiration by the shaft seal is avoided and dry running prevented. In case of flooded operation the regulating valve is not required.

The structural design and mode of operation of the screw pump ensure a very low noise level and an almost pulsation-free delivery.

4.3 Construction of the pump aggregate

4.3.1 Drive

The pumps can be directly coupled with electric motors or any other prime movers.

In most cases, surface-cooled three-phase squirrel cage induction motors are used as driving motors, type IM B3 or IM V1, class of protection IP 54 to IEC standard, class B insulation, outputs and main dimensions to DIN 42 673 or 42 677.

The exact motor data are to be found on the order data sheet.

4.3.2 Shaft coupling and contact protection

Power transmission is effected via a flexible coupling to DIN 740. Additional radial forces must not act on the driving spindle.

Protection against accidental protection to EN 809 is provided where the product package comprises a pump, base plate and shaft coupling, or where a wall/foot lantern or intermediate fitting lantern is supplied as part of the product package.



According to accident prevention regulations, the pump must only be operated with a protection against accidental contact as per EN 809.

If no contact protection is provided, it must be attached by the operator.

4.3.3 Base plate

Horizontal foot pumps are mounted with the drive motor on a common base plate. Base plates can be provided in cast or steel design.

4.3.4 Wall/foot lantern

Horizontally or vertically mounted flange pumps are connected to the drive motor by way of a wall/foot lantern.

4.3.5 Fitting lantern

Fitting in fluid tanks is enabled by using fitting lanterns.

4.3.6 Motor lantern/intermediate lantern

Vertically mounted plinth pumps are connected to the drive motor by way of a motor lantern or intermediate lantern. In the plinth pumps the end-side cover is executed as a round foot for vertical plinth mounting.

5 Installation/Mounting

5.1 Installation

The pumps can be horizontally or vertically mounted.



For safety reasons the "downward-facing motor" arrangement is not permitted.

5.2 Mode of fastening

The mode of fastening is dependent on the design type and size of the pump and the coupled motor, as well as local installation conditions.

Horizontal foot pumps are normally mounted with the drive motor on a common **base plate**.

Flange pumps can be fastened by means of a **wall/foot lantern**, either horizontally or vertically, at the place of installation.

Vertical plinth pumps have a small installation area due to their design, and can also be fastened on a **concrete foundation** or **foundation frame**.

In the case of flange and insertion pumps which are installed in immersion bodies, tanks, cylinder housings etc., the **fixing flange** of the pump, together with the **flange contact surface**, provides a fastening option in the various executions.

Precise details on form and dimensions are given in the installation drawing.

5.3 Foundation

5.3.1 General

The foundation may be a floor/concrete base or a load-bearing steel foundation frame.

Note: The foundation must be designed so it can take the weight of the pump aggregate across its entire area.

5.3.2 Characteristics of a steel foundation frame

A steel foundation frame must be designed so that the base plate makes contact across its entire area, and can be bolted or welded down.

ATTENTION If the base plate is only supported at four points the pump aggregate will hang down in the middle. This will affect the alignment of the coupling and may also lead to severe noise being generated.

5.3.3 Characteristics of a floor/concrete foundation

The foundation must be horizontal, flat and clean, and be capable of bearing the full load upon it.

Note: Concrete foundations must be executed with standard concrete of strength class B 25 as a minimum.

5.3.4 Alignment of the pump aggregate

The pump aggregate must be aligned to its pre-set height and system dimensions. This is done using suitable steel shims, arranged directly adjacent to each fixing bolt.

The total height of the steel shims is determined by the pre-set system dimensions of the plant. The steel shims and the base plate must sit flush.

If the fixing holes are more than 750 mm apart, we recommend fitting additional steel shims in the middle of the base plate.

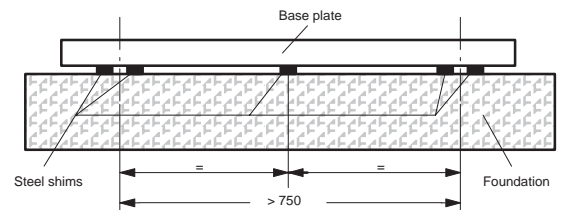


Fig. 2: Alignment with steel shims

Horizontal alignment of the aggregate is produced by way of flat-machined surfaces on the pump using a machine spirit level. Measurements are taken in longitudinal and transverse directions of the pump aggregate.

Permissible deviation: max. 1 mm per 1 m length.

5.3.5 Fixing the pump aggregate

When the aggregate has been aligned on the foundation the fixing bolts should be tightened evenly, alternating side to side.

Recommendation: As far as possible, the base plate should be cast-on over its entire length with a non-shrinking mortar casting compound.

Note: When casting-on and packing with the mortar casting compound, it must be ensured that the base plate makes contact with the foundation over its entire area, and that there are no cavities.

5.4 Checking the coupling alignment

5.4.1 Checking the coupling alignment in case of horizontal setup on base plate (if used)

A complete delivered pump aggregate has been carefully assembled at the factory. After proper installation, and prior to start-up of the pump aggregate, the alignment of the coupling must be checked.

The check can be made with a straight-edge and a feeler gauge, or with other suitable equipment (such as a laser alignment device).

The measurements are taken in two planes, each offset by 90°, on the circumference of the coupling.

If a height, lateral or angle offset is detected between the two coupling halves, the drive motor should be re-aligned such that the coupling halves are flush with each other (level out with flat packing shims as necessary).

The gap between the two coupling halves must be the same all round the circumference of the coupling. The specified gap is shown in the installation diagram.

The spacing between the straight-edge laid over both coupling halves and the respective shaft must be the same all round the circumference.

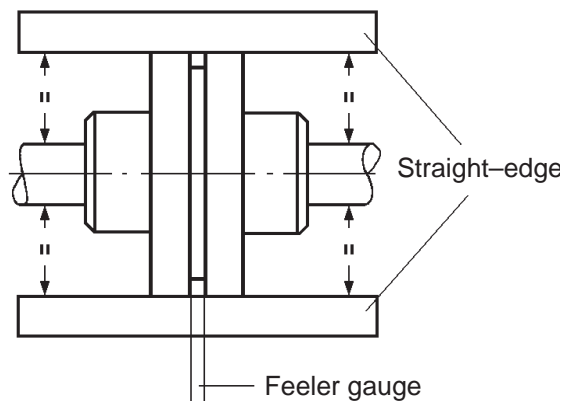


Fig. 3: Alignment of the coupling with straight-edge and feeler gauge

For couplings with a distance piece (removable couplings) the alignment of the coupling can be checked with dial gauges.

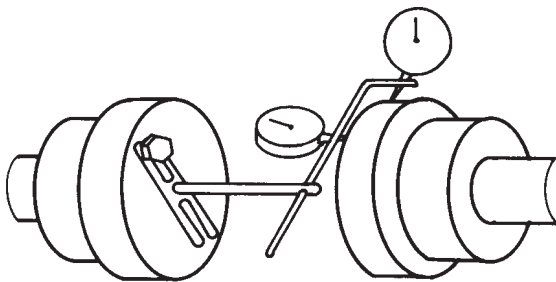


Fig. 4: Alignment of the coupling with dial gauges

Note: The permissible axial and radial deviation, measured on the front face of the coupling and the coupling circumference respectively, may be max. 0.1 mm, but as far as possible should be kept below 0.05 mm.

When the fixing bolts have been aligned and tightened the pump/drive motor unit must be able to be spun by hand without pressure points.

ATTENTION Out-of-flush errors on the coupling may lead to heavier wear of the coupling, the anti-friction bearing and the shaft seal, and even cause the shaft end to be torn off.

5.4.2 Coupling alignment in case of flanged aggregates (if used)

In the case of pumps with flanged drive motor, the pump and motor are precisely centered in the lantern. Alignment or re-alignment of the coupling is not required.

Note: Improper handling, e.g. during transportation, may impair the alignment between the pump and the motor. In this case the pump and the motor must be returned to the factory for checking.

5.4.3 Coupling alignment of special designed couplings (if used)

Refer to the operating instructions of the coupling manufacturer.

5.5 Assembly of pump and motor

If the aggregate is only assembled at the place of use, the coupling is assembled as follows:

1. Coat the pump and motor shaft ends with a fine film of molybdenum disulfide (e.g. Molykote) and insert keys.
2. Push on the coupling halves on the pump and motor side with the aid of a pusher device until the shaft end is flush to the coupling hub.
If no puller is available, heating the coupling halves to approx. 100°C (without rubber buffer) facilitates pushing.

ATTENTION Impacts to the components of the pump or motor must be avoided.

3. Tighten the grub screw on both coupling hubs.
4. When assembling the pump and motor, make sure the specified gap between the coupling halves is maintained (see our installation drawings).
5. In the case of horizontally mounted pump aggregates fixed on a base plate or directly on the foundation, the coupling must be aligned as described in Section 5.4.
In the case of pump aggregates with flanged motor, the coupling does not need to be re-aligned.

6. Mount the contact protection.



According to accident prevention regulations, the pump must only be operated with a protection against accidental contact.

5.6 Space required for maintenance and repair

ATTENTION The pump must be accessible from all sides in order to be able to carry out necessary visual inspections.

Adequate space must be provided for maintenance and repair work. It must also be ensured that all pipelines can be attached and removed without hindrance.

5.7 Laying the pipelines

5.7.1 Nominal widths

If possible, the nominal widths of the suction and pressure pipelines should be rated so that the rate of flow does not exceed a maximum of 1 m/s in the suction pipeline and 3 m/s in the pressure pipeline. If possible, suction pipelines laid "uphill" are to be avoided.

5.7.2 Change of cross-sections and directions

Sudden changes of cross-sections and directions, as well as hairpin bends, are to be avoided.

5.7.3 Supports and flange connections

The pipelines must be connected to the pump, stress-free. They must be supported close to the pump and must allow easy screwing-on to avoid twisting. When the connections are loosened the pipeline must neither be slanted nor springing, nor must it be under pressure.

Any thermal stresses occurring on the pipelines must be kept away from the pump by suitable means, e.g. installing compensators.

5.7.4 Cleaning pipelines prior to attachment

Prior to assembly, all pipeline parts and valves must be thoroughly cleaned; especially in the case of welded pipelines, burrs and welding beads must be removed. Flange gaskets must not protrude inwards. Blanking flanges, plugs, protective film and/or protective paint on flanges and seals must be removed completely. Water residues, still in the pipeline network from pressing-out or steeping for example, must be removed.

Delivery of water destroys the pump. The pump relies on the fluid being conveyed for its lubrication.

5.7.4.1 Inlet/suction conditions (NPSH)

To ensure fault-free continuous operation, the inlet and suction conditions of the plant must be appropriately adjusted to the pump demand (NPSHreq.)

The service condition is fulfilled when the plant NPSH value (NPSHavail.) is above the pump NPSH (NPSHreq.). The NPSHreq. is given in the characteristic sheets of the respective pumps

ATTENTION When pumping air-laden or volatile liquids, particular attention must be paid to the NPSH requirements of the plant.

5.7.5 Stop valves

Stop valves are to be installed in the suction and pressure pipelines close to the pump.

5.7.6 Pressure-relief valve

See Section 4.1 ...

5.7.7 Check valve

It is recommended to install a check valve between the pressure connection of the pump and the stop valve in order to prevent the pump from running dry when it is at a standstill and the pressure stop valve is open.

5.7.8 Vent valve

A vent valve must be provided at the highest point in the pressure pipeline.

5.7.9 Filtering

To protect the pump against coarse dirt contamination, we recommend as a matter of principle installing a filter in the suction pipeline, mesh width 0.6 mm.

Note: The service life of the pump is decisively influenced by the degree of dirt contamination of the fluid being conveyed, that is, by the number, size and hardness of the abrasive components.

5.7.10 Auxiliary pipelines (if present)

All auxiliary pipelines must be connected in accordance with the installation drawing, stress-free and sealed.

5.8 Safety and control devices**5.8.1 Manometers**

Suitable pressure gauges are to be installed in the inlet and pressure pipelines, and in the pressurized auxiliary pipelines.

5.8.2 Safety device in the pressure pipeline

ATTENTION For pumps delivered without a pressure-relief valve, an overload protection must be provided in the control, or a pressure-relief valve (return valve) in the pressure pipeline (see separate Operating Instructions).

5.9 Electrical connections

The power supply cables of the coupled drive motor must be connected by a trained electrician, according to the motor manufacturer's circuit diagram. The applicable VDE regulations and local power company rules must be observed.

Danger from electrical energy must be eliminated.

6 Start-up/Shutdown

6.1 Preparation for start-up

6.1.1 Filling the pump with fluid

ATTENTION Prior to initial operation, the screw pump must be filled with fluid and bled. This at the same time provides the spindles with the sealing required for suction.

The pump must not run dry.

ATTENTION Before filling, the operator must ensure careful and thorough rinsing of the pump if the fluid to be conveyed is not chemically compatible with the test medium (see performance test report).

The fluid is filled through a bore hole in the pump casing or via the pressure pipeline. The pump must be filled with fluid until the fluid emerges free from air.

In the case of immersion pump aggregates the filling level must ensure adequate covering of the inlet rim before and during operation.



During bleeding of the pump and the plant, hazardous or environmentally harmful fluid and gas emerging must be safely collected and discharged.

6.1.2 Control of drive motor direction of rotation

The direction of rotation of the motor must match the direction of rotation arrow on the pump. The motor can be briefly switched on with the suction and pressure valves open to check the direction of rotation. If the direction of rotation is wrong there is no pump suction. This damages the pump. The direction of rotation of the three-phase motor can be reversed by swapping any two phases.

ATTENTION If the direction of rotation is to be checked before the pump is filled with fluid, the drive motor must be disconnected from the pump. The pump must not run dry.

6.1.3 Switching on any auxiliary devices

Before switching on the pump, any additional devices (e.g. heating, cooling, quench system, pressure relief system) must be set in operation and must have reached the necessary flow/temperature and pressure values.

Note: Ensure that flow/temperature and pressure values are in accordance with the order data sheet or manufacturer's operating instructions!

6.2 Start-up

6.2.1 Starting

1. Prior to starting, the stop valves in the suction and pressure pipelines must be completely opened.
2. Where the pump is fitted with a pressure-relief valve, it is set on our test panel to respond 10% above the operating pressure. The opening pressure can be altered within narrow limits by means of

an adjusting screw. The installation of a pressure-relief valve is always required when an impermissible pressure rise is possible, due to a stop device or throttle point in the pressure pipeline for example. If the pressure-relief valve has a hand-wheel regulation, the pump can be started at zero pressure. For this, the pressure-relief valve must be completely opened using the hand-wheel. The starting torque of the motor is thereby reduced.

ATTENTION When starting and stopping the pump under pressure, make sure that the speed- and viscosity-dependent pressure load is not exceeded.

If this is not ensured, the pump must be started and stopped at zero pressure. This also applies to pumps with speed-controlled drive motors.

3. During starting, a vent valve installed on the outlet side of the plant must be opened until the air has escaped from the suction side of the pump. As soon as fluid emerges the vent valve can be closed. The pump is self-priming and is automatically vented without counter-pressure.
4. The fluid level in the tank must be checked. It must be ensured that, when the plant is running, the fluid level in the tank does not fall below the minimum limit. Top up fluid as necessary.

6.2.2 Drive

Switch on the motor.

Pay attention to product-specific characteristics. Refer to the operating instructions of the drive motor manufacturer.

6.2.3 Checking the delivery values

When the motor has reached its operating speed, the inlet pressure and outlet pressure of the pump must be checked using manometers.

For pumps fitted with a hand-regulated pressure-relief valve, the hand-wheel must be closed slowly beforehand, until the pump outlet pressure is reached.

The motor must not be overloaded. The current consumption can be checked with an ammeter. In this connection, the temperature and viscosity of the fluid must also be checked. The readings must be checked against the layout or acceptance test report.

ATTENTION If there should be an inadmissible increase in pressure, mounted pressure-relief valves may shift the media from the discharge to the intake side (recirculation).

Recirculation leads to heating up of the medium. An inadmissible pressure and temperature increase can be indicated by a pressure gauge and a thermometer. Determine the cause immediately and eliminate it in order to avoid damage to the pump as the result of excessive heating up and the related drop in viscosity.

6.3 Shutdown

6.3.1 Stopping and interrupting operation

1. Switch off the motor. Make sure the pump runs down smoothly and evenly.
2. If a check valve is installed in the pressure pipeline, the stop valve can remain open. If no check valve is fitted, the stop valve must be closed.
3. Stop any additional devices that are present (e.g. heating, cooling, quench system, etc.).

6.3.2 Measures in case of prolonged interruption

If a prolonged interruption is intended, the pump must be drained thoroughly via the connections on the pump casing. We recommend removing cartridge-unit pumps and immersion pumps from the tank or the plant.



Safe draining and environmentally compatible disposal of the fluid must be ensured.

Preservative should then be applied to the pump (see Section 3.3).

7 Maintenance/Repair

7.1 Maintenance

- The instructions in Section 2, *Safety*, must be observed in maintenance and repair work.
- Regular monitoring and maintenance of the pump and drive motor increases their service life.

The following instructions are generally applicable.

7.1.1 General monitoring

1. The pump must not run dry.
2. The drive motor must not be overloaded.
3. The suction and pressure pipelines must be checked for leaks. Air must be prevented from entering the delivery system.
4. Built-in stuffing boxes must drip slightly in operation. Mechanical seals must have no inadmissible leakage.
5. Pressure and temperature monitors must be observed.
6. Any additional devices on the pump/shaft seal must be operated and monitored in accordance with regulations.

7.1.2 Maintenance of components

7.1.2.1 Bearing and lubrication

The driving spindle is borne on a maintenance-free, grease-lubricated groove ball bearing.

The groove ball bearing of the screw pumps is designed for a service life of approx. 24,000 hours under normal operating conditions.

The actual service life may be reduced due to intermittent operation, high temperature, low viscosity, poorly lubricating fluids and the like. We therefore recommend checking the running noises and temperature in the bearing area at regular intervals.

If scraping or rattling noises are heard compared to the normal humming, or if excessive temperature rises are detected, this indicates impending bearing damage, and the groove ball bearing should be replaced as soon as possible.

In case of pumps with the design feature "D" and "KA", the groove ball bearing is provided with sealing washers on both sides and a life-time grease filling. The groove ball bearing is maintenance-free.

Pumps with special design feature "E" are fitted with a greasable groove ball bearing. The groove ball bearing and the bearing area in the bearing cover are adequately charged with grease at the factory. This groove ball bearing must be subsequently greased in accordance with the intervals below.

Rolling bearing greases

For the lubrication of the groove ball bearing, we recommend to use the below-listed rolling bearing greases or equivalent. The order of producers is no quality ranking.

Producer	Brand name	Designation to DIN 51825
Agip	Agip GR MU3	K3K-20
ARAL	Aralub HL3	K3K-20
BP	BP Energ grease LS3	K3K-20
ESSO	BEACON 3	K3N-30
Fuchs	RENOLIT FWA 220	K3N-20
Klüber	MICROLUBE GL 263	K3N-20
Mobil-Oil	Mobilux 3	K3K-20
Shell	Shell Alvania Fett R3	K3N-30
SKF	SKF-Fett LGMT3	K3K-30

In case of temperatures of the liquid pumped over 150 °C, the below-listed rolling bearing grease is to be used to increase the operating safety of the pump.

Producer	Brand name	Designation to DIN 51825
Klüber ①	AMBLYGON TA30/2	K2P-20

① Producer: KLÜBER, LUBRICATION MÜNCHEN KG
Geisenhausenerstr. 7
81379 München
Germany

If none of the listed rolling bearing greases is available, we recommend in any case a multi-purpose grease on lithium basis which corresponds to the above DIN designation.

Grease mixture with grease grades of different basic oils and thickeners leads to a reduction of the lubricating properties and must therefore be avoided.

Relubrication period

The relubrication period depends on the temperature of the pumped liquid and pump speed.

Temperat. of pumped liquid	Pump speed	every ... hours	at least every... month
< 100 °C	1450/1750 min ⁻¹	6000 h	6
	2900/3500 min ⁻¹	4000 h	4
> 100 bis 150 °C	1450/1750 min ⁻¹	2000 h	3
	2900/3500 min ⁻¹	700 h	1
> 150 °C	1450/1750 min ⁻¹	1200 h	2
	2900/3500 min ⁻¹	400 h	1

Grease quantity

The table below shows the allocation of the pump size to the groove ball bearing size with the grease filling in grams.

Pump size	Groove ball bearing Abbreviation	Grease quantity in grams
40	6304 J C3	8
80	6304 J C3	8
120	6305 J C3	12
210	6306 J C3	16
280	6307 J C3	18
440	6308 J C3	22
660	6309 J C3	30
940	6310 J C3	35
1300	6311 J C3	40
1700	6312 J C3	45

Relubrication

Relubrication is effected by means of a grease gun through the lubricating nipple (50) screwed in the bearing cover.

Relubrication must be continued for such a period of time until the old grease is displaced and fresh grease emerges at the groove ball bearing.

Horizontal foot pumps are fastened on a base plate with the coupled driving motor can be relubricated with the pump running.

Flange-mounted, cartridge-unit and plinth-mounted pumps with flange-connected fastening lantern can only be relubricated during standstill. For these purposes, the protection against accidental contact must be removed.

7.1.2.2 Shaft seal

The shaft is either sealed by the stuffing box or mechanical seal.

- **Stuffing box (Design KA2)**

Increased leakages, if any, at the stuffing box during the first operating hours normally disappear automatically during the running-in time. If necessary, slightly tighten hexagon nuts (39) at the gland (9). See to it that the stuffing box must be slightly dripping. Thus, the frictional heat generated at the sealing surface is dissipated.

If leakage losses increase excessively and if even repeated slight tightening of the hexagon nuts (39) does not result in any leakage reduction, the packing rings have lost their elasticity of shape and must be replaced.

- **Mechanical seal (Design D... or E...)**

An uncooled, maintenance-free mechanical seal will be installed which, in its mode of operation, corresponds to the requested operating conditions. Minimal dripping of non-volatile media resulting from the functioning of the components is to be expected. In the event of heavy leakage due to wear, the mechanical seal should be replaced.

ATTENTION Since the mechanical seal must not be allowed to run dry, the pump must only be started up when charged and bled.

7.1.2.3 Pressure-relief valve

Pressure-relief valves must be checked from time to time, in particular after prolonged downtimes, for passage and functioning. Leaking pressure-relief valves may cause damage to the pump. Damaged parts should be replaced or repaired as necessary.

Note: Operating instructions for pressure-relief valves should be ordered separately.

7.1.2.4 Coupling

The alignment of the coupling and the condition of the flexible elements in the coupling should be checked after initial start-up and at regular intervals.

Note: Worn flexible elements must be replaced.

7.1.2.5 Drive

Refer to the operating instructions of the motor manufacturer.

7.2 Repair (Dismounting and Mounting Instructions)**General**

Trained Service fitters are available on request to carry out mounting and repair work.



Where repairs are carried out by the operator's own personnel or by specialist fitters, it must be ensured that the pump is fully drained and cleaned.

This particularly applies to pumps which are sent for repair to our factory or one of our service workshops. We must refuse acceptance of repair work on pumps filled with fluid, for the protection of our staff and for environmental reasons. Otherwise we must invoice the customer/operator for the costs of environmentally compatible disposal.

Where repairs are to be carried out on pumps which have been operated with hazardous substances ① and/or environmentally harmful media, the customer/operator must inform its own personnel on site, or our personnel where repairs are returned to our factory or a service workshop, without being specifically requested to do so.

In such cases a verification of delivery material, for example in the form of a DIN safety data sheet, must be submitted to us together with the request for a Service fitter.

Alternatively, you can request a certificate of safety (form no. 448/191) from our Service department, filling it out truthfully, correctly and in full. Send the completed form to the center commissioned with carrying out the repair, or hand it to our Service fitter.

① **Hazardous substances are:**

- Toxic substances
- Health-endangering substances
- Corrosive substances
- Irritants
- Explosive substances
- Fire-inducing substances
- Highly flammable, easily flammable and normally flammable substances
- Carcinogenic substances
- Substances impairing fertility
- Genetically distorting substances
- Substances in other ways hazardous to humans



For all work on site, the operator's own personnel and/or our fitters must be advised of the possible dangers involved in the repair work.

The most important dismantling and mounting operations are described in these instructions. The mounting steps described in the individual sections must be consistently observed.

7.2.1 Dismounting the screw pump

Before dismantling, the following work must be carried out:



- The power supply cable must be disconnected from the motor by an authorized electrician. Electrical danger must be eliminated! The motor must be secured against being switched on.
- Close all stop devices in the inlet and delivery pipeline, and in the auxiliary pipelines.
- Drain the fluid in flowable condition from the pump.
Note: Use a collecting tank.



- Hazardous substances and/or environmentally harmful media must be drained off and collected such that no danger to life and limb is created. Environmentally compatible disposal must be ensured.
- The pump and any auxiliary systems must be depressurized and drained.
- Allow the pump and motor to cool to ambient temperature.
- Remove the manometer cables, manometers and retaining brackets.
- Remove the contact protection.
- Remove the motor from the base plate or pump bracket where appropriate.
Note: Use suitable lifting gear.
- Remove immersion pump aggregates from the tank.
- Remove supply/suction and pressure pipelines as appropriate.
- Dismount auxiliary pipelines, if any.
- Loosen the fastening and remove the pump from the base plate or pump bracket.
Note: Use suitable lifting gear.

7.2.1.1 Dismounting the shaft seal, Design KA2 Stuffing box

- Loosen grub screw at the coupling hub and withdraw coupling half from the shaft end (12). Use pull-off device!
- Remove key (41) from the driving spindle (12).
- Loosen hexagon nuts (39) at the gland (9), and push gland (9) against the groove ball bearing (34).

- Dismount packing rings (32) and junk ring (81) from the shaft sealing housing (5). Carefully clean stuffing box chamber.

7.2.1.2 Dismounting the shaft seal, Designs D12.1 and E12.1 – Mechanical seal

- Loosen grub screw at the coupling hub and withdraw coupling half from the shaft end (12). Use pull-off device!
- Remove key (41) from the driving spindle (12).
- Remove circlip (35) and spacer bush and/or labyrinth ring (16) from the driving spindle (12).
- Loosen socket-head cap screws (54) at the bearing cover (5), and screw out.
- By means of the forcing-off screws, force off bearing cover (5) from the pump cover, drive side (3), and dismount over the driving spindle (12).
Note: During forcing-off, the groove ball bearing (34) and the stationary seal ring (83) remain in the bearing cover (5).
Note: Particularly see to it that the bearing cover with stationary seal ring is pulled out concentrically and not canted to avoid damages to the stationary seal ring.
- Remove gasket (22) and clean sealing surfaces.
- By means of an auxiliary tool, dismount stationary seal ring (83) and O-ring from the bearing cover (5).
- Dismount rotating part of the mechanical seal (83) over the driving spindle (12).
- Dismount spacer ring (80) and junk ring (81).
Note: For pump sizes 40, 80 and 210, the spacer ring (80) is not required.

7.2.1.3 Dismounting the shaft seal, Designs D6.7 and E6.7 Mechanical seal

- Loosen grub screw at the coupling hub and withdraw coupling half from the shaft end (12). Use pull-off device!
- Remove key (41) from the driving spindle (12).
- Remove circlip (35) and spacer bush (16) from the driving spindle (12).
- Loosen socket-head cap screws (54) at the bearing cover (5), and screw out.
- By means of the forcing-off screws, force off bearing cover (5) from the pump cover, drive side (3), and dismount over the driving spindle (12).
Note: During forcing-off, the groove ball bearing (34) and the stationary seal ring (83) remain in the bearing cover (5).
Note: Particularly see to it that the bearing cover with stationary seal ring is pulled out concentrically and not canted to avoid damages to the stationary seal ring.
- Remove gasket (22) and clean sealing surfaces.

- By means of an auxiliary tool, dismount stationary seal ring (83) and O–ring from the bearing cover (5).
- Dismount rotating part of the mechanical seal (83) over the driving spindle (12).
- Dismount junk ring (81).

7.2.1.4 Dismounting the groove ball bearing

- Loosen grub screw at the coupling hub and withdraw coupling half from the shaft end (12). Use pull–off device!
- Remove key (41) from the driving spindle (12).
- Remove circlip (35) and spacer bush and/or labyrinth ring (16) from the driving spindle (12).
- Loosen socket–head cap screws (54) at the bearing cover (5), and screw out.
- By means of forcing–off screws, force off bearing cover(S) from the pump cover, drive side (3), and dismount over the driving spindle (12).
- Dismount circlip (37) from the bearing cover (5).
- By means of an appropriate tool, concentrically dismount groove ball bearing (34) from the bearing cover (5).
Note: In case of shaft seal design "KA2", previously remove gland (9).
- Dismount supporting washer (36).

7.2.1.5 Dismounting the set of spindles

Dismounting the set of spindles is effected following the dismounting of the shaft seal and the groove ball bearing (please refer to Sections 7.2.1.1 to 7.2.1.4 above).

- Following the dismounting of the shaft seal and the groove ball bearing (34), loosen socket–head cap screws (51), and dismount the cartridge–unit pump from the pump casing (1) towards the driving side. Use forcing–off screws!
Note: Not required for cartridge–unit pumps of series SME and SMEF without pump casing.
- Remove gasket (21) and clean sealing surfaces.
- Loosen socket–head cap screws (55), and dismount pump cover, drive side (3) over the driving spindle (12).
- Remove gasket (24), and clean sealing surfaces.
- Pull set of spindles consisting of driving spindle (12) and two idler spindles (13) with the balance bushes (8) out of the pump casing insert (2).
- Remove idler spindles (13) with the balance bushes (8) from the driving spindle (12).

7.2.2 Mounting the screw pump

ATTENTION

Before remounting check all parts for wear and, as necessary, replace with **original replacement parts**.

Clean all parts before mounting. Always fit new gaskets.

7.2.2.1 Mounting the set of spindles

- Insert new O–ring (29) in the groove of the pump casing insert (2).
- Push pump casing insert (2) with (balance) pipe (20) above into the pump casing (1).
Note: Not required for cartridge–unit pumps of series SME and SMEF without pump casing.
- Insert set of spindles consisting of driving spindle (12) and two idler spindles (13) with the balance bushes (8) in the pump casing insert (2). In doing so, oil set of spindles and bearing points.
Note: In the pump casing insert, the balance bushes (8) on the two idler spindles (13) are protected against torsion by means of the spring dowels (42). The groove in the balance bushes (8) must correspond to the position of the spring dowels (42) in the pump casing insert.
- Place new gasket (24) onto the cleaned sealing surface of the pump casing insert (2).
Note: Mind the bore holes in the balance bushes (8). Gasket must be congruent with the bore holes.
- Place new gasket (21) onto the cleaned sealing surface of the pump casing.
- By means of the two socket–head cap screws (55), fix pump cover, drive side (3) over the driving spindle (12) to the pump casing insert (2).
Note: Mount pump cover, drive side (3) so that the bore holes of the cover and balance bushes (8) are congruent.
- By means of the socket–head cap screws (51), fix pump cover, drive side (3) to the pump casing (1).
Note: Not required for cartridge–unit pumps of series SME and SMEF without pump casing.

7.2.2.2 Mounting the groove ball bearing

Note: In case of pumps with the design feature "KA" and "D", the groove ball bearing is provided with sealing washers on both sides and with a life–time grease filling. The groove ball bearing is ready for installation. Pumps with the design feature "E" are provided with a regreasable groove ball bearing. In case of remounting, the groove ball bearing and the bearing chamber in the bearing cover must be provided with a sufficient grease filling.

- Place new gasket (22) onto the pump cover, drive side (3).

- By means of the socket-head cap screws (54), fix bearing cover (5) with installed stationary seal ring (83) and O-ring to the pump cover, drive side (3).
Note: In case of shaft seal design with mechanical seal, mind exact positioning of the sliding surfaces! Slightly oil sliding surfaces with clean oil. In case of shaft seal design with stuffing box packing, previously fix gland (9) to the bearing cover (5).
- Slightly oil cleaned bearing seat in the fixed bearing cover (5) with clean oil.
- Mount supporting washer (36) over the driving spindle (12).
- By means of an appropriate pipe length and a mounting washer, press groove ball bearing (34) over the driving spindle (12) into the bearing cover (5).
Note: The mounting force must uniformly act on the side faces of the inner and outer bearing ring.
- Insert circlip (37) in the bearing cover (5) in front of the groove ball bearing (34).
- Mount spacer bush and/or labyrinth ring (16) over the driving spindle (12) in front of the groove ball bearing (34).
- Insert circlip (35) in the shaft keyway of the driving spindle (12).
- Mount key (41) in the driving spindle (12).
- Heat pump-side coupling half without rubber buffers to approx. 100°C and mount on the driving spindle (12).
- In case of pumps with the special design feature "E", grease groove ball bearing (34) and bearing chamber in the bearing cover (5) with the specified grease quantity.

For **relubrication** and **rolling bearing greases**, please refer to Section 7.1.2.1 above.

7.2.2.3 Mounting the shaft seal, Designs D12.1 and E12.1 – Mechanical seal

Mechanical seals are high-quality precision parts. Careful handling and extreme cleanliness during mounting are a condition of proper functioning. To facilitate mounting, an appropriate lubricant must be used (e.g. oil, no grease).

Note: In connection with the mounting of the mechanical seal, the bearing cover (5) must be mounted without groove ball bearing (34) at the pump cover, drive side (3). Dismounting of the groove ball bearing from the bearing cover (5) is described in Section 7.2.1.4 above.

- Mount junk ring (81) with spacer ring (80) in front of the shaft shoulder of the compensating piston of the driving spindle (12).
The spacer ring (80) is not required for pump sizes 40, 80 and 210.
Note: The specified number of junk rings (81) with or without spacer ring (80) must be mounted in order to achieve the assembly dimension "X".
The assembly dimension "X" depends on the pump size.

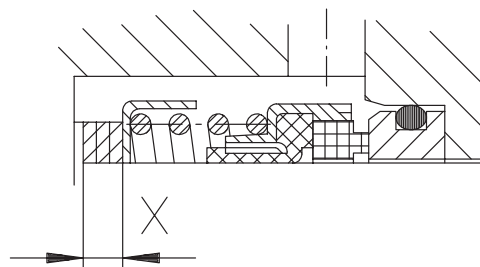


Fig. 5: Mechanical seal D12.1 and E12.1 with assembly dimension «X»

The table below shows the number of junk rings (81) and spacer rings (80) to be installed and their dimensions as well as the resulting dimension "X" depending upon the pump size.

Pump size	Junk ring (81) Quantity Dimension [mm]	Spacer ring (80) Quantity Dimension [mm]	Dimension »X« [mm]
40	1 piece Ø 25/35x12,2	–	12,2
80	1 piece Ø 25/35x12,2	–	12,2
120	1 piece Ø 30/42x11,5	1 piece Ø 30/46x3,5	15,0
210	5 pieces Ø 35/45x2,5	–	12,5
280	1 piece Ø 40/52x12,5	1 piece Ø 40/60x5,5	18,0
440	1 piece Ø 45/58x12	1 piece Ø 45/65x7	19,0
660	1 piece Ø 50/66x20	1 piece Ø 50/66x4,5	24,5
940	2 pieces Ø 55/68x3	1 piece Ø 55/72x17,5	23,5
1300	1 piece Ø 60/78x18	1 piece Ø 60/78x9,5	27,5

- Concentrically press stationary seal ring (83) with new O-ring into the cleaned bearing cover (5).
- Push spring and valve spring plate of the rotating part of the mechanical seal onto the driving spindle (12).

- Coat location hole of the rotating part of the mechanical seal with a lubricant (oil, no grease). Push rotating seal ring, casing, retaining ring and profile washer onto the driving spindle (12) until a contact with the spring is achieved without pre-tensioning the spring.
- Place new gasket (22) onto the cleaned sealing surface of the pump cover, drive side (3).
- By means of the socket-head cap screws (54), fix bearing cover (5) without groove ball bearing with installed stationary seal ring to the pump cover, drive side (3).
Note: Mind exact positioning of the sliding surfaces! The sliding surfaces must not be damaged. Slightly oil sliding surfaces with clean oil.
- Loosen socket-head cap screws (54) to some degree, and slightly untension bearing cover (5) with the stationary seal ring once again from the assembly position to check the axial flexibility of spring and mechanical seal.
Note: As the profile washer of the mechanical seal is relatively soon sucked on the driving spindle, finish mounting of the mechanical seal should be effected within a short period of time after mounting commencement.
- By means of the socket-head cap screws (54), firmly screw bearing cover (5) to the pump cover, drive side (3).
- Install groove ball bearing (34) as described under Section 7.2.2.2 above.
- Mount key (41) in the driving spindle (12).
- Heat pump-side coupling half without rubber buffers to approx. 100°C, and mount on the driving spindle (12).

7.2.2.4 Mounting the shaft seal, Designs D6.7 and E6.7 Mechanical seal

Mechanical seals are high-quality precision parts. Careful handling and extreme cleanliness during mounting are a condition of proper functioning. To facilitate mounting, an appropriate lubricant must be used (e.g. oil, no grease).

Note: In connection with the mounting of the mechanical seal, the bearing cover (5) must be mounted **without** groove ball bearing (34) at the pump cover, drive side (3). Dismounting of the groove ball bearing from the bearing cover (5) is described in Section 7.2.1.4 above.

- Mount junk ring (81) in front of the shaft shoulder of the compensating piston of the driving spindle (12).
Note: The specified number of junk rings (81) must be mounted in order to achieve the assembly dimension "X".
The assembly dimension "X" depends on the pump size.

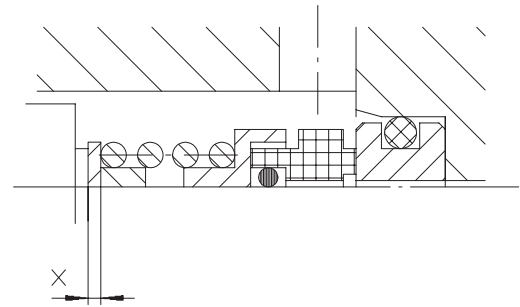


Fig. 6: Mechanical seal 6.7 and E6.7 with assembly dimension «X»

The table below shows the number of junk rings (81) to be installed and their dimensions as well as the resulting dimension "X" depending upon the pump size.

Pump size	Junk ring (81) Quantity Dimension [mm]	Dimension »X« [mm]
40	1 piece Ø 25/40x5,2	5,2
80	1 piece Ø 25/40x5,2	5,2
120	1 piece Ø 30/42x11,5	11,5
210	2 pieces Ø 35/45x2,5	5,0
280	1 piece Ø 40/52x12,5	12,5
440	1 piece Ø 45/58x12	12,0
660	1 piece Ø 50/68x20	20,0
940	3 pieces Ø 55/68x3	9,0
1300	1 piece Ø 60/78x18	18,0

- Concentrically press stationary seal ring (83) with new O-ring into the cleaned bearing cover (5).
- Mount rotating part of the mechanical seal consisting of rotating seal ring, intermediate ring, spring, slotted ring and O-ring over the driving spindle (12).
Note: The slotted ring must be pushed against the junk ring (81).
- Place new gasket (22) onto the cleaned sealing surface of the pump cover, drive side (3).
- By means of the socket-head cap screws (54), fix bearing cover (5) **without** groove ball bearing with installed stationary seal ring to the pump cover, drive side (3).
Note: Mind exact positioning of the sliding surfaces! The sliding surfaces must not be damaged. Slightly oil sliding surfaces with clean oil.
- Install groove ball bearing (34) as described under Section 7.2.2.2 above.

- Mount key (41) in the driving spindle (12).
- Heat pump–side coupling half without rubber buffers to approx. 100°C, and mount on the driving spindle (12).

7.2.2.5 Mounting the shaft seal, Design KA2 Stuffing box

- Bend up four new packing rings (32) in axial direction.
- Mount one packing ring (32) over the driving spindle (12) in the cleaned stuffing box chamber of the bearing cover (5). In case of pump size 40, install two packing rings (32).
- Mount junk ring (81) in the stuffing box chamber of the bearing cover (5).
- Mount the other three packing rings (32) over the driving spindle (12) in the stuffing box chamber of the bearing cover (5). In doing so, carefully rebend packing rings in annular shape. The kerfs of the individual packing rings are to be staggered.

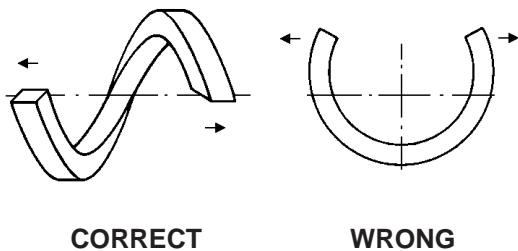


Fig. 7: Bending–up of the packing rings

- Push gland (9) over the driving spindle (12) into the bearing cover (5), and turn hexagon nuts (39) onto the stud bolts and/or eyelet bolts (38).
- Uniformly tighten hexagon nuts (39) at the gland (9) until when turning the driving spindle (12) by hand, a frictional resistance is felt.
- Loosen hexagon nuts (39) again, and thereafter, slightly tighten.
- Mount key (41) in the driving spindle (12).
- Heat pump–side coupling half without rubber buffers to approx. 100°C, and mount on the driving spindle (12).

When the screw pump has been mounted the following work must be carried out:

- Align coupling if necessary (see Section 5.4).
- Attach supply/suction and pressure pipelines.
- Attach auxiliary pipelines of the additional devices, if any.
- Attach manometer lines, manometers and brackets to pump.
- Install immersion pump aggregate in the tank.
- Attach contact protection.
- The power supply cable must be connected to the motor by an authorized electrician. Electrical danger must be eliminated! Pay attention to direction of rotation.
- Fill pump with fluid.



Start up pump as per instructions in Section 6.

7.3 Replacement parts/spare parts

The parts marked in the parts list can be provided as replacement/spare parts. The drive spindle (12) and idler spindles (13) are available only as a complete spindle set.

However, for operational safety reasons, we recommend you always stock a complete cartridge–unit or standby pump.

The advantage is that in the event of a fault or damage the standby unit can replace the non–functioning unit quickly and without great effort.

When ordering spare and replacement parts, besides the **part number, denomination** and **quantity**, the following should also be quoted:

Pump abbreviation,
Pump number,
Year of construction.

This information is engraved on the name plate of the pump.

8 Operating Faults, Causes and Remedial Action

8.1 Faults with reference number for cause and remedial action

The table below is intended as a guide to identifying faults and their possible causes. Faults relating to the pressure-relief valve are listed separately.

If faults occur which are not listed here, or which cannot be traced back to the listed causes, we recommend consulting the factory, or one of our branch offices or sales offices.



The pump must be depressurized and drained when faults are being rectified.

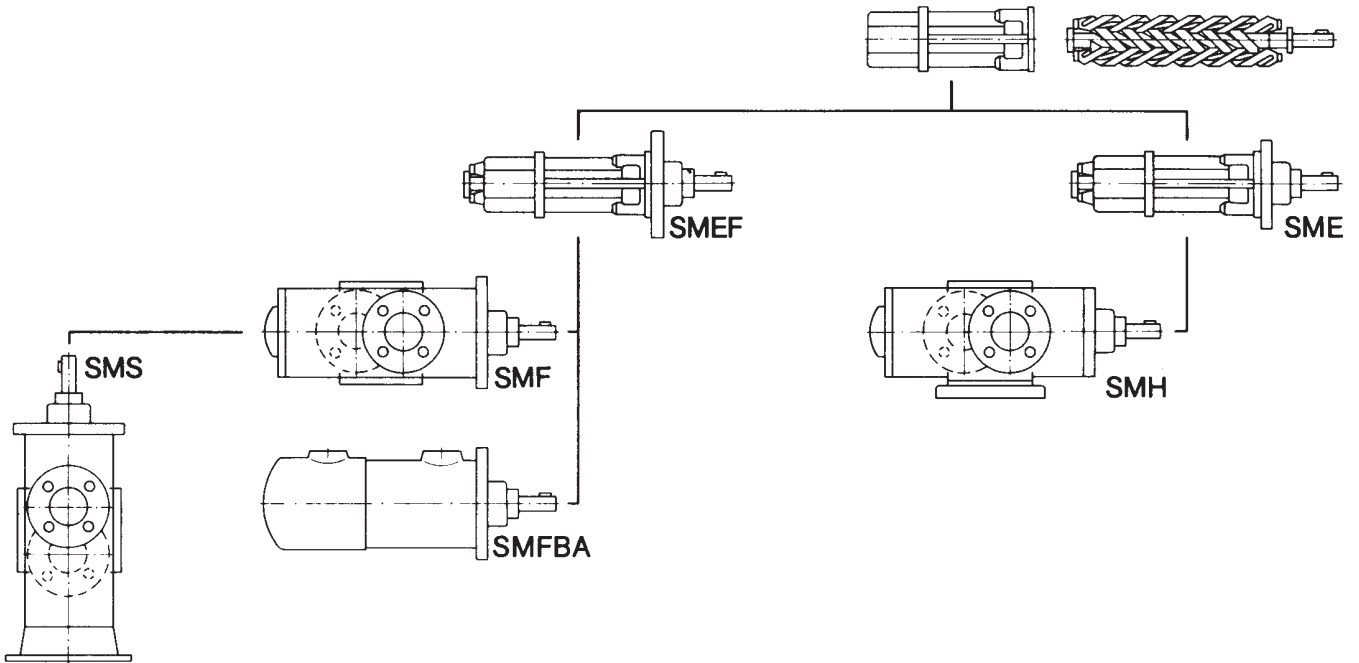
Screw pump faults	Reference numbers for cause and remedial action
No pump suction and no delivery	1, 2, 3, 4, 5, 11
Delivery too low	2, 6, 7, 8, 9, 10, 11
Pump operates noisily	4, 5, 6, 7, 8, 10, 11, 12, 13
Irregular delivery	6, 7, 10
Pump gets too warm	6, 7, 11, 14, 16
Pump is seized	14, 15, 16
Motor overload	6, 13, 14, 15, 16
Pressure-relief valve faults	Reference numbers for cause and remedial action
Delivery pressure drops	17
Pressure-relief valve does not open	18
Pressure-relief valve does not close	19
Pressure-relief valve knocks	20

8.2 Causes and remedial action

Ref. no.:	Cause	Remedial action
1	Pump not filled with fluid before initial operation.	Fill pump with fluid.
2	Stop valves/sliders not open or only partially open.	Fully open stop valves/sliders during operation.
3	Motor direction of rotation wrong.	The direction of rotation of the motor must match the direction of rotation arrow on the pump. The direction of rotation can be reversed by swapping any two phases.
4	Suction pipeline or shaft seal leaky.	Retighten flange screw connections. Check shaft seal.
5	Air in suction and pressure system.	Open vent valve on pump pressure side until air has escaped. Close valve again.
6	Wrong fluid viscosity.	Check that viscosity matches entries in acceptance test report. In case of zero-pressure delivery of low-viscosity fluids, apply 1 to 2 bar to pump.
7	Pressure-relief valve leaking.	Check pressure-relief valve for passage. If necessary, regrind valve seat and/or exchange valve cone.
8	Geodetic suction head too high.	Check underpressure on suction side using connected pressure/vacuum gauge. Increase fluid level in tank, lower pump.
9	Motor speed too low.	Check speed and current consumption of motor. Check voltage and frequency against motor rating plate.
10	Air separating time in operating tank too short.	Provide better air separation in operating tank. Return lines must emerge below oil level of tank.
11	Fluid level in tank too low.	Fill tank to necessary fluid level.

12	Flow rate in suction and pressure pipelines too high.	Flow rate in suction pipeline must not exceed max. 1 m/s, and in pressure pipeline max. 3 m/s.
13	Motor speed too high.	Check speed and current consumption. Check voltage and frequency against motor rating plate.
14	Delivery pressure too high.	Set specified delivery pressure via pressure-relief valve. Pump outlet pressure must not be exceeded.
15	Foreign bodies in pump.	Dismantle pump, remove foreign bodies and smooth damaged points with oilstone. Check suction filter and strainer.
16	Damaged ball bearing.	Replace ball bearing.
17	Pressure spring fatigued.	Install new pressure spring.
	Valve seat leaking.	Install new valve cone.
18	Pressure spring heavily pre-tensioned.	Release pressure spring using adjusting screw, and reset to required pressure.
	Valve cone stuck in valve housing.	
	a) Due to foreign body or	Dismantle pressure-relief valve. Clean internal parts.
	b) Operating temperature of plant substantially higher than quoted on order.	Consult factory.
19	Pressure spring not pre-tensioned, or insufficiently pre-tensioned.	Turn adjusting screw to right until required operating pressure is reached.
	Valve seat leaking.	Rework or replace valve cone and valve housing.
20	Pressure-relief valve knocking.	Check overpressure with pressure valve closed. Reset valve. Opening pressure 10 % above operating pressure.

Modular principle



The pumps of series **SMF**, **SMFBA** and **SMS** are not represented as same differ only in the type of installation or the casing design.

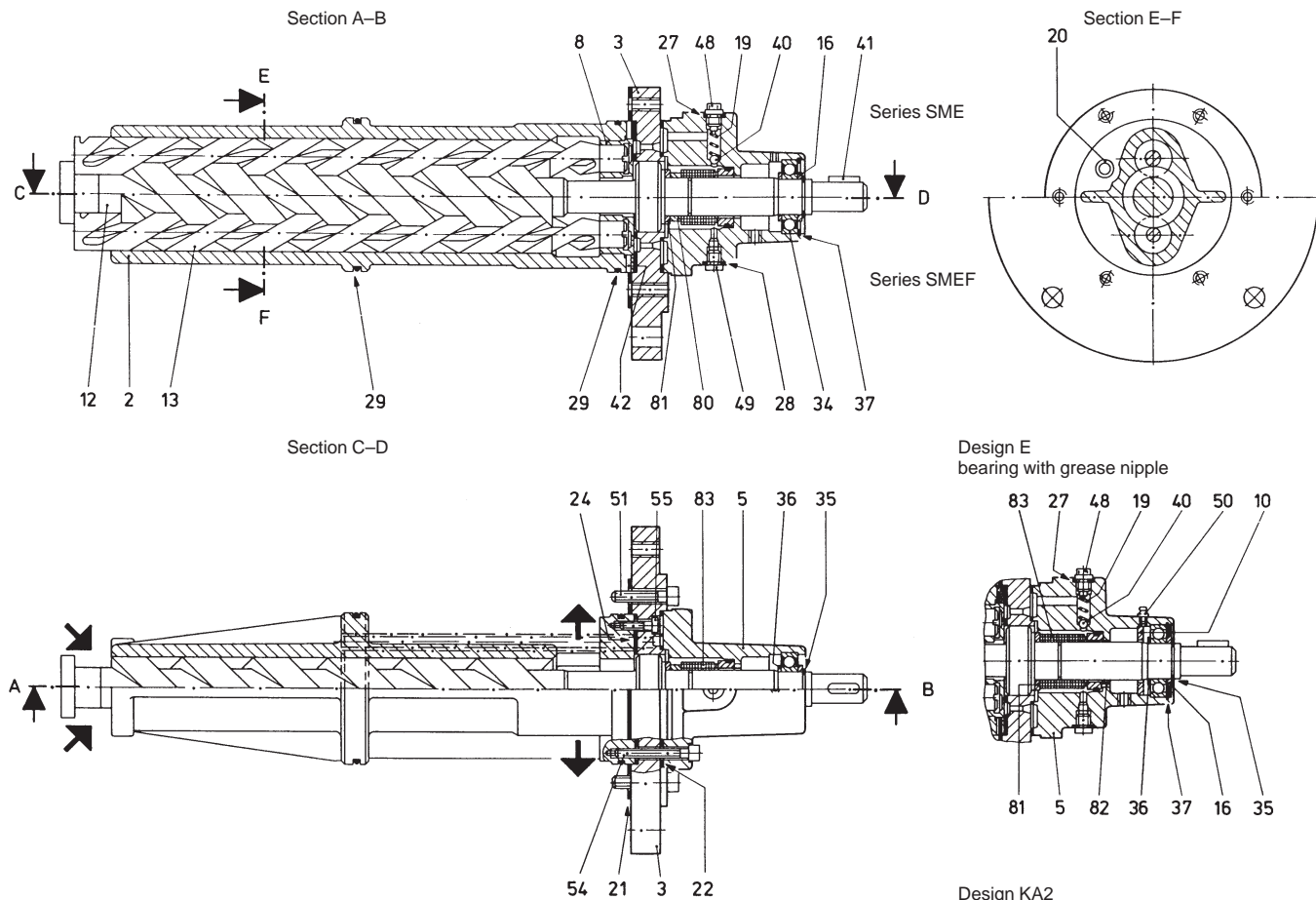
Sectional drawing

SME..., SMEF... – cartridge unit,

external ball bearing, with mechanical seal, design D... and E...

external ball bearing, with stuffing box, design KA2

Design D...



Part No.	Denomination
2 ①	Pump casing insert
3	Pump cover, drive side
5	Bearing housing
8 ①	Balance bush
9	Gland
10	Greasing chamber disc
12 ①	Driving spindle
13 ①	Idler spindle
16	Spacer bush
	Labyrinth ring (only with design E)
19	Valve spring
20	Balance pipe
21 ①	Gasket
22 ①	Gasket
24 ①	Gasket
27 ①	Joint washer
28 ①	Joint washer
29 ①	O-ring
32 ①	Gland packing ring
34 ①	Groove ball bearing
35	Circlip
36	Supporting washer
37	Circlip
38	Stud bolt (with pump size 40 to 210)
	Eyelet bolt (with pump size 280 to 1300)
39	Hexagon nut
40	Ball valve
41	Key
42	Spring dowel

Part No.	Denomination
48	Stop screw
49	Screw plug
50	Lubricating nipple
51	Socket-head cap screw
54	Socket-head cap screw
55	Socket-head cap screw
80	Spacer ring
81	Support ring
83 ①	Mechanical seal

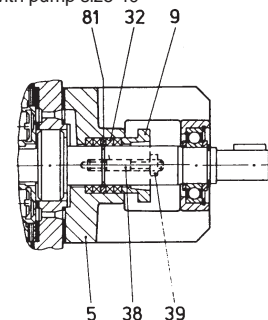
① Replacement parts/Spare parts

Design KA2

* Up to size 210 with stud bolt (38).
 Pump size 280 to 1300 with eyelet
 bolt (38) and spring dowel (82)
 (not shown in the drawing)

Design KA2

with pump size 40

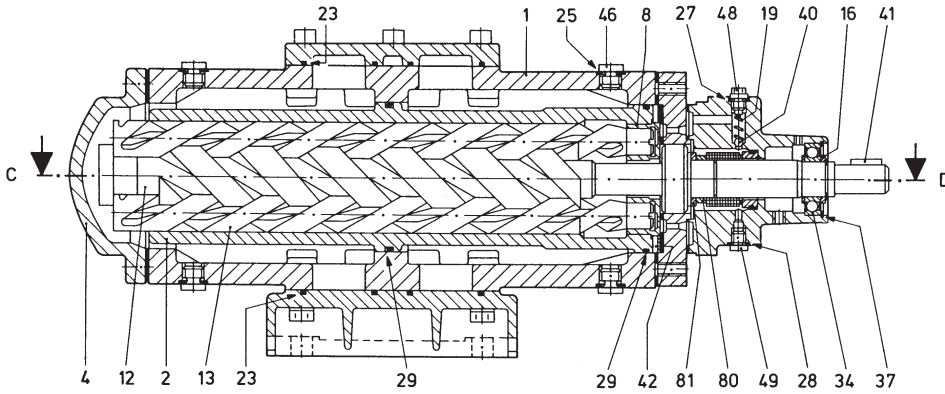


Sectional drawing

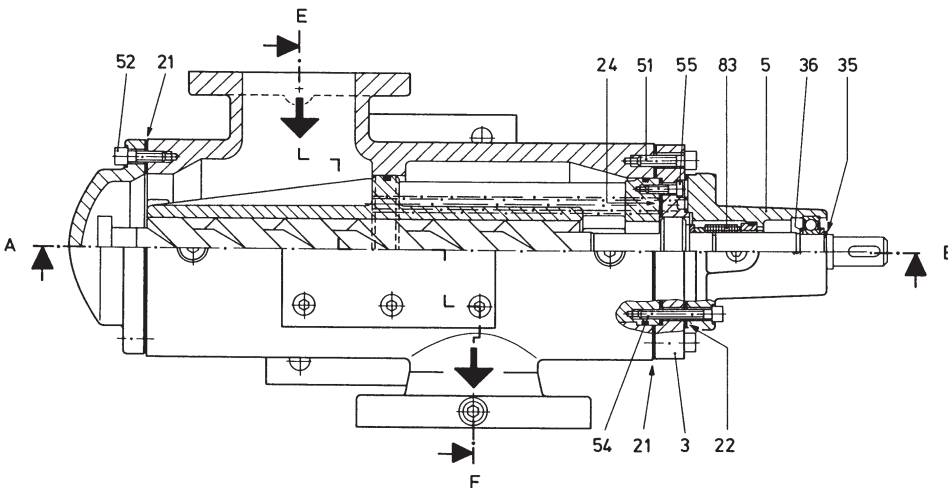
SMH... – horizontal foot pump, external ball bearing, with mechanical seal, design D... und E...
 external ball bearing, with stuffing box, design KA2

Design D...

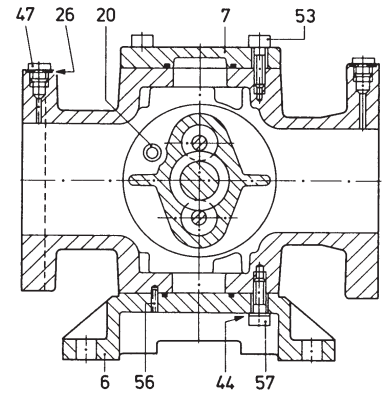
Section A–B



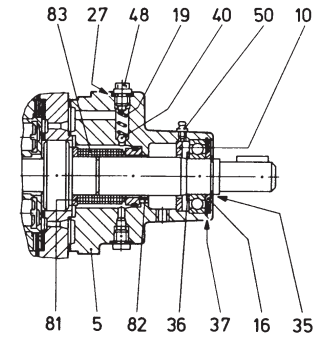
Section C–D



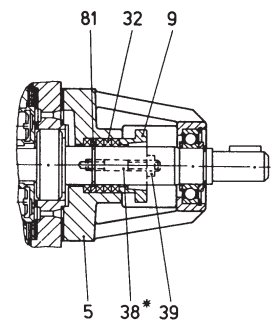
Section E–F



Design E...
bearing with grease nipple

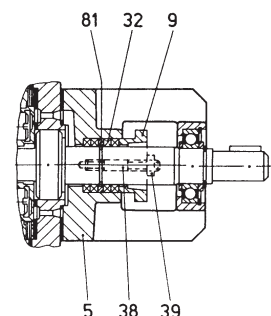


Design KA2



* Up to size 210 with stud bolt (38).
 Pump size 280 to 1300 with eyelet bolt (38) and spring dowel (82)
 (not shown in the drawing)

Design KA2
with pump size 40



Part No.	Denomination
1	Pump casing
2 ①	Pump casing insert
3	Pump cover, drive side
4	Pump cover, non-drive side
5	Bearing housing
6	Pump foot
7	Pump casing cover
8 ①	Balance bush
9	Gland
10	Greasing chamber disc
12 ①	Driving spindle
13 ①	Idler spindle
16	Spacer bush
19	Labyrinth ring (only with design E)
20	Valve spring
21 ①	Balance pipe
22 ①	Gasket
23 ①	Gasket
24 ①	Gasket
25 ①	Joint washer
26 ①	Joint washer
27 ①	Joint washer
28 ①	Joint washer
29 ①	Joint washer
32 ①	O-ring
34 ①	Gland packing ring
35 ①	Groove ball bearing
36	Circlip
36	Supporting washer

Part No.	Denomination
37	Circlip
38	Stud bolt (with pump size 40 to 210)
39	Eyelet bolt (with pump size 280 to 1300)
40	Hexagon nut
41	Ball valve
41	Key
42	Spring dowel
44	Lock washer
46	Screw plug
47	Screw plug
48	Stop screw
49	Screw plug
50	Lubricating nipple
51	Socket-head cap screw
52	Socket-head cap screw
53	Socket-head cap screw
54	Socket-head cap screw
55	Socket-head cap screw
56	Spring dowel
57	Hexagon screw
80	Spacer ring
81	Support ring
82	Spring dowel
83 ①	Mechanical seal
①	Replacement parts/Spare parts

Heating – not valid for fabricated Design

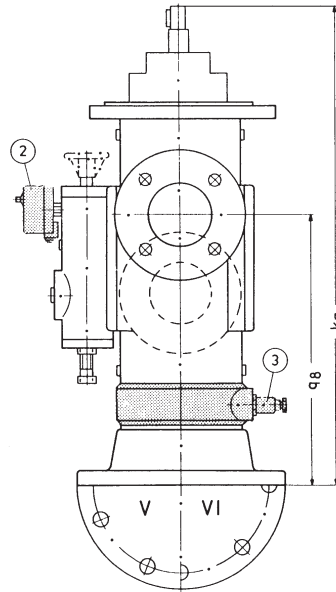
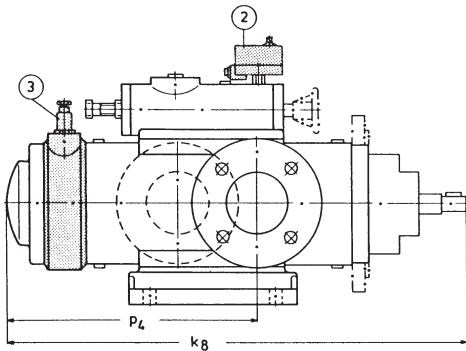
Series SMH, SMF, SMS,

Design ...E = with heating elements for electrical heating
 Design ...P = with heating cartridge for steam or heat conveyors
 Design ...X = with heating cover for steam or heat conveyors

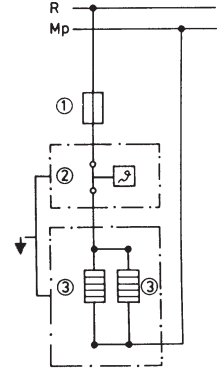
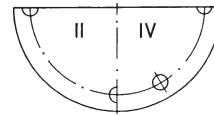
Design ...E (with 2 heating elements, electric)
 SMH/SMF 40 bis 1300

SMS 40 bis 1300

Wiring diagram



Screw arrangement at pump foot
 II = SMS 40
 IV = SMS 80 to 210
 V = SMS 280 to 940
 VI = SMS 1300

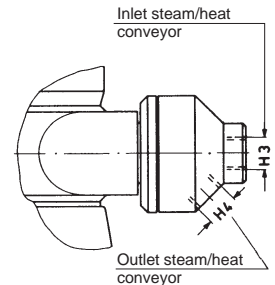
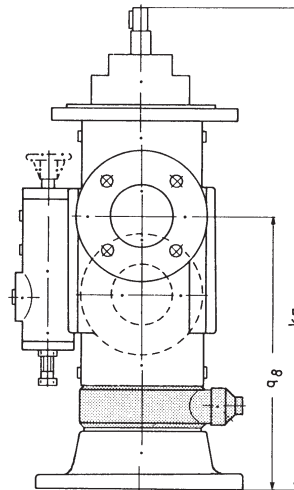
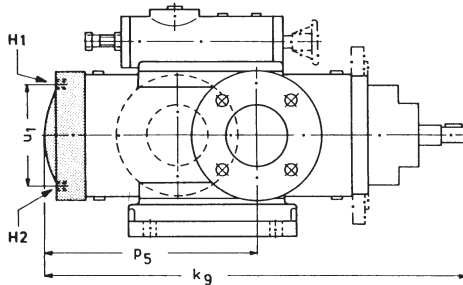


- ① Fuse
- ② Thermostat (control range 0 up to 150 °C)
- ③ Heating elements 220 V, 50 Hz

Design ...X (with heating cover)
 SMH/SMF 40 to 1300

Design ...P (with 2 heating cartridges, steam/heat conveyor)
 SMS 40 to 1300

Connection – cartridge




Dimensions in mm
 Alteration of dimensions reserved

Pump size	Pump dimensions ④							Heating steam/heat conveyor		Total heating capacity (2 elements) W	Heating (electrical)				Heating up time of pump in minutes at Δt =			
	k7	kg	kg	p4	p5	q8	u1	H1/H2	H3/H4		Heating elements 220 V, 50 Hz				25 °C	50 °C	75 °C	100 °C
											Length	Ø	Con- nection	Key width				
40	546,5	524,5	484	274,5	234	296,5	100	G 1/4	G 3/8	240	130	20	G 3/4	32	60	120	240	320
80	631,5	603,5	567	315,5	278	342,5	120	G 1/4	G 3/8	260	150	20	G 3/4	32				
120	718,5	699,5	631	339,5	271	358,5	145	G 1/4	G 3/8	300	170	20	G 3/4	32				
210	795,5	792,5	748	404,5	360	407,0	170	G 1/4	G 1/2	420	190	25	G 1	41				
280	978,5	868,0	800	466,0	398	576,5	175	G 3/8	G 1/2	460	210	25	G 1	41				
440	1028	954,0	921	497,0	464	571,0	200	G 3/8	G 1/2	460	210	25	G 1	41				
660	1141	1101	1050	551,0	500	591,0	225	G 3/8	G 1/2	680	240	32	G 1 1/4	60				
940	1279	1240	1176	709,0	645	748,0	244	G 3/8	G 1/2	880	250	40	G 1 1/2	60				
1300	1380	1326	1260	771,0	705	825,0	265	G 1/2	G 1/2	1000	280	40	G 1 1/2	60				

④ Further dimensions see dimensions leaflet VM 618/... 2000 for SMH, VM 618... 2001 for SMF, VM 618... 2002 for SMS.

Subject to technical changes.

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