

# Instruction and Maintenance Manual

Internal Gear Pumps  
Type R

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Pump No.

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- Original -

## A. Declaration of conformity

We hereby declare that the internal gear pumps type **R** comply with the following relevant requirements:

⇒ EC Machinery Directive 2006/42/EC, Appendix II A.

Pumps **without a drive unit** are intended to be connected to other machines. It is forbidden to start-up the machine in which the pump is installed if the machine has not been declared conform to the above named EC Directives.

By pumps **with a drive unit** that are modified and/or are not used for the purpose intended, will render null and void the validity of this declaration of conformity.

The following standards have been found helpful and have been used in their entirety or in part:

- ⇒ EN 809:2009
- ⇒ EN 12100-1:2003
- ⇒ EN 12100-2:2003
- ⇒ EN ISO 14121-1:2007

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## B. Introduction

### 1. Introduction

- 1.1 The instruction manual contains important information on how to operate the pump safely, properly and most efficiently. Observing these instructions helps to avoid danger, to reduce repair costs, downtimes and to increase the reliability and life of pump.
- 1.2 The operating instructions must always be available wherever the pump is in use.
- 1.3 The operating instructions must be read and applied by any person in charge of carrying out work on the pump.
- 1.4 Observe the mandatory rules and regulations for accident prevention and environmental protection in the country and place of use of the pump. The generally recognized technical rules for safe and proper working must also be observed.
- 1.5 It is presumed that fundamental project work as well as all work with regard to transport, assembly, installation, start-up, maintenance and repair is performed by qualified personnel or supervised by skilled labor taking overall responsibility.

### 2. Safety

- 2.1 A pump that is installed incorrectly, operated wrongly, or maintained poorly can present a hazard. If the following considerations are overlooked, the safety of personnel or satisfactory operation of the pump may be endangered.
- 2.2 Attention must be given to the safe handling of all items. Where pumps, pump units or components weigh in excess of 20 kg (44 lb.), it is recommended that suitable lifting equipment should be used in the correct manner to ensure that personal injury or damage to pump components does not occur.

<b>WARNING</b> Note that lifting eyes fitted to individual pieces such as pump and motor are designed to lift only this part and not the complete assembly.
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- 2.3 Before starting to dismantle a pump all relevant and appropriate safety precautions must be taken, particularly if the pumps have been handling hazardous or toxic products. Seek advice from your safety officer or the manufacturer if you have any doubts.
- 2.4 Always wear adequate protective clothing and eye protection when dismantling pumps that have been used to pump toxic or hazardous products. Breathing apparatus may be necessary.
- 2.5 Always isolate the pump electrically before dismantling. Ensure that the electrical switch gear cannot be operated whilst any work is being carried out on the pump.
- 2.6 Always drain the pump casing of product before removing the pump from its associated pipe-work.
- 2.7 Flush out the pump casing and shroud with a compatible flush and drain away to a safe area.
- 2.8 Check with your process people to see if any special decontamination procedures have to be followed before working on a pump.
- 2.9 All pumps returned for factory servicing must be decontaminated and labeled to inform what precautions should be taken before dismantling.

### 3. Shipment inspection

- 3.1 Pumps and units are shipped suitably protected to prevent damage in transit from normal handling. When received, the shipment should be inspected immediately. Damages to the packaging or crating that may reveal content damages when unpacked should be reported to the carrier and possibly photographed.
- 3.2 A photograph is helpful in any claims to be made against the carrier. Inform manufacturer or the local authorized distributor, too.

- Original -

- 3.3 Shipment shortages, checked against the transport documents, should be reported to the carrier.
- 3.4 Check the nameplate data against the shipping papers and against your purchase order to ensure that the proper pump is provided.

#### 4. Storage

- 4.1 After receipt and inspection, a pump not immediately installed should be repackaged and placed in suitable storage.
- 4.2 Protective coatings on unpainted surfaces should be inspected and left intact. Unpainted surfaces, not factory treated with a rust inhibiting coating, should have a protective coating applied.
- 4.3 Plastic or gasket type port covers should be left in place.
- 4.4 Pumps should be stored in a clean, dry location. When moist, dusty atmosphere must be used for storage, further protect the pump with a moisture repellent cover.
- 4.5 If the pump has been used please empty the pump casing by opening the clean-put cover or plug and fill with some corrosion inhibiting oil.

#### 5. Pump description

- 5.1 R pumps are internal gear rotary pumps suitable for pumping liquids of any viscosity. Special versions can also pump liquids containing abrasive objects.
- 5.2 Pumps are self-priming and work on suction lifts up to a maximum of 8 meters water column. The suction lift is limited by fluid vapor pressure or by low viscosity.
- 5.3 The gear within a gear working principle produces a smooth, non pulsating flow.
- 5.4 Pumps have only one shaft seal.
- 5.5 The axial position of the rotor can be adjusted without removing the pump.
- 5.6 Pumps are reversible. Full capacity is obtained in either directions of rotation.

<p><b>WARNING</b> If the pump is fitted with a safety valve, the cover, with the adjusting screw, must be on the suction port side. If the direction of pump rotation has to be reversed, the safety valve must also be inverted by losing the 4 screws of the valve. <b>THIS IS NOT POSSIBLE FOR CHOCOLATE OR MAGNETIC PUMPS!</b> Please contact your pump partner for alternatives.</p>
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- 5.7 Pumps are supplied with a bearing housing suitable for coupling with V-belts or flexible couplings.
- 5.8 Pumps are identified by the type and the serial number. The pump model is stamped on a nameplate fixed on the bearing housing. The serial number is punched on the pump casing, close to the nameplate.

## C. Operating instructions

### 1. Installation

- 1.1 Pumps are supplied with an internal protective liquid. If this liquid can pollute the product being pumped, flush the pump before installation.

**WARNING** Pumps must never be tested with water as they can be damaged.

- 1.2 Install the pump on a level surface as close as possible to the level of the liquid to be pumped, in an accessible position for maintenance and operation.
- 1.3 The diameter of the suction line should be at least equal to that of the pump suction port. The length of the suction line should be as short as possible. Avoid curves, constrictions and valves as far as possible. Liquefied gases can be pumped only on flooded suction.
- 1.4 To easily mount the pump it can be necessary to change the connecting pipe. It is necessary to loosen the screws on the rear cover and rotate the casing. For the right safety valve position see section C.2.4, Start the motor and check the direction of rotation. See Figure 1., page 6. To invert the safety valve, loosen the 4 screws of the valve and install it back to front.

**WARNING** The casing of chocolate or magnetic pumps must never be rotated. This action can damage the pump. Please ask to your pump partner for alternative operations.

- 1.5 It is advisable to fit a filter in the suction line near the suction port to protect the pump from foreign bodies, welding scarves, flakes of iron, etc. which can damage the pump.
- 1.6 The size of the delivery line must be calculated to reduce friction losses. High pressures may reduce the pump life especially if the liquid contains abrasive impurities.
- 1.7 Ensure that pipes are clean in order to prevent overpressures to the pump casing. Check the alignment of the flexible coupling.
- 1.8 If a non-return valve is fitted in the delivery line and a pressure higher than 2 bar is applied, the pump cannot self-prime because the air expelled from the pump cannot escape through the non-return valve. In this case fit an exhaust vent between the pump and the valve.
- 1.9 Safety valves (by-pass), available on request, are designed primarily to protect the pump casing and the piping against damage if the pump runs with closed or clogged delivery line. If the pump is used in both directions, double safety valves are also available.

**WARNING** Safety valves must not be considered as flow regulation valves. To change the pump capacity use either a variable speed drive or an external by-pass line.

- 1.10 Pumps supplied with a heating jacket can be heated with steam (max. pressure 10 bar) or with heat transfer oil up to 250 °C. If pumps have more than one heating jacket, they can be connected in series or in parallel.
- 1.11 It is suggested to install a vacuum and a pressure gauge near the suction and the delivery flanges. Pumps are provided with connections to this purpose. Vacuum and pressure gauges help to find possible causes of problems either in the pump or in the unit.
- 1.12 Electric motors must be protected by adequate overload cutoff switches that should be set to +10% with respect to the maximum current shown on the motor nameplate. Ensure that the surroundings are adequately ventilated (see the instructions of the motor producer).
- 1.13 Check that pipe threads, flange gaskets and quick couplings are completely airtight. If necessary, seal them with grease.

### 2. First start-up

- 2.1 Before the first start-up, it is suggested to pour some liquid into the pump casing to help self-priming.
- 2.2 Check by hand that the pump can rotate freely. In case of pumps with packing seal, the screws of the packing gland must be loosen before.
- 2.3 Check that all valves in the suction and delivery line are open.

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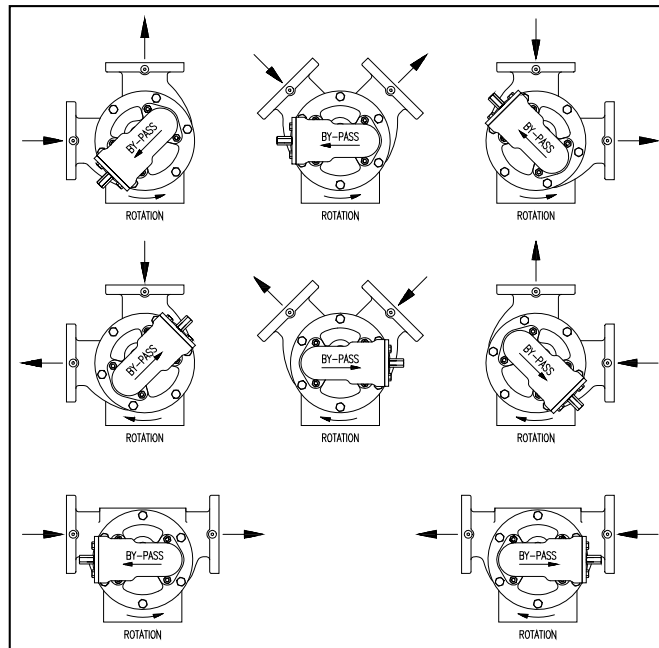
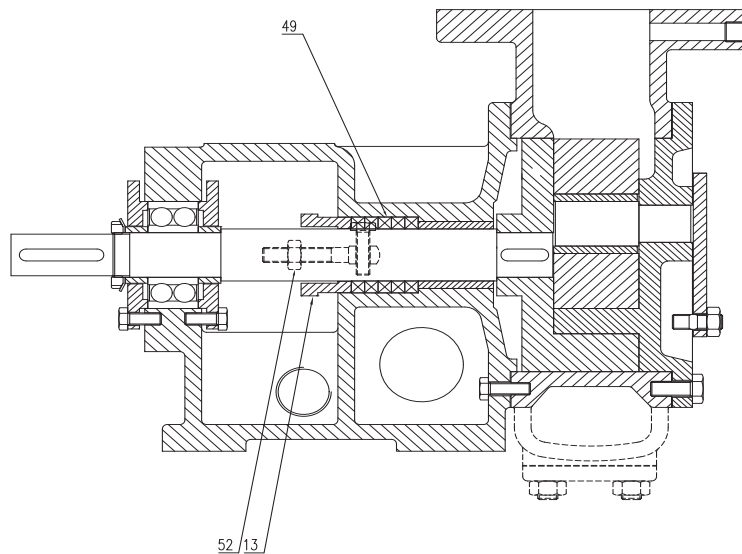


Figure 1 - Direction of rotation

- 2.4 Start the motor and check the direction of rotation. See Figure 1.

**WARNING** If the pump is fitted with a safety valve, the cover, with the adjusting screw, must be on the suction port side. If the direction of pump rotation has to be reversed, the safety valve must also be inverted by losing the 4 screws of the valve. **THIS IS NOT POSSIBLE FOR CHOCOLATE OR MAGNETIC PUMPS!** Please contact your pump partner for alternatives.

- 2.5 If pumps are coupled with engines, they are generally provided with clutches. Start the engine with the clutch disengaged, let the engine idle for some minutes and warm-up, then carefully engage the clutch. At last accelerate to reach the required speed.
- 2.6 If present, fill the +O<sub>2</sub> reservoir with the quench liquid. See section D.2 "Quench reservoir +O<sub>2</sub>", page 10.



- 2.7 In case of pumps with packing seal, tighten up the Pos. 13 packing gland lightly using the screws (Pos. 52) (up to a maximum torque of 10 N) and then loosen them slightly again.

- Original -

**WARNING** Never tighten up the packing gland so that it is skewed. This would create the risk of the shaft coming into contact with the packing gland with the risk to create sparks during operation.

- 2.8 Start the pump and check after some minutes if the pump is working as planned.

**WARNING** Any deviation from normal operating conditions (increased power consumption, temperature, vibrations, noise etc.) or warning signals by monitoring equipment suggest malfunction. Inform the responsible maintenance personnel at once to prevent the trouble from getting worse and causing, directly or indirectly, serious physical injury or material damage.  
**In case of doubt disconnect the machine immediately!**

- 2.9 Check the pressure of the pump. In case of over pressure or too low pressure it is necessary to adjust the safety valve. See section E "Safety valve", page 13.
- 2.10 In case of pumps with packing seal, during the running-in phase (approx. 20 min), watch the leakage and minimize it by tighten the screws gradually and evenly. The leakage rate will fall faster or more slowly, depending on pressure, viscosity, tolerances, temperature and speed. Leakage may be reduced until it is some drops per minute.

**WARNING** The pump must never work with no leakage. This could arise the temperature which is dangerous for operation in hazardous conditions.

- 2.11 The pump will need to be checked at the following intervals to make sure it is pumping properly and not making strange noises: 10 min. / 1 hour / 10 hours / 1 day / 1 week / 1 month. Inspection may take place thereafter at monthly intervals provided the conditions of use do not change.

### 3. Operating troubles

- 3.1 In case of troubles, always check the pressure on the suction and delivery line of the pump, at first. Pumps are provided with ¼" connections on the flanges for this purpose.
- 3.2 **PUMP DOES NOT PRIME.** Possible causes:
- (a) Wrong direction of rotation (see section C.2.4 Start the motor and check the direction of rotation. See Figure 1., page 6).
  - (b) No liquid in pump casing to create a seal (see section C.2.1, page 5). The vacuum gauge needle hardly moves. Should the pump self-prime at every start and has difficulty in priming, it is recommended to fit either a goose neck (curve upwards and reverse curve) or a foot valve in the suction line to ensure that there will be always liquid in the pump.
  - (c) Closed valve in the suction line, suction line or filter clogged. Vacuum gauge reading is high. Check the suction line thoroughly.
  - (d) Air leaks in the suction line. Check that all flange screw threads and gaskets are airtight.
  - (e) Trapped air in the delivery line. Check that all valves are fully open. If necessary, let the air out by venting the delivery line.
  - (f) Excessive suction lift. Reduce static suction lift.
  - (g) Rotation speed too low. If the liquid has a viscosity less than 20 mm<sup>2</sup>/s (cSt), do not run at a speed less than ⅓ of the nominal speed.
  - (h) Safety valve (by-pass) blocked by impurities in open position. Clean the safety valve and its seat.
- 3.3 **LOW CAPACITY.** Possible causes:
- (a) Rotation speed too low. Check that the speed corresponds to that necessary to obtain the required capacity.
  - (b) Suction line or filter obstructed. The vacuum gauge reading is high. Cavitation noise.
  - (c) Air leaks in the suction line. The vacuum gauge and the pressure gauge oscillate. Check connections, threads, gaskets, welds etc.. Air leaks in the suction line are very difficult to detect. They are nearly invisible in case of low pressure in the suction line.

- Original -

- (d) Pressure of safety valve is set too low causing some liquid to recycle. Tighten the safety valve adjusting screw (see section E "Safety valve", page 13). The pressure gauge will show a higher pressure.
- (e) Suction line not sufficiently immersed in liquid causing air to enter suction line. The vacuum gauge oscillates.
- (f) Liquid viscosity too high. The vacuum gauge reading is very high. Cavitation noise. Reduce the viscosity of the liquid by heating, or increase the diameter of the suction line.
- (g) Excessive suction lift or excessive suction friction losses. The vacuum gauge reading is high. Cavitation noise. Reduce static suction lift and shorten the suction line as much as possible by eliminating unnecessary valves, bends or external constrictions.
- (h) Air leaks from the packing seal or the mechanical seal. Tighten or replace packing seal or replace mechanical seal. These defects occur primarily when the delivery pressure is lower than the suction pressure.
- (i) Pump axial adjustment not correct. Please re-adjust. See section D.6 "Rotor axial adjusting", page 12.
- (j) Excessive wear of the internal parts of the pump. Please contact your pump partner.

**3.4 EXCESSIVE PUMP NOISE – CAVITATION.** Possible causes:

- (a) Suction line is obstructed. Vacuum gauge always has a very high reading. Locate and clear obstruction. Open valves fully.
- (b) Filter clogged. Examine and clean.
- (c) Rotation speed too high for the viscosity of the liquid. Reduce the viscosity of the liquid by heating. Increase the diameter of the suction line. Reduce RPM. Change pulleys or gear box ratios.

**3.5 MOTOR OVERLOAD.** Possible causes:

- (a) Valves partially closed in delivery line. Pressure gauge reading is high. Check all valves.
- (b) Delivery line obstructed or too small in diameter, pressure gauge reading is high. Locate and clear the obstruction or change the line.
- (c) Packing too tight. Shaft and packing seal box overheated. Loosen gland screws (see section D.3.2 "Packing seal:", page 10).
- (d) Liquid with viscosity or density higher than that for which the pump was designed. Reduce the viscosity, reduce rotation speed, increase diameter of the delivery line or install a higher powered motor.
- (e) Shaft bush or idler bush tend to seize and stop the pump. Rear cover or idler pin extremity overheated. Clean the shaft or the pin and bore the bushes to allow larger tolerances. Better to contact your pump partner.

**3.6 EXCESSIVE WEAR.** Possible causes:

- (a) Liquid containing particles with a diameter greater than 0.5÷1 mm. Fit a suction filter. Liquid containing abrasive impurities. Decrease RPM. With abrasive liquids pump speed must be reduced to 1/3 of the rated speed.
- (b) Excessive pressure. With abrasive liquids the pressure must not exceed 4 bar.
- (c) Pump version not suitable for the pumped liquid. The pump is corroded by aggressive liquids. E.g.: solvents used in pumps designed for lubricating liquids.
- (d) Distortion due to the pipe-work loads transmitted directly to the pump casing, couplings not aligned, V-belt too tight, overloaded shaft, uneven foundation.

**3.7 MAGNETIC COUPLING SLIDING.** Possible causes:

- (a) Torque too high. Check pressure and viscosity.
- (b) Start-up torque too high. Install a soft starter or a frequency converter.
- (c) The pump is blocked. Check the rotor and the idler.



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- Original -

- 3.8 **For any other operation troubles**, please contact your pump partner by mentioning:
- ⇒ Pump type
  - ⇒ Serial no.
  - ⇒ Problem
  - ⇒ Running time
  - ⇒ And possibly attach photographs of pump and piping.

#### 4. Warranty

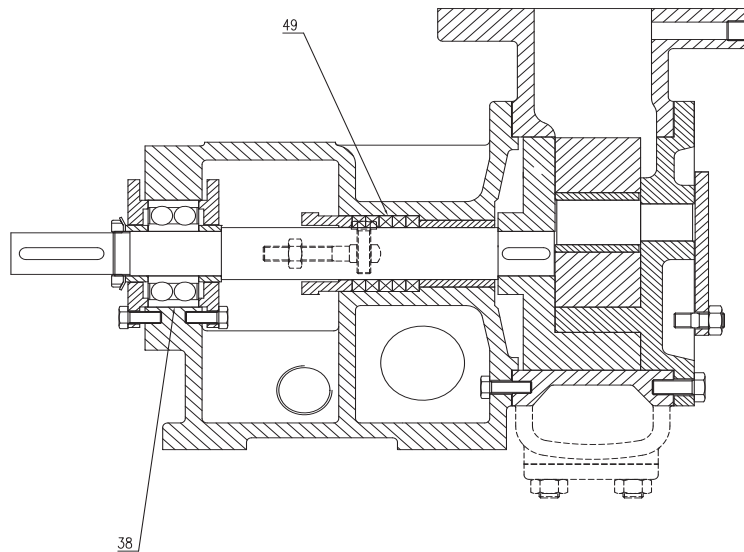
- 4.1 The manufacturer warrants the pump against defects or faulty workmanship for a period of 12 months from the date of delivery.
- 4.2 Repair of the pump or replacement of parts or of the pump itself can only be carried out after careful examination of the pump in our workshop where the pump should be sent by carriage paid. Any exceptions must be confirmed in writing.
- 4.3 This warranty does not cover parts subject to deterioration or normal wear, or damaged by misuse or improper handling of the pump by the user.
- 4.4 This warranty is no longer valid if the pump is disassembled or modified without the authorization of the manufacturer.

- Original -

## D. Maintenance

### 1. Maintenance plan

- 1.1 After start-up the pump will need to be checked at least at the following intervals to make sure it is pumping properly and not making strange noises: 10 min. / 1 hour / 10 hours / 1 day / 1 week / 1 month. Inspection may take place thereafter at monthly intervals provided the conditions of use do not change.
- 1.2 Every month, if present, check and adjust the packing seal. See section D.3.1, page 10.



- 1.3 Every month check the ball bearing (Pos. 38) with regard to wear or noise. If necessary replace it to avoid the explosion hazard due to high temperature.
- 1.4 Every 3 months, if present, lubricate the ball bearing. See section D.5 "Bearing", page 11.
- 1.5 Every 3 months, if present, change the quench liquid in the quench reservoir +O2. See section D.2 "Quench reservoir +O2", page 10.
- 1.6 Every 6 months clean the pump and the motor. If necessary, check more frequently.
- 1.7 Every 5-10 years make a general pump recondition.

### 2. Quench reservoir +O2

- 2.1 The purpose of the reservoir is to keep a quench liquid inside the mechanical seal, preventing any contact between pumped liquid and air.
- 2.2 The most suggested quench liquids are viscous, thermo stable oils, compatible with the pumped liquid (e.g. Vaseline, glycerine, glycol, Balistol).
- 2.3 Install the quench reservoir after the ¼" curve, near the seal.
- 2.4 Unscrew the cap of the quench reservoir and fill half of the glass with the quench liquid.
- 2.5 The level of the quench liquid can increase or decrease according to the temperature and the tightness of the seal. Should the liquid overflow, drain the quench liquid up to half of the reservoir and each day during one week check if the mechanical seal is tight. If not, replace the mechanical seal.
- 2.6 Every 3-4 months drain the liquid through the ¼" taps near the mechanical seal and re-fill the reservoir with non-used quench liquid.

### 3. Shaft seal

- 3.1 The pump is equipped with one shaft seal of the following types:
- 3.2 **Packing seal:**  
If the leakage along the packing is excessive, tighten the nuts of the eye bolts gradually.

- Original -

**WARNING** Do not over tight the gland nuts. During operation, liquid must leak through the packing for lubricating and cooling. If this loss is dangerous due to corrosion or fire, the pump must be equipped with a mechanical seal or a magnetic coupling.

**WARNING** Never tighten up the packing gland so that it is skewed. This would create the risk of the shaft coming into contact with the packing gland and sparking occurring during pump operation.

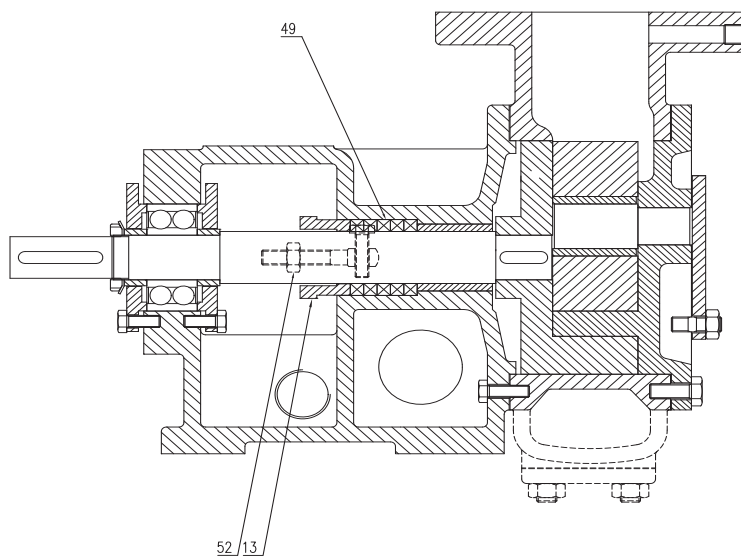
### 3.3 Mechanical seal:

- ⇒ Single: maintenance free.
- ⇒ Double, tandem: with reservoir (see section D.2 “Quench reservoir +O2”, page 10) or according to API Plan 52.
- ⇒ Double, back to back: according to API Plan 53 (min. 1 bar over the pump pressure).
- ⇒ Cartridge: see Data Sheet; normally this can operate with reservoir or according to API Plan 52 or Plan 53.

### 3.4 Magnetic coupling:

Is maintenance free.

## 4. Replacement of packing rings



- 4.1 Loosen the screws (Pos. 52) and push the packing gland (Pos. 13) to the rear.
- 4.2 Remove the old packing rings (Pos. 49) and clean the packing space.
- 4.3 Check the surface of the shaft with regard to wear and, if necessary, replace the shaft.
- 4.4 Insert new packing rings one by one, and pre-seal them with the cut ends offset by 180°.

**WARNING** Use only original Victor Pumps packing rings as incorrect materials may increase the packing temperature.

- 4.5 Slide in the packing gland (Pos. 13) and screw in the screws (Pos. 52) by hand.
- 4.6 Start-up the pump like a first time following section C.2 “First start-up”, page 5, to run the new packing seal correctly.

## 5. Bearing

- 5.1 The pump is equipped with bushings which are maintenance free as either lubricated by the liquid being pumped or self-lubricated.

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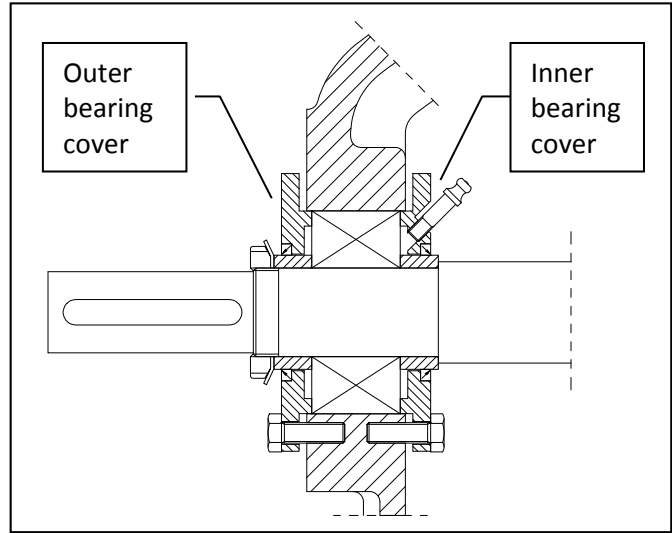
- 5.2 The ball bearing on the pedestal is generally maintenance free. Some have grease nipples and have to be lubricated every 500 operating hours or every 3 months with just one hub of grease.

## 6. Rotor axial adjusting

- 6.1 If pressure and/or capacity of the pump is no more sufficient, the axial clearance of the gears can be set-up by adjusting the rotors. This is not possible for magnetic coupling pumps that can only be adjusted with thicker cover gaskets (1-3 gaskets).
- 6.2 A high axial clearance is better against wear and high viscosity, but worse for the pumping pressure and self-priming with low viscosity products.

6.3 Adjusting:

- (a) Loosen the inner bearing cover.
- (b) Tighten the outer bearing cover.
- (c) Loosen the outer bearing cover screws as shown in the following table.
- (d) Re-tighten the inner bearing cover.



*Bearing covers*

mm <sup>2</sup> /s (cSt) °C			<200 <40		200÷4000 <180		>4000 >180	
Type	Screw	Step	R	mm	R	mm	R	mm
R 35,40	M8	1,25	1/6	0,2	1/3	0,4	1/2	0,6
R 50	M8	1,25	1/3	0,4	1/2	0,6	2/3	0,8
R 65	M8	1,25	1/3	0,4	1/2	0,6	2/3	0,8
R 80	M8	1,25	1/2	0,6	2/3	0,8	1	1,2
R105	M10	1,5	1/2	0,7	2/3	1	1	1,5
R151	M10	1,5	1/2	0,7	2/3	1	1	1,5
R180	M12	1,75	1/2	0,8	2/3	1,2	1	1,8
R200	M12	1,75	1/2	0,8	2/3	1,2	1	1,8
R250	M16	2	1/2	1	2/3	1,4	1	2
Class			A		B		C	

R = Screw rotation

**Classes:**

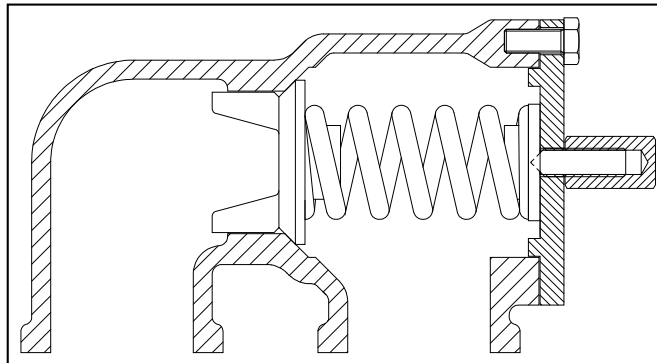
A = pumps for low viscosity liquids (i.e. solvents)

B = standard

C = pumps for high temperature or viscous liquids

- Original -

## E. Safety valve



*Safety valve (by-pass)*

### 1. Introduction

- 1.1 The internal gear pump can arrive to an unlimited pressure that can damage the pump itself and the line. A safety over pressure valve prevents these damages.
- 1.2 Under request, the pump can be assembled with an integrated safety valve on the pump cover. As alternative, the pump must be protected by other controls (e.g. external return line, sliding clutch, pressure switch).

### 2. Adjustment

- 2.1 In case of double safety valves set-up the valves separately, according to the two directions of rotation.
  - (a) Unscrew the cap.
  - (b) Loosen or tight the adjusting screw in order to decrease or increase the pressure at which the by-pass is set. Pay attention to the motor performance. It is possible to make the adjustment with pipes full of liquid while the pump is running as slip losses from the screw are minimal.

**WARNING** Do not loosen the screw too much. When the spring is not compressed, the adjusting screw becomes loosen. At this point do not unscrew any further. Caution must be used when pumping inflammable or corrosive liquids.

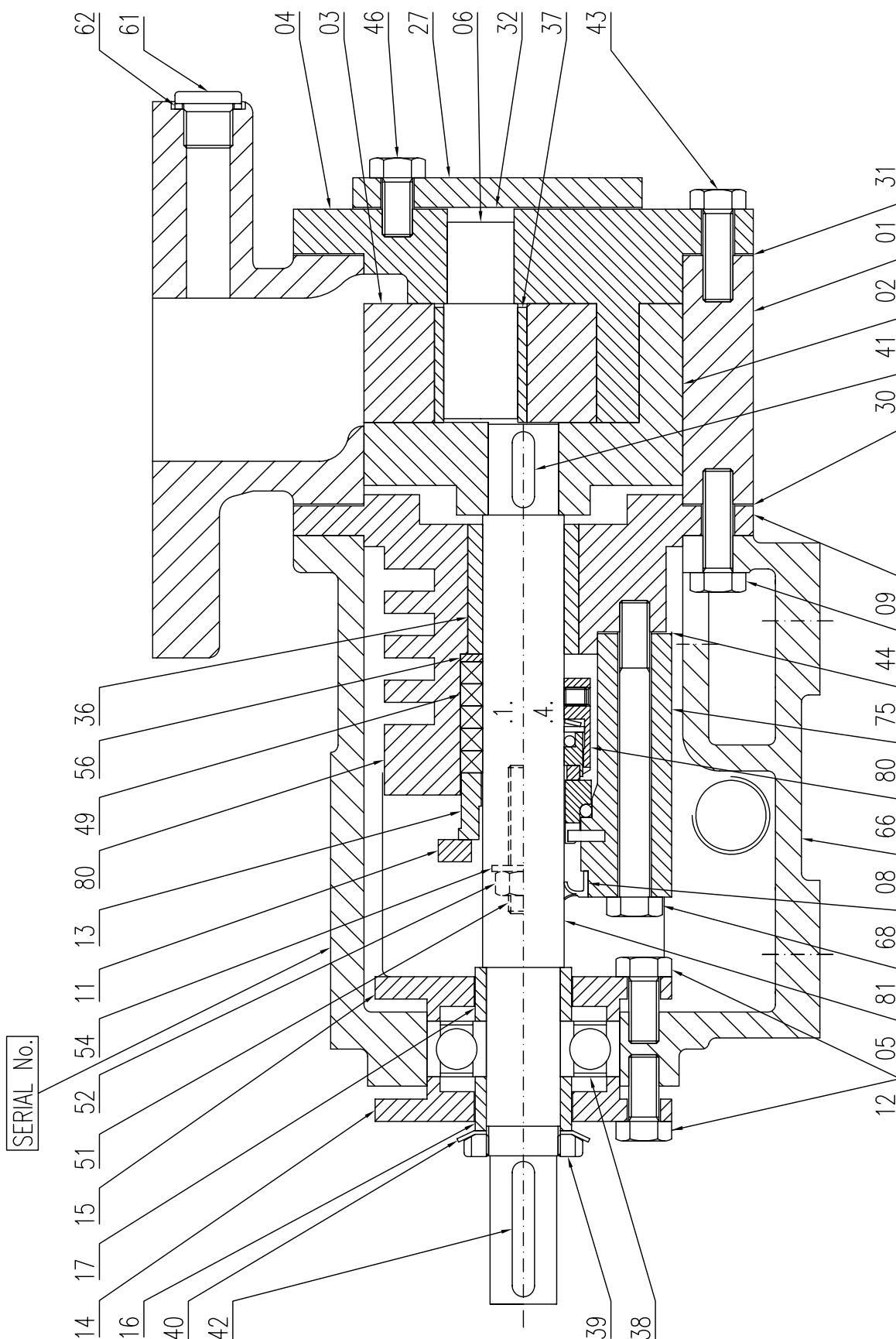
**WARNING** Do not tight the screw to the end limit. This would compress the spring till the max. limit and the safety valve will not work properly.

- (c) Screw on the cap again.

### 3. Direction of rotation

- 3.1 The safety valve is set for only one direction of rotation (except for double safety valve type +YY).  
Please install the valve according to section C.2.4, page 6.

**R ...BF Ersatzteilliste**  
**Spare Parts List - Liste des pièces de rechange - Elenco ricambi**



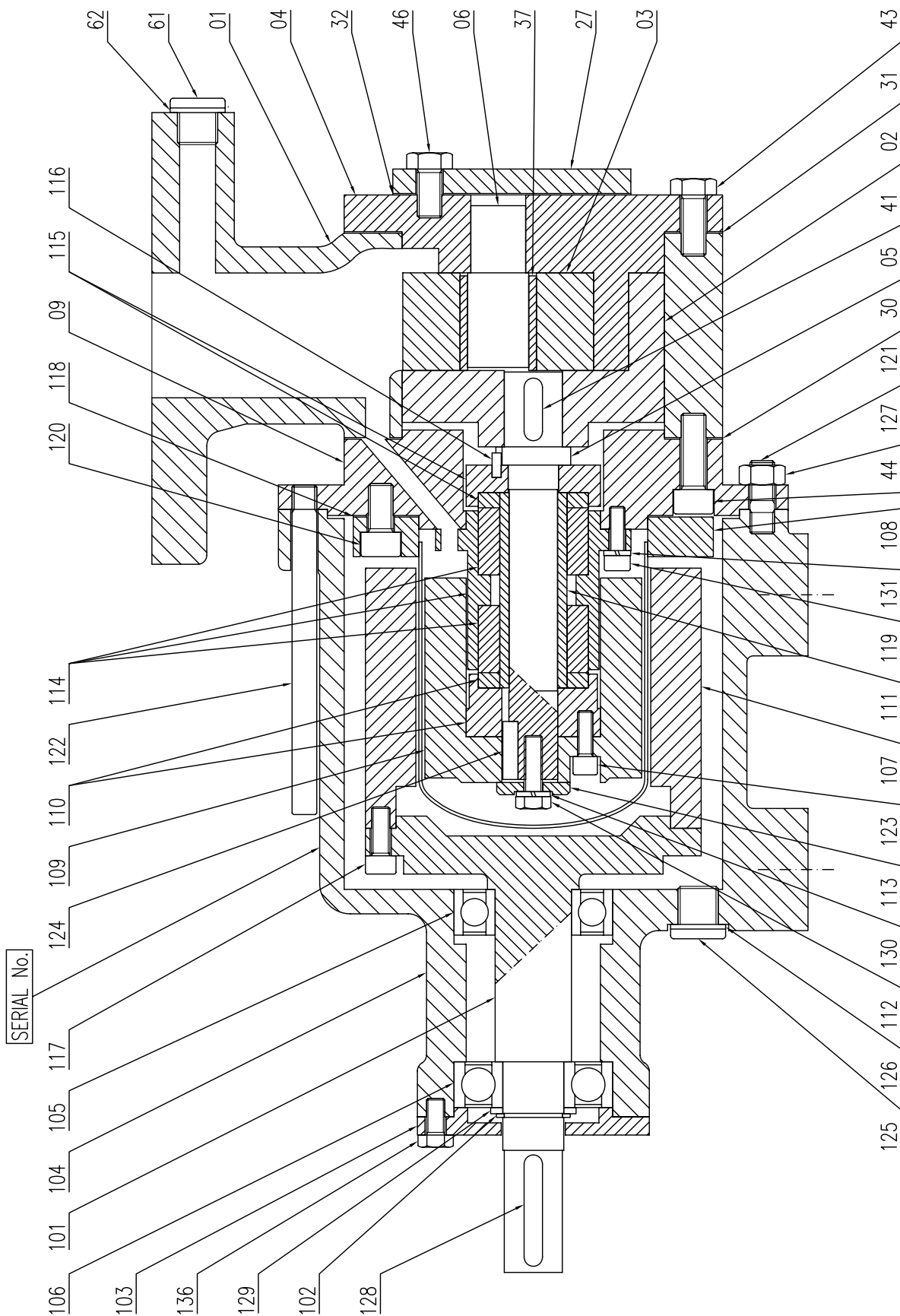
## Ersatzteilliste R ...BF

### Spare part List – Liste des pièces de rechange - Elenco ricambi

Zu Zch. - To Dwg. – Des. - Dis. R-408016

Pos Ref. Rif.	Benennung	Part Name	Dénomination	Denominazione
01	Gehäuse	Casing	Corps	Corpo
02	Rotor	Rotor	Rotor	Rotore
03	Ritzel	Idler	Engrenage entraîné	Ruota oziosa
04	Deckel	Cover	Couvercle	Coperchio
05	Welle	Shaft	Arbre	Albero
06	Zapfen	Pin	Pivot	Perno
08	Lagerbock	Bearing Housing	Support	Supporto
09	Hinterer Deckel	Rear Cover	Bride support	Flangia supporto
11	Brille	Gland	Presse-étoupe	Premitreccia
12	Schraube, Lagerdeckel	Screw, Bearing Cover	Vis protège roulement	Vite copricuscinetto
13	Brille	Gland	Presse-étoupe	Premitreccia
14	Kugellagerdeckel	Bearing Cover	Protège roulement	Copricuscinetto
16	Distanzhülse	Sleeve	Embout	Ghiera
17	Distanzhülse	Sleeve	Embout	Ghiera
27	Flansch, By-Pass	Flange, By-Pass	Bride by-pass	Flangia by-pass
30	Dichtung, Gehäuse	Gasket, Casing	Joint corps	Guarnizione corpo
31	Dichtung, Deckel	Gasket, Cover	Joint couvercle	Guarnizione coperchio
32	Dichtung, By-Pass	Gasket, By-Pass	Joint by-pass	Guarnizione by-pass
36	Gleitlager, Welle	Bushing, Shaft	Coussinet support	Bronzina supporto
37	Gleitlager, Ritzel	Bushing, Idler	Coussinet engrenage entraîné	Bronzina ruota oziosa
38	Kugellager	Ball Bearing	Roulement à billes	Cuscinetto
39	Nutmutter	Lock Nut	Embout	Ghiera
40	Sicherungsblech	Washer	Rondelle	Rosetta di sicurezza
41	Paßfeder, Rotor	Key, Rotor	Clavette rotor	Linguetta rotore
42	Paßfeder, Welle	Key, Shaft	Clavette arbre	Linguetta albero
43	Schraube, Deckel	Screw, Cover	Vis couvercle	Vite coperchio
44	Schraube, Gehäuse	Screw, Casing	Vis corps	Vite corpo
46	Schraube, By-Pass	Screw, By-Pass	Vis by-pass	Vite by-pass
49	Packungssatz	Packing Set	Presse-étoupe à tresses	Baderna
51	Schraube, Brille	Screw, Gland	Vis presse-étoupe	Vite premitreccia
52	Mutter, Brille	Nut, Gland	Ecrou presse-étoupe	Dado premitreccia
54	Scheibe, Brille	Washer, Gland	Rondelle presse-étoupe	Rondella premitreccia
56	Stutzscheibe	Trust Ring	Ecrou blocage	Anello sostegno Baderna
61	Verschlußschraube	Plug	Bouchon	Tappo
62	Dichtung, Verschlußschraube	Gasket, Plug	Joint bouchon	Guarnizione tappo
66	Gleitringdichtung (mit 68)	Mechanical Seal (with 68)	Garniture mécanique (avec 68)	Tenuta completa (con 68)
68	Wellendichtring	Oil Retainer	Pare-huile	Paraolio
75	Dichtung, GLRD-Träger	Gasket, Seal Box	Joint boîte à garniture	Guarnizione portatenuta
80	GLRD-Träger	Seal Box	Boîte à garniture	Portatenuta
81	Schraube, GLRD-Träger	Screw, Seal Box	Vis boîte à garniture	Vite portatenuta
	Öler	Oil Lubricator	Burette à huile	Oliatore
	Bogen	Bend	Coude	Curva

**R ...M II Ersatzteilliste**  
**Spare Parts List - Liste des pièces de rechange - Elenco ricambi**





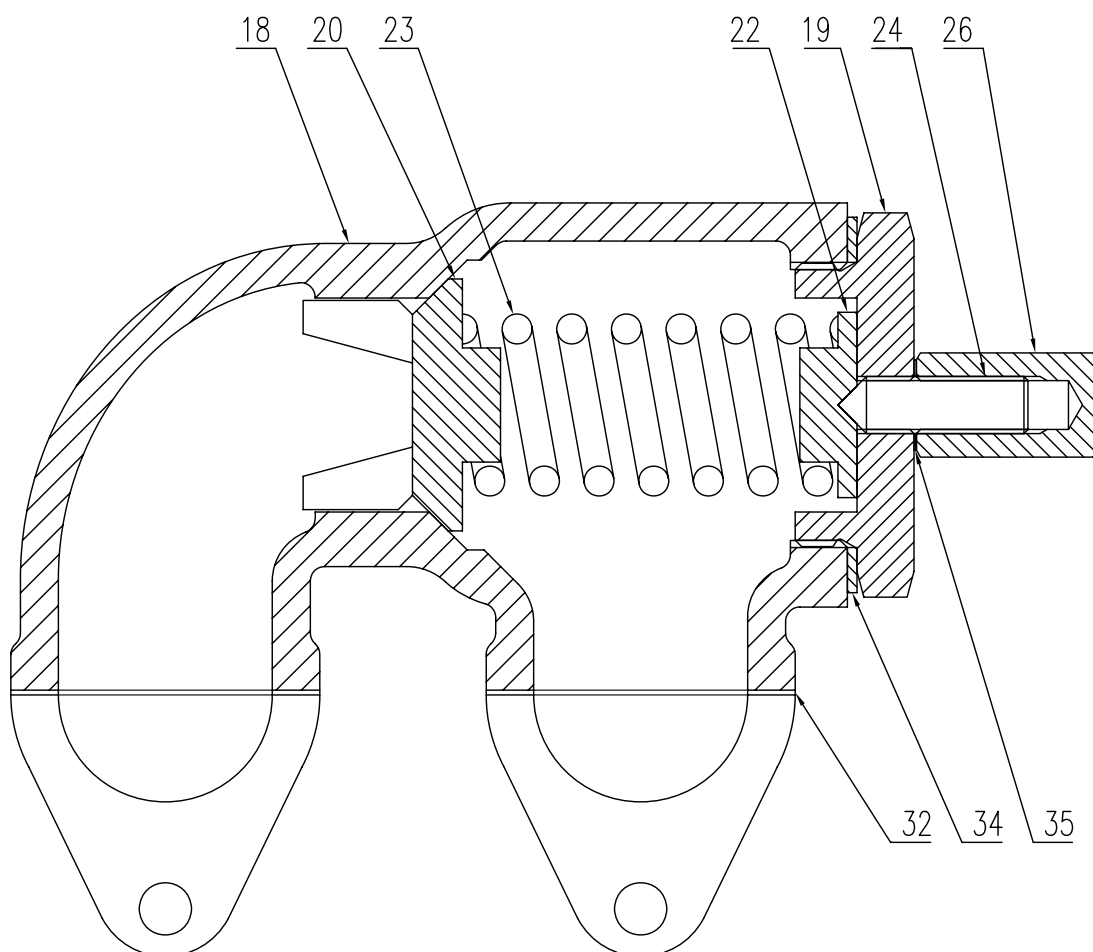
## Ersatzteilliste R ...M II

### Spare part List – Liste des pièces de rechange - Elenco ricambi

Zu Zch. - To Dwg. – Des. - Dis. R-870131

Pos Ref. Rif.	Benennung	Part Name	Dénomination	Denominazione
01	Gehäuse	Casing	Corps	Corpo
02	Rotor	Rotor	Rotor	Rotore
03	Ritzel	Idler	Engrenage entraîné	Ruota oziosa
04	Deckel	Cover	Couvercle	Coperchio
05	Welle	Shaft	Arbre	Albero
06	Zapfen	Pin	Pivot	Perno
09	Hinterer Deckel	Rear Cover	Bride support	Flangia supporto
27	Flansch, By-Pass oder By-Pass	Flange, By-Pass or By-Pass	Bride by-pass ou By-Pass	Flangia by-pass o By-Pass
30	Dichtung, Gehäuse	Gasket, Casing	Joint corps	Guarnizione corpo
31	Dichtung, Deckel	Gasket, Cover	Joint couvercle	Guarnizione coperchio
32	Dichtung, By-Pass	Gasket, By-Pass	Joint by-pass	Guarnizione by-pass
37	Gleitlager, Ritzel	Bushing, Idler	Coussinet engrenage entraîné	Bronzina ruota oziosa
41	Paßfeder, Rotor	Key, Rotor	Clavette rotor	Linguetta rotore
43	Schraube, Deckel	Screw, Cover	Vis couvercle	Vite coperchio
44	Schraube, Gehäuse	Screw, Casing	Vis corps	Vite corpo
46	Schraube, By-Pass	Screw, By-Pass	Vis by-pass	Vite by-pass
61	Verschlußschraube	Plug	Bouchon	Tappo
62	Dichtung, Verschlußschraube	Gasket, Plug	Joint bouchon	Guarnizione tappo
101	Welle, außen	Shaft, outer	Arbre externe	Albero esterno
102	Sicherungsring, Welle	Circlip, Shaft	Ecrou de blocage, arbre externe	Anello elastico albero esterno
103	Lagerdeckel	Bearing Cover	Couvercle roulement	Copricuscinetto
104	Lagerbock	Bearing Housing	Support	Supporto
105	Kugellager, innen	Ball Bearing, inner	Roulement à billes interne	Cuscinetto interno
106	Kugellager, außen	Ball Bearing, outer	Roulement à billes externe	Cuscinetto esterno
107	Magnet, außen	Magnet, outer	Aimant externe	Magnete esterno
108	Spalttopf	Can	Boîte d'aimant	Calotta
109	Magnet, innen	Magnet, inner	Aimant interne	Magnete interno
110	Mitnehmer, außen mit Axial Gleitlager	Collar, outer with Trust Ring	Collier, externe avec anneau	Trascinatore esterno con anello spallamento
111	Wellenhülse	Shaft sleeve	Chemise d'arbre	Boccola Albero SiC
112	Schraube, innen welle	Screw, inner shaft	Vis, arbre interne	Vite albero interno
113	Scheibe, innen welle	Washer, inner shaft	Rondelle, arbre interne	Rondella albero interno
114	Lagerträger mit Radial Gleitlager SiC	Bush Housing with Radial Bushing SiC	Porte coussinet avec coussinet SiC	Portaboccole con boccole in SiC
115	Mitnehmer, innen mit Axial Gleitlager	Collar, inner with Trust Ring	Collier, interne avec anneau axial	Trascinatore interno con anello spallamento
116	Stift, innen mitnehmer	Pin, inner collar	Goupille, collier interne	Spina trascinatore interno
117	Schraube, Magnet, außen	Screw, Magnet, outer	Vis, aimant externe	Vite magnete esterno
118	Dichtung, Spalttopf	Gasket, Can	Joint, boîte d'aimant	Guarnizione calotta
119	Schraube, Lager Träger	Screw, Bush Housing	Vis, porte coussinet	Vite portaboccola
120	Schraube, Spalttopf	Screw, Can	Vis, boîte d'aimant	Vite calotta
121	Schraube/ Stiftschraube, Lagerbock	Screw/ Stud, Bearing Housing	Vis/Goujon, Support	Vite/prigioniero supporto
122	Führungsstange	Slide Bar	Tige de montage	Asta guida
123	Schraube, Magnet, innen	Screw, Magnet, inner	Vis, aimant interne	Vite magnete interno
124	Paßfeder, Magnet, innen	Key, Magnet, inner	Clavette, aimant interne	Linguetta magnete interno
125	Verschlußschraube, Lagerbock	Plug, Bearing Housing	Bouchon, Support	Tappo supporto
126	Dichtung, Verschlußschraube, Lagerbock	Gasket, Plug, Bearing Housing	Joint, bouchon, Support	Guarnizione tappo supporto
127	Mutter, Lagerbock	Nut, Bearing Housing	Ecrou, support	Dado supporto
128	Paßfeder, Welle, außen	Key, Shaft, outer	Clavette, arbre externe	Linguetta albero esterno
129	Stutzscheibe	Supporting ring	Rondelle	Anello sostegno cuscinetto
130	Federring, Welle, innen	Spring Washer, Shaft, inner	Rondelle à ressort, Arbre interne	Rondella Grower albero interno
131	Federring, Lagerträger	Spring Washer, Bush Housing	Rondelle à ressort, porte coussinet	Rondella Grower portaboccola
132	Verschlußschraube, Lagerbock (für Fühler)	Plug, Bearing Housing (for sensor)	Bouchon Support (pour sonde)	Tappo supporto (per sonda)
133	Dichtung, Verschlußschraube, Lagerbock	Gasket, Plug, Bearing Housing	Joint, bouchon, Support	Guarnizione tappo supporto (per sonda)
134	Verschlußschraube, hinterer deckel	Plug, rear cover	Bouchon, bride, support	Tappo flangia supporto
135	Dichtung, Verschlußschraube, hinterer deckel	Gasket, Plug, rear cover	Joint, bouchon, bride, Support	Guarnizione tappo flangia supporto
136	Schraube, Lagerdeckel	Screw, Bearing Cover	Vis, protège roulement	Vite copricuscinetto

**+ Y Ersatzteilliste**  
**Spare Parts List - Liste des pièces de rechange - Elenco ricambi**



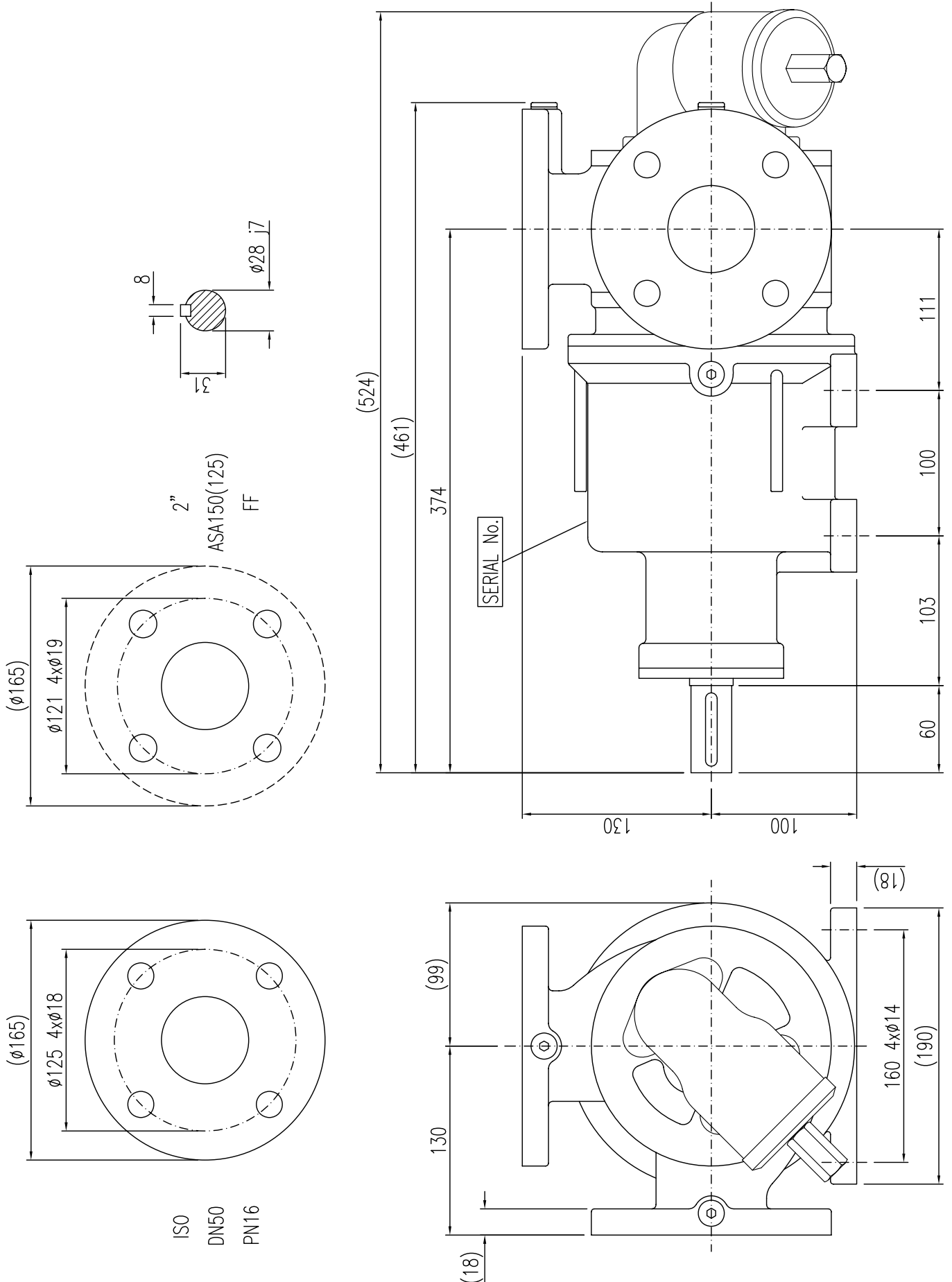
Pos Ref. Rif.	Benennung	Part Name	Dénomination	Denominazione
18	Gehäuse, By-Pass	Casing, By-Pass	Corps by-pass	Corpo by-pass
19	Deckel, By-Pass	Cover, By-Pass	Couvercle by-pass	Coperchio by-pass
20	Ventil	Valve	Clapet	Valvola
22	Teller	Guide	Plateau	Piattello
23	Feder	Spring	Ressort	Molla
24	Stell Schraube	Setting Screw	Vis régulation	Vite regolazione
26	Kappe	Cap	Capuchon	Cappello
32	Dichtung, By-Pass	Gasket, By-Pass	Joint by-pass	Guarnizione by-pass
34	Dichtung, By-Passdeckel	Gasket, By-Pass Cover	Joint couvercle by-pass	Guarnizione coperchio by-pass
35	Dichtung, Kappe	Gasket, Cap	Joint capuchon	Guarnizione cappello

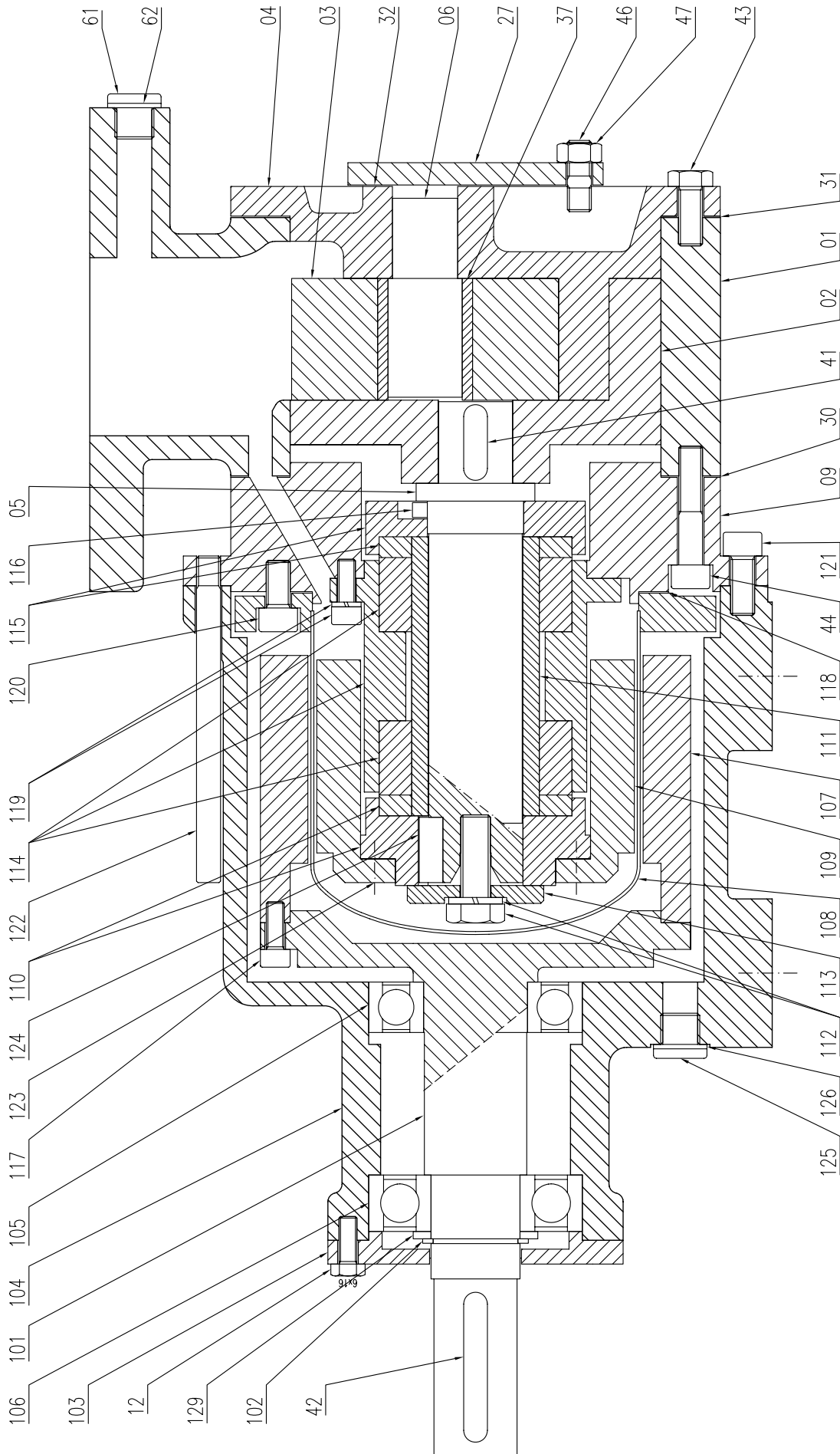
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Zu Zch. - To Dwg. - Dis. R-835070

Pos Ref.	Best. Nr. Part No. Codice	Ws Mat Mat	Für For Per	Abmessungen Dimensions Dimensioni	Menge Q.ty Q.tà	Benennung	Part Name	Denominazione
01	500443	GS			1	Gehäuse (mit 61,62)	Casing (with 61,62)	Corpo (con 61,62)
02	501730	S		90×125×41	1	Rotor	Rotor	Rotore
03	502727	G		32×90×41	1	Ritzel	Idler	Ruota oziosa
04	502921	G			1	Deckel	Cover	Coperchio
05	592401	K9			1	Welle (mit 40,41,112,116)	Shaft (with 40,41,112,116)	Albero (con 40,41,112,116)
06	506982	T		D.25	1	Zapfen	Idler Pin	Perno
	506992	W	V,W					
09	592903	S			1	Hinterer Deckel	Rear Cover	Flangia supporto
12	600054	S		M6×16 DIN933	4	Schraube, Lagerdeckel	Screw, Bearing Cover	Vite copricuscinetto
27	503684	S			2	By-Passflansch	By-Pass Flange	Flangia by-pass
30	667352	E		125×165×0,5 8B9	1	Dichtung, Gehäuse	Gasket, Casing	Guarnizione corpo
31	667349	E		125×165×0,5 8B9	1	Dichtung, Deckel	Gasket, Cover	Guarnizione coperchio
32	667331	E		49×88×1 2B9	2	Dichtung, By-Pass	Gasket, By-Pass	Guarnizione by-pass
37	692070	FS		25×32×40	1	Ritzelgleitlager	Idler Bushing	Bronzina ruota oziosa
	693645	W	W					
41	611097	K		8×25 DIN6885A	1	Paßfeder, Rotor	Key, Rotor	Linguetta rotore
42	614524	S		8×50 DIN6885A	1	Paßfeder, Welle, außen	Key, Shaft, outer	Linguetta albero esterno
43	600119	S		M8×20 DIN933	8	Schraube, Deckel	Screw, Cover	Vite coperchio
44	610840	K		M8×40 DIN912	8	Schraube, Gehäuse	Screw, Casing	Vite corpo
46	613359	S		M8×18 DIN938	4	Stiftschraube, By-Pass	Stud, By-Pass	Prigioniero by-pass
47	612035	S		M8 DIN934	4	Mutter, By-Pass	Nut, By-Pass	Dado by-pass
61	638099	S		R $\frac{1}{4}$ " DIN908	2	Verschlußschraube, Gehäuse	Plug, Casing	Tappo corpo
62	619883	E		13,5×18×1,5	2	Dichtung, Verschlußschraube	Gasket, Plug, Casing	Guarnizione tappo corpo
101	592408	S			1	Welle, außen (mit 42,102)	Shaft, outer (with 42,102)	Albero esterno (con 42,102)
102	615106	S		A30 DIN471	1	Sicherungsring, Welle	Circlip, Shaft	Anello elastico albero
103	615156	S		J72 DIN472	1	Lagerdeckel	Bearing Cover	Copricuscinetto
104	592218	G			1	Lagerbock	Bearing Housing	Supporto
105	656067	S		6207-2RS	1	Kugellager, innen	Ball Bearing, inner	Cuscinetto interno
106	655059	S		6306-2RS	1	Kugellager, außen	Ball Bearing, outer	Cuscinetto esterno
107	592220	S	22	D.110	1	Magnet, außen	Magnet, outer	Magnete esterno
		S	24					
	592250	S	26					
108	592221	K			1	Spalttopf	Can	Calotta
109	592222	K	22		1	Magnet, innen	Magnet, inner	Magnete interno
		K	24					
	592258	K	26					
110		K			1	Mitnehmer, außen	Collar, outer	Trascinatore esterno
		Y						
111		Y			1	Wellenhülse	Shaft, Sleeve	Boccola albero
		Y						
112	610211	K		M10×25 DIN933	1	Schraube, innen Welle	Screw, inner Shaft	Vite albero interno
	614372	K		M10 DIN6798A	1	Federring, innen Welle	Spring Washer, inner Shaft	Rondella elastica albero interno
113	592206	K		10,5×46×5	1	Scheibe, Welle	Washer, Shaft	Rondella albero
114	592225	K			1	Lagerträger	Bush Housing	Portaboccola
		Y						
115		K			1	Mitnehmer, innen	Collar, inner	Trascinatore interno
		Y						
116	615910	H		5×12 DIN7	1	Stift, Mitnehmer	Pin, Collar	Spina trascinatore
117	610612	K		M6×16 DIN912	4	Schraube, Magnet, außen	Screw, Magnet, outer	Vite magnete esterno
118	592205	E		110×125×0,5	1	Dichtung, Topf	Gasket, Can	Guarnizione calotta
119	610612	K		M6×16 DIN912	4	Schraube, Lagerträger	Screw, Bush Housing	Vite portaboccola
	614354	K		M6 DIN7980	4	Federring	Spring Washer	Rondella elastica
120	610229	K		M8×16 DIN912	8	Schraube, Topf	Screw, Can	Vite calotta
121	611257	K		M8×16 DIN938	8	Stiftschraube, Lagerbock	Stud, Bearing Housing	Prigioniero supporto
	612035	S		M8 DIN934	8	Mutter	Nut	Dado
122	592607	H		M8×100	3	Führungsstange	Slide Bar	Asta guida
123		K		DIN912	4	Schraube, Magnet, innen	Screw, Magnet, inner	Vite magnete interno
124	611152	K		10×20 DIN6885A	1	Paßfeder, Mitnehmer	Key, Collar	Linguetta trascinatore
125	638099	S		R $\frac{1}{4}$ " DIN908	1	Verschlußschraube, Lagerbock	Plug, Bearing Housing	Tappo supporto
126	619883	E		A 14×18×1,5 DIN7603	1	Dichtung, Verschlußschraube, Lagerbock	Gasket, Plug, Bearing Housing	Guarnizione tappo supporto
129	703938	S		SS30×42×2,5	1	Stutzscheibe	Supporting ring	Rondella spallamento
		E				Dichtungssatz (mit 30,31,32,62, 118,126)	Gasket Set (with 30,31,32, 62,118,126)	Serie guarnizioni (con 30,31, 32,62,118,126)
	592266	K+Y				Lagerungssatz (mit 110,111,114, 115,116)	Bushing set (with 110,111, 114,115,116)	Set portaboccole (con 110, 111,114,115,116)

