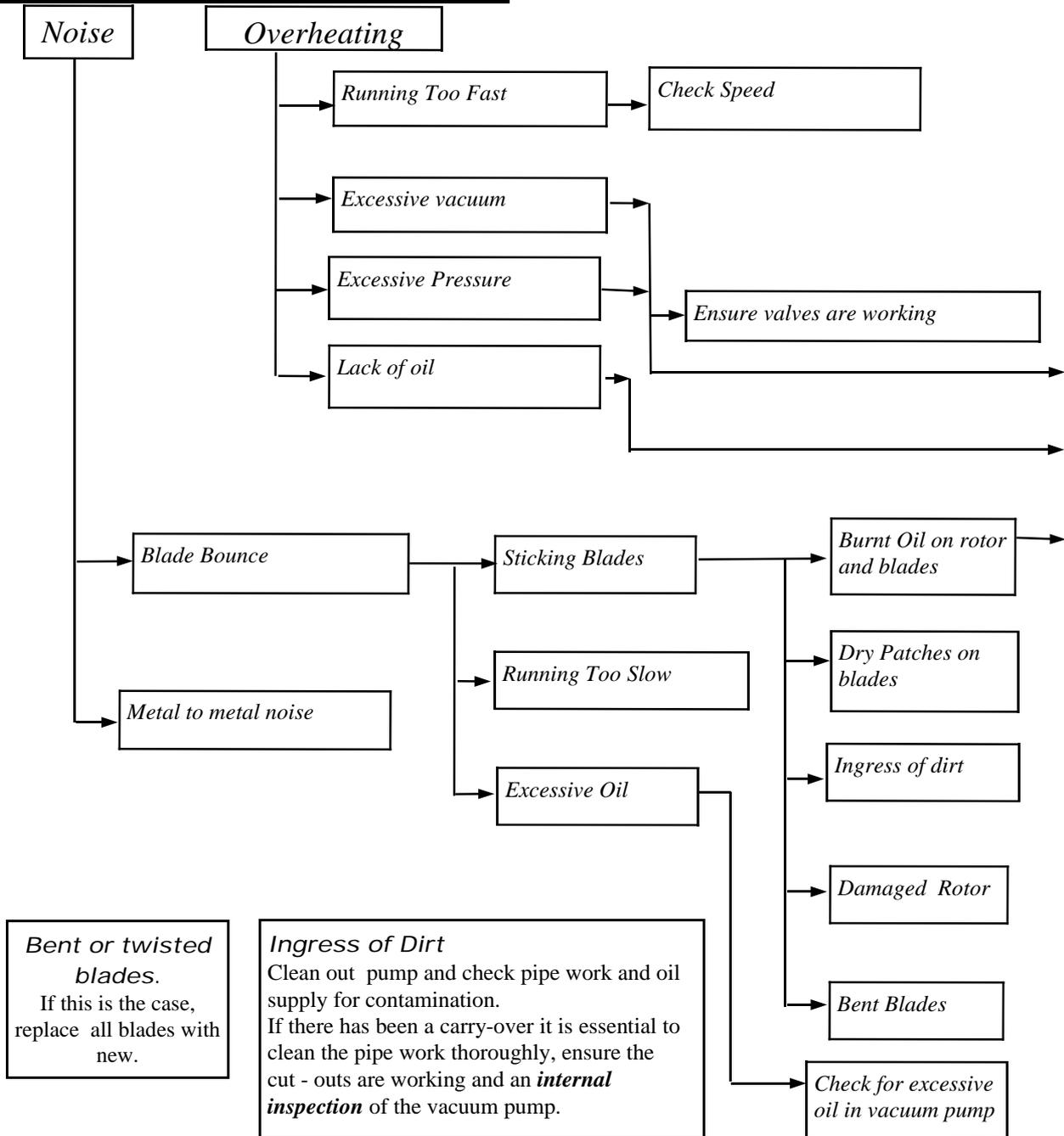


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TROUBLESHOOTING



Bent or twisted blades.
If this is the case, replace all blades with new.

Ingress of Dirt
Clean out pump and check pipe work and oil supply for contamination. If there has been a carry-over it is essential to clean the pipe work thoroughly, ensure the cut - outs are working and an **internal inspection** of the vacuum pump.

Metal to metal
Check for fans or couplings rubbing against guard

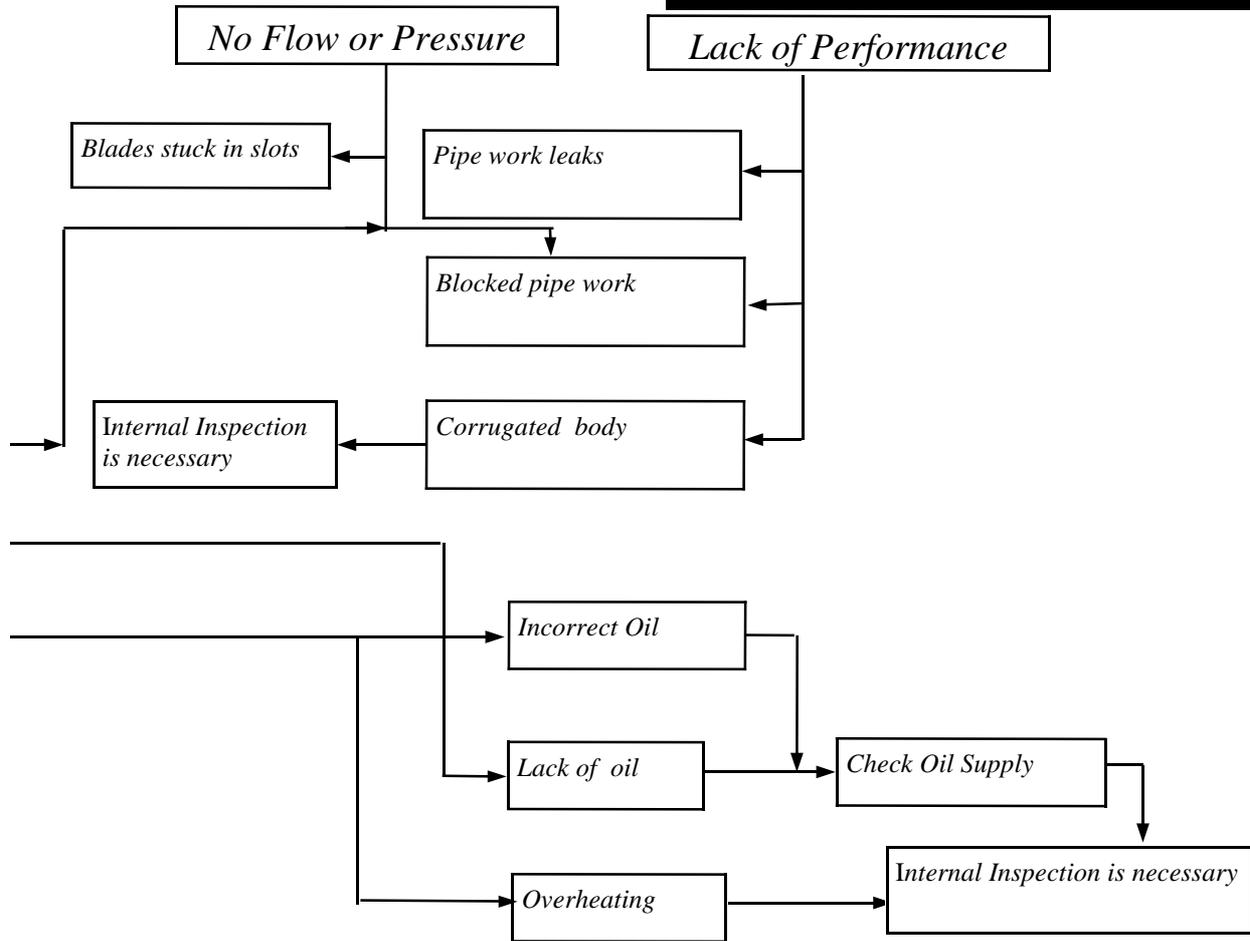
Valves
The valves should always protect the vacuum pump from excessive duties - they may not be working or they may not be fitted.

Blocked Line
Check the filters, flame traps, coalescers and isolating valves for possible restrictions in the line.

Internal Inspection
Strip pump to check inside. The resin bonding in the blades may have begun to break down at the blade tips causing them to appear chipped. These blades will have to be replaced. Also check for damage to the body (bore corrugation or split in casting), rotor (slot damage or bent shaft) and sideplates (scoring by rotor).

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TROUBLESHOOTING



Excessive Oil in vacuum pump

This will happen if oil has been fed into the vacuum pump while it was not operating or if oil can drain back into the vacuum pump due to the pipe work design or when the vacuum pump is operating at a high vacuum oil for long periods.

This will cause blade bounce. The pump will have to be stripped and cleaned of all excess oil.

Once the machine is rebuilt, check the lubrication rate and ensure it is correct. Ensure there is no oil feeding back when the vacuum pump is not running.

In future operations ensure the vacuum pump is run periodically with the vent valve fully open.

Check Oil Supply

Should be SAE 20 / ISO 68 Mineral.

Replace and run machine again.

Check the Lubricators are delivering the correct amount of oil.

If oil lub. pump is being used, disconnect the oil feed pipes from the vacuum pump to check for oil flow.

If oil is flowing correctly. The pump may sound noisy when it is initially run after installation or after a long period of rest.

Turn lubrication rate up until the pump quietens down. Reduce the lubrication rate to the correct level.

Speeds

Check the running speed. this should be within the recommended range stated in these instructions.

Excessive Pressure or Vacuum

Check running pressure and/or vacuum. that the pump is creating when running.

Incorrect Build

- 1 Ensure fans are on correct ends
- 2) .Check for restricted cooling eg blocked cooling fins or obstructed cowls
- 3) Ensure correct direction of rotation
- 4) Check for drive mis-alignment