



OPERATING MANUAL LIQUID RING VACUUM PUMPS AND COMPRESSORS

Series

TRH - TRS - TRM - TRV - SA

&

Systems

HYDROSYS - OILSYS



OPERATING MANUAL FOR INSTALLATION, START-UP AND MAINTENANCE FOR LIQUID RING VACUUM PUMPS AND COMPRESSORS

This manual applies to TRAVAINI liquid ring pumps single stage series **TRM**, **TRS**, **TRV**, double stage series **TRH**, compressors series **SA** and systems series **HYDROSYS** and **OILSYS**, which utilize above pump series. (Please see chapters 20 or 21 for details pertaining to systems).

NOTE: Unless otherwise specified, the term pump used throughout this manual means also pump/motor assembly or system type HYDROSYS and/or OILSYS.

Manufacturer:

POMPETRAVAINI S.p.A.

Via per Turbigo, 44 - 20022 CASTANO PRIMO - (Milano) - ITALY

Tel. +39 0331 889000 - www.pompetravaini.com

WARRANTY: All products manufactured by POMPETRAVAINI are guaranteed to meet the conditions listed on the general terms & conditions of sales and/or conditions listed on the order confirmations.
Failure to strictly adhere to the instructions and recommendations listed in this manual, will void the manufacturer's warranty. Guarantee will be preserved only if the pump maintenance is carried out by Pompetravaini or an authorized service. Any modification introduced to the pump without the authorization of Pompetravaini will lead to the loss of the guarantee.
If it is strictly necessary to dismantle the pump, please consult Disassembling Instructions on our website "www.pompetravaini.com".



This manual is valid only for the listed pump series. This manual IS NOT for the total installation. Instruction and maintenance manual for the installation must be obtained from the engineer that designed the installation. Furthermore, the installation manual will take precedence over the pump manual.



The liquids handled by the pumps and also their parts could be potentially dangerous for persons and environment: provide their possible disposal in conformity with the laws into force and a proper environment management.



The present manual is not assigned for pumps subjected to the ATEX 2014/34/EU directive. In case the pump is assigned in environments subjected to the application ATEX 99/92/CE directive or in case the pump is provided with a nameplate indicating the ATEX stamp, it strictly forbidden proceed to start up the pumps but necessary to consult POMPETRAVAINI for clarifications.

For pumps subjected to the ATEX 2014/34/EU directive it is available a dedicated integrative manual.



According to what expected from 2012/19/UE Directive on Waste Electric and Electronic Equipment the electrical pump assembly from us supplied (pump coupled with an electrical motor of Pompetravaini supply or customer supply) placed on the market after the 15th of August 2018 fell within the limits of application of the Directive. As a consequence, conforming to article 14 of the 2012/19/UE Directive of the European Parliament of the 4th of July 2012, Pompetravaini Spa is registered on the Italian list of EEE manufacturer.

The electrical pump assembly supplied by Pompetravaini Spa that should be discontinued from use must not be disposed with common waste because it is composed of different materials that can be recycled at the appropriate facilities. If it is not intended to proceed autonomously at the management of the electrical pump assembly at authorized disposal companies it is possible to contact the Pompetravaini branch closer to you that will give you the necessary information on a proper disposal in accordance with mandatory laws.

The pump unit must be previously cleaned up by the pumped product upon disposal.

After reclamation the electrical pump assembly is not potentially dangerous for human health and environment, not containing harmful substances according to 2011/65/UE (RoHs) Directive, but if abandoned in the environment will have a negative impact on the ecosystem. Sending the electrical pump assembly to an adequate process of disposal and recovery of materials protect the environment and help to limits consumption of available resources with effective recycling of materials. **The abandonment in the environment of the apparatus or the illegal disposal of the same are punished by law.**

In preparing this manual, every possible effort has been made to help the customer and operator with the proper installation and operation of the pump and/or system. Should you find errors, misunderstandings or discrepancies please do not hesitate to bring them to our attention.

Continuing research of POMPETRAVAINI results in product improvements: therefore, any specifications may be subject to change without notice.

INDEX

- 1 - General instructions**
 - 1.1 - General instruction
 - 1.2 - Reading template
- 2 - Safety instructions**
- 3 - In case of emergency**
 - 3.1- Basic first aid
- 4 - Pump outlines**
 - 4.1- Principle of operation
 - 4.2- Service liquid properties
 - 4.3- Pump models and tables for material of construction
- 5 - Unpacking, lifting and moving instructions**
- 6 - Storage instructions**
- 7 - Installation instructions**
 - 7.1- Piping connections
 - 7.2- Accessories
 - 7.3- Installation schematics for vacuum pumps
 - 7.3.1 - Service liquid:
 - Once-through system (no recovery)
 - 7.3.2 - Service liquid: Partial recovery system
 - 7.3.3 - Service liquid: Total recovery system
 - 7.4- Installation schematics for compressors
 - 7.5- Installation of "HYDROSYS" systems
 - 7.6- Installation of "OILSYS" systems
 - 7.7- Service liquid (H₂O at 15°C) flow (in m³/h) for vacuum pumps
 - 7.8- Service liquid flow (H₂O at 15°C) and pressure for compressors series "SA"
 - 7.9- Typical installation schematics for vacuum pumps
 - 7.10 - Typical installation schematics for compressors
 - 7.11 - Connections location
 - 7.12 - Pump engineering data
- 8 - Mounting and alignment instructions**
 - 8.1- Assembly of base mounted pump unit
 - 8.2- Alignment procedures for monoblock and for pump/motor assembly on baseplate
 - 8.3- Alignment instructions
- 9 - Electrical connections**
- 10 - Check list prior to start-up**
- 11 - Starting, operating and stopping procedures**
 - 11.1 - Start-up
 - 11.2 - Operation
 - 11.3 - Shut down
 - 11.4 - Start-up of "OILSYS" systems
 - 11.5 - Operation of "OILSYS" systems
 - 11.6 - Shut down of "OILSYS" systems
- 12 - Operating maintenance**
 - 12.1 - "OILSYS" systems
- 13 - Recommended maintenance**
 - 13.1 - Bearing maintenance
 - 13.2 - Periodic checks
- 14 - Packed stuffing boxes**
- 15 - Mechanical seals**
- 16 - Trouble shooting: problems, causes and solutions**
- 17 - Repairing and removing pump from the installation**
- 18 - Spare parts**
- 19 - Engineering data**
 - 19.1 - Influence of service liquid temperature, specific gravity and viscosity on pump performance
 - 19.2- Service liquid temperature change across the pump
 - 19.3 - Operation with partial recovery of service liquid
 - 19.4 - Units conversion table
- 20 - Engineering data for "HYDROSYS" systems**
- 21 - Engineering data for "OILSYS" systems**
 - 21.1 - Lifting and moving of "OILSYS" systems

KEY TO SYMBOLS

	Indications for the pump preservation		Signals for the operator's safety. DANGER: indicates imminent conditions of danger of serious harm or death. CAUTION: indicates a possible danger of minor harm.
	Warnings for the environment safeguard		Electric dangers for the operator's safety.
	Warnings for the ATEX Directive 2014/34/EU		

Pompetravaini ensures that its documentation is compliant in Italian and English languages.

Technical documentation and manuals provided in languages other than these two are subject to a translation by third parties.

Documentation and manuals in the two official languages are available on the Pompetravaini website.

1 - GENERAL INSTRUCTIONS

1.1 - GENERAL INSTRUCTIONS

This manual is intended to provide reference to:

- application and operating safety
- installation and maintenance for pump or system
- starting, operating and stopping procedures for pump or system

NOTE: All references made to pumps are also applicable to systems that employ these pumps, unless otherwise specified.

Upon receipt of this manual, the operator should complete the bottom page with the requested data. The manual should then be read CAREFULLY and kept in a safe file for future reference. It should always be available to the qualified operating and maintenance personnel responsible for the safe operation of the pump or system.

Definition of "Authorized person or person"

The pages of this manual for "authorized person or personnel" refer to those who, due to their experience, training and knowledge of accident prevention regulations, have been instructed by the plant manager to intervene for the adjustment, maneuvering and maintenance operations of the job they perform within the company organization.

IMPORTANT!

The pump is to be used only for the applications specified on the confirming order for which POMPETRAVAINI has selected the design, materials of construction and tested the pump to meet the order specifications. Therefore the pump CANNOT be used for applications other than those specified on the order.



In the event the pump is to be used for different applications, please contact the sales office or representative of the manufacturer. POMPETRAVAINI declines to assume any responsibility if the pump is used for different applications without prior written consent confirmation.

Pumps are for industrial and continual use in installations fit for the purpose by authorized and trained personnel. The use in unfit or unprotected installations, without proper precautions preventing the contact with untrained personnel or children, is strictly forbidden.

If construction and operation data of the pump in question are not available must be requested to POMPETRAVAINI specifying the type and serial number printed on the nameplate (see example at side) easily identifiable on the pump itself: always refer to it to request additional technical information and/or ordering spare parts.

The user is responsible for the verification of the ambient conditions where the pump will be stored or installed. Extreme low or high temperatures may severely damage the pump or system unless proper precautions are taken.

POMPETRAVAINI does not guarantee repairs or alterations done by user or other unauthorized personnel.

Special designs and constructions may vary from the information given in this manual. Please contact POMPETRAVAINI should you have any difficulty or doubt.

 ISO 9001 Certified pompetravaini S.p.A. 20022 CASTANO PRIMO (MILANO) - ITALY	
PUMP TYPE 	
SERIAL NO.	YEAR
ITEM	
Q m ³ /h	KW abs.
H m.c.l.	mbar

NOTE: Drawings appearing in this manual are only schematics. These drawings are not for construction. For construction drawings contact POMPETRAVAINI or the authorized local representative.

1.2 - READING THE INFORMATIONS MARKED ON PUMP'S NAMEPLATES AND SERVICE CARDS

The machinery Directive 2006/42/EC and the ATEX Directive 2014/34/EU require the marking of certain information on the pump's nameplates. The pump nameplate must be applied so that it is not easily removable and remains legible for long time.

Furthermore, according to the regulations in force, it is necessary to provide the machines with a document, the Declaration of Conformity, to the safety requirements imposed by the Machinery Directive for all pumps (usually named as EC Declaration of Conformity) and to the ATEX Directive for pumps intended for use in environments subject to the directive (usually named ATEX Declaration of Conformity).

Pompetravaini has chosen to make each Declaration supplied with the pump's documentation unique, applying on it an adhesive tag that incorporate the information of the pump nameplate applied on the pump.

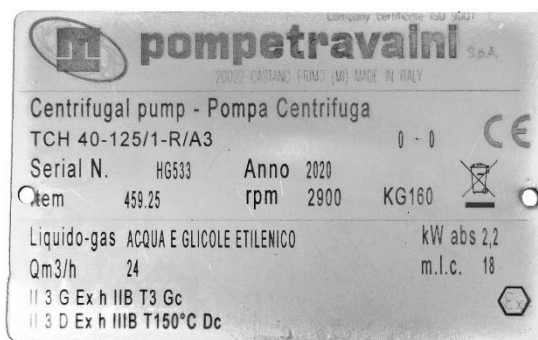
In this way each Declaration of conformity is uniquely identified with the same serial number as the pump for which it was issued. By convention in Pompetravaini this tag is called Service Card.

Markings on nameplates of pumps and vacuum systems

The pump nameplate must bear all the all the mandatory information required by the applicable directives (Machinery Directive and ATEX Directive if requested). The appearance and arrangement of the markings on the nameplate may differ depending on the type of pump and the recipient of the pump. Or for some branches of Pompetravaini customized executions are provided. The minimum information required by the regulations remains present in the various possible configurations.

The vacuum system packages are provided with a single nameplate that identify them as an assembly of pump, or pumps, with vessel and accessories. The system nameplate is applied on the body of the vacuum pump (or on the pumps if the system has more than one) and the serial number is unique for the whole system.

For Pompetravaini everything that is supplied as a vacuum package, identified by the serial number on the nameplate and for the bill of material associated to the serial number, it is integral part of the package and therefore included in the EC Declaration of Conformity and also ATEX Declaration of Conformity if required by the Order Confirmation.



Pompetravaini nameplate shows:

- Name of the manufacturer and address: *Pompetravaini spa*
- Pump type, es.: *Centrifugal pump- Pompa centrifuga*
- Model, es.: *TCH 40-125/1-R/A3*
- Serial number es.: *HG533*
- Year (of production), es.: *2020*
- Number of Item (of the customer), es.: *459.25*
- Turn by minute/rpm, es.: *2900*
- Weight, kg, es.: *160*
- Pumped fluid, liquid or gas, es.: *Water and glycol*
- Absorbed flow, kW abs, es.: *2,2*
- Requested power, Q, m3/h: *24*
- Pump head, m.c.l., es.: *18*
- ATEX markings (when applicable), es.: *II 3 G Ex h IIB T3 Gc*
- Second line of ATEX markings (when applicable), es.: *II 3 D Ex h IIB T150°C Dc*

The lasts are the ATEX markings, that begin with a string of characters identifying the level of protection of the pump. The first row is the ATEX marking that refer to a use in a Zone classified for Gas. The second row is the ATEX marking that refer to a use in a Zone classified for Dust.

There could be another string, for example for the Technical File 8TCx19R006) if necessary.

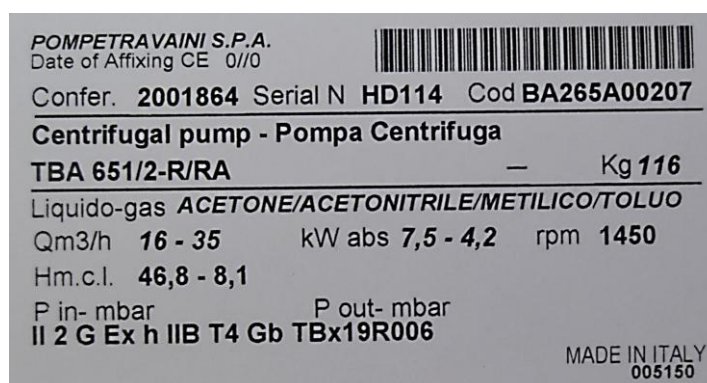
There are also symbols identifying some particularities of the pumps and systems.

The EC symbol  identify a product subject to the Machinery Directive 2006/42/CE.

The trash bin symbol  identify a product subject to the WEEE Directive 2012/19/EU

The symbol EX  identify a pump that is also subject to the ATEX Directive 2014/34/EU

Markings on Service Card of pumps and vacuum systems



The Service Card tag applied on the Declaration of Conformity of the pump or vacuum system shows:

La Service Card applicata sulle Dichiarazioni di Conformità della pompa o dell'impianto riporta:

- Name of the manufacturer and address: *Pompetravaini spa*
- Issue date of the Service Card, es.: *01/04/2020*
- Barcode identifying the production order
- Confirmation of Order number, es.: *2001864*
- Serial number es.: *HD114*

- Pump code, es.: *BA265A00207*
- Pump type, es.: *Centrifugal pump- Pompa centrifuga*
- Model, es.: *TBA 651/2-R/RA*
- Weight, kg, es.: *116*
- Pumped fluid, liquid or gas, es.: *Acetone*
- Requested flow, Q, m3/h: *16*
- Absorbed power, kW, es.: *7,5*
- Turn by minute/rpm, es.: *1450*
- Pump head, for centrifugal pumps, m.c.l., es.: *46,8*
- Suction pressure, for vacuum pumps, P in mbar, or discharge P out – mbar, for vacuum pumps
- ATEX markings (when applicable), es.: *II 2 G Ex h IIB T4 Gb TBx19R006*

The Service Card bears all the information of the pump nameplate and still others more as complement.

For the management system of Pompetravaini, starting with the serial number of the pump or vacuum system it is possible to uniquely identify the product code and its bill of material.

This allows to associate everything provided with the order confirmation sent to the customer.

The code shown on the Service Card includes the pump as the main element, but also the electric motor, vessel or other equipment and instruments included in the supply and included in the bill of material corresponding to the code.

On the Service Card are not marked the same symbols of the nameplate because it is requested by the norms and to have more space for other information.

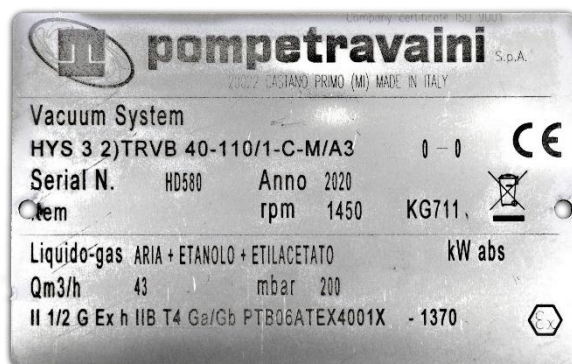
The EC Declaration of Conformity on which the Service Card is applied, such as the declaration of conformity to the ATEX Directive, they are thus inclusive of everything that is part of the bill of materials associated with the specific code.

Pompetravaini has taken care of assessing that all other equipment and accessories supplied and included in the bill of material are compliant with CE and ATEX requirements and guarantee a degree of protection equal to or higher than that of the pump they are coupled to.

Each device, instrument or accessory has been selected and assembled by Pompetravaini according to the manufacturer's instructions and so as not to compromise its certifications which are provided together with the Pompetravaini documentation.

In the case of pump assemblies coupled with other accessories subject to the ATEX Directive 2013/34 / EU, all the certifications of the individual components issued by their manufacturer remain valid, Pompetravaini has brought everything together in a functional whole.

An example of nameplate for a vacuum system:



- Name of the manufacturer and address: *Pompetravaini spa*
- Pump type, es.: *Vacuum System*
- Model, es.: *HYS 3 2) TRVB 40-110/1C-M/A3*
- Serial number es.: *HD580*
- Year (of production), es.: *2020*
- Number of Item (of the customer), es.: *---*
- Turn by minute/rpm, es.: *1450*
- Weight, kg, es.: *780*
- Pumped fluid, liquid or gas, es.: *Air + Ethanol + Ethilacetate*
- Absorbed power, kW abs, es.: *---*
- Requested power, Q, m3/h: *43*
- Pump head, m.c.l., es.: *200*
- ATEX markings (when applicable), es.: *II 1/2 G Ex h IIB T4 Ga/Gb PTB06ATEX4001X – 1370*

In this case the ATEX marking is for a vacuum system intended for an application with an atmosphere classified as Zone 0 inside and Zone 1 outside, therefore it includes the code of the certificate received from the Notified Body (*PTB06ATEX4001X*) and the code of the Notified Body that deals with production surveillance (*1370*).

2 - SAFETY INSTRUCTIONS



CAUTION:
CAREFULLY READ FOLLOWING INSTRUCTIONS.

Strictly adhere to the instructions listed below to prevent personal injuries and/or equipment damage.

- ALWAYS apply the pump for the conditions outlined on the confirming order.
- Be ALWAYS informed on locations of first aid sites inside the company and carefully read safety and medical first aid prescriptions in force.
- ALWAYS have a fire extinguisher in the vicinity of the pump installation.
- Any work on the pump must ALWAYS be carried out by at least 2 qualified people and expressly authorized.
- Electrical connections on the motor or accessories must ALWAYS be carried out by authorized personnel and in accordance to the local codes.
- When approaching the pump ALWAYS be properly dressed (avoid use of clothes with wide sleeves, neckties, necklaces, etc.) and/or wear safety equipment (hard hat, safety glasses, safety shoes, etc.) adequate for the work to be done. Also refrain from wearing long and loose hair.
- DO NOT attempt to remove the safety guards when the pump is operating.
- After completion of the work ALWAYS re-install the safety guards previously removed.
- DO NOT operate the pump in the wrong direction of rotation.
- NEVER put hands or fingers in the pump openings or holes.
- ALWAYS disconnect the power to the motor prior to working or removing the pump from the installation.
- Make sure you have taken the necessary steps to prevent a possible inadvertent return of tension.
- Ensure the proper isolation of the components and ground connection before inserting the tension.
- ALWAYS stop the pump prior to touching it for whatever the reason. Wait for the complete pump stopping and make sure that all the installation control devices are properly set in order to avoid any return flow.
- Pump and piping connected to the pump must NEVER be under pressure when maintenance or repair is carried out.
- NEVER work on the pump when it is hot.
- NEVER touch pump or piping having temperatures higher than 70°C or lower than -10°C.
- ALWAYS be careful when handling pumps that convey acids or hazardous fluids.
- NEVER step on pump and/or piping connected to the pump.
- ALWAYS make sure that the pump is permanently fixed and steady to the installation (i.e. during removal, handling, installation, etc.)

DANGER!

Possible contact with hazardous media and hazardous substances There are certain components in the pump which may be dangerous to people coming in their contact even during normal operation procedures and/or maintenance, see table 1.

Take care of their possible disposal according to the laws into force and to a safe local environment management.



CAUTION!

Danger due to smokes or vapours. In case smokes or vapours are released by the pump do not inhale and immediately stop the pump for inspection.

Tab. 1

MATERIAL	USE	POSSIBLE DANGER
Oil and Grease	General lubrication, ball or roller bearings	Skin and eye irritation
Plastic and elastomer components	O-Ring, V-Ring, Splash ring, Oil seals	Release of fumes and vapours when overheated
Teflon & Kevlar fibres	Packing rings	Release of dangerous powders, release of fumes when overheated
Varnishes	Exterior pump surface	Release of powder and fumes in case of rework, flammable
Liquid compound	Gasket between flat surfaces	Skin, eye and breathing organs irritation
Protective liquid	Pump inside surface	Skin and eye rash

3 - IN CASE OF EMERGENCY

Should the pump break down leak gas and/or service liquid, immediately disconnect the electrical power following the instructions given in chapter 11. Alert the maintenance personnel, at least two people should intervene using precautions as it is required for the specific installation: pump may be handling dangerous and/or hazardous fluids.

After correction of all the problems that created the emergency situation, it is necessary to carry out all the recommended starting procedures (see chapter 10).

3.1 - BASIC FIRST AID

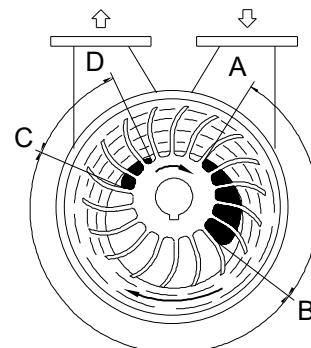
In the event dangerous substances have been inhaled and/or have come in contact with the human body, immediately contact the medical staff and follow the instructions given by the company's internal medical safety procedures.

4 - PUMP OUTLINES

The instructions given in this manual are for liquid ring vacuum pumps and compressors and for systems type HYDROSYS or OILSYS which utilize said pumps.

NOTE: Capacities, vacuum and pressures are nominal and are the maximum attainable values under standard operating conditions. Please contact POMPETRAVAINI for data on liquid ring compressors series TR...

TRM	Single stage liquid ring vacuum pumps Capacity to 350 m ³ /h, max vacuum 33 mbar
TRS	Single stage liquid ring vacuum pumps Capacity to 3500 m ³ /h, max vacuum 150 mbar
TRV	Single stage vacuum pumps Capacity to 1050 m ³ /h, max vacuum 33 mbar
TRH	Two stage liquid ring vacuum pumps Capacity to 3500 m ³ /h, max vacuum 33 mbar
SA	Double acting liquid ring compressors Capacity to 180 m ³ /h, pressures to 10 bar



4.1 - PRINCIPLE OF OPERATION (See figure at side)

The aspirated gas enters the pump chamber A-B via the pump suction flange. The gas is trapped between 2 impeller vanes. The impeller rotates eccentrically in relation to the centreline of the liquid ring that, by centrifugal force, assumes the shape of the impeller casing. The progressive change of volume between the 2 vanes, the impeller hub and the liquid ring first create a vacuum and then a compression of the gas in the B-C area till the gas is discharged, together with a portion of the liquid, through the discharge port C-D. The lost liquid must then be replenished.

4.2 - SERVICE LIQUID PROPERTIES

For a good operation the liquid ring pumps must be supplied with a service liquid which is clean, non-abrasive and free of any solids.

The service liquid temperature should not exceed 80°C and the gas handled should be maximum 100°C; the liquid density should be between 800 and 1200 g/dm³ and the viscosity should be less than 40 cSt (the pump performance will change if the service liquid has properties different than those of water at 15°C). All engineering data is based on the use of 15°C as service liquid, see chapter 19 for additional information.

Contact POMPETRAVAINI before using liquids with properties outside the ranges listed above.

In case the metallic pump wetted parts come into contact with aggressive liquids it is recommended to stick to the following limitations:

- pH limit for cast iron and ductile iron ≥ 6
- pH limit for stainless steel $\geq 2,5$

The above values are approximate and refer to ambient temperature. It is recommended to contact POMPETRAVAINI for doubts, particular conditions or in case different materials are used.

4.3 - PUMP MODELS AND TABLES FOR MATERIAL OF CONSTRUCTION

On the pump nameplate are printed the pump serial number, the year of manufacture and the pump model. Refer to the following example for understanding the coding of the pump model.

Every letter or number in the pump model designation has a specific meaning relating to the pump design.

Example of pump model number:

T R H C 80 - 750 / C - M / GH - Z			
T	⇒ Manufacturer POMPETRAVAINI	C	⇒ C = Shaft sealing by mechanical seal B = Shaft sealing by stuffing box
R	⇒ Liquid ring pump	M	⇒ Monoblock design with motor flange (upon request)
H	M and V = Single stage pump with high vacuum ⇒ S = Single stage pump with medium vacuum H = Two stage pump with high vacuum	GH	⇒ Material of construction GH - F - RA - A3 (see following table)
C	⇒ Revision of hydraulic design	Z	⇒ Special design
80	⇒ Ø Flange size (mm)		
750	⇒ Nominal capacity in m ³ /h		

T R V X 100 7 / 1 - C / A3 - M / Z			
T	⇒ Manufacturer POMPETRAVAINI	1	⇒ Constructive project number

R ⇒ Liquid ring pump	C ⇒ Shaft sealing by mechanical seal
V ⇒ M e V = Single stage pump with high vacuum	A3 ⇒ Material of construction
X ⇒ Stainless steel hydraulic plate version	F - RX - A3 (see following table)
100 ⇒ Ø Flange size (mm)	M ⇒ Monoblock design with motor flange
7 ⇒ Nominal size rate	Z ⇒ Special design

STANDARD materials of construction

VDMA	Description	GH	F	RA	A3
106	Suction casing	Cast iron			Stainless steel AISI 316
107	Discharge casing				
137	Intermediate plate				
110	Centre body				
210	Shaft	Stainless steel AISI 420			
147	Manifold	Carbon steel			
357	Bearings & M. S. housing	Cast iron			
230	Impeller	Bronze	Ductile iron	Stainless steel AISI 316	

For additional details regarding standard or special materials contact POMPETRAVAINI.

Models for systems HYDROSYS and OILSYS are made out of a number which indicates the system size, followed by the pump model number which is fitted in the system.
(ex.: HYDROSYS 5 – TRHB 50-420/C – M / GH).

5 - UNPACKING, LIFTING AND MOVING INSTRUCTIONS

Upon receipt verify that the material received is in exact compliance with that listed on the packing slip.

When unpacking follow the instructions listed below:

- check for visible damages on the crate that could have occurred during transport
- carefully remove the packaging material
- check that pump/or accessories such as tanks, piping, valves, etc. are free from visible markings such as dents and damage which may have occurred during transportation
- in the event of damage, report this immediately to the transport company and to POMPETRAVAINI's customer service department.

DANGER!

Danger due to cut, prick or abrasion. Take immediate actions to dispose of possible packaging parts that may generate injuries or risks (for example edges, nails, splinters, etc.).



Organize the right management of materials subjected to controlled and differentiate disposal according to the laws into force and to a safe environment management. The packaging could consist of the following materials: wood **FOR50** and/or cardboard **PAP20** and/or cellophane **LDPE 04** and/or stretch wrap **PE-LD 04** and/or polystyrene **PS06** and/or packing strap **PET1, PP05** (D.I.gs. 116/2020 and Decision 97/129/CE).

If the pump will be stored, as foreseen in our Operating Manuals, we recommend a proper care to avoid oil dropping on the ground.

The pump or assembly must ALWAYS be moved and transported in the horizontal position.

Prior to moving the unit find the following:

- total weight
- center of gravity
- maximum outside dimensions
- lifting points location.

DANGER!

Danger due to overturning or crushing. For safe lifting to prevent material damages and/or personal injuries, it is recommended to use ropes, or belts properly positioned on the pump and/or lifting eyebolts and make correct movements.

Operate provided with apposite protective devices.

(For the Oilsys systems see chapter 21).

The fig. 1 and 2 show several additional examples of lifting.

Avoid lifts whereby the ropes or straps, form a triangle with the top angle over 90°(see fig. 3).

Lifting eyebolts fitted on single components of the assembly (pump or motor) should not be used to lift the total assembly.

The fig. 4 shows several additional examples of lifting to be avoided.



CAUTION!

Possible contact with fluids or harmful substances. Before removal after a period of operation, the pump, together with auxiliary piping and jacketing, must be drained and decontaminated from the handled media. Every hole and opening communicating with the inside of the pump must be properly plugged. For removing the pump from the installation see chapter 19. Operate provided with apposite protective devices.

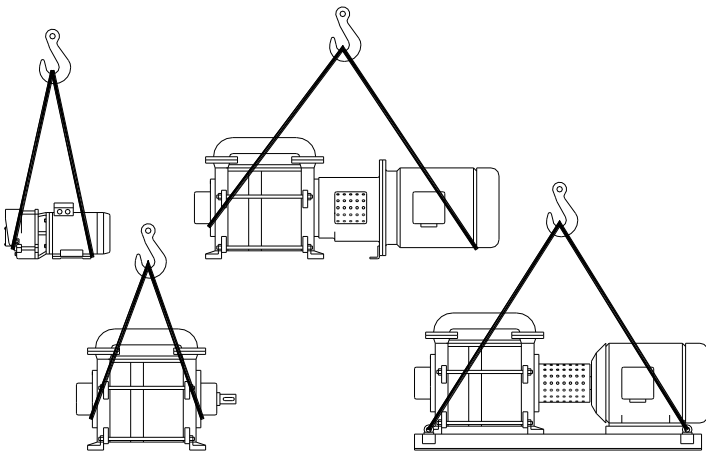
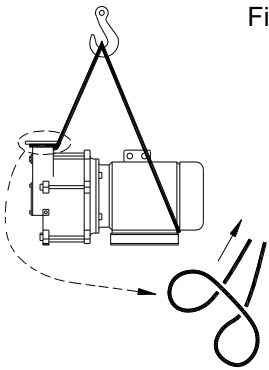


Fig. 1



OK

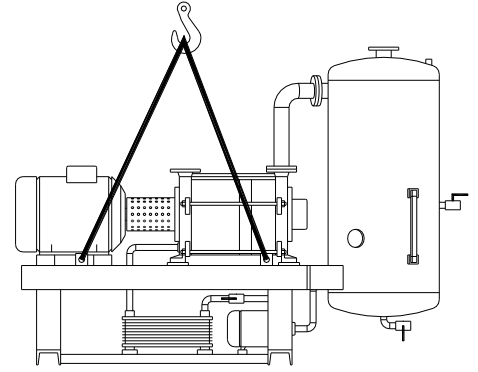
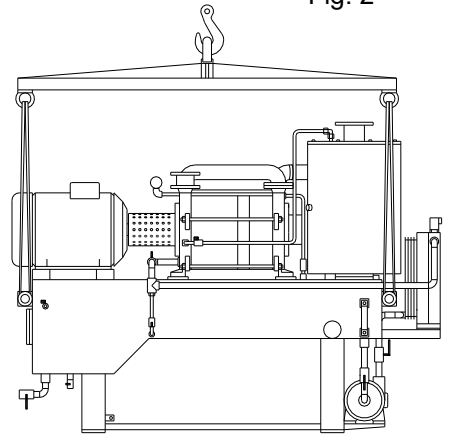
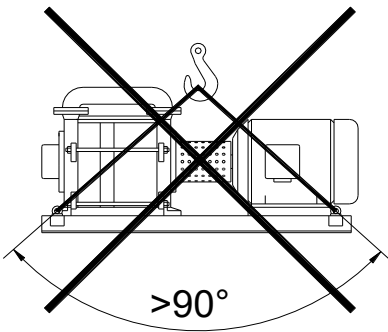


Fig. 2



(For the Oilsys systems see chapter 21)

Fig. 3



NO

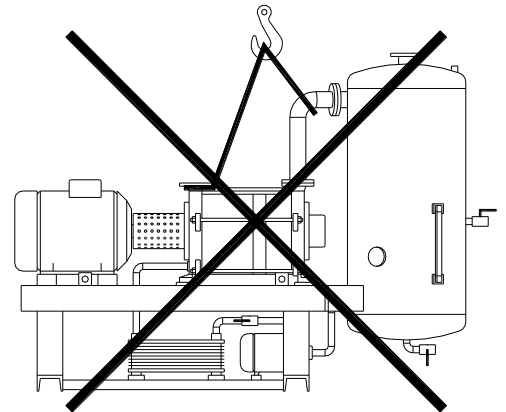
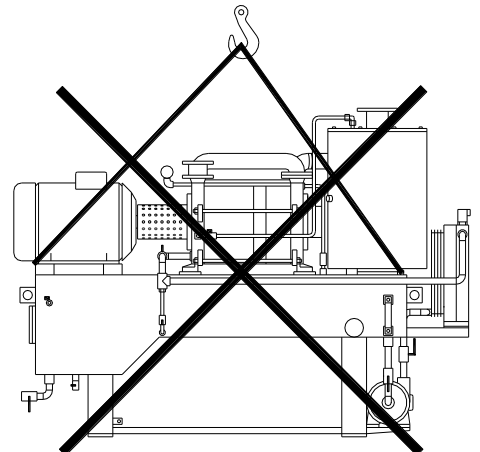
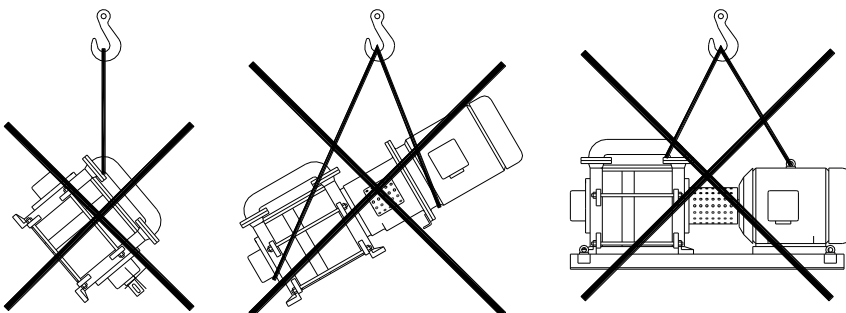


Fig. 4



6 - STORAGE INSTRUCTIONS

After receipt and inspection, if not immediately installed, the unit must be repackaged and stored.

For a proper storage proceed as follows:

- store the pump in a location that is closed, clean, dry and free of vibrations
- do not store in areas with less than 5°C temperature (for lower temperature it is necessary to completely drain the pump of any liquids that are subject to freezing).

POSSIBILITY OF FREEZING!



Where the ambient temperature is less than 5°C it is recommended to drain the pump, piping, separator, heat exchanger, etc. or add an anti-freeze solution to prevent damage to the equipment.

It is possible to use as antifreeze a mixture of surface-active glycol or other suitable products making sure they are compatible with both pump gaskets and elastomers.

- fill the pump with a rust-preventative liquid that is compatible with the pump gaskets and elastomers. Rotate the shaft by hand to impregnate all internal surfaces. Drain the excessive liquid from the pump and associated piping (see chapter 11).

Please note that the pumps with cast iron internal parts have been treated at the factory, prior to shipment, with a rust-preventative liquid: this liquid is capable of protecting the pump against rust for a period of 3 to 6 months.

A further solution, for long term storage, is to fill the pump with the rust inhibitor, rotate the pump shaft by hand to eliminate any air pockets (the liquid must be suitable with gasket, elastomers and pump materials).

- plug all openings that connect the pump internals to the atmosphere
- protect all machined surfaces with an anti-rust material (grease, oils, etc.)
- cover the unit with plastic sheet or similar protective material
- rotate pump shaft at least every three months to avoid possible rust build-up or seizing
- keep the pump in a dry and clean place not subjected to vibrations caused by other sources
- pump accessories should be subjected to similar procedure.

7 - INSTALLATION INSTRUCTIONS

CAUTION!



Avoid installing the unit in narrow areas and lacking of ventilation where unfavorable conditions for the personnel may take place. Allow the personnel a good visibility of the pump assembly by providing a proper lighting.

CAUTION!

A proper pump installation must not transmit vibrations to ambient in the permanent presence of personnel.

Information to determine the piping sizes and floor space requirements can be obtained from dimension drawings and other engineering data. The information required is:

- size and location of suction and discharge flanges
- size and location of service liquid connection and connections for cooling, heating, flushing, draining, etc.
- location and size for mounting bolts for monoblock pump and/or baseplate and/or frame.

In the event additional accessories are required to complete the installation such as separators, piping, valves, etc. refer to chapters 7.2 to 7.8.

Proper lifting devices should be available for installation and repair operations.

Pump assembly should be installed in an accessible location with adequate clear and clean space all around for maintenance, so that an efficient and proper installation can be made.

It is important to have proper room around the unit for ventilation of motor and air-cooled radiator, if applicable. Avoid installing the unit in hidden locations, dusty and lacking of ventilation (minimum 0,6 meters of empty room around).

Select a mounting pad that will minimize vibrations or torsion of the pump baseplate or frame. It is generally preferred to have a concrete base or sturdy steel beams. The installation must not transmit vibrations to the pump.

It is important to provide adequate anchor bolting for the pump frame or baseplate to be firmly attached to the foundations (see fig. 5).

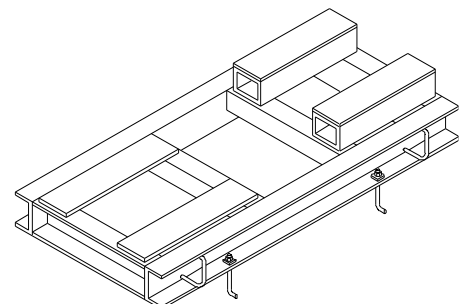
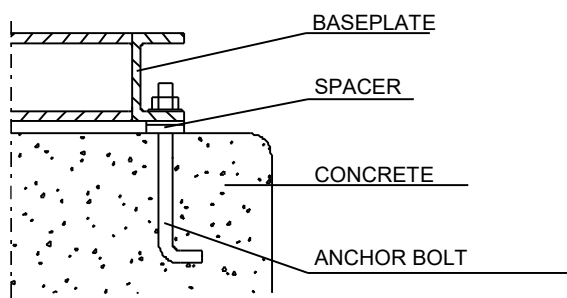


Fig. 5

Concrete pads and other concrete works must be aged, dry and clean before the pump assembly can be positioned in place. Complete all the work relating to the foundations and grouting of the pump assembly, before proceeding with the mechanical and electrical portion of the installation.

7.1 - PIPING CONNECTIONS

Identify first locations and dimensions of all connections required to interconnect the pump with the installation, then proceed with the actual piping: connect the pump suction and discharge flanges, the service liquid line and all other service connections (see fig. 6 to 15).



CAUTION!

Possible contact with hazardous media and hazardous substances, cold or warm.

Be sure to pipe the correct connection from the installation to the respective pump connection! operate only provided with apposite protective devices.

To prevent any limb or foreign matters from entering the pump during installation, do not remove protection cap from flanges or cover from openings until the piping is ready for hook-up.

Verify that all foreign objects such as welding bits, bolts, nuts, rags and dirt are removed from piping, separators, etc. before these are connected to the pump.

Flanges should be connected parallel with each other, without stress and with bolt holes lined up. The weight of the pipe must not weigh on the pump.

The flange gaskets should not interfere with the inside diameter of piping and/or flange.



All piping must be independently supported, easily located and must not transmit forces or torque to the pump due to the weight or to thermal expansions.

Piping size must never be less than the respective connection on the pump.

Suction and discharge flanges are vertical and identified with arrows.

To minimize friction losses and back-pressures, the discharge piping should be one size larger than the pump connection size. To avoid back-pressure and possibility of flooding the pump when it stops, it is recommended to limit the rise of the discharge piping to approximately 50 cm above the pump discharge flange.

Upon completion piping and connections should be tested for leakage under vacuum.

7.2 - ACCESSORIES

Listed below are common accessories that may be supplied with the pump or added at a later date. See fig. 6 to 15 for locations and connection sizes on the pumps.

Non return valve, (check valve)

Prevent back-flow of gas and liquid in the suction piping and/or discharge piping when the pump stops.

Is installed on the pump suction flange in the case of vacuum service or on the pump discharge flange in the case of compressor service.

Vacuum relief valve

It is used to protect the pump from cavitation or to regulate the suction minimum pressure (or max vacuum).

When the pump capacity exceeds the system load at a given vacuum, the relief valve opens letting in atmospheric air or gas (if connected to the discharge separator) keeping constant the pre-set vacuum.

Automatic draining valve

It is used to drain the pump to the shaft centerline when the pump stops so to prevent that the pump has excessive liquid for the next start-up. Starting the pump full or with too much liquid could severely damage the pump.

Vacuum gauge

Usually installed under the pump suction flange, will provide an indication of the pump operating vacuum (pressure).

Discharge reservoir separator

It separates the service liquid from the gases at the pump discharge.

It can be mounted on the pump discharge flange (type HSF) or on the pump baseplate (type HSP).

It is required when the system is with partial or total recovery of the service liquid.

Heat exchanger

It cools the service liquid for those systems with total liquid recovery: it can be plate and frame type, shell and tube type or radiator type, depending upon the application.

Filter

Required to stop solids from entering the pump suction. Sizing of the filter is very important as it could create excessive pressure drops which would affect the pump performance.

7.3 - INSTALLATION SCHEMATICS FOR LIQUID RING VACUUM PUMPS



CAUTION!

Possible contact with hazardous media and hazardous substances, cold or warm. Operate only provided with apposite protective devices.

The working principle of the vacuum pump requires a continuous flow of fresh and clean liquid that enters the pump at the service liquid connection identified by the letter Z (see chapter 7.11). The liquid is discharged together with the handled gas through the pump discharge flange.



Dispose the waste liquids according to the current regulations protecting the environment. The obtained liquid-water mixture must be collected and, according to the environmental disposal regulations, treated as special liquid.

The quantity of said liquid will vary with pump size and degree of working vacuum (see performance curves and/or tab. 2). The service liquid absorbs the compression heat generated by the pump compression therefore its temperature will rise by some 3-4°C (for additional information see chapter 19).

There are three basic installation schematics listed below that may be considered, depending upon the quantity of service liquid that is desired and possible to be recycled.

7.3.1 - Service liquid: Once-through system (no recovery)

All the service liquid is supplied from an external source. The liquid is separated from the incoming gas in the discharge separator and is totally drained.

This is the most common installation scheme and can be applied when it is available an abundant constant flow of fresh liquid and/or when the liquid contamination problem never exists.

The service liquid should be supplied at the pump connection with a pressure of 0.4 bar maximum to avoid flooding the pump with too much liquid. If this is not possible it is recommended to install a reservoir fitted with a float valve, this tank is supplied with the liquid that is then pulled by the pump as required by the operating conditions.

The liquid level in the reservoir should be approximately at the pump shaft centerline.

Schematic fig. 6 illustrates the once-through system.

7.3.2 - Service liquid: Partial recovery system

This type of installation is used where it is desired to minimize the use of fresh service liquid (for calculations see chapter 19).

The service liquid enters and leaves the pump same as the once through system, however part of the liquid is recycled from the discharge separator and the balance is continuously supplied from an external source. The excessive liquid is drained through the separator overflow connection: take care of its possible disposal according to the laws into force and to a safe local environment management.

The temperature of the mixed liquid supplied to the pump will be higher than the temperature of the make-up liquid. Its final temperature will depend upon the amount of the recycled liquid.

It is important to remember that with higher service liquid temperature the pump performance will decrease (see chapter 19) with the possibility of operating the pump in the cavitation area.

When the separator/reservoir is installed along side of the pump (type HSP), its liquid level should not be above the pump shaft centerline.

When flanged separators (type HSF) are mounted on the pump discharge flange, the liquid level is automatically maintained by the location of the connections.

Schematic fig. 7 illustrates the system with partial recovery of the service liquid.

7.3.3 - Service liquid: Total recovery system

This system has total recycle of the service liquid without fresh liquid make-up from an outside source.

A heat exchanger is required to lower and control the temperature of the recycled service liquid: for sizing and calculations of heat loads see chapter 19.

A circulating pump will be required for those applications where the vacuum pump operates for extended period of times in the pressure ranges above 500/600 mbar or when there are high pressure drops in the closed loop including the heat exchanger (over approximately 1,5 m).

The liquid level in the separator/reservoir should not be above the pump shaft centerline.

Losses of liquid from the closed loop must be compensated with an equal amount from an outside source.

Schematic fig. 8 illustrates the system with total recovery of the service liquid.

7.4 - INSTALLATION SCHEMATICS FOR LIQUID RING COMPRESSORS

The liquid ring vacuum pump can also operate as a compressor up to a maximum differential pressure, depending upon the models, of about 2 bar. The compressors series SA are specifically engineered to perform with differential pressures of up to 10 bar, depending on models.

The principle of operation is same as given in previous paragraph (7.3 for vacuum pumps) and there are three possible type of installations: once-through service liquid, partial recovery service liquid and total recovery service liquid.

The service liquid entering the compressor connection should have a pressure of minimum 0,4 bar g above the compressor operating inlet pressure. A booster pump will be required if the service liquid is available at lower pressures.

Separator/reservoir is considered a pressure vessel and as such it must be engineered and built to the applicable codes (ISPEL, ASME, PED, etc.). Accessories such as pressure relief valve, check valve (non-return valve), automatic float type drain valve (water trap), etc. are required in a compressor system.

Fig. 9, 10 and 11 illustrate the three possible types of installations.

7.5 - INSTALLATION OF "HYDROSYS" SYSTEMS

HYDROSYS systems are factory assembled and piped including discharge separator/reservoir, heat exchanger (air/liquid or air/air), circulating pump, and all required accessories mounted on a common compact baseplate/frame. See chapter 20 for additional details.

Installation of HYDROSYS system is similar to that of a vacuum pump or a compressor with partial recovery or total recovery of service liquid depending upon the application (see chapter 7.3 or 7.4).

It is important to properly engineer the connecting piping to the system suction and discharge, cooling lines, flushing lines, and draining lines.

The used heat exchanger is designed with service liquid being cooled approximately 4 to 6°C over the available cooling media temperature. The cooling liquid flow is approximately same as the service liquid flow needed by the pump at the operating conditions (see chapter 7.7 or 7.8).

Schematics for once-through, partial and total service liquid recovery are shown in fig. 7 - 8 - 10 - 11.

7.6 - INSTALLATION OF "OILSYS" SYSTEMS

CAUTION!



Possible contact with hazardous media, cold or warm, and pump surfaces, cold or warm. During the functioning the pump, the separator tank and pipes connections may reach temperatures higher than 60°C. In case, adopt the necessary precautions and protection to satisfy the safety regulations in force. Operate only provided with apposite protective devices.

OILSYS are factory packaged systems including liquid ring vacuum pump using oil for service liquid. For additional details see chapter 21. The system is complete with oil circulating pump, heat exchanger, oil demister, cyclone for removal of dust (optional) and other accessories upon request.

Installation is simple and does not require additional details other than those already discussed in the previous chapter.

Suction and discharge piping should be connected to the respective pump flanges. When locating the discharge piping it should be noted that although the system is fitted with oil demister, there may still be traces of oil fumes carried by the vented gas. Make sure therefore, that the selected area for vacuum pump discharge is suitable for such purpose.

All other connections, (heat exchanger, draining, etc.) must be properly done. See fig. 48 for location of connections.

7.7 - SERVICE LIQUID (H₂O at 15°C) FLOW (in m³/h) FOR VACUUM PUMPS

The listed values are referred to the system with "Once-through" service liquid, handling dry air at 20°C (for more specific data see the pump's performance curve).

To reduce the amount of service liquid flow read the information given in chapter 19.

If the pump is handling saturated or condensable gases at relatively high temperatures, there will be condensation inside the pump. In those cases, the service liquid flow listed below can be increased up to 25% to reduce the discharge temperature and minimize the danger of pump cavitation at high vacuum.

Tab. 2

PUMP MODEL	SUCTION PRESSURE (in mbar)		
	33 - 200	> 200 - 600	> 600
TRH 32-4	0,20	0,20	0,16
TRH 32-20	0,36	0,30	0,28
TRH 32-45			
TRH 32-60	0,90	0,70	0,60
TRH 40-110			
TRH 40-140			
TRH 40-190	1,00	0,85	0,70
TRH 50-280	2,40	1,70	0,90
TRH 50-340	3,00	2,22	1,20
TRH 50-420	3,60	2,76	1,60
TRH 80-600	2,50	1,98	1,30
TRH 80-750	3,00	2,40	1,60
TRH 100-870	7,40	5,70	3,80
TRH 100-1260			
TRH 100-1600			
TRH 150-2000	12,00	9,60	6,00
TRH 150-2600	13,20	11,10	6,60
TRH 150-3100	16,20	14,10	8,70

PUMP MODEL	SUCTION PRESSURE (in mbar)	
	200 - 600	> 600
TRS 32-20	0,34	0,24
TRS 32-50		
TRS 40-55	0,78	0,44
TRS 40-80		
TRS 40-100	0,96	0,57
TRS 40-150	1,17	0,72
TRS 50-220	2,40	1,29
TRS 100-550	2,90	1,74
TRS 100-700	3,30	2,10
TRS 100-980	9,00	5,40
TRS 125-1250	8,70	4,20
TRS 125-1550	9,90	4,50
TRS 200-1950	18,00	11,40
TRS 200-2500	20,10	11,70
TRS 200-3100	25,80	17,40

PUMP MODEL	SUCTION PRESSURE (in mbar)		
	33 - 200	> 200 - 600	> 600
TRM 25-30	0,24	0,18	0,12
TRMX & TRVX 257	0,30	0,23	
TRM 32-50	0,48	0,24	0,15
TRM 32-75	0,72	0,41	0,34
TRMX 327	0,63	0,53	0,36
TRM-TRV 40-110	1,20	0,80	0,50
TRM-TRV 40-150			0,54
TRM-TRV 40-200	1,30	0,90	0,60
TRMX & TRVX 400	1,14	0,72	0,54
TRM-TRV 50-300	1,60	1,20	0,80
TRMX-TRVX 503			
TRV 65-300			
TRV 65-450	2,40	1,68	0,90
TRVX 650			
TRVX 1000	2,60	1,80	1,30
TRVX 1250	5,25	3,64	2,76
TRVN 40-70	0,25	0,23	0,21
TRVN 40-110	0,50	0,49	0,45
TRVN 65-250	2,00	1,80	1,00
TRVN 80-350	2,0	1,95	1,85
TRVN 80-500	3,00	2,50	2,00
TRVN 80-600	3,4	3,1	2,7

For the above pumps running as compressors without the specific performance curves, please contact POMPETRAVAINI.

7.8 - SERVICE LIQUID FLOW (H₂O at 15°C) AND PRESSURE FOR COMPRESSORS SERIES "SA"

Values are applicable when the compressor suction is barometric pressure (1013 mbar) and the gas is air at 20°C.

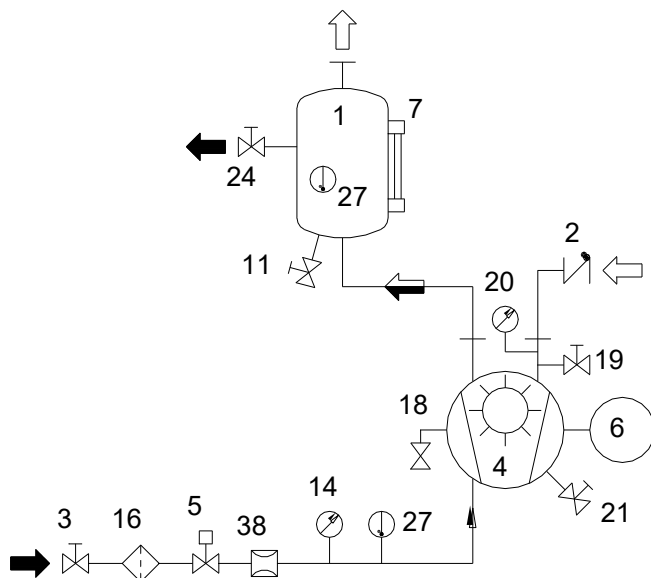
SA0E3U	= 0,90 m ³ /h	} constant throughout the field work
SA0G2D	= 1,00 m ³ /h	
SA0G2G	= 1,50 m ³ /h	

The minimum pressure inlet of the service liquid should be (according to the use of the compressor):

SA0E3U	= 0,90 m ³ /h at minimum pressure of 2,5 to 3 bar
SA0G2D	= 1,00 m ³ /h at minimum pressure of 2 to 3,5 bar
SA0G2G	= 1,50 m ³ /h at minimum pressure of 2 to 3,5 bar

7.9 - TYPICAL INSTALLATION SCHEMATICS FOR VACUUM PUMPS

Fig. 6



- 1 Separator/reservoir
- 2 Non return valve
- 3 Shut off valve
- 4 Liquid ring vacuum pump
- 5 Solenoid valve
- 6 Electric motor
- 7 Level gauge glass
- 8 Float valve
- 9 Heat exchanger
- 10 Make-up solenoid valve
- 11 Drain valve
- 13 Flow control valve
- 13A By-pass valve
- 14 Compound gauge
- 15 Level switch
- 16 Filter (y-strainer)
- 18 Automatic drain valve (check valve)

Fig. 7

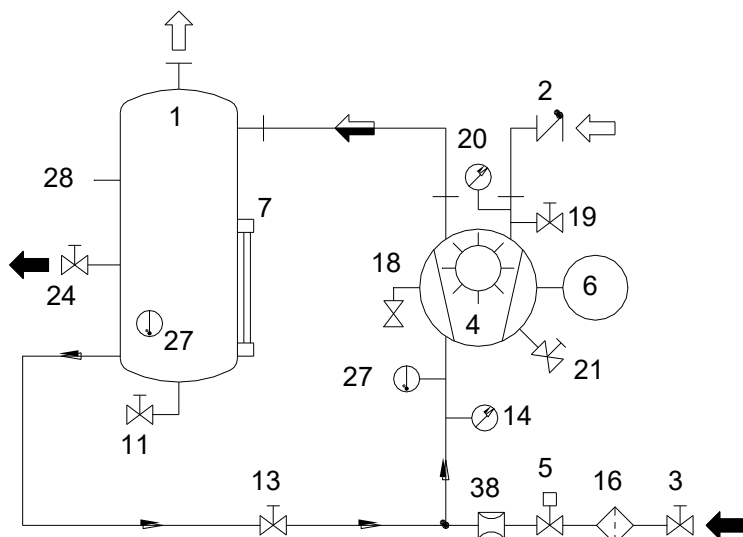
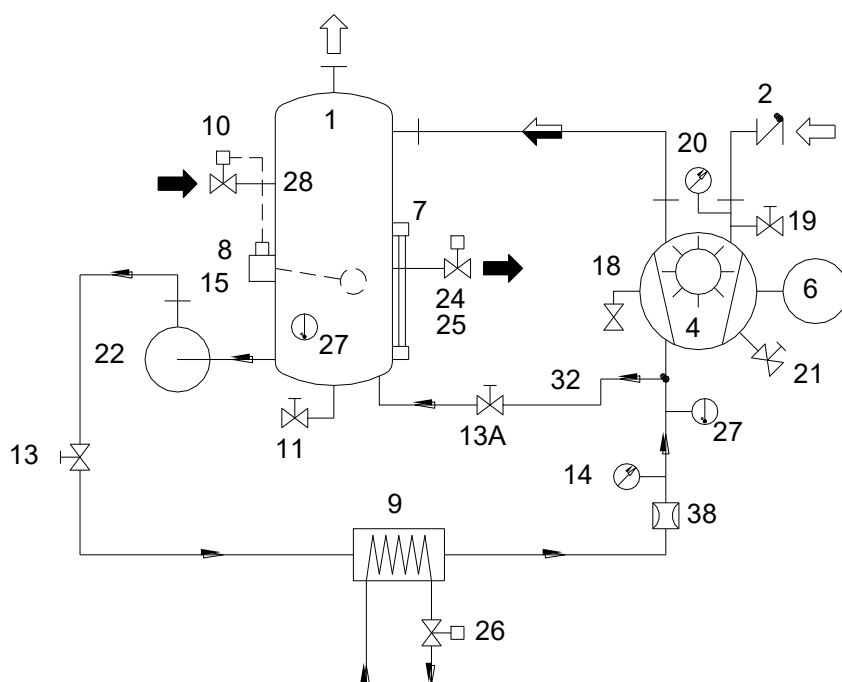


Fig. 8



7.10 - TYPICAL INSTALLATION SCHEMATICS FOR COMPRESSORS

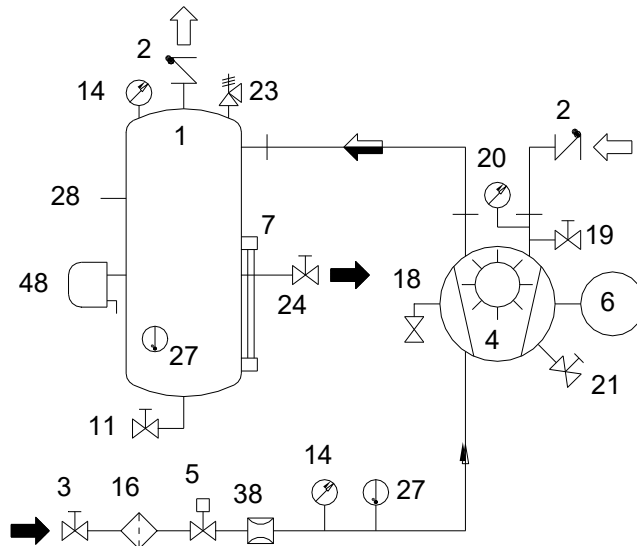


Fig. 9

19 Valve for spare vacuum connection

20 Vacuum gauge

21 Anti-cavitation valve

22 Circulating pump

23 Pressure relief valve

24 Overflow valve

25 Draining solenoid valve

26 Solenoid valve for heat exchanger cooling liquid

27 Temperature gauge

28 Fill-up connection

32 By-pass piping

38 Orifice flow

48 Automatic drain valve or water trap

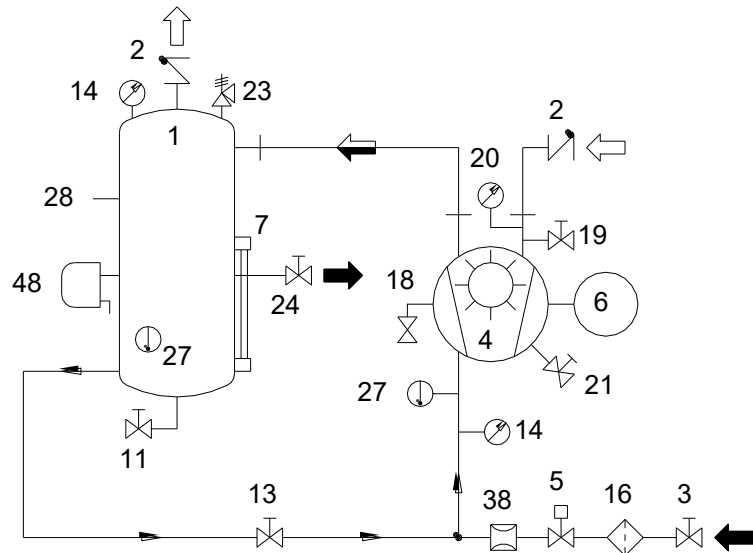


Fig. 10

↑ Air or Gas

↑ Liquid-Gas mixture

↑ Liquid

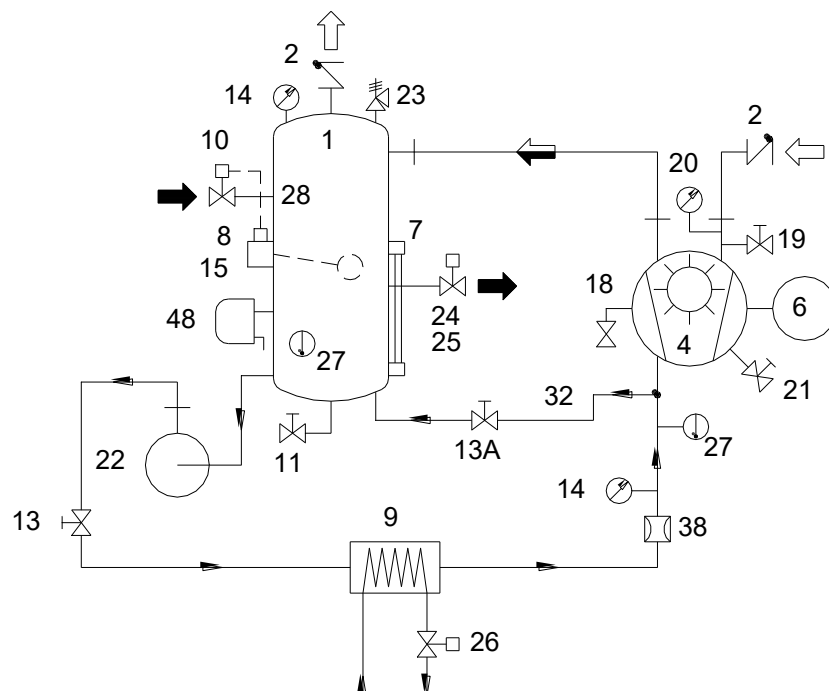


Fig. 11

7.11 - CONNECTIONS LOCATION

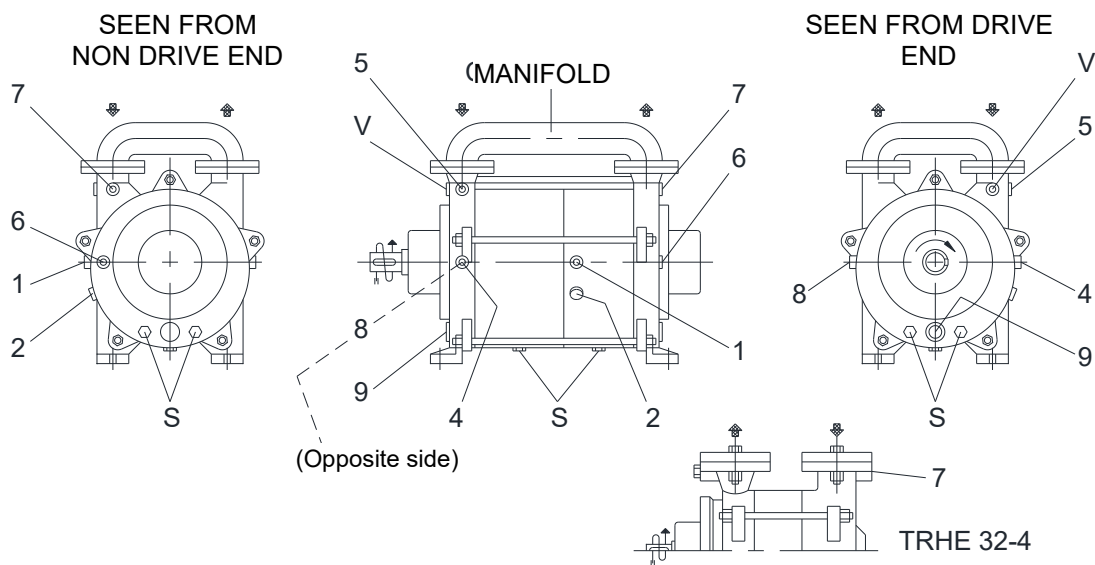


Fig. 12 - Pump series TRH (for details see tab. 3)

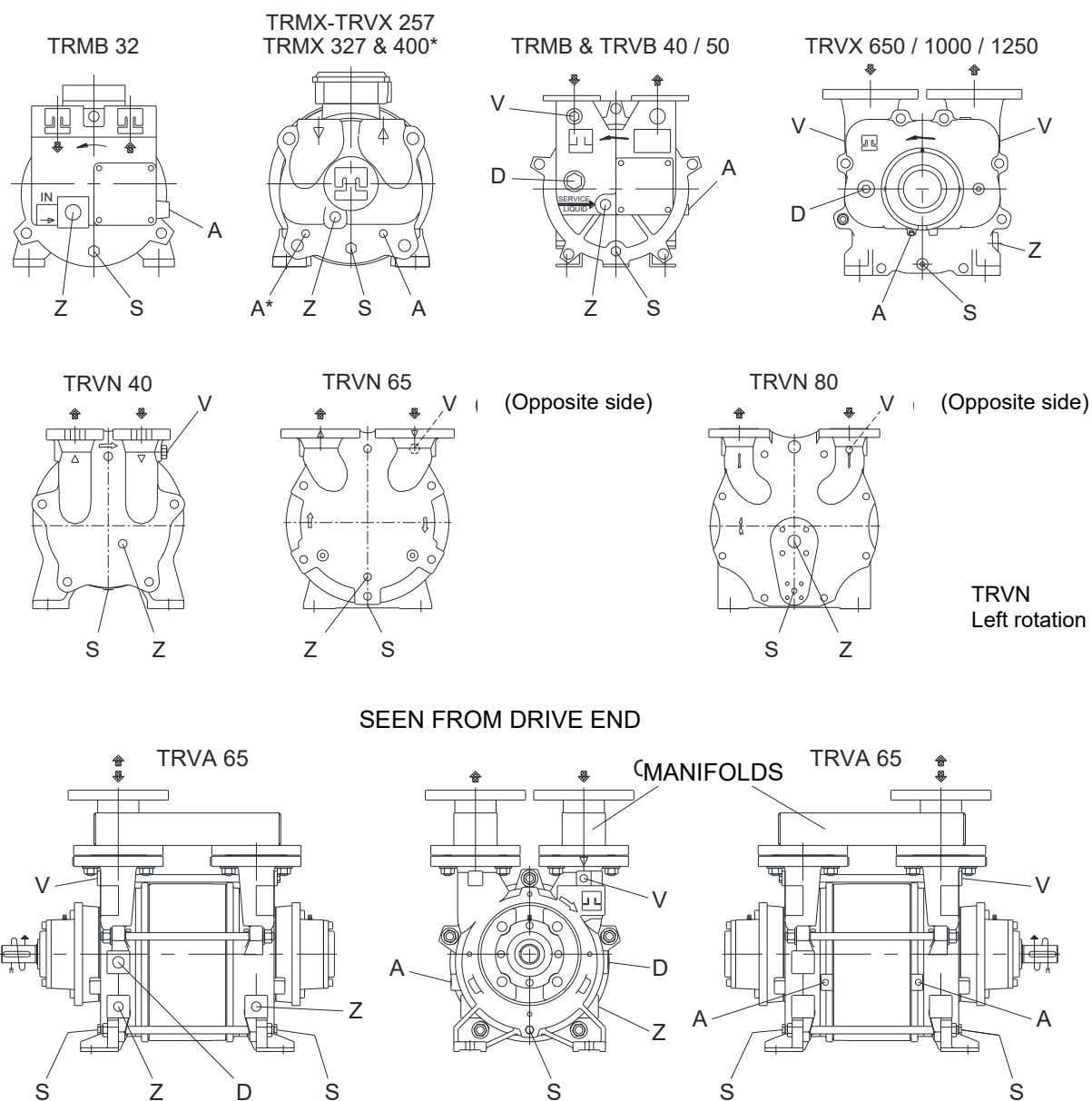
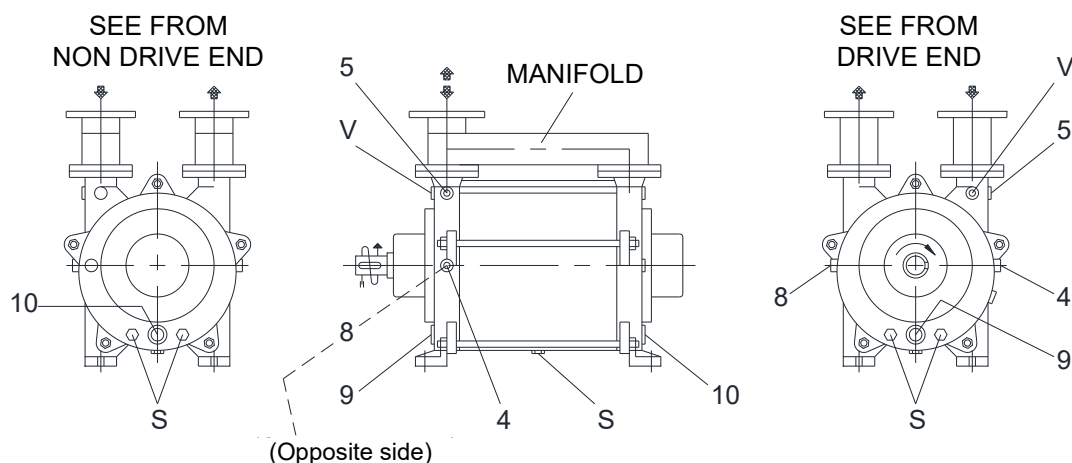


Fig. 13 - Pump series TRM - TRV (for details see tab. 3)

Fig. 14 - Pump series TRS
(for details see tab. 3)



Tab. 3 - Pump series TRH

PUMP MODELS	Flange size	A		D		V	Z		Qty.° Manifolds
		Location	Dimens.	Location	Dimens.	Dimens.	Location	Dimens.	
TRHE 32-4	G 1 1/4	---	---	---	---	---	7	G 1/4	---
TRHE 32-20 & 45		1	G 1/4				8	G 3/8	
TRHC 32-20 & 45							4	G 1/2	1
TRHE & TRHC 32-60									
TRHE 40-110	DN 40	2	G 1/4	4	G 1/2	G 1/4	9	G 3/4	---
TRHC 40-110								G 1/2	
TRHE 40-140 & 190								G 3/4	1
TRHC 40-140 & 190								G 1/2	
TRHB 50	DN 50	7	G 1						
TRHC 80	DN 80	6	G 1 1/4						
TRHE 100	DN 100		G 1 1/2						
TRHA 150	DN 150		7	G 2 1/2					

Pump series TRM – TRV

PUMP MODEL	Flange size	Dimensions					Qty.° Manifolds	
		A	D	S	V	Z		
TRMB 25-30 & 32-50	G 1	G 1/8	---	G 1/8	---	G 1/4	---	
TRMX & TRVX 257						G 3/8		
TRMB 32-75	G 1 1/2		G 1/2	G 1/4	G 1/4	G 1/2		
TRMX 327	G 1 1/4					G 3/4		
TRMB & TRVB 40	40	G 1/8	G 3/4			G 3/4		
TRMX & TRVX 400	G 1 1/2					G 1/2		
TRMB & TRVB 50	DN 50		G 1/2		G 1/2	G 3/4		
TRMX & TRVX 503	DN 50					G 1		
TRVA 65	DN 65		G 1/2	G 1/2		G 1 1/2		
TRVX 650						G 1 1/2		
TRVX 1000	DN 100	n° 2 x G 1/4	G 1 1/2	G 1/2	G 1/2	G 1		
TRVX 1250	DN 125					G 1 1/2	G 1 1/2	
TRVN 40	DN 40	-	-	Rp 1/4	G 3/8	G 3/8	---	
TRVN 65	DN 65	-	-	G 3/8	G 1/2	G 1/2		
TRVN 65 /Z2					NPT 1/2	DN 25 ⁽¹⁾		
TRVN 80	DN 80	-	-	DN 15 ⁽¹⁾	G 1/2	DN 40 ⁽¹⁾		

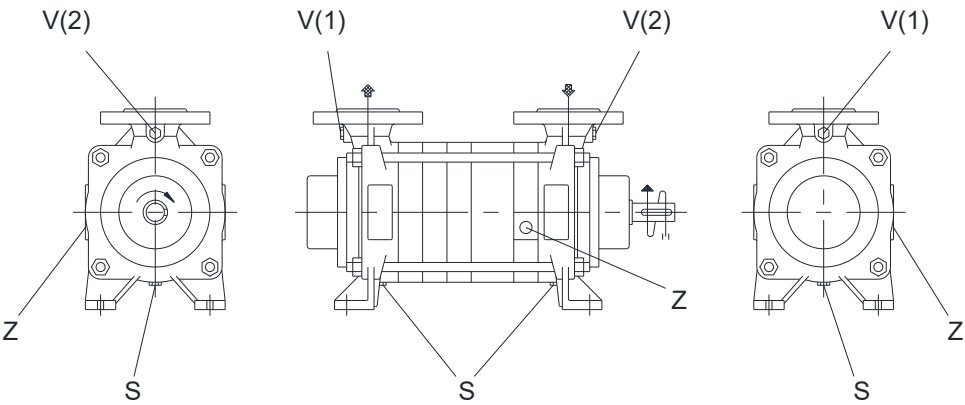
(1) Flanged connection.

Pump series TRS

PUMP MODEL	Flange size	D		V	Z		Qty.° Manifolds	
		Location	Dimens.	Dimens.	Location	Dimens.		
TRSE 32	G 1 1/4	---	---	---	8	G 3/8	---	
TRSC 32					4			
TRSE 40-55 ÷ 150	DN 40	4	G 1/2	G 1/4	9	G 3/4		1
TRSC 40-55 ÷ 100					G 1/2			
TRSC 40-150	DN 50					G 3/4	9 - 10	2
TRSE 50-220					G 1/2			
TRSC 50-220			G 1 1/4					
TRSB & TRSC 100					DN 100	G 1		
TRSE 125	DN 125	G 2 1/2						
TRSA 200	DN 200		4 - 5					

Fig. 15 - Pump series SA

V(1) – PRESSURE GAUGE
V(2) – VACUUM METER



Pump series
SA

COMPRESSORS MODEL	Flange size	Dimension		
		S	V	Z
SA0E3U	DN 32	G 1/4	G 1/4	G 3/8
SA0G2D	DN 50			G 1/2
SA0G2G				

- A = Connection anti-cavitation valve
D = Auxiliary connection for automatic draining valve, connection valve for spare vacuum pick-up, vacuum relief valve
S = Connection for draining plugs or valves
V = Connection for vacuum gauge, vacuum meter and pressure gauge
Z = Connection for service liquid

All drawings are general and schematics (for additional details see the specific pump catalogue).

Fig. 16 - Pump series
TRH – TRS – TRVA 65
with Cartridge Mechanical
seals construction

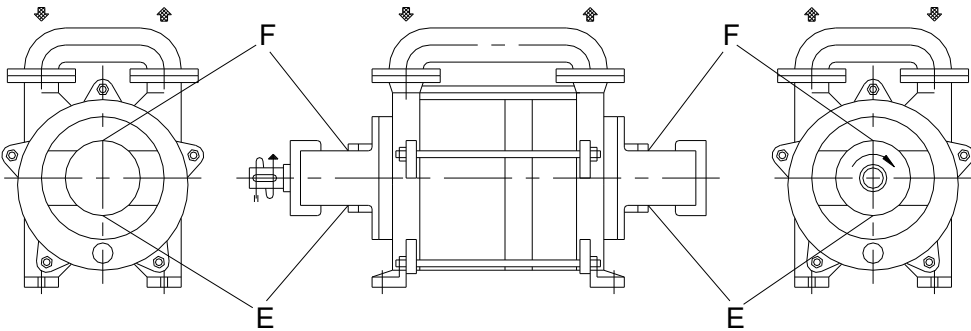
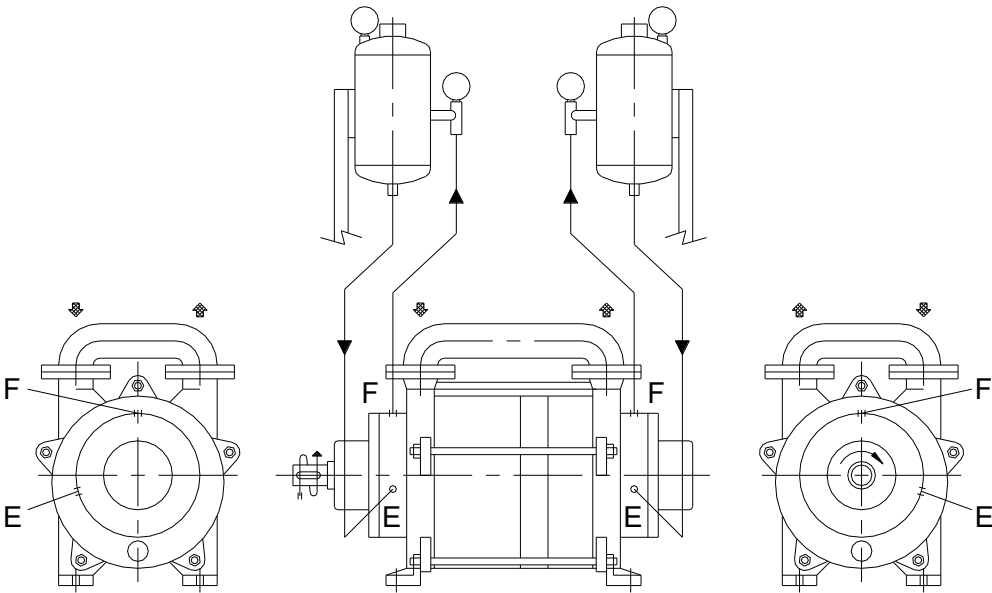


Fig. 17 - Pump series
TRH – TRS – TRVA 65
with Double Tandem or
Double Back-to-Back
Mechanical seals flushed by
reservoir construction



- E = Mechanical seals flushing liquid inlet connection
F = Mechanical seals flushing liquid outlet connection

NOTE: The drawings are generic and schematic: connections dimensions depend on pump type and on mechanical seals supplier, for more detailed information please contact POMPETRAVAINI.

7.12 - PUMP ENGINEERING DATA

Tab. 4

PUMP MODEL	Noise level p (L _w) 50 Hz	Noise level (L _w) 60 Hz	Vibration Level	Weight, Bare pump	Weight ass.ly Monoblock (B5 design)	Weight ass.ly with baseplate	Operating speed		Installed Motor size		Electric Motor frame size	
	dB(A)	dB(A)					RPM		kW		50 Hz	60 Hz
							50 Hz	60 Hz	50 Hz	60 Hz		
TRHE 32-4	67 (78)	68 (79)	V1	14	19	32	1450	1750	0,55	0,75	80 A	80 B
TRHC 32-20	66 (77)	69 (81)		25	31	41	2900	3500	1,1	1,5	80 B	90 S
TRHE 32-20				18	22,5	34						
TRHC 32-45				28	34	44						
TRHE 32-45				21	25,5	37						
TRHC 32-60				30	36	47						
TRHE 32-60				26	31	43						
TRHC 40-110	65 (77)	68 (79)		67	79	92	1450	1750	4	5,5	112 M	132 S
TRHE 40-110				49	61	74						
TRHC 40-140				79	88	119						
TRHE 40-140				67	76	100						
TRHC 40-190				87	105	137						
TRHE 40-190				75	93	118						
TRHB 50-280	70 (82)	73 (86)		130	146	195			9	15	132 M	160 L
TRHB 50-340				140	170	212			11		160 M	
TRHB 50-420	71 (82)	74 (87)		145	178	220			15	18,5	160 L	180 M
TRHC 80-600	76 (89)	79 (92)		220	245	360			22	30	180 L	200 L
TRHC 80-750				240	280	377			30	37	200 L	225 S
TRHE 100-870	79 (92)	82 (95)		412	---	574	225 M	250 M				
TRHE 100-1260				485		652	37	45			250 M	280 S
TRHE 100-1600				518		690	45	75	280 S	315 S		
TRHA 150-2000	83 (98)	84 (99)	V2	1330	---	1805	740	890	75	90	315 MA	315 MB
TRHA 150-2600	84 (99)	85 (99)		1480		2095			90	110	315 MB	355 S
TRHA 150-3100				1630		2245			110	160	355 S	355 MB

PUMP MODEL	Noise level p (Lw) 50 Hz	Noise level (Lw) 60 Hz	Vibration Level	Weight, Bare pump	Weight ass.ly Monoblock (B5 design)	Weight ass.ly with baseplate	Operating speed		Installed Motor size		Electric Motor frame size					
	dB(A)	dB(A)	class	kg	kg	kg	RPM		kW		50 Hz	60 Hz				
							50 Hz	60 Hz	50 Hz	60 Hz						
TRSC 32-20	69 (81)	70 (82)	V1	19	25	39	2900	3500	1,1	1,5	80 B	90 S				
TRSE 32-20				15	19,5	31										
TRSC 32-50				20	26	40										
TRSE 32-50				17	21,5	33										
TRSC 40-55	66 (77)	68 (79)		54	67	79	1450	1750	2,2	3	100 L	100 L				
TRSE 40-55				34	47	59										
TRSC 40-80				57	70	82										
TRSE 40-80				37	50	62										
TRSC 40-100	67 (78)	69 (81)		60	72	85			4	5,5	112 M	132 S				
TRSE 40-100				39	52	64										
TRSC 40-150				71	88	96										
TRSE 40-150				44	57	69										
TRSC 50-220	76 (89)	78 (91)		87	104	122			5,5	7,5	132 S	132 M				
TRSE 50-220				74	92	109										
TRSC 100-550				200	225	327							15	18,5	160 L	180 M
TRSC 100-700				230	255	380										
TRSB 100-980	78 (91)	80 (93)		250	290	385			30	37	200 L	225 S				
TRSE 125-1250	79 (92)	82 (95)		436	---	596	980	1180	37	45	250 M	280 S				
TRSE 125-1550				462		634			45	75	280 S	315 S				
TRSA 200-1950	83 (98)	85 (99)	V2	1125	---	1600	740	890	75	90	315 MA	315 MB				
TRSA 200-2500	84 (99)			1225		1700				110		355 S				
TRSA 200-3100				1325		1800			110	160	355 S	355 MB				

PUMP MODEL	Noise level p (L_w) 50 Hz	Noise level (L_w) 60 Hz	Vibration Level	Weight ass.ly Monoblock 50 Hz motor	Weight ass.ly Monoblock 60 Hz motor	Operating speed		Installed Motor size		Electric Motor frame size	
	dB(A)	dB(A)	class	kg	Kg	RPM		kW		50 Hz	60 Hz
						50 Hz	60 Hz	50 Hz	60 Hz		
TRMX 253	64 (74)	66 (77)	V1			2900	3500	0,75	1,1	80A	80B
TRMB 25-30	65 (75)	68 (79)	V1	17	18	2900	3500	0,75	1,1	80 A	80 B
TRMX 257	64 (74)	66 (77)		27	27			1,5	2,2	90 S	90 L
TRMB 32-50	69 (79)	70 (81)		24	26						
TRMB 32-75	70 (80)	73 (84)		37	42						
TRMX 327				39	45			3	4	100 L	112 M
TRMB 40-110				66	71						
TRMX 403	68 (79)	69 (81)		69	---	1450	1750	4	5,5	112 M	132 S
TRMB 40-150	69 (80)	70 (82)		76	106						
TRMX 405	72 (84)	74 (86)		74	---						
TRMB 40-200				103	111			5,5	7,5	132 S	132 M
TRMX 407				110	---						
TRMB 50-300		...			126	---		---	7,5	---	132 M
TRMX 503	71 (82)	...	V1	133	---		1750			132M	---

PUMP MODEL	Noise level p (Lw) 50 Hz	Noise level (Lw) 60 Hz	Vibration Level	Weight, Bare pump	Weight ass.ly Monoblock (B5 design)	Weight ass.ly with baseplate	Operating speed		Installed Motor size		Electric Motor frame size			
	dB(A)	dB(A)	class	Kg	Kg	Kg	RPM		kW		50 Hz	60 Hz		
							50 Hz	60 Hz	50 Hz	60 Hz				
TRVX 257	64 (74)	66 (77)	V1	---	18	---	2900	3500	1,5	2,2	90 S	90 L		
TRVB 40-110	68 (79)	69 (81)			62		1450	1750	3	4	100 L	112 M		
TRVX 403					60									
TRVB 40-150					64									
TRVX 405	69 (80)	70 (82)			73				4	5,5	112 M	132 SB		
TRVB 40-200					78									
TRVX 407					88									
TRVB 50-300	72 (84)	...			88				5,5	7,5	132 S	132 M		
TRVX 503	71 (82)	...		---	7,5	11							132 M	160 M
TRVA 65-300	70 (82)	73 (86)		133		---								
TRVX 653				97		11								
TRVA 65-450				146	11									
TRVX 657				115	11									
TRVX 1003	75 (88)	77 (90)		148	15	22			160 L	180 L				
TRVX 1005				161	18,5	30			180 M	200 L				
TRVX 1007				171	22	30			180 L					
TRVX 1253	79 (92)	82 (95)		370	---	535	980	1180	30	37	225 M	250 M		
TRVX 1255				411		580			37	45	250 M	280 S		
TRVX 1257				456		603			45	75	280 S	315 S		
TRVN 40-70	70 (82)	73 (86)		35	---	---	2900	3500	2,2	4	90 L	112 M		
TRVN 40-110	72 (85)	74 (86)		50		---	2900	3500	4	5,5	112M	132 S		
TRVN 65-250				135		---	1450	1750	7,5	11	132 M	160 M		
TRVN 80-350				296		---	975	1170	11	15	160 L	180 L		
TRVN 80-500	82 (95)	83 (97)		310	---	975	1170	15	18,5	180 L	200 L			
TRVN 80-600				340	---	975	1170	18,5	30	200 L	225 L			

PUMP MODEL	Noise level (L_w) 50 Hz	Noise level (L_w) 60 Hz	Vibration Level	Weight, Bare pump kg	Weight ass.ly with baseplate kg	Operating speed		Installed Motor size		Electric Motor frame size	
	dB(A)	dB(A)				RPM		kW		50 Hz	60 Hz
SA0E3U	67 (79)	69(81)	V1	56	110	2900	3500	11 15	15 22	160 M 160 M	160 M 180 M
SA0G2D	69 (80)	70(82)		83	135			11 18,5	18,5 37	160 M 160 L	160 L 200 L
SA0G2G		70(82)		87	139 157			15 22	22 45	160 M 180 L	180 M 225 M

Noise level (sound pressure level measured at 1 m distance, without motor, with pump installed in the system and sound power level L_w) for pump series TRH, TRM, TRV when operating at 80 mbar and pump series TRS when operating at 250 mbar with motor at 50 Hz operating speed; applicable tolerance of +/- 2 dB.

The values can change depending on the installed motor. Contact POMPETRAVAINI for further information.

The class of vibration level (values rms mm/s) show the limit values for the continuous working of the pump if properly installed. For higher values it needs to proceed with maintenance of the pump following the table below.

	Continuous working	Preventive maintenance	Extraordinary maintenance
Class V1	< 3,5 (3,0 for TRM)	> 3,5 (3,0 TRM) < 7 (4,5 TRM)	> 7 (4,5 TRM)
Class V2	< 7	> 7 < 11	> 11

- Weights are for pumps fitted with Mechanical Seals and in Cast Iron materials (tolerance $\pm 10\%$).
- The assemblies (Monoblock and with Baseplate) are suitable for 50 Hz motors, except where otherwise noted. Indicated total weights for the assemblies are without motors.
- The installed motor size cover the whole performance curve when operating as vacuum pump.
- The electric motors over the frame size 315 M are not unified.
- For exact weights refer to the specific motor manufacturer data.

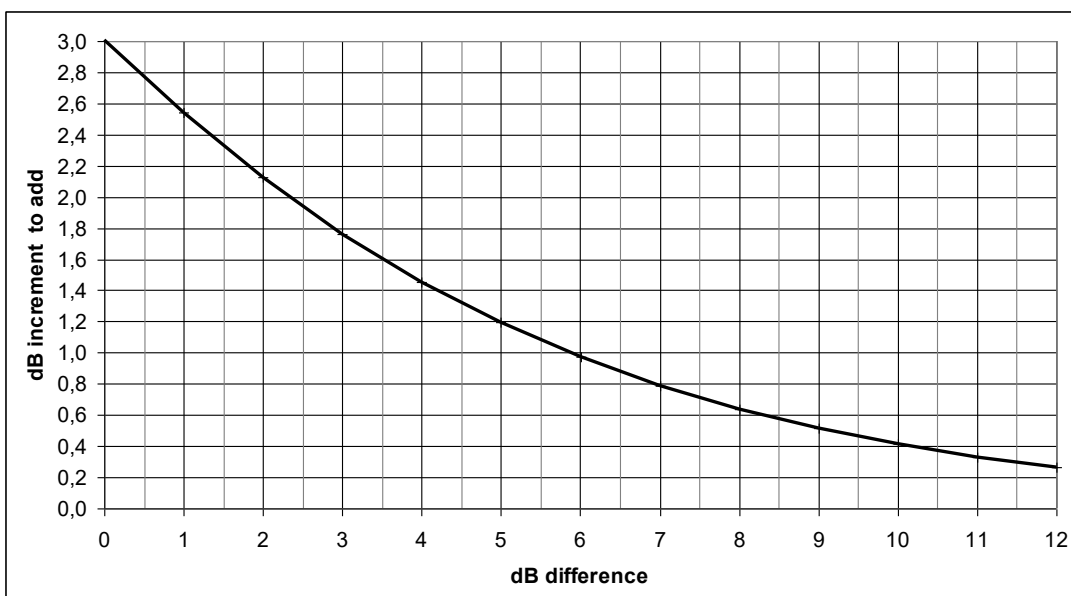
In order to have approximate values of the noise level for the pump-motor assembly the sound power level of the motor and the pump can be added. The tab. 5 shows some values of the motor noise level. The addition has to be calculated using the diagram below.

In order to get the total sound power level it is necessary to calculate the difference between the pump and motor noise level; by that value calculate, from the following diagram, the increment that will have to be added to the higher value of the power sound level. Ex: motor 80 dB and pump 75 dB, level difference 5 dB, increment 1,2 dB, total power sound level 81,2 dB. Taking into account that the noise level depends on several factors, contact POMPETRAVAINI to know more accurate values.

The noise level of the pumps is to be understood as lower / equal ($\leq$) to that indicated in the tables because it depends on the conditions of use. The values can change depending on the installed motor.

Tab. 5

POWER kW	Noise level L_p (L_w)				Noise level L_p (L_w) ATEX			
	dB(A)				dB(A)			
	8 poles	6 poles	4 poles	2 poles	8 poles	6 poles	4 poles	2 poles
0,75	55 (63)	50 (58)	48 (56)	59 (67)	54 (62)	48 (56)	53 (61)	64 (72)
1,1	55 (63)	50 (58)	54 (62)	60 (68)	54 (62)	48 (56)	56 (64)	64 (72)
1,5	57 (65)	53 (61)	54 (62)	63 (71)	56 (64)	57 (65)	56 (64)	71 (79)
2,2	57 (65)	55 (61)	55 (63)	63 (71)	60 (68)	59 (67)	57 (65)	71 (79)
3	58 (66)	57 (65)	55 (63)	67 (75)	60 (68)	62 (70)	57 (65)	74 (82)
4	60 (68)	57 (65)	58 (66)	69 (77)	64 (72)	62 (70)	62 (70)	74 (82)
5,5	60 (68)	57 (65)	61 (69)	72 (81)	64 (72)	62 (70)	66 (74)	75 (83)
7,5	60 (68)	63 (71)	61 (69)	72 (81)	64 (72)	66 (74)	69 (77)	77 (85)
11	63 (71)	64 (72)	68 (78)	74 (82)	66 (75)	66 (74)	71 (79)	77 (86)
15	65 (73)	64 (72)	68 (78)	74 (82)	67 (77)	69 (78)	71 (79)	78 (86)
18,5	67 (75)	66 (74)	68 (78)	74 (82)	70 (81)	71 (81)	72 (81)	78 (86)
22	67 (75)	66 (74)	68 (78)	74 (82)	70 (81)	71 (81)	72 (81)	76 (85)
30	69 (80)	68 (78)	73 (84)	82 (93)	70 (81)	72 (83)	72 (82)	78 (88)
37	67 (75)	70 (81)	75 (86)	82 (93)	62 (74)	72 (83)	75 (86)	78 (88)
45	67 (77)	72 (84)	75 (86)	82 (93)	62 (74)	67 (79)	75 (86)	80 (90)
55	67 (77)	72 (84)	78 (86)	84 (98)	63 (77)	67 (79)	77 (88)	80 (91)
75	67 (77)	77 (87)	73 (82)	79 (89)	65 (77)	67 (81)	72 (84)	77 (89)
90	67 (77)	77 (88)	73 (82)	79 (89)	65 (79)	71 (85)	72 (84)	77 (89)
110	73 (85)	77 (88)	79 (92)	84 (97)	65 (79)	72 (86)	73 (86)	77 (91)
132	76 (88)	77 (88)	79 (92)	84 (97)		72 (86)	77 (86)	85 (99)
160		78 (89)	79 (92)	84 (97)			77 (91)	85 (99)
200			79 (92)	84 (97)			77 (91)	85 (99)
250			83 (95)	84 (97)				





DANGER!

Danger of collision, harm and crushing! Do not start up the pump without the needful guards on both coupling and motor. The coupling procedures must be carried out when the pump is stopped, after having activated the safety procedures to prevent an accidental start-up (also see chapter 2). Operate provided with apposite protective devices (helmet, glasses, gloves, shoes, etc.).

8.1 - ASSEMBLY OF BASE MOUNTED PUMP UNIT

If the pump has been purchased with free shaft end, a proper baseplate is required to mount the pump/motor assembly. The baseplate must be properly designed for maximum rigidity to prevent vibrations and distortions. It is recommended the use of a fabricated baseplate manufactured with rigid "U" shaped channel (fig. 5 illustrates an example). When the pump has been purchased without the electric motor, it is then required to select the proper motor before proceeding to the installation of the unit. Selection of motor must consider the following:

- maximum power absorbed by the pump over the total operating range
- pump operating speed (RPM)
- available power (Hertz, voltage, etc.)
- motor enclosure type (CVE, ATEX, etc.)
- motor mount (B3, B5, horizontal, vertical, C-flange, D-flange, etc.).

Flexible couplings are selected considering:

- nominal motor horsepower
- motor operating speed
- coupling guard must meet safety standards
- possible pump damaging.



Flexible couplings must be properly aligned. Bad alignments will result in coupling failures and damage to pump and motor bearings.

Assembly instructions for MONOBLOCK design are listed on paragraph 8.3 steps 1, 2, 4, 5, 6.

Assembly instructions for PUMP-MOTOR ON BASEPLATE are listed on paragraph 8.3 steps 7, 1, 8, 5, 9, 10, 11.

For pump driven with V-Belt, please consult POMPETRAVAINI for possible information.

8.2 - ALIGNMENT PROCEDURES FOR MONOBLOCK AND FOR PUMP/MOTOR ASSEMBLY ON BASEPLATE.

The pump/motor assembly is properly aligned by POMPETRAVAINI prior to shipment.

It is however required to verify the alignment prior to the start-up. Misalignment can occur during handling, transportation, grouting of assembly, etc.

For alignment procedures of MONOBLOCK design see paragraph 8.3 steps 1, 2, 4, 5, 6.

For alignment procedure of BASEPLATE design see paragraph 8.3 steps 7, 1, 8, 5, 9, 10, 11.

PLEASE NOTE: Coupling sizes and permissible coupling tolerances listed in this manual are applicable to the particular coupling brand installed by POMPETRAVAINI as a standard. For sizes and tolerances of other type of couplings, follow the instructions given by their respective manufacturer.

8.3 - ALIGNMENT INSTRUCTIONS

Alignment should be done at ambient temperature, obviously with power to the motor disconnected and following the safety procedures to avoid accidental starting (see chapter 2).

Do not try to force the fitting of the coupling onto the shaft. First remove the elastomeric dowels and then heat up the half coupling up to 150°C (do not use microwave ovens).

Should the pump operate at high temperatures that could upset the coupling alignment, it is necessary to check the alignment to secure proper working operation at such operating temperatures.

It is recommended the use of proper hand protections such as gloves, when carrying out the operations listed below (schematics for various assemblies are shown).

NOTE: The following points must be followed with the sequence stated above and depending upon the type of operation: alignment assembly or alignment verification.

1 - Thoroughly clean motor/pump shaft ends and shaft keys, place the shaft keys in the proper key way slots and fit the coupling halves in line with the shaft ends. The use of rubber hammers and even pre-heating of the metal half couplings may be required (see fig. 18).

Lightly tighten the set screws. Verify that both pump and motor shafts rotate freely.

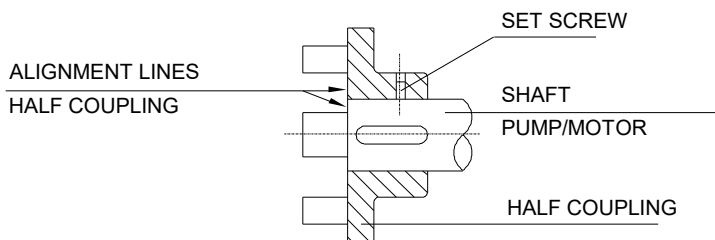


Fig. 18

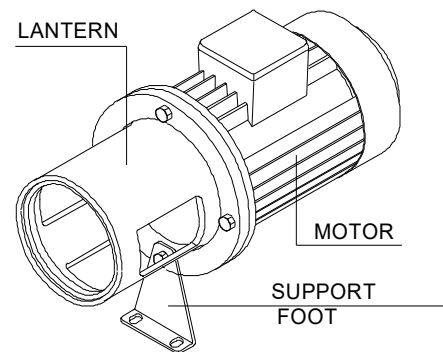


Fig. 19

- 2 - Insert the perforated metal sheet coupling guard inside the lantern so that the coupling is accessible from one of the lateral openings. Couple the electric motor to the pump lantern engaging the two coupling halves, hands may reach the coupling halves through the lateral opening (see fig. 20) tighten the assembly with bolts supplied with the unit and install the supporting foot, when applicable (see fig. 19). When tightening the connecting screws between lantern and motor make sure not to force the two half-couplings until they touch each other. If this occurs remove the motor, axially move the half-coupling on the shaft and repeat the fixing procedure.

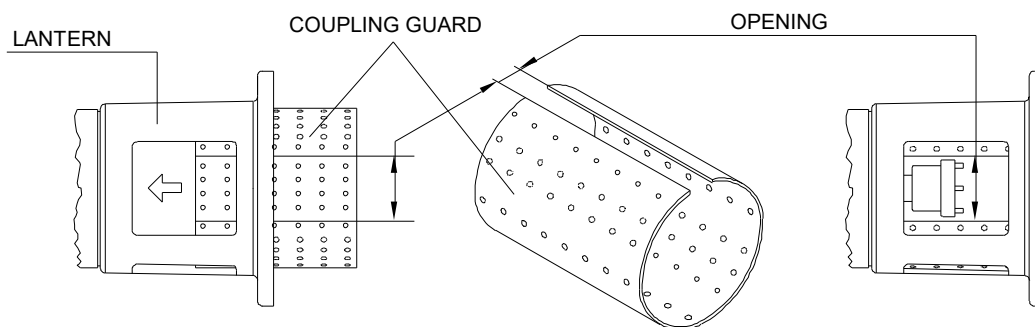


Fig. 20 - PREPARING TO ASSEMBLE THE MONOBLOCK DESIGN

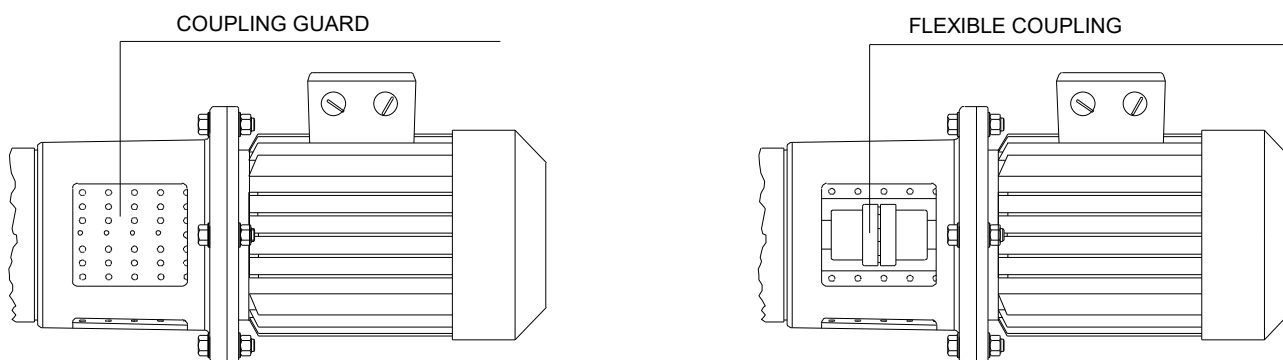


Fig. 21 - CHECKING THE ALIGNMENT ON MONOBLOCK DESIGN

- 3 - Applying slight hand pressure to the coupling guard, rotate it so that one opening of the lantern is accessible (see fig. 21).
- 4 - Rotate by hand the coupling through the lateral opening of the lantern to make sure the pump is free.
- 5 - With a feeler gauge, check the distance between the two coupling halves. The gap value "S" should be as listed on table 2 or as given by the coupling manufacturer.
In the event an adjustment is necessary, loosen the set screws on the coupling half and with a screw driver move the coupling half to attain the gap "S" (see fig. 25). Then tighten the set screw and rotate the rotor by hand to make sure, once more, that there is no obstruction.
- 6 - Rotate back the coupling guard by hand through the two openings of the lantern so that both openings are completely covered. This will complete the alignment verification of the MONOBLOCK design.
- 7 - Remove the coupling guard and its extension (if there is one) attached to the pump, by removing the two locking screws (see fig. 22 and 23).

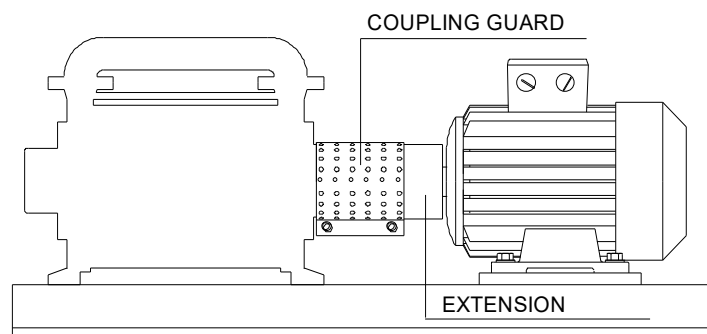


Fig 22 - CHECKING ALIGNMENT ON BASE MOUNTED PUMP DESIGN

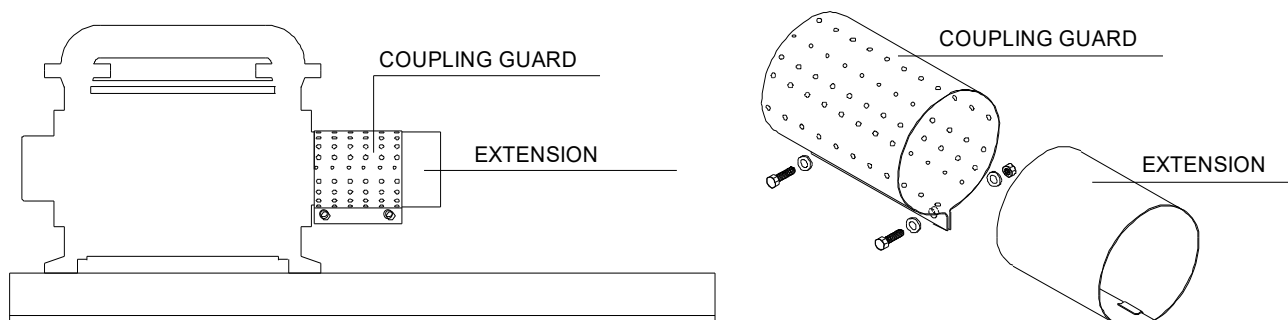


Fig. 23 - ASSEMBLING THE UNIT ON THE BASEPLATE

8 - Place the electric motor on the baseplate and bring the two coupling halves together with approx. 2 mm gap between them keeping the motor axially aligned with the pump shaft. In the event the two shaft heights do not align, proper shimming under the pump or motor feet will be required. Mark the motor and/or pump anchoring bolt holes. Remove motor and/or pump, drill and tap the holes, clean and mount pump and/or motor in place and lightly tighten the bolts (see fig. 24).

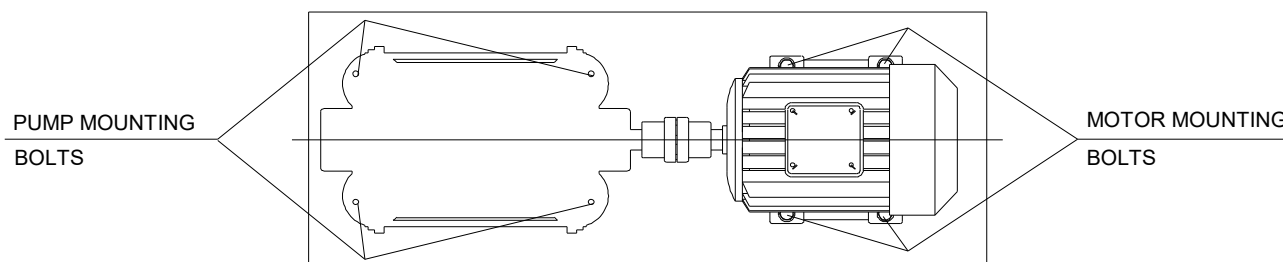


Fig. 24

9 - With a straight edge ruler check the parallelism of the two coupling halves at several points ,90° from each other (see fig. 26).

NOTE: Easier and more accurate readings can be attained with instruments such as Dial Indicators (if readily available).

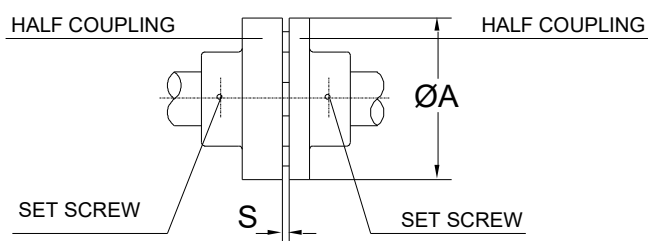


Fig. 25

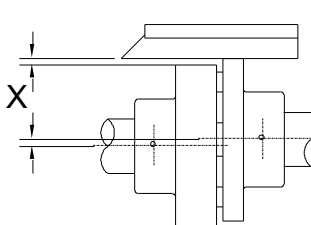


Fig. 26

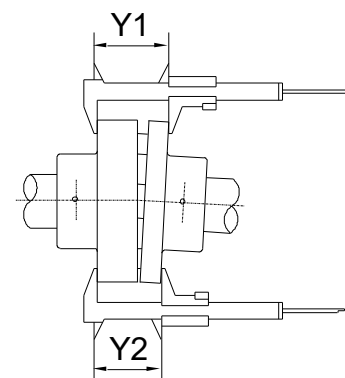


Fig. 27

If the maximum value of "X" is higher than that listed in the tab. 6 (for the given coupling size) it will be required to correct the alignment by using shims under the pump or motor feet.

When the measured values fall within the tolerances, the pump and motor mounting bolts can be tightened.

10 - Angular misalignment can be measured with a caliper. Measure the outside coupling dimension at several points (see fig. 27).

Find the minimum and maximum width of the coupling, the difference between these two readings "Y" (Y1-Y2) should

not exceed the value listed in tab. 6 for the given coupling size. Should this value be greater it will be necessary to correct the alignment by shimming the pump and/or motor.

Following this operation it is recommended to check once more the value "X" to make sure that both values are within the allowed tolerance (see point 9). Make sure that both set screws on the coupling halves are properly secured.

Tab. 6

COUPLING "Ø A" mm	GAP "S" mm	PARALLEL "X" mm	ANGULAR "Y" mm
60 ÷ 80	2 ÷ 2,5	0,10	0,20
100 ÷ 130		0,15	0,25
150 ÷ 260	3 ÷ 3,5		0,30
290	4 ÷ 5		
330	5 ÷ 7		

- 11 - Install the coupling guard and its extension (if applicable) on the pump, secure the two locking bolts. The gap between motor frame and the guard should not be greater than 2 to 3 mm (see fig. 28).

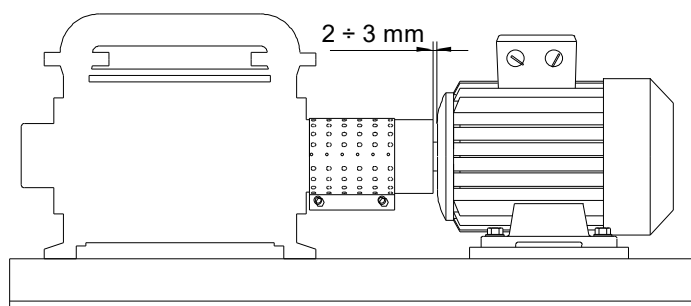


Fig. 28

9 - ELECTRICAL CONNECTIONS



DANGER!

Electric danger. Electrical connections must be made exclusively by qualified personnel in accordance with the instructions from the manufacturer of the motor or other electrical components and must adhere to the local National Electrical Code. Always ground the motor verifying it is properly wired. When the pump is coupled on baseframe carry out the ground connection also for the baseframe on the pre-posed position with screw or through hole marked by the ground connection symbol.



Remove a portion of the paint on the connection point to ensure electrical continuity between the base and the earthing cable. It is advisable to have an electrical switch near the pump for emergency situations.

FOLLOW ALL SAFETY PRECAUTIONS AS LISTED IN CHAPTER 2.

BEFORE DOING ANY WORK TO THE INSTALLATION DISCONNECT ALL POWER SUPPLIES



All electric motors and possible connected accessories must be protected against overloading by means of circuit breakers and/or fuses. Circuit breakers and fuses must be sized in accordance with the full load amperage appearing on the motor nameplate.

It is recommended that motors over 5.5 kW be wired for Star-Delta start-up, to avoid electrical overloads to the motor and mechanical overloads to the pump.



It is advisable to have an electrical switch near the pump for emergency situations.

Be sure to replace all safety guards before switching on the electrical power.

Prior to connecting the electrical wiring, turn the pump shaft by hand to make sure that it rotates freely. Connect the electrical wiring in accordance with local electrical codes and be sure to ground the motor. Motor connection should be as indicated on the motor tag (frequency and voltage) and as discussed in the motor instruction manual.

If possible, check the direction of rotation before the motor is coupled to the pump but protect the motor shaft to prevent any accidents. When this is not possible briefly jog the pump to check its direction of rotation (see arrow on pump for correct rotation). If the direction must be changed 2 of the 3 electrical wire leads must be alternated with each other (at the terminal box or at the motor starter).

Please be aware that rotation in the wrong direction and/or pump running dry may cause severe pump damage.

Electrical instrumentation such as solenoid valves, level switches, temperature switches, etc. which are supplied with the pump or systems must be connected and handled in accordance with the instructions supplied by their respective manufacturers.

10 - CHECK LIST PRIOR TO START-UP



If the installed pump is designated to be used in environments subjected to the application of the ATEX 99/92/CE directive but does not show the wording "ATEX" on the name plate, and the integrative ATEX manual hasn't been received or undelivered, it is strictly forbidden to proceed to start up the pumps but necessary to consult POMPETRAVAINI for clarifications.



CAUTION!

All questions listed below must have POSITIVE answers prior to proceeding to the pump start-up (the following list may not be complete for special installations which may require further precautions as the cases dictate)..



- Is this manual entirely read and understood?
- Are all the safety protections in order?
- Are the electrical connections properly wired, grounded and protected?
- Is the position of the pump switch-off button evident, accessible and clear?
- The piping system has been flushed of any foreign particles, welding impurities, etc.?
- Have all piping and pump obstruction been removed?
- All connections and piping are leak proof and there are no external forces or moments applied to the piping or pump flanges?
- Pump and motor are properly lubricated, if required?
- Pump/motor alignment has been checked?
- If mechanical seal requires flushing has this been connected?
- All valves in the installation are in the correct position?
- Has this pump's direction of rotation been checked by jogging the motor?
- Are pump and installation ready for start-up?

11 - STARTING, OPERATING AND STOPPING PROCEDURES

Upon receipt and/or completion of installation, before turning on the power to the electric motor, rotate the pump shaft by hand to make sure that the pump rotor is free. In the event the shaft does not turn, try to free it up by applying a torque to the pump coupling with a pipe wrench. To free the rotor of a monoblock style pump (without coupling) introduce a bolt (or similar tool) at the motor shaft end that has a threaded connection and apply the torque by hand.

In the event the pump does not become free with the above procedures, fill up the pump with a suitable solvent or lubricating liquid, let it rest for several hours to allow softening of the rust build-up inside the pump, drain the pump and apply torque to the pump shaft as described above to finally free the rotor.



The selected solvent or lubricating fluid must be compatible with the pump, seals and gasketing materials.

New pumps from the factory and pumps coming from long term storage are likely impregnated with a rust preventative liquid; before the start-up, these pumps should be subjected to fresh water rinsing for approximately 15 minutes.

The obtained liquid-water mixture must be collected and, according to the environmental disposal regulations, treated as special liquid.



Dispose the waste liquids according to the current regulations protecting the environment.



CHECK PUMP-MOTOR COUPLING ALIGNMENT!

This must be done prior to the first start-up and before every start-up if pump or motor has been removed from the installation for maintenance or other reasons. See chapter 8.2.

Prior to starting the pump verify that all auxiliary components are available, ready for use and, where required, they are in the open position (i.e.: double mechanical seals are pressurized with buffer liquid, cooling liquid to heat exchanger is open, etc.) and the pump bearings are lubricated.

If the gas and/or service liquid temperatures are in the dangerous levels, it is recommended to insulate the pump, piping and separator to avoid direct contact with their surface, avoid freezing, thermal shock or losing heat energy.

NOTE: See chapters 11.4 to 11.6 for OILSYS systems start-up, operation and shut-down.

11.1 - START-UP

(In the following, reference is made to certain ITEM numbers which appear on fig. 6 to 11 of chapters 7 and 20).

Open valve at gas discharge if installed and partially open the valve at the suction side.

When operating the pump as compressor there must be a check valve ITEM 2 fitted at the discharge side.

When pump ITEM 4 is fitted in a partial recovery or total recovery or HYDROSYS systems, as built by POMPETRAVAINI, it is required to have drain valve ITEM 11 at separator ITEM 1 in the closed position, flow regulating valve ITEM 13 and overflow valve ITEM 24 in the open positions. Separator overflow valve ITEM 24 should be piped to drain (or collecting

container). Before start-up fill the pump to the shaft centerline, separator and piping of system with service liquid through pump inlet flange or fill connection ITEM 28. Check all components for leakage.

If the automatic drain valve ITEM 48 is installed, the overflow valve ITEM 24 must be closed after the filling.



CAUTION!

Possible contact with hazardous media, cold or warm, and pump surfaces, cold or warm.

During the following operations it is particularly important to avoid contact and/or inhale of possible spilled liquid (vapor): therefore, all safety precautions must be taken. Operate only provided with apposite protective devices.

Start all accessories (temperature switches, level switches, pressure switches, etc.) open cooling and flushing lines. Start the pump and open the service liquid valve ITEM 3 (if applicable), soon after start the circulating pump ITEM 22 (if applicable) and adjust the service liquid flow (see tab. 7).

Gradually open the valve at gas suction side till the required vacuum level is reached.

Check the system for abnormal conditions (see chapters 12 and 16).

If the system is fitted with a circulating pump and/or the service liquid has an excessive pressure the by-pass valve ITEM 13A (if available) or valve ITEM 13 can be adjusted to reduce the service liquid flow to the vacuum pump and/or optimize the thermodynamic efficiency of the heat exchanger ITEM 9.

NOTE: HYDROSYS systems engineered with multiple pumps are fitted with isolating valves at suction, discharge, and service liquid lines of each pump. When one or more pumps are not operating it is required to isolate the idle pump(s) by closing these valves. When the pumps are put back into service the said valves (at suction and discharge) must be opened.

11.2 - OPERATION

After starting the vacuum pump check the following:

- the vacuum level is as desired or adjust the flow regulating valve to the required vacuum
- flow and temperature of service liquid and/or cooling liquid are as expected (within 25% tolerance)
- motor does not draw more amperage than shown on its nameplate
- the pump-motor assembly does not have abnormal vibrations and noises such as cavitation
- there are no leaks from mechanical seals, joints and flushing or cooling liquid lines
- liquid level in separator is between the minimum and the maximum.
- the operating temperature at full load, does not exceed approximately 85°C



CAUTION!

Never run the pump dry.



CAUTION!

Possible contact with warm surfaces. Operate only provided with apposite protective devices.

If the gas discharge is not open to the immediate atmosphere but it is piped to other locations, the pump discharge should be checked for back-pressures that could cause higher power consumption and loss of pump capacity.

11.3 - SHUT DOWN

DANGER!



Danger due to collision, crushing or harm. Wait for the complete pump stopping before handling the unit.

Take precautionary measures by draining the pump or closing the pipes by mean of a valve. Operate only provided with apposite protective devices.

First close the service liquid flow and cooling liquid flow (if applicable) then shut down the circulating pump ITEM 22 (if there is one).

Where possible, gradually decrease the vacuum level to 400/900 mbar in about 10 seconds max or, if compressor, decrease the discharge pressure. The discharged service liquid from pump ITEM 4 helps producing a slow deceleration rather than sudden stop.

Turn off the power to motor ITEM 6 and close any accessories and flushing lines.

Make sure the non-return valves ITEM 2, or similar, at suction and discharge lines are leak tight.

Should the system be idle for an extended period of time it is recommended to disconnect the electricity to the motor panel, drain all liquids from pump, separator and piping. Refer to chapter 6 for storage procedures.

11.4 - START UP OF "OILSYS" SYSTEMS



CAUTION!

Possible contact with warm media and warm surfaces. Operate only provided with apposite protective devices.

(In the following, reference is made to certain ITEM numbers which are listed in the figures and legend of chapters 12.1 and 19).

Open the valve at the gas discharge, if applicable, and partially close the valve at the suction side.

Close draining valve ITEM 11 and valves for condensate recovery ITEMS 13F and 13L which are on the frame separator ITEM 1B; open the valve ITEM 13D which is between the circulating pump ITEM 22 and the frame separator ITEM 1B,

then partially open flow regulating valve ITEM 13 between the discharge of circulating pump ITEM 22 and the heat exchanger ITEM 9 and the by-pass valve ITEM 13A.

If the system is fitted with a separator cyclone ITEM 1D and the adjacent collecting tank ITEM 1E, it is required to close valves ITEM 11A and 12 and open valve ITEM 13E.

Fill frame separator with service oil through the filling plug ITEM 28. Proper oil level can be seen on sight glass ITEM 7. Refer to tab. 11 and 12 for the required oil quantity.

Start and/or open applicable accessories (temperature switches, level switches, etc.) and circuitry for cooling and flushing. Start vacuum pump ITEM 4 and soon after start the circulating pump ITEM 22. Adjust the circulating pump capacity with valve ITEM 13.

Gradually open the system suction valve till the desired vacuum is achieved. Check the systems for abnormal noises or vibrations (see chapters 12 and 16).

Adjust by-pass valve ITEM 13A to regulate the oil flow to the vacuum pump or to improve the thermodynamic efficiency of the heat exchanger.

When switching on the vacuum pump, if the oil is cold and has a high viscosity, the selected operating point could cause excessive power absorption by the electric motor, with the thermal protection tripping. In these cases, it is advisable to adjust the pump operating point to around 60 mbar to keep the electrical absorption within the motor's nameplate data, maintaining it for the time necessary to bring the oil to working temperature. When the oil has warmed up it will be less viscous and the electrical absorption will decrease.

NOTE: OILSYS systems engineered with multiple pumps are fitted with isolating valves at suction, discharge, and service liquid lines of each pump. When one or more pumps are not operating it is required to isolate the idle pump(s) by closing these valves. When the pumps are put back into service the said valves (at suction and discharge) must be opened.

11.5 - OPERATION OF "OILSYS" SYSTEMS

After starting the vacuum pump check the following:

- the vacuum level is as desired or adjust the flow regulating valve to the required vacuum
- the oil temperature is between 60 and 80°C. If required, adjust the thermostat on the radiator or in case of water/oil heat exchanger adjust the cooling water flow
- motor does not draw more amperage than shown on its nameplate
- the pump-motor assembly does not have abnormal vibrations or noises such as cavitation
- the frame temperature at full load, does not exceed approximately 85°C
- that there are no leaks from mechanical seals, joints, flushing or cooling liquid lines
- liquid level in separator and frame is between the minimum and the maximum
- the pressure gauge of the oil demister separator does not read more than 0,3 bar. When this value is exceeded, it will be required to change the filter element.

If the gas discharge is not open to the immediate atmosphere but it is piped to other locations, the pump discharge should be checked for back-pressures that could cause higher power consumption and loss of pump capacity.

11.6 - SHUT DOWN OF "OILSYS" SYSTEMS

Close, if applicable, the cooling water to the water/oil heat exchanger ITEM 9, then turn off the power to the circulating pump ITEM 22.

Where possible, gradually decrease the vacuum level to 400/900 mbar in about 10 seconds max. The discharged service liquid from pump ITEM 4 helps producing a slow deceleration rather than sudden stop.

Turn off motor ITEM 6, radiator ITEM 9 and any accessories and flushing circuitry.

Make sure the non-return valves ITEM 2, or similar, at suction and discharge lines are leak tight.

Should the system be idle for an extended period of time it is recommended to disconnect the electricity to the motor panel, drain all liquids from pump, separator and piping. Refer to chapter 6 for storage procedures.

12 - OPERATING MAINTENANCE

Periodically check the working conditions of the system by means of the instrumentation on the installation (pressure gauges, vacuum gauges, temperature gauges, amp meters, etc.) and if the pump is consistently handling the application for which it was selected.

The operation of the pump should be without abnormal vibrations or noises, if any of these problems is noticed, the pump should be stopped immediately, search for the cause and make the necessary corrections.

It is good practice to check the pump/motor alignment, the running conditions of the bearings and of the mechanical seals (see chapter 13) at least once a year, even if no abnormalities have been noticed.

If there is a deterioration of the pump performance, which is not attributable to changes in system demands, the pump must be stopped and proceed with necessary repairs or replacement.

If the mechanical seals are fitted with external flushing and/or quenching lines their pressures, temperatures and flows must be checked constantly.



If during operation the pump seems to run irregularly, because of noise or vibrations, it is necessary to stop the unit and investigate the causes of the malfunctioning (see chapter 18).

NEVER ALLOW THE PUMP TO OPERATE IN THE CAVITATION AREA!

Cavitation has the characteristic metallic sound, like if gravel was rotating inside the pump, and it causes also high pump vibrations. This happens when the pump is running at absolute pressures close to the vapor tension of the service liquid at the running conditions.

This is a damaging condition for the impellers, port plates and casings. The cavitation causes erosion taking away metal particles and attacking the surface of the pump components. This is particularly damaging if the pump is handling corrosive gases, see chapter 16 for suggestions to correct the problem.

Pump series TRH, TRM and TRV are designed for the application of an anti-cavitation valve that should be left open (if required) see fig. 11 and 12 for the location. This valve should be connected toward the upper part of the discharge separator so that, depending upon the operating vacuum, the pump can either take air or discharge excessive liquid.

For OILSYS systems the anti-cavitation valve ITEM 13H is piped from pump ITEM 4 to the frame separator ITEM 1B.

During operation it must be avoided to have sudden and frequent variations from high to low vacuum. (e.g.: suddenly opening the suction valve when the pump is operating at pressures lower than 200 mbar).

This would flood the pump creating high power absorption that would put heavy stress on the motor and coupling.

Particular attention should be put on the quantity of the service liquid flow. The flow will depend upon the type of installation (see chapter 7), the pump size, and/or the desired temperature rise.

The flow of service water at 15°C, for standard pumps and normal operating conditions at various vacuum levels, is listed on the specific pump curves and/or on tab. 2 of chapter 7.7.

Usually, the temperature rise of service water, when handling dry air at 20°C, is approximately 4°C.

When condensable (e.g.: vapors) are present in the gas stream the heat load to be removed by the service water will be higher, therefore the service water temperature rise will be higher.

The service liquid flow and its temperature will affect the pump performance.

Generally, the low service liquid flow will decrease the pump capacity, while a high service liquid flow will increase the absorbed power by flooding the pump (see chapter 19 for information and calculations).

Hard service water will generate limestone build-up inside the pump. The severity of the deposit will vary with the water temperature. Limestone or mineral deposits on the surface of the internal pump components will cause an increase of absorbed power, wear of the components and will possibly seize the pump.

It is recommended to monitor the water hardness and, if too high (>18°F), treat the water. If there are no alternatives, there should be periodical flushing of the pump with a solution that will remove the specific deposits, or the pump must be periodically disassembled, cleaned of all incrustations and re-assembled.

Systems with total service liquid recovery require periodical change of the service liquid contained in the closed loop. The heat exchanger must be kept well cleaned of all mineral deposits for an effective thermodynamic heat exchange.

During operation, a closed loop system will lose some of the service liquid, due to evaporation and/or saturation of the discharged gases. It will be required to periodically make-up fresh liquid into the system.

This operation is not required for those systems that are fitted with a float type automatic make-up valve ITEM 8. This valve requires water at a pressure of approximately 1 bar.

Systems that handle condensable will experience a rise in the level of the service liquid in the separator. The excessive liquid will be overflowed through the overflow valve or connection.

If the specific gravity of the condensable is higher than that of the service liquid, the condensable must be discharged through the separator drain valve ITEM 11, preferably with system not running.

12.1 - "OILSYS" SYSTEMS



CAUTION!

Possible contact with warm media and warm surfaces. Operate only provided with apposite protective devices.

(For ITEM numbers refer to fig. 29 and legend of chapter 21).



In case of systems OILSYS series, as service liquid, mineral oil is used which, if dropped on the ground, is greatly polluting and dangerous for the environment: therefore, high and constant care to possible leaks and, if the case, provide immediately to dispose the leaks in conformity with the laws into force.

It is very important to keep the service oil temperature under control; when the oil temperature exceeds 90°C there is the danger of seizing the pump and the gasketing may start leaking.

Every 100/200 working hours it is suggested to check the oil level in the frame reservoir ITEM 1B, make-up oil if necessary and change the oil every 4000/6000 working hours (depending upon the use and the application): take care of its possible disposal according to the laws into force and to a safe local environment management.

Those installations where the handled gases are contaminated with dust or suspended solids that can alter the oil characteristics will require more frequent oil check and changes.

The frame is fitted with two inspection ports ITEM 43 which can be used for cleaning the frame reservoir after it has been drained of all the oil.

Condensable, if present during evacuation, can be flushed right through the discharge of the separator (if they have low boiling point) or, when the system is idle, can be drained by opening valves ITEM 13F and/or 13L.

During the service, the oil demister filter will be impregnated with oil particles; the pressure gauge ITEM 14 installed at the housing ITEM 1C will provide an indication of the filter being plugged; pressure reading over 0.3 bar is an indication that the filter needs replacement. At higher discharge pressures the discharged air quality will decrease and the vacuum pump absorbed power will increase.

The oil separated by the filter is accumulated at the bottom of the filter cartridge.

To remove this oil there is a scavenger line with a regulating valve ITEM 13G that is connected to the vacuum pump suction flange. It is recommended to keep this valve ITEM 13G minimally opened.

To replace the oil demister filter, simply disconnect the oil scavenger line, remove the cover ITEM 1C, remove the used filter element.



Dispose the waste grease according to the current regulations protecting the environment.

Apply a liquid gasketing material over the 2 gasket faces of the new filter and place the latter in the housing, put in place the cover and the scavenger line.

For systems with separator cyclone ITEM 1D and recovery tank ITEM 1E it is required to periodically remove the accumulated materials.

For this operation close the valve ITEM 13E between the cyclone and the reservoir, open the vent valve ITEM 12 situated at the upper part of the separator, open the reservoir drain valve ITEM 11A to discharge the collected materials.

After the cleaning operation, return to the original position by reverting the above steps.

It is possible to by-pass the service liquid circulating pump by closing the suction and discharge valves and opening the valve ITEM 13C in the by-pass line.

This will connect the frame reservoir directly with the heat exchanger.

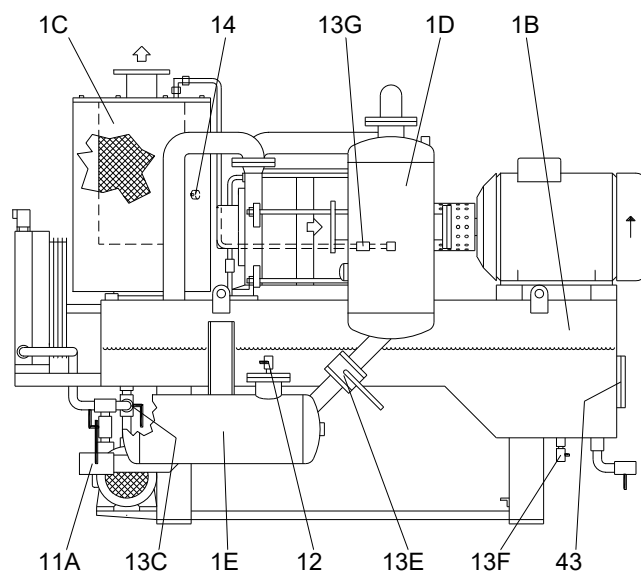


Fig. 29 (General schematic drawing)

13 - RECOMMENDED MAINTENANCE

13.1 – BEARINGS MAINTENANCE

DANGER!



Danger due to collision, crushing or harm. Wait for the complete pump stopping before handling the unit. If the pump still contains some fluid, it may suddenly start to rotate once again. Take precautionary measures by draining the pump or closing the pipes by mean of a valve. Possible contact with high temperature surfaces, wait for the pump cooling. Maintenance must be absolutely carried out when the pump is at a standstill, disconnecting the power supply and any other connection. Please make sure that the power supply is restored only by the operator making the maintenance. It is necessary the presence of at least two operators and a foreman must be aware there is a maintenance in progress.

Operate only provided with apposite protective devices.

FOLLOW THE SAFETY STANDARDS LISTED IN CHAPTER 2.

Ball bearings requiring lubrication are pre-lubricated with grease during assembly. Shell Gadus S2 V100 3 grease is used for all pump series except the TRHA 150 and TRSA 200 series; its operating temperature range is -30°C to +130°C.

The TRHA 150 and TRSA 200 series use Molykote Complex 150 grease; its operating temperature range is -20°C to +180°C.

The bearings must be lubricated every 2000/2500 hours, or at least once a year, by injecting a moderate quantity of lubricating grease of the same or equivalent and compatible type (about 1/5th of the quantity shown in table 8). Any leakage of old grease must be removed. We recommend replacing the bearings every 15000 hours or when replacing the mechanical seals (for replacement see the "Disassembly and assembly instructions").



Dispose the waste grease according to the current regulations protecting the environment.

The sealed pre-greased never need lubrication, but must anyway controlled after 2000/2500 working hours.

Bearing temperature should not exceed the 85°C during normal working conditions and normal environments.

Bearings can overheat for reasons such as too much grease, misalignment of flexible coupling, wrong bearings, excessive vibrations, bearing wear. See tab. 8 for bearing numbers and type used for each pump.

13.2 – PERIODIC CHECKS

A properly installed and operated liquid ring vacuum pump has no components that require frequent periodic maintenance.

It is advisable to periodically monitor that:

- the vacuum level is as expected (if necessary, intervene on the appropriate regulation valves)
- the flow rate and temperature of the operating liquid and/or the cooling liquid are as expected (with a tolerance of +/- 25%)
- the absorption of the electric drive motors does not exceed the plate values
- the electric pump unit is free from abnormal vibrations and noises
- there are no leaks from the mechanical seals, connections and any flushing circuits

- the liquid levels inside the tanks are between the maximum and minimum
- the temperature of the supports, under normal conditions, is lower than approximately 85°C

The recommended initial frequency is within 500 hours; the user can modify the time interval based on the experience acquired for the specific application.

The frequency of checks on the pump and mechanical seal must be increased if the pump operates under severe operating conditions. For example, with frequent switching on and off, in conditions close to cavitation, with high temperature service liquid, with suspended solids or abrasive particles, or chemically aggressive liquid or if its release could be dangerous for personnel, the system or the pump itself.

14 - PACKED STUFFING BOXES

DANGER!



Danger due to collision, crushing or abrasions. Possible contact with hazardous fluids, cold or warm. Wait for the complete pump stopping before handling the unit. If the pump still contains some fluid it may suddenly start to rotate once again. Take precautionary measures by draining the pump or closing the pipes by mean of a valve. Remove protections only in case of maintenance. Operate only provided with apposite protective devices.

Pumps fitted with packed stuffing boxes require packing flushing either from an external source or directly from the pumped media through pump internal passages.

This liquid is necessary to remove the friction heat generated between the shaft and the packing.

The dripping quantity is a function of the pump size and of the pressure in the stuffing box housing.

In any event the liquid drops coming out of the stuffing box should not exceed a temperature of 60 - 70°C in relation to handling a liquid at ambient temperature.

14.1 - ADJUSTING THE PACKING SEALS

All adjustment operations must be performed with the **PUMP NOT RUNNING** following the safety measures given in chapter 2. After completion of the work **ALWAYS** re-install the safety guards previously removed.

At first start up loosen the nuts of the packing gland allowing a steady flow of liquid to drain out (see fig. 30).

After obtaining a steady flow of leakage gradually tighten the gland nuts until attaining a steady dripping within the limit of the above recommended temperature.

A few hours' time span may be required to establish a steady dripping at low temperatures.

Packing adjustment is required when the liquid leakage increases.

When adjustment is no longer possible, the packing material should be replaced with new one.

Follow the "Disassembly and Assembly Instructions" to replace the packing materials.

In the event the pump remains out of service for more than 2 months it is recommended to replace the packing rings, prior to start-up.

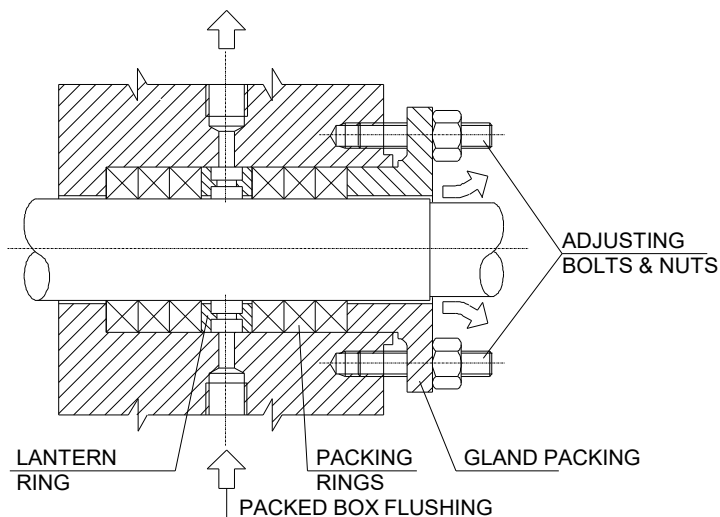


Fig. 30

15 – MECHANICAL SEALS

DANGER!



Danger due to collision, crushing or abrasions. Possible contact with hazardous fluids, cold or warm. Wait for the complete pump stopping before handling the unit. If the pump still contains some fluid, it may suddenly start to rotate once again. Take precautionary measures by draining the pump or closing the pipes by mean of a valve. Remove protections only in case of maintenance. Operate only provided with apposite protective devices.

Purpose of mechanical seals is to retain handled product inside the pump in the area where the shaft exits the pump casing. Mechanical Seals can be of many different materials, types and configurations (see fig. 32-33-34 for some examples).

To assure maximum reliability and safe operation Pompetravaini evaluates seal choices at time of pump selection in connection with customer's requirements, application and liquid details.

In the case of self-lubricated single mechanical seals (API Plan 01, 02 or 11, see fig. 32) flushing and /or pressure system are not required, pump has been engineered to provide proper seal lubrication with pump operating pressure.

In the event the application requires increased safety margin against possibilities of product leaking through a single type mechanical seal, it is possible to install two mechanical seals working simultaneously thus creating a safety barrier from the pumped liquid.

There are two possible types of double mechanical seals: Back-to-Back (also known as "Opposite" type) API Plan 54, see fig. 33 and in Series (also known as "Tandem" type) API Plan 52, see fig. 34.

Double mechanical seals Back-to-Back are generally selected where pumped liquid is absolutely not allowed to leak from the pump. Double mechanical seals in Series are chosen where the pumped liquid may escape the pump toward the

pump exterior but it is controlled and contained in the closed seal loop but never to escape to the atmosphere.

In the event the application requires increased safety margin against possibilities of product leaking through a single type mechanical seal, it is possible to install two mechanical seals working simultaneously thus creating a safety barrier from the pumped liquid.

There are two possible types of double mechanical seals: Back-to-Back (also known as "Opposite" type) API Plan 54, see fig. 33 and in Series (also known as "Tandem" type) API Plan 52, see fig. 34.

Double mechanical seals Back-to-Back are generally selected where pumped liquid is absolutely not allowed to leak from the pump. Double mechanical seals in Series are chosen where the pumped liquid may escape the pump toward the pump exterior but it is controlled and contained in the closed seal loop but never to escape to the atmosphere.

Double mechanical seal installations require a flushing (buffer) liquid from an external source that is compatible with the pumped product as well as the working conditions. Flushing liquid system is such as to guarantee adequate buffer liquid pressure and temperature to the mechanical seals: seal flushing system with proper instrumentation and controls is of paramount importance for a successful pump installation, it must be installed by qualified personnel familiar with every detail of the application and with system set-up.

All flushing systems **MUST** use tubing with diameters equal or larger than the connections provided on the pump, buffer liquid must be compatible with the pumped product. Pressure on the buffer liquid should always be constant and/or high enough to cover the entire pump performance.

In the case of 'once through' seal flushing (buffer liquid not recycled), it is very important the regulation and control of pressure in the seal housing. In the double seal case, it is recommended to adjust the buffer liquid pressure with a flow regulating valve installed after the seal housing while reading pressure on a gauge installed between the seal housing and the valve. Avoid controlling buffer liquid pressure before the seal housing, reading the pressure before the seal housing is **NOT** recommended as it could lead to wrong conclusions which could be cause for serious damages.

With an adequate seal tank in the system (see fig. 37) a closed loop seal flushing, containing possible leakages is provided. Adequate controls and/or instrumentation will provide pressure and liquid level controls in the tank to indicate the conditions of the sealing system. Increase of liquid level (or pressure) is indication of product leaking through the pump seal. Decrease of liquid level (or pressure) is indication of buffer liquid leaking inside the pump or to the atmosphere through the outside seal, in which case the leakage is also visible.

The liquid to be used in the seal tank must offer full compatibility with the pumped liquid in the event the seal at pump side will leak, (for example when the two liquids will mix there must not be any dangerous chemical reactions) as well the liquid must offer good lubricating characteristics and good heat dissipation. Some good examples of suitable buffer liquids are water, vaseline oils or vegetable oils.

Pressure in the seal tank is often kept with pressurized Ozone or Nitrogen bottle. Cooling of the buffer liquid in the loop (picks up friction heat from the seal faces) is achieved with fresh liquid through the cooling coil fitted inside the seal tank. Seal tank is provided with Inlet & Outlet connections for sealing liquid. **DO NOT** reverse these two connections; the liquid circulates by natural heat convection (warm liquid moves upward and cold liquid downward), reversing the connections would prevent the start of such natural phenomenon. The buffer liquid outlet connection going to pump seal housing is at bottom of tank while the return connection is approximately at the middle of the tank.

Checking of proper liquid circulation is done while pump is in service; the piping at seal housing connection should be colder by 3 to 5°C than the outlet tubing exiting the seal housing going to the tank. If this is not the case simply change the tubing on the seal housing (connect tubing from inlet to the outlet and vice versa) do not change the connections on the tank. Sometimes this adjustment is required because the rotation of the mechanical seal (and at times peculiar seal design) generates a hydraulic pressure that could be opposite and higher than the natural. Only in 'field' check one can be assured of the correct liquid circulation. Monitoring the pressure in the seal tank with pressure switches or pressure gauges and/or controlling the liquid level in the tank allow the verification of possible seal leakages and prompt corrective actions can be taken when required.

Use good quality gauges to monitor the pressure, with good dial and scale graduation adequate for good reading in the anticipated pressure range. As a minimum use liquid filled gauges with dial size of minimum 60 mm and 2.5 accuracy. Additional data and information may be requested from Pompetravaini or its local representative if required.



Incorrect pressure of seal housing could cause severe damage to the rotating parts. To minimize seal system malfunctions avoid pressure fluctuations in the seal loop as well as in the pump operating pressure.

Seal housing with double mechanical seals back-to-back type, must always have a pressure such that the inside seal (closer to pump impeller) will not be pushed out of its seat by the total pump pressure (suction plus pump operating pressures) even when pump is in stand-by mode. Flushing liquid therefore must be at least 0.5 bar over the maximum pump discharge pressure throughout its performance.

A lower pressure, even if for a moment, will cause the stationary part of internal seal to come out of its seat and the pumped liquid will mix with the flushing liquid due to the higher pressure inside the pump, see fig. 31.

In the case of double seals in series (Tandem) the pressure of the flushing liquid should be as low as possible but high enough to provide good flow in the circuit. High pressures (over 0.3 bar over the atmospheric pressure) may push the stationary seat of mechanical seal at product side (closer to pump impeller), out of its seat (especially when pump is at rest without pressure), therefore flushing liquid would mix with the product inside the pump following seal system damage.

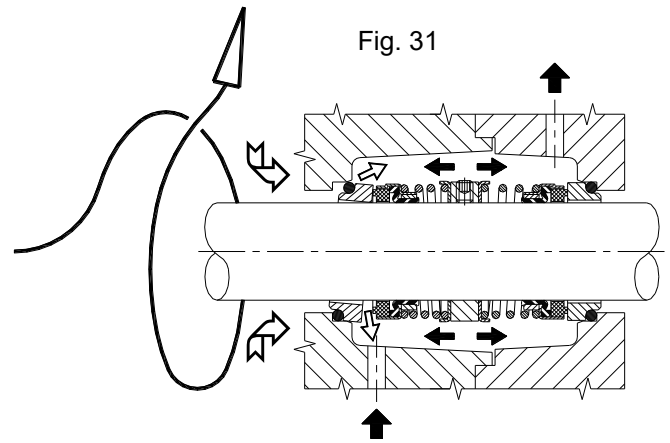


Fig. 31



Incorrect pressure in sealing system is the most common cause for seal system failure, therefore a continued monitoring with prompt corrective actions is necessary.

Required flow and pressure for buffer liquid are listed in tab. 7 and/or contact Pompetravaini and/or seal supplier.

Standard mechanical seals supplied with our pumps meet ISO 3069/UNI EN 12756 standards, see pump "Disassembly and Assembly Instructions" for overall dimensions. Special or non-standard seals can be installed after proper evaluation by our technical department. Mechanical seals do not require maintenance until losses of liquid are visible (for seal replacement see "Disassembly and Assembly Instructions"). Losses of few drops of liquid in several minutes is normally considered acceptable and it is not an indication of seal failure.

Seal leakage or even seal failure should be properly corrected considering the impact on environment, toxicity and safety issues.



CAUTION!

Pay attention to possible leakage of pumped liquid from mechanical seal which, by its characteristics, could be harmful to the environment.

Mechanical seals should NEVER run dry, without flushing liquid (internal or external). This could cause severe damage to the seal faces, O-Rings and elastomer.

Mechanical seals are wearing parts: the actual mechanical seal life depends on the severity of the duty load.

Every 4000/5000 hours approximately it is recommended to check the wear condition of the contact faces of the mechanical seals and replace them if necessary.

It is recommended to check the wear of seal faces every 4000 working hours. This is an acceptable normal life span for mechanical seals. Exceeding this life span can lead to losses due to wear and tear and will require seal replacement.

In case a mechanical seal is replaced, the condition of shaft sleeve (if present) must be checked: if the sleeve surface is damaged, or in case of doubt, it is recommended to replace also the shaft sleeve together with the mechanical seals.

The mechanical seal replacement interval is indicative and also recommended for interventions on pumps that are still operating without any signs of deterioration of the mechanical seal system.

15.1 - MECHANICAL SEALS WITH QUENCH

There are two types of Quench/Barrier, available upon request: API Plan 61 and 62.

System Plan 61 (see fig. 35) includes a bushing on the back of the seal at atmospheric pressure side (single or double) to hold the bulk of the liquid in the event of accidental failures. The bushing requires a minimum clearance over the shaft therefore the liquid is NOT sealed completely but most of it will be retained in case of a sudden seal breakage. Drain and vent connections are threaded. This arrangement does not allow a continuous flushing because the above-mentioned clearances would cause considerable losses of liquid over the shaft toward the outside. This system is chosen for avoid emergencies or to limit losses of liquid.

System Plan 62 (see fig. 36) requires (contrary to Plan 61) a constant flushing because the auxiliary seal is of the contact type and CANNOT work without a liquid that removes the generated heat of friction. The auxiliary seal is usually a lip seal (radial seal ring) not to be confused with the traditional mechanical seal. Losses of several liquid drops should be tolerated and with time its reliability will decrease. This system is often used where there is the need to wash the back of the mechanical seal on the atmospheric side preventing crystallization or coking of handled product. It is a less effective alternative to the double mechanical seals in series. Pressure of buffer liquid must follow same rules as for the double seals in series, therefore max pressure can be 0.3 bar over the atmospheric pressure and temperature can be max 60°C.

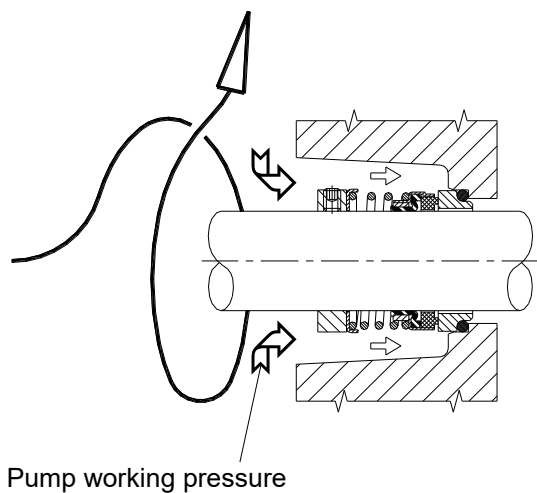


Fig. 32
Typical example of self-flushed SINGLE mechanical seal - API Plan 01, 02 or 11

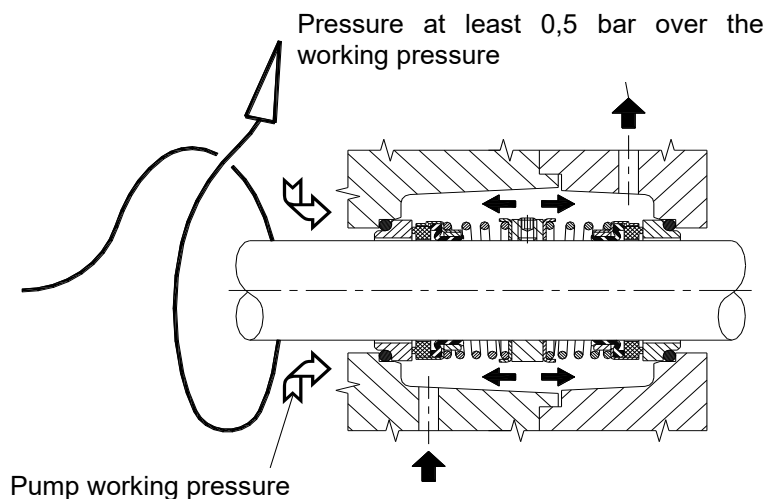


Fig. 33
Typical example of DOUBLE BACK-TO-BACK mechanical seal with liquid from an outside source - API Plan 54

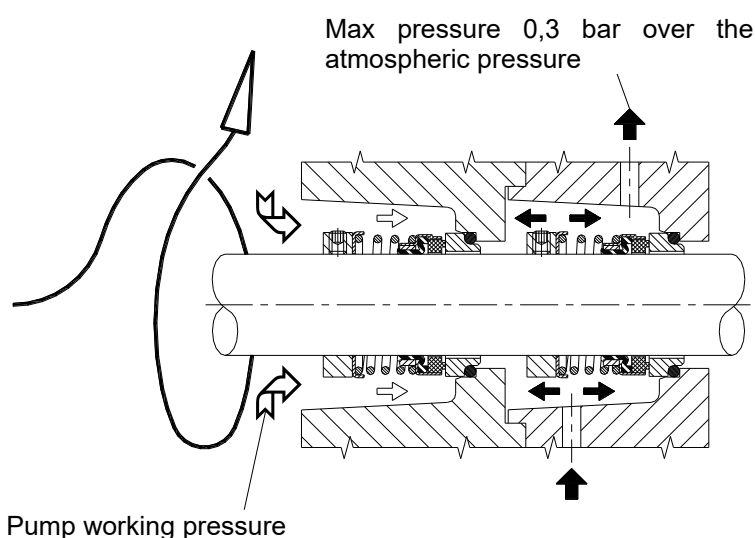


Fig. 34
Typical example of DOUBLE mechanical seals in SERIES with buffer liquid from an outside source - API Plan 52

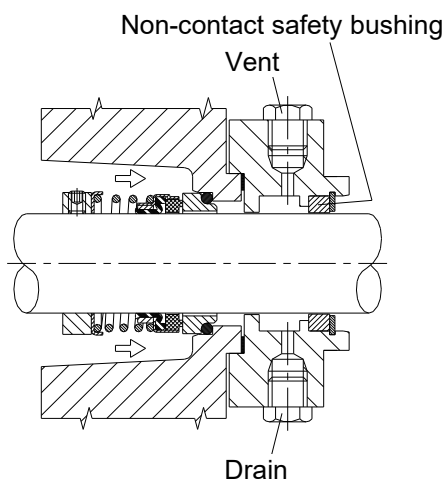
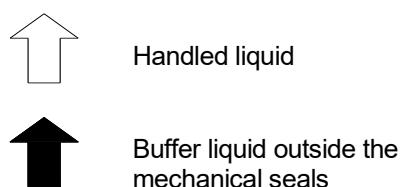


Fig. 35
Example of SINGLE mechanical seal with QUENCH API Plan 01/61
(NOTE.: Continuous flushing is not possible)

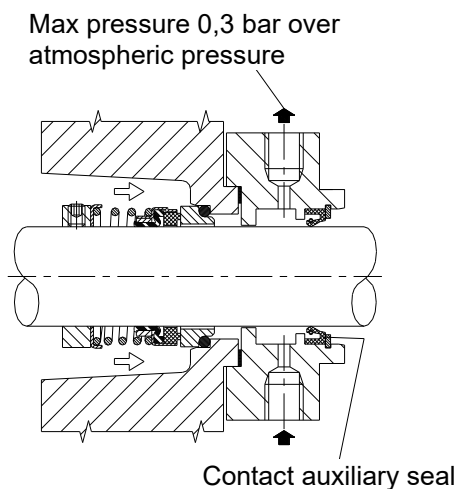


Fig. 36
Example of SINGLE mechanical seal with QUENCH API Plan 01/62

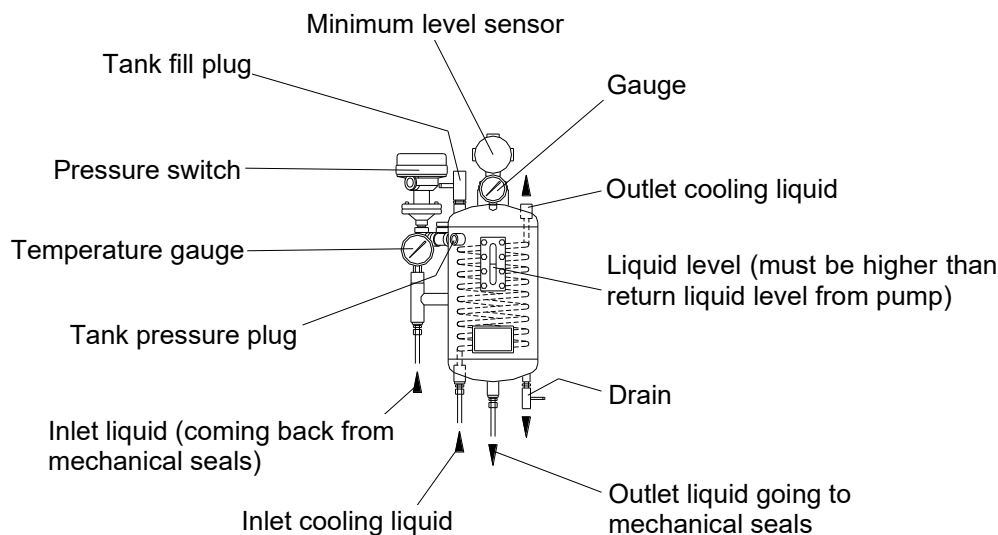
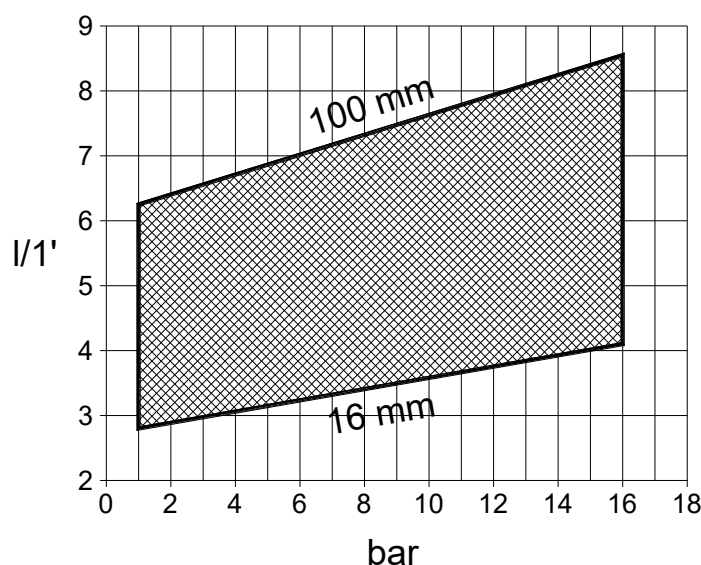


Fig. 37
Typical example of seal tank, pressurized, cooling liquid and instrumentation. (Instrument location can vary)

NOTE: Tank installation must be at least 1 m above the rotating pump shaft



Tab. 7 - REQUIRED LIQUID FLOW TO FLUSH MECHANICAL SEALS FROM OUTSIDE SOURCE

mm = installed shaft seal diameter
bar = maximum pump working pressure (total of inlet pressure and pump generated pressure as measured at pump discharge flange)

l/l' = required liquid flow (lit/min) for single seals or double in series type seals (tolerance $\pm 25\%$ depending upon temperatures)

NOTE: DOUBLE quantity of liquid flow for double mechanical seals back-to-back type.

CAUTION: Flushing liquid PRESSURE for back-to-back double seals must be min 0.5 bar over the max pump working pressure, while NOT more than 0.3 bar over the atmospheric pressure in case of double seals in series (TANDEM).

Tab. 8

PUMP MODEL	BEARING			MECHANICAL SEAL				
	Quantity	Type	Grease Quantity each bearing - gr.	Quantity	Diameter mm			
TRHE 32-4	1	6302.2RS	---	1	16			
TRHC & TRSC 32 TRHE 32-20/45/60 - TRSE 32	2	6304.2RS		2	22			
TRHE 40-110 - TRSE 40	2	6305.2RS			28			
TRMB 25-30	1	6205.2RS		1	22			
	1	6204.2RS						
TRMX 257 – TRMB 32-50	1	6305.2RS				24		
	1	6205.2RS						
TRVX 257	2	6007.2Z						
TRMB 32-75	1	6306.2RS				28		
	1	6206.2RS						
TRMX 327	1	6306-2ZC3				43		
	1	6206-2ZC3						
TRMB 40-110 – 3 kW	1	6208.2Z			35			
	1	6206.2Z						
TRMB 40-110 – 4 kW	1	6208.2Z						
	1	6306.2Z						
TRMB 40-150 – 4 kW	1	6208.2Z						
	1	6306.2Z						
TRMB 40-150 – 5.5 kW	1	6210.2ZC3						
	1	6208.2ZC3						
TRVB 40-110 - TRVB 40-150	2	6208.2Z						
TRMB 40-200 – 5.5 kW	1	6210.2ZC3				45		
	1	6208.2ZC3						
TRMB 40-200 – 7.5 kW	1	6210.2ZC3						
TRMB 50-300 – 7.5 kW	1	6208.2ZC3						
TRVB 40-200 - TRVB 50-300	1	6210.2Z						
	1	6208.2Z						
TRMX 403 & 405	2	6306-2ZC3						
TRMX 407		6308-2ZC3				55		
TRVX 403 & 405		6208-2Z				45		
TRVX 407	1	6208-2Z		55				
	1	6210-2Z						
TRVX 503	1	6208-2Z		35 - 45				
	1	6306-2RS						
TRHC & TRSC 40 - TRHE 40-140/190 TRSC & TRSE 50	2	6306.2RS		2	35			
TRHB 50 - TRVA 50 - TRVA 65	2	6308	60		43			
TRSB 100 - TRSC 100	2	6310	90		55			
TRHC 80	1	6310	110					
	1	21310E						
TRHC 80/1	1	3210B	70					
	1	6310-C3	80					
TRVX 650	1	6308-C3	40		45			
	1	3207B						
TRVX 1000	1	3210B	70		55			
	1	6310-C3	55					
TRVX 1250	1	21313E	100		75			
	1	22213E	140					
TRHE 100 - TRSE 125	1	6314	280		110			
	1	NU314E						
TRHA 150 - TRSA 200	2	7320B/UAM	750					
	1	22320E-C3						
TRVN 40-70	2	6307-2RS	---	1	32			
TRVN 40-70/Z4	3	6308-2RS	---	1	32			
TRVN 40-110	2	6308-2RS	---	1	35			
TRVN 65	2	6310-2Z 6311-2Z	---	1	50			
TRVN 80	2	6217-2RS 6317-2RS	---	1	80			

NOTE: The supplied data are for pumps in STANDARD construction. For special construction (e.g. /1X-1Y-1W and belt drive) please contact POMPETRAVINI.

16 - TROUBLE SHOOTING: PROBLEMS, CAUSES AND SOLUTIONS

Consult the following tab. 9 when problems are experienced, if solutions are not found in this chart or should there be any doubts, do not hesitate to contact POMPETRAVAINI or your local representative.

Tab. 9 - LIST OF PROBLEMS

PROBLEM	LIST OF POSSIBLE CAUSES
Pump does not create or the vacuum is too low	1 - 2 - 3 - 4 - 9 - 11 - 18 - 19 - 22 - 23 - 24 - 25
Excessive noise	1 - 4 - 5 - 6 - 7 - 10 - 24
High power consumption	1 - 5 - 6 - 8 - 9 - 15 - 24 - 25
Vibration	5 - 6 - 7 - 8 - 10 - 12 - 13 - 24
Mechanical seal leaking	11 - 14
Pump loses liquid	11 - 19 - 23
Bearing failure	5 - 6 - 7
Pump does not start	1 - 6 - 20 - 21
Shaft partially or totally locked	6 - 10 - 15 - 16 - 21
Cavitation	3 - 4 - 8 - 9 - 17 - 24

	CAUSES	SOLUTIONS
1	Defective motor or wired wrong	Check the voltage, the frequency, motor type, power consumption, rotation, wiring connections, phase consistency
2	Leakage in suction piping	Repair piping; check valves for leakage
3	Service liquid high temperature	Lower the service liquid temperature; check the level of the service liquid; adjust the cooling liquid flow; adjust the radiator thermostat to lower temperature setting
4	Low service liquid flow	Increase the service liquid flow
5	Coupling misalignment	Re-align the coupling and the pump/motor assembly (see cap. 7)
6	Faulty bearing	Replace the bearing (see "Disassembly & Assembly Instructions")
7	Cavitation	Open the anti-cavitation valve or set the relief valve to a lower vacuum (see tab. 3)
8	High service liquid flow	Reduce the service liquid flow; adjust the by-pass valve
9	High back pressure	Check the discharge line for obstructions or high friction losses; reduce the back-pressure to maximum 0.1 bar
10	Wrong pump/motor assembly	Verify that the base surface is level and that all pump feet are resting on the surface, add spacers if required (see chapter 11)
11	Mechanical seal failure	Change the mechanical seal (see "Disassembly & Assembly Instructions")
12	Wrong pump mounting	Remount the pump (see chapter 7)
13	Piping weight resting on pump	Support the piping with hangers or other means (see chapter 11)
14	Inadequate seal lubrication	Check flushing liquid temperature, flow and pressure
15	Mineral deposits from hard water	Clean the pump
16	Foreign particles in pump	Disassemble the pump to remove the foreign objects (see "Disassembly & Assembly Instructions")
17	Low suction pressure	Open the vacuum regulating valve and/or the anti-cavitation valve (see tab. 3)
18	Wrong pump rotation	Reverse the rotation (see chapter 8)
19	Bad gaskets	Replace the defective gaskets (see the "Disassembly & Assembly Instructions")
20	Wrong motor connections	Check the electrical connections (connectors, fuses, breakers) and the power supply line (see chapter 8)
21	Pump seized	Disassemble and repair the pump (see "Disassembly & Assembly Instructions")
22	Pump undersized	Select a pump with higher capacity
23	Pump worn-out	Disassemble and repair the pump (see "Disassembly & Assembly Instructions")
24	Excessive liquid flow through suction line	Reduce the liquid flow through the pump suction; install a centrifugal separator (cyclone) before the pump
25	Instrumentation out of calibration	Check the working characteristics, replace if required

17 - REPAIRING AND REMOVING PUMP FROM THE INSTALLATION

Should there be the need for pump repair a knowledge of the specific "Disassembly and Assembly Instructions" is required.

DANGER!



Danger due to collision, crushing or harm. Wait for the complete pump stopping before handling the unit. If the pump still contains some fluid, it may suddenly start to rotate once again. Take precautionary measures by draining the pump or closing the pipes by mean of a valve. Possible contact with high temperature surfaces, wait for the pump cooling. Maintenance must be absolutely carried out when the pump is at a standstill, disconnecting the power supply and any other connection. Please make sure that the power supply is restored only by the operator making the maintenance. It is necessary the presence of at least two operators and a foreman must be aware there is a maintenance in progress.

Operate only provided with apposite protective devices.

FOLLOW THE SAFETY STANDARDS LISTED IN CHAPTER 2.

Before working on the pump it is important to:

- procure and wear the proper safety equipment (hard hat, safety glasses, gloves, safety shoes, etc.)
- disconnect the electrical power supply and, if required, disconnect the electrical cable from the motor
- close the isolating valves at pump inlet, outlet and service liquid
- let the pump cool down to ambient temperature if it has been handling hot fluids
- adopt safety measures if the pump has been handling hazardous liquids
- drain the pump internals of the pumped liquid through the draining connections, if necessary rinse with neutral liquid.

To remove the pump and the motor from the installation proceed as follows:

- remove bolts from pump suction and discharge flanges
- remove the coupling guard
- remove the spacer of the coupling, if there is one
- if required, remove the motor anchor bolts on the baseplate, for base mounted assembly, or the bolts on the adapter flange in the case of monoblock design
- remove the pump anchor bolts on the baseplate
- remove the pump from the installation. Avoid damaging other system components.

Before returning the pump to POMPETRAVAINI or an authorized service decontaminate the pump and ask for the "handled media" examination form.



In case of pump removal from the installation dispose the unit by following the current regulations and the right measures to protect the environment.

After pump repairs, re-install following the steps from "Assembly and Alignment" procedures and after (see the applicable chapters).

18 - SPARE PARTS

When ordering the pump it is good practice to also order the necessary spare parts, especially when there are no stand-by pumps in the installation. This will minimize unnecessary down times in the event of pump failure or routine maintenance.

It is therefore, recommended to stock the following spare parts for each pump size:

1	Impeller set
1	Complete shaft assembly
1	Bearing set
1	Mechanical seal set (or packing set)
1	Gasket sets
1	Radial seal ring set
1	Bearing spacer set
1	Coupling rubber insert set

For better parts management, the VDMA 24296 standards suggest to stock the number of parts as a function of the number of pumps being used in the plant.

On the pump nameplate are printed pump model, year of manufacture and pump serial number. When ordering spare parts always provide this information. Pump type, parts item number (VDMA) and description as per the pump sectional drawing and parts list is useful information that helps to supply correct spare parts for your pump.

We recommend the use of original spares: in case this is not respected, POMPETRAVAINI declines any responsibility for possible damages and not correct running caused by not original spare parts.

19.1 - INFLUENCE OF SERVICE LIQUID TEMPERATURE, SPECIFIC GRAVITY AND VISCOSITY ON PUMP PERFORMANCE

The performance of liquid ring vacuum pumps is based on the use of water at 15°C as service liquid. With water at different temperatures the pump capacity and the maximum attainable vacuum level will vary in function of the type of pump, as illustrated by the curve sets of fig. 38 and 39.

EXAMPLE: Pressure = 60 mbar - Water temperature = 24°C - Pump series TRH - Capacity (15°C water) = 120 m³/h from curves of fig. 39 we find the correcting factor of 0,80, therefore the actual capacity for the pump at the given conditions will be: $120 \times 0,80 = 96 \text{ m}^3/\text{h}$.

The maximum suction pressure before incurring cavitation will be approximately 45 mbar.

Regarding the performance variation due to changes of specific gravity and viscosity, it can be assumed a proportional variation in power consumption however, the changes in capacity at different pressures must be analyzed case by case. Please refer the conditions to POMPETRAVINI when these corrections are needed.

Fig. 38
Single stage pump
(series TRM, TRS, TRV)

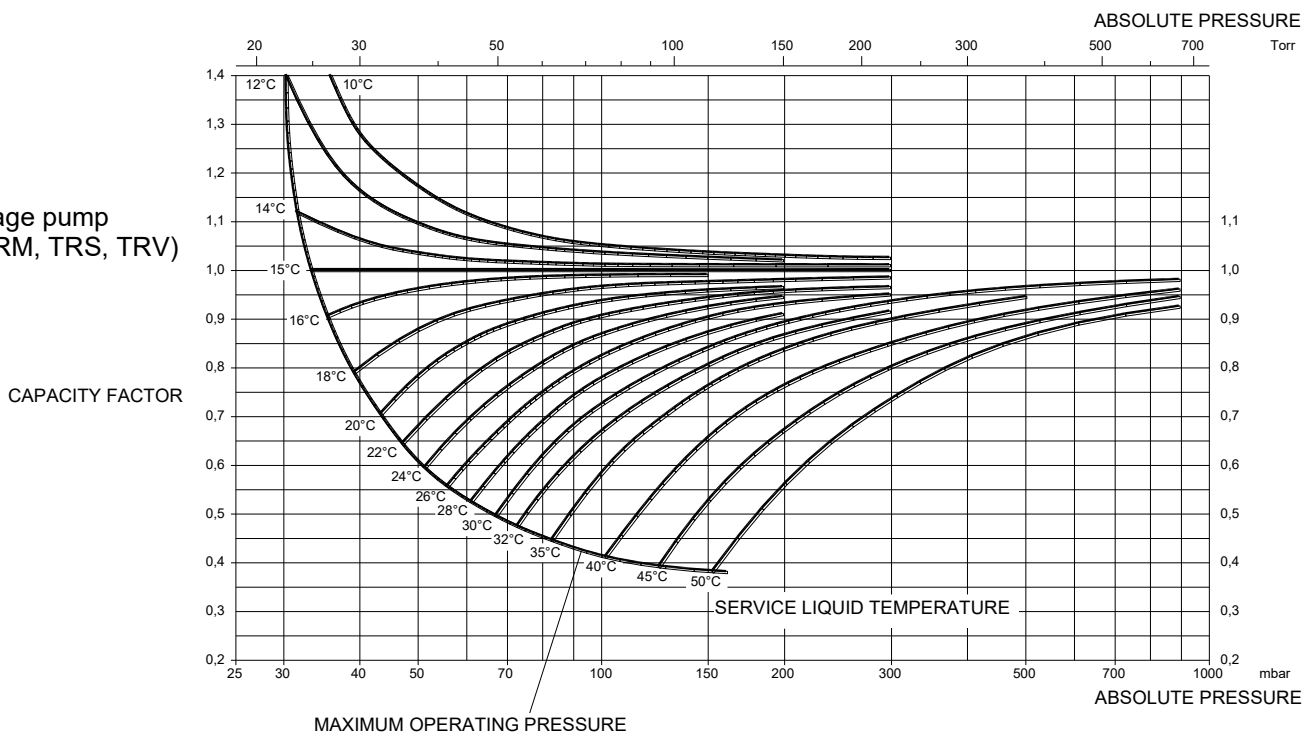
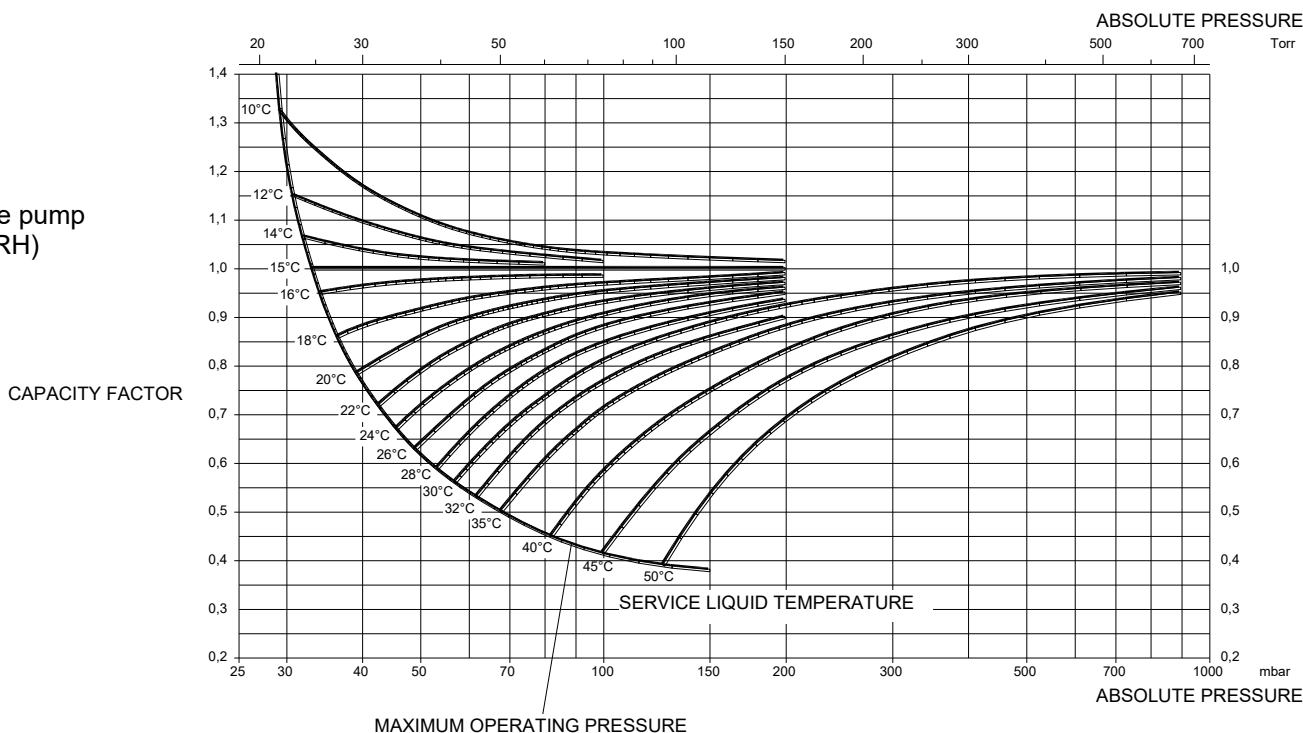


Fig. 39
Two stage pump
(series TRH)



19.2 - SERVICE LIQUID TEMPERATURE CHANGE ACROSS THE PUMP

The service liquid of a liquid ring pump absorbs total heat Q_T as follows:

$$Q_T \text{ (kJ/h)} = Q_c + Q_K + Q_R$$

Where:

$Q_c = 0,9 \times P \times 3600 =$ Isothermal compression heat

$Q_K = m_v \times r =$ Condensation heat

$Q_R = m_g \times c_p \times \Delta T_a =$ Cooling heat (Generally negligible, ignored in calculation of Q_T)

$m_v =$ mass condensed incoming vapor in kg/h

$m_g =$ mass incoming gas in kg/h

$P =$ absorbed power at operating point in kW

$c_p =$ gas specific heat in kJ/Kg x K

$r =$ heat of vaporization in kJ/Kg

$\Delta T_a =$ differential temperature in K, between incoming gas T_G and service liquid discharge temperature ($T_2 + \Delta T$)

$K =$ Kelvin temperature

Once the Q_T is known it is possible to calculate the differential temperature ΔT of the pump service liquid:

$$\Delta T = \frac{Q_T}{Q_A \cdot \rho \cdot c_p}$$

Where:

$Q_T =$ total heat load before calculated in kJ/h

$Q_A =$ pump service liquid flow in m³/h

$\rho =$ service liquid density in kg/m³ (water = 1000)

$c_p =$ service liquid specific heat in kJ/kg x K

(Some values for c_p : Water = 4,2 - Air = 1,0 - Water Vapor = 1,84)

NOTE: It can be assumed that the discharge gas and service liquid have same temperature.

19.3 - OPERATION WITH PARTIAL RECOVERY OF SERVICE LIQUID

Where the working conditions will allow it, the service liquid temperature can be increased utilizing a smaller quantity of fresh liquid from an outside source. A similar flow as the make-up is discharged to the drain while the balance of liquid required by the pump is recirculated. In these cases the service liquid working temperature rises and the pump capacity will require correction per curves of fig. 38 and 39. The system installation will be similar to the schematic of fig. 40.

Depending upon the affordable loss of capacity the service liquid temperature T_2 may be set and the make-up flow of fresh liquid Q_F can then be calculated:

$$Q_F \text{ (m}^3\text{/h)} = \frac{Q_A \cdot \Delta T}{T_2 - T_1 + \Delta T}$$

where:

$Q_F =$ Fresh make-up flow from outside source in m³/h

$Q_A =$ Total service liquid flow required for the operating conditions in m³/h

$\Delta T =$ Service liquid temperature rise (see chapter 19.2)

$T_2 =$ Service liquid temperature to pump

$T_1 =$ Temperature of make-up liquid

The fig. 40 indicates a generic schematic of a liquid ring vacuum pump in a partial recovery system.

By closing the recirculation line the system would become a "once through" installation where all the service liquid is drained, therefore:

$$Q_A = Q_F \quad \text{and} \quad T_2 = T_1$$

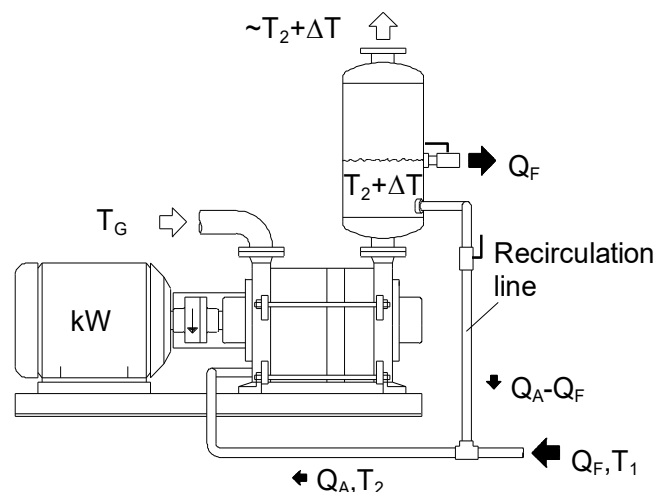


Fig. 40

19.4 - UNIT CONVERSION TABLE

Absolute pressure					Vacuum				Dry air flow at 15°C		Saturated vapor flow		Saturated water temperature		Vaporization heat
KPa	mbar	Torr	"Hg	Ata	%	mH2O	cmHg	"Hg	m3/kg	m3/kg	°C	°F	kJ/kg		
100	1013	760	30	1,033	0	0	0	0	0,816	1,673	100	212	2260		
90	900	700	25	0,9	10	1	10	5	0,9	2	95	210	2270		
80	800	600	20	0,8	20	2	20	10	1	2,5	90	200	2280		
70	700	500	15	0,7	30	3	30	15	1,5	3	85	190	2290		
60	600	400	10	0,6	40	4	40	20	2	4	80	180	2300		
50	500	300	7,5	0,5	50	5	50	25	2,5	5	75	170	2310		
40	400	250	6	0,4	60	6	60	30	3	6	70	160	2320		
30	300	200	4,5	0,3	70	7	70	35	3,5	7	65	150	2330		
25	250	150	3,5	0,25	75	7,5	75	40	4	8	60	140	2340		
20	200	100	2,5	0,2	80	8	80	45	4,5	9	55	130	2350		
15	150	75	1,5	0,15	85	8,5	85	50	5	10	50	120	2360		
10	100	50	1,033	0,1	90	9	90	55	6	11	45	110	2370		
9	90	40	0,9	0,09	91	9,1	91	60	6,6	12	40	100	2380		
8	80	30	0,8	0,08	92	9,2	92	65	6,7	13	35	90	2390		
7	70	25	0,7	0,07	93	9,3	93	70	6,8	14	30	80	2400		
6	60	20	0,6	0,06	94	9,4	94	75	6,9	15	25	70	2410		
5	50	15	0,5	0,05	95	9,5	95	80	7	16	20	60	2420		
4	40	10	0,4	0,04	96	9,6	96	85	7,1	17	15	50	2430		
3	30	7,5	0,3	0,03	97	9,7	97	90	7,2	18	10	40	2440		
2,5	25	6	0,25	0,025	97,5	9,75	97,5	95	7,3	19	5	32	2450		
2	20	4,5	0,2	0,02	98	9,8	98	100	7,4	20	0	32	2460		
1,5	15	3,5	0,15	0,015	98,5	9,85	98,5	105	7,5	21			2470		
1	10	2,5	0,1	0,01	99	9,9	99	110	7,6	22			2480		
0,9	9	2	0,09	0,009	99,1	9,91	99,1	115	7,7	23			2490		
0,8	8	1,5	0,08	0,008	99,2	9,92	99,2	120	7,8	24			2500		
0,7	7	1,033	0,07	0,007	99,3	9,93	99,3	125	7,9	25					
0,6	6	0,9	0,06	0,006	99,4	9,94	99,4	130	8	26					
0,5	5	0,75	0,05	0,005	99,5	9,95	99,5	135	8,1	27					

WORKING PRINCIPLE

The HYDROSYS packages main components are: a liquid ring vacuum pump ITEM 4 from series TRH, TRS, TRM, TRV, an air/liquid separator reservoir ITEM 1, a heat exchanger ITEM 9, all mounted on a common and compact frame ITEM 30. When working, the vacuum pump discharges from the discharge port the gas handled with a portion of the liquid from the pump internal liquid ring. This liquid must be continuously returned to the pump.

The gas/liquid mixture is separated in a cylindrical tank (separator), the gas is vented through the top mounted discharge flange of the separator and the liquid is collected at the bottom of the separator ready to be returned to the vacuum pump.

During the suction and compression cycle of the vacuum pump, all the energy is transformed into heat energy and almost all of it is absorbed by the service liquid. Therefore the liquid must be cooled prior to be returned to the pump, either with a heat exchanger (total recovery system) or with the addition of cool make-up liquid (partial recovery system).

The TOTAL RECOVERY system (see fig. 41 and legend on following page) does not require an appreciable flow of make-up from an external source but only the necessary amount to compensate for the liquid lost due to evaporation, with the discharged gases.

The heat exchanger sizing should be based on using a minimum amount of cooling liquid (usually water) to keep the service liquid at the ideal temperature for the best efficiency of the vacuum pump. Remember, the higher the temperature of the service liquid the higher the losses in pump capacity and maximum vacuum, see chapter 19.

This system is particular suitable where the service liquid and the condensed gases cannot be discharged to the environment, either for pollution reasons or because the fluids are too valuable.

The PARTIAL RECOVERY system (see fig. 42 and legend on following page) requires a constant flow of cold make-up liquid from an external source. This liquid must be of the same nature as the service liquid being used by the pump. The mixture of the make-up and the service liquid being discharged by the pump, will have a constant temperature when enters the vacuum pump service liquid connection.

The same amount of service liquid taken from the outside source must be overflowed through the separator overflow connection situated at the pump shaft centerline.

This system is utilized in many applications for conditions where there is intermittent use, or low vacuum levels, or there is no danger of pollution and the liquid can easily be drained.

Furthermore this may prove to be the only alternative to the total recovery system for those installations where the cooling liquid is not available or it is too warm.

Numerous accessories are available to meet the customers' requests and suitable for the installation, process and maintenance.

For materials of construction and some engineering data see tab. 10 and 11.

(General schematic drawings)

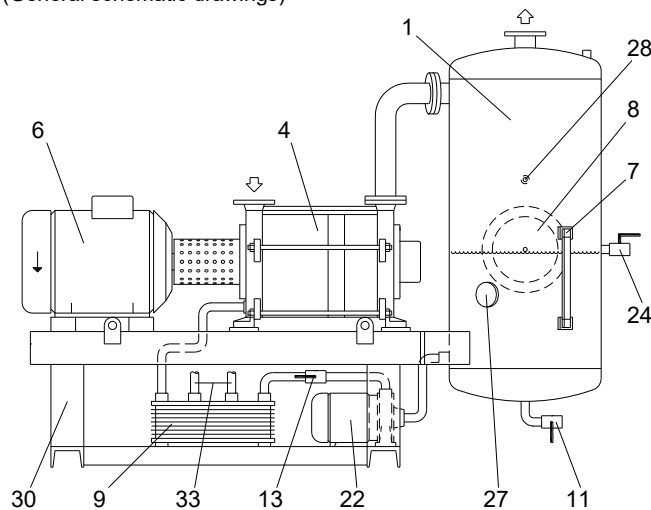


Fig. 41 - TOTAL RECOVERY system

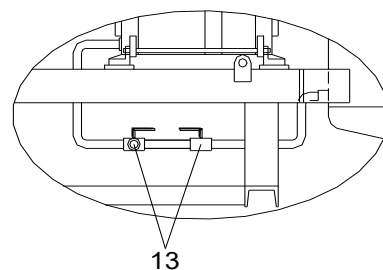


Fig. 42 - PARTIAL RECOVERY system

Tab. 10 - STANDARD MATERIALS FOR “HYDROSYS” SYSTEMS

COMPONENT		MATERIAL DESIGN	
Vacuum pump		GH - F - RA Carbon steel	A3
Separator reservoir			AISI 316 SS
Frame			
Heat Exchanger	Plates	AISI 316 SS	
	Gaskets	Nitrile rubber / Viton	
Circulating pump		Cast iron	AISI 316 SS
Piping		Carbon steel	
Valves – Thermometer		Brass	
Level gauge		Polycarbonate	“Pirex” Glass

For vacuum pump materials (GH - F - RA - A3) see chapter 4.

SOME EXAMPLES OF “HYDROSYS” SYSTEMS (General schematic drawings)

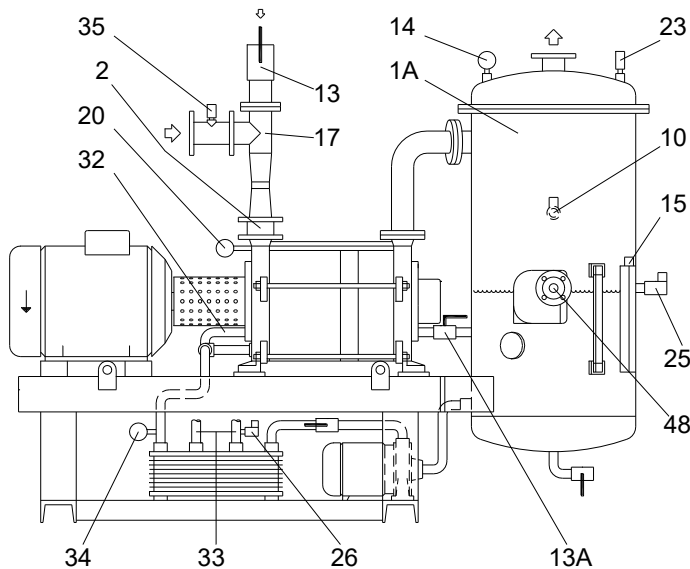


Fig. 43 - Accessories upon request

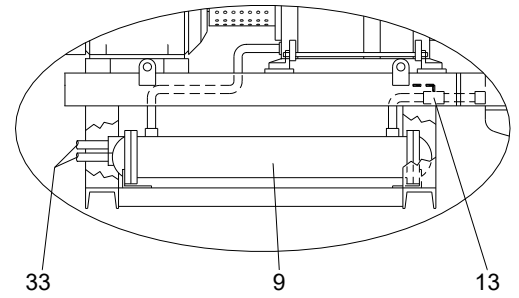


Fig. 44 - Option with Shell & Tubes heat exchanger

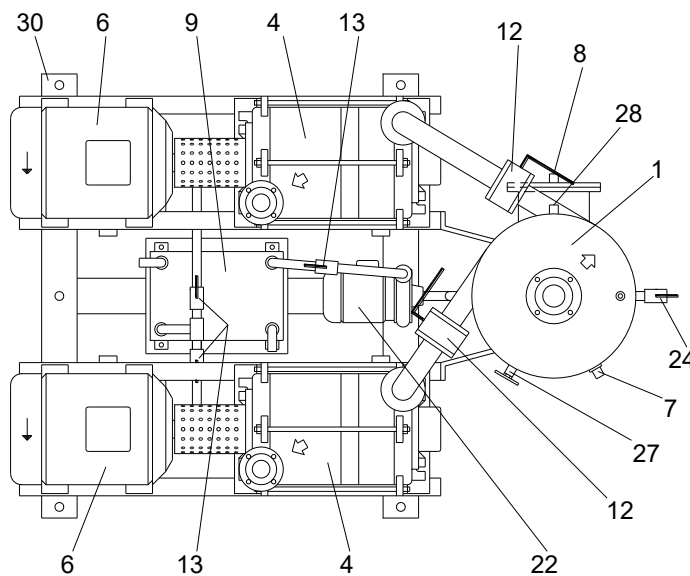


Fig. 45 - Duplex system, total recovery (Top view)

LEGEND

- 1 Separator reservoir
- 1A Separator reservoir with removable lid
- 2 Check valve
- 4 Vacuum pump
- 6 Electric motor
- 7 Level gauge
- 8 Float valve
- 9 Heat exchanger
- 10 Solenoid valve liquid make-up
- 11 Drain valve
- 12 Isolating valve
- 13 Service liquid flow regulating valve
- 13A By-pass valve
- 14 Pressure gauge
- 15 Level switch
- 17 Air ejector
- 20 Vacuum gauge
- 22 Circulating pump
- 23 Pressure relief valve
- 24 Overflow valve
- 25 Solenoid valve for overflow
- 26 Solenoid valve for cooling liquid
- 27 Thermometer
- 28 Fill connection
- 30 Frame
- 32 By-pass piping
- 33 Connection cooling lines
- 34 Temperature switch
- 35 Vacuum relief valve
- 48 Automatic drain valve (for systems used as Compressor only)

Tab. 11 - GENERAL AND NOT BINDING ENGINEERING DETAILS FOR “HYDROSYS” & “OILSYS” SYSTEMS

PACKAGE SERIES	Motor size	Dry weight without Pump and Motor kg		Service Liquid Quantity litres	Service Oil Quantity litres
		HYDROSYS	OILSYS	HYDROSYS	OILSYS
HYDROSYS OILSYS 2	3 kW 2 poles / 50 Hz	80	180	12	40
HYDROSYS OILSYS 3	4 kW 4 poles / 50 Hz	90	220	35	98
HYDROSYS OILSYS 4	7,5 kW 4 poles / 50 Hz	120	280	50	110
HYDROSYS OILSYS 5	15 kW 4 poles / 50 Hz	150	350	80	145
HYDROSYS OILSYS 6	30 kW 4 poles / 50 Hz	230	500	135	186
HYDROSYS OILSYS 7	45 kW 6 poles / 50 Hz	500	750	320	360

WORKING PRINCIPLE

OILSYS packages main components are: a liquid ring vacuum pump ITEM 4 from series TRH, TRS, TRM, TRV, an air/liquid separator reservoir ITEM 1B which is also a self-contained frame, a heat exchanger ITEM 9 and an oil demister filter ITEM 1C.

Turbine type mineral oil, or equal (see tab. 12), is used for service liquid. The characteristics of the chosen oil are such that at pressures below 100 mbar, the pump capacity is greater than what would be when using water, and higher vacuum levels are attainable. When working, the vacuum pump discharges the gas handled with a portion of the liquid in the special frame ITEM 1B that acts as separator of gas from the oil and let settle any condensable or particles coming through the pump suction flange. The circulator pump ITEM 22 pumps the oil back to the vacuum pump after it has been through the heat exchanger ITEM 9 and cooled at about 60/80°C. The gas is vented after being cleaned of all oil with the special oil demister element; a pressure gauge ITEM 14 on the filter housing ITEM 1C gives indication of the degree of dirt contained by the filter element. Special inspection openings ITEMS 43 are easily accessible for maintenance and cleaning of the frame separator. Contrary to rotary vane vacuum pumps, there are no moving parts that come in contact with each other, therefore there is no need for lubrication of the pump internals; these are very robust and reliable pump packages which offer extended operating life even when handling condensable gases. See tab. 13 for materials of construction and tab. 11 in chapter 20 for some engineering data.

Tab. 12 - SUGGESTED OILS

MANUFACTURER	TYPE
AGIP	OTE 32
ESSO	TERESSO 32
LUBRA	OLNEO 32
MOBIL	DTE LIGHT 32
SHELL	TURBO OIL 32
TOTAL	PRESLIA 32

COMPONENT	MATERIAL DESIGN
Vacuum pump	GH - F - RA
Frame separator reservoir	Carbon steel
Heat exchanger air-oil	Cooler core
	Shroud
	Fan - Guard
Circulating pump	Cast iron
Piping	Carbon steel - Carburite rubber
Valves - Thermometer	Brass
Level gauge	Polycarbonate

Tab. 13 - STANDARD MATERIALS FOR "OILSYS" SYSTEMS

See chapter 4 for vacuum pump materials of construction (GH - F - RA).

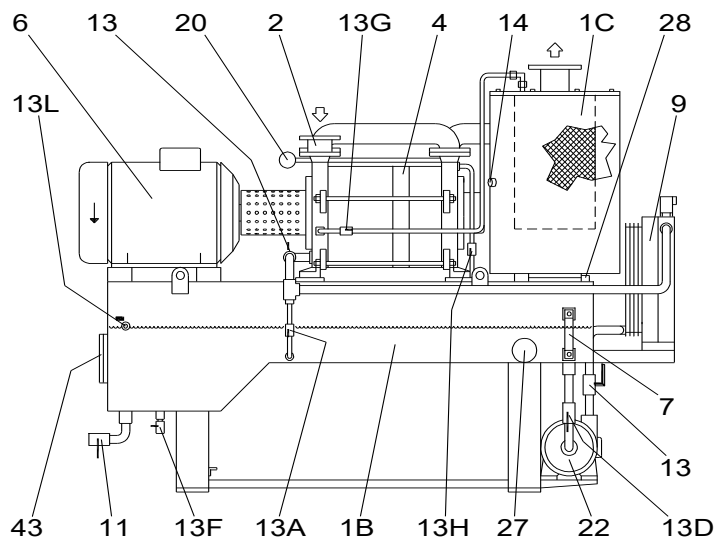


Fig. 46 - STANDARD design

LEGEND

1B - Frame separator	11 - Drain valve
1C - Filter housing	11A - Drain valve
1D - Cyclone separator	12 - Overflow valve
1E - Collecting tank	13 - Flow regulating valve
2 - Check valve	13A - By-pass valve
4 - Vacuum pump	13C - By-pass valve
6 - Electric motor	13D - Isolating valve
7 - Level gauge	13E - Isolating valve
9 - Heat exchanger	13F - Condensate drain valve

13G - Oil drain valve
13H - Ant cavitation valve
13L - Condensate drain valve
14 - Pressure gauge
20 - Vacuum gauge
22 - Circulating pump
27 - Thermometer
28 - Fill connection
43 - Inspection openings

(General schematic drawings)

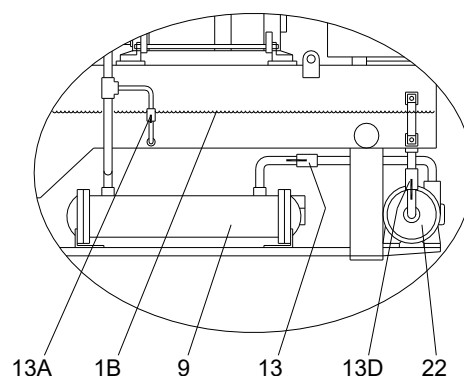


Fig. 47 - Option with Shell & Tube heat exchanger

21.1 – LIFTING AND MOVING OF OILSYS SYSTEMS

DANGER!

Danger due to overturning or crushing. The Oilsys systems must ALWAYS be handled and lifted and moved in horizontal position and without any oil in the tank.



For a safe lifting it is necessary use only ropes or belts positioned on metal bars that were previously inserted in the lifting holes present on the base (see fig. 48) and handle it carefully to avoid damages to the system or harm to the operators.

The bars diameter MUST NOT BE MORE than 5 mm smaller than the diameter of the lifting holes on the base. During handling always use appropriate protective devices.

The bars diameter must not be more than 5 mm smaller than the diameter of the lifting holes on the base.

The lifting bars, after having been inserted in the lifting holes, must be blocked at both ends to avoid the withdraw of the rope or of the bars itself.

For the lifting with ropes or belts use only a balance beam to have a traction upright to the ground.

NOTE: The eyebolts intended for the lifting of a single component of the system MUST NOT be used to lift the entire pump system.

For further information and clarifications ask our Sales Office.

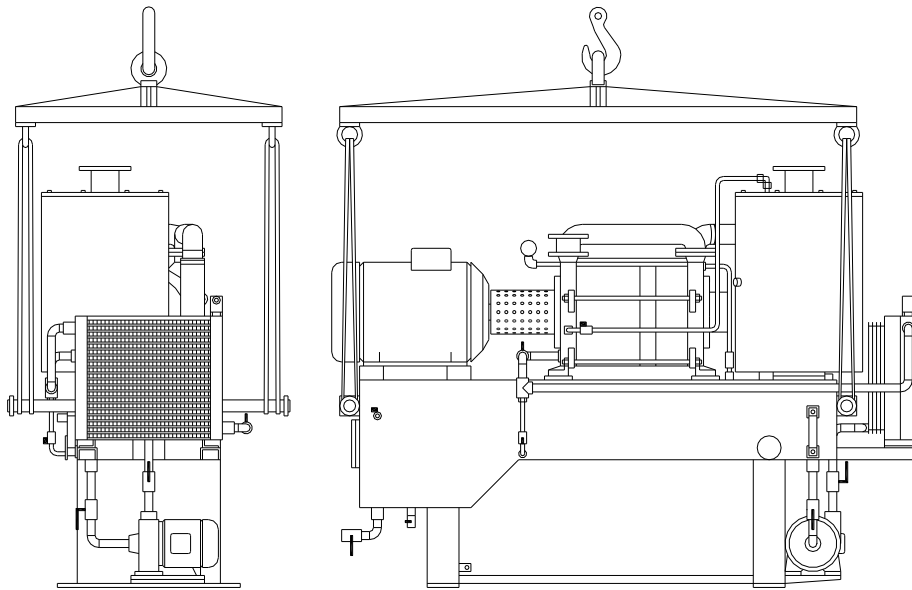


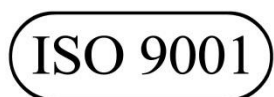
Fig. 48

(blank page)

(blank page)

PRINTED IN ITALY

Continuing research of POMPETRAVAINI results in product improvements: therefore, any specification may subject to change without notice.



pompetravaini

20022 CASTANO PRIMO (Milano) ITALY
Via per Turbigo, 44
Tel. 0331 889000
www.pompetravaini.com

I Dichiarazione CE di Conformità
GB EC Declaration of Conformity
F Déclaration CE de Conformité
D CE Konformitätserklärung
E Certificado de Conformidad CE

NL EG Verklaring van Overeenstemming
DK CE Overensstemmelseserklæring
S CE Försäkran om överensstämmelse
FIN EU Vaatimustenmukaisuusvakuutus
PL CE Certyfikat zgodności

I La Ditta GB The Company F La Société D Die Firma E La Empresa
NL Fabrikant DK Firmaet S Företag FIN Yritys PL Firm:a



pompetravaini

20022 CASTANO PRIMO (Milano) ITALY - Via per Turbigo, 44
Tel. +39 0331 889000 - www.pompetravaini.com

ISO 9001

I firmataria della presente, dichiara sotto la propria esclusiva responsabilità, che la macchina è conforme a quanto prescritto dalle Direttive
GB the signatory of this letter certifies, under its own responsibility, that the machine complies with the requirements prescribed by the Directives
F signataire de la presente, déclare sous sa propre et exclusive responsabilité, que la machine est conforme aux Directives
D der Unterzeichner dieses Briefes bestätigt unter seiner eigenen Verantwortung, dass die Maschine den in den Richtlinien beschriebenen Bestimmungen entspricht
E el firmante de esta carta certifica, bajo su propia responsabilidad, que la maquina cumple con los requerimientos prescritos por las directivas
NL de ondertekenaar van deze verklaring verklaart, onder zijn eigen verantwoording, dat dit product in overeenstemming is met de vereisten, vastgelegd in de richtlijnen
DK signaturen i dette dokument certificerer, under eget ansvar, at maskinen overholder de krav, der stilles i de anførte direktiver
S undertecknare av detta certifikat certifierar, under eget ansvar att maskiner uppfyller följande beskrivna föreskrifter
FIN tämän kirjeen allekirjoitus vakuuttaa että kone täyttää Direktiivien edellyttämät vaatimukset
PL sygnatariusz niniejszego dokumentu zaświadcza, że urządzenie spełnia wymogi opisane w Dyrektywie

Direttiva Macchine / Machinery Directive 2006/42/CE

EN ISO 12100:2010 Sicurezza del macchinario/Safety of Machinery - EN 809:1998 + A1:2009 Pompe e gruppi di pompaggio per liquidi. Requisiti generali di sicurezza / Pumps and pump unit for liquids. Common safety requirements - EN ISO 13857:2019 Sicurezza del macchinario. Distanze di sicurezza / Safety of machinery. Safety distances - EN ISO 14120:2015 Sicurezza del macchinario. Ripari/ Safety of machinery. Guards. - Compatibilità elettromagnetica / EMC Directive 2014/30/UE - Direttiva Bassa Tensione / LVD 2014/35/UE - EN 60204-1:2018 Sicurezza del macchinario. Equipaggiamento elettrico delle macchine / Safety of machinery. Electrical equipment of machines. EN 60034-1:2010 Macchine elettriche rotanti. Valutazione e prestazioni / Rotating electrical machines. Rating and performance.

I Questa dichiarazione perde validità nel caso in cui alla macchina venissero apportate delle modifiche non esplicitamente approvate dal costruttore o nel caso di un uso non conforme della macchina.
GB This certificate will be invalidated in case any modification not approved by the manufacturer is applied to the machine or in case of improper use of the machine itself.
F Ce certificat sera invalidé dans le cas où une modification qui n'est pas approuvée par le fabricant est appliquée à la machine ou en cas d'utilisation impropre de la machine elle-même.
D Bei jeder Modifikation der Maschine, die nicht durch den Hersteller genehmigt wurde oder im Falle des unsachgemäßen Gebrauchs der Maschine verliert dieses Zertifikat seine.
E Esta certificación quedará invalidada si se le aplica a las maquinas cualquier modificación no aprobada por el constructor o en caso de un uso inadecuado de las mismas.
NL Deze verklaring zal ongeldig zijn, indien een modificatie op dit product heeft plaatsgevonden, zonder toestemming van de fabrikant, of bij onjuist gebruik.
DK Dette certifikat er ikke længere gyldigt, såfremt maskinen modificeres på en måde, der ikke er godkendt af producenten eller i tilfælde af uhensigtsmæssig brug af maskinen.
S Om ändringar görs av maskin eller felaktig användning utan godkännande av producent kommer detta certifikat att ogiltigförklaras.
FIN Tämä vakuutus ei ole voimassa jos koneeseen tehdään muutoksia joita ei ole hyväksytetty valmistajalla tai jos konetta käytetään väärin.
PL Certyfikat traci ważność w przypadku modyfikacji dokonanych bez wiedzy i zgody producenta dołączonej do urządzenia, a także w przypadku nieprawidłowego użytkowania urządzenia.

Service Card

I Il Presidente
e responsabile tecnico
GB The President
and Technical Manager
F Le Président
et le Directeur Technique
D Der Geschäftsführer
und Technische Manager
E El presidente
y el director técnico
NL De algemeen
en technisch directeur
DK Direktøren
og Teknisk Chef
S Verkställande direktör
eller Teknisk chef
FIN Toimitusjohtaja ja
Tekninen Johtaja
PL Prezes Zarządu
i Dyrektor Techniczny

Sig. Carlo Travaini