

## **Operation Manual (EN)**

Original version of the operation manual

# Rotary vane pumps Two-stage

CRVpro8 CHEM



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# 1. Table of Contents


<b>1</b>	<b>IMPORTANT INFORMATION</b>	<b>3</b>
1.1	MEANING OF THE WARNING AND INFORMATION NOTES	3
1.2	GENERAL INFORMATION	3
1.3	TARGET GROUPS	4
1.4	INTENDED USE	4
1.5	USE FOR AN UNAUTHORIZED PURPOSE	4
1.6	PRODUCT STANDARDS, SAFETY REGULATIONS	4
<b>2</b>	<b>BASIC SAFETY INSTRUCTIONS</b>	<b>5</b>
2.1	GENERAL INFORMATION	5
2.2	ELECTRICITY	5
2.3	MECHANICAL SYSTEMS	5
2.4	HAZARDOUS SUBSTANCES	6
2.5	HIGH TEMPERATURES	6
<b>3</b>	<b>DESCRIPTION</b>	<b>7</b>
3.1	DESIGN	7
3.2	AREA OF APPLICATION	7
3.3	SCOPE OF DELIVERY	8
3.4	FUNCTION	9
3.4.1	<i>Principles of Vacuum Pump Operation</i>	9
3.4.2	<i>Working Principle of Rotary vane pumps</i>	9
3.4.3	<i>Working Principle of Two-Stage Rotary vane pumps (CRVpro8 CHEM)</i>	10
3.4.4	<i>Oil Functions</i>	11
3.4.5	<i>Pump Lubrication</i>	11
3.4.6	<i>Exhaust Filter</i>	11
3.4.7	<i>Gas Ballast</i>	11
<b>4</b>	<b>TECHNICAL DATA</b>	<b>14</b>
4.1	DIMENSIONS	14
4.2	PUMPING SPEED / INTAKE PRESSURE – DIAGRAM	15
4.3	DEVICE DATA	16
4.4	MOTOR DATA	16
4.5	LUBRICATION DATA	16
4.6	ORDER NUMBERS	17
<b>5</b>	<b>INSTALLATION AND OPERATION</b>	<b>18</b>
5.1	UNPACKING	18
5.2	PUMP MOUNTING	18
5.3	PUMP LOCATION / ENVIRONMENTAL CONDITIONS	18
5.4	GENERAL REFERENCES	19
5.5	INSTALLATION AND CONNECTION	19
5.5.1	<i>Connecting to the Electricity Supply</i>	20
5.5.2	<i>Installation of the Grounding Plug</i>	21
5.5.3	<i>Change the Voltage Setting</i>	22
5.5.4	<i>Motor Protection</i>	22
5.6	STARTING-UP	23
5.7	OPERATING TEMPERATURE	23
5.8	OIL FOR DRAWING OFF OXYGEN	24
5.9	GAS BALLAST CONTROL	24
5.10	TRAP INSTALLATION AND MAINTENANCE	24
5.11	SIDE PANEL FITTING PORT	25
5.12	CLOSING DOWN	25
5.13	STORAGE	26
5.14	SCRAP DISPOSAL	26


<b>6</b>	<b>MAINTENANCE AND SERVICING</b>	<b>27</b>
6.1	STEPS FOR FILLING OIL	28
6.2	OIL LEVEL CONTROL	29
6.3	OIL COLOR CHECK AND WATER IN OIL	29
6.4	OIL CHANGE AND FLUSHING	30
6.5	SHUTDOWN PROCEDURES	34
6.6	HIGH PRESSURE OPERATION	35
6.7	VACUUM PROBLEMS	35
6.8	EXTENDING SERVICE LIFE THROUGH PROPER MAINTENANCE	36
6.8.1	<i>Developing a Maintenance Schedule for Changing Oil and Oil Filter</i>	36
6.8.2	<i>Recommendations for Pump Operation and Downtime</i>	36
6.9	RECOMMENDATIONS FOR PUMPING CORROSIVE GASES AND VAPORS	37
6.10	RECOMMENDATIONS FOR PUMPING SOLVENTS	37
6.11	APPLICATION NOTE : FREEZE DRYERS	38
6.12	SHAFT SEAL REPLACEMENT	38
6.13	MAJOR FACTORY REPAIR	39
<b>7</b>	<b>TROUBLESHOOTING</b>	<b>39</b>
<b>8</b>	<b>OVERVIEW OF ACCESSORIES</b>	<b>40</b>
8.1	OVERVIEW AND ORDER NUMBERS FOR EMEA, ASIA	40
8.2	OVERVIEW AND ORDER NUMBERS FOR AMERICAS	41
8.3	INLET CONDENSOR AKS 16	42
8.4	OIL MIST SEPARATOR AKD 16	43
<b>9</b>	<b>REVIEW OF SPARE PARTS</b>	<b>44</b>
9.1	OIL FILTER KIT	44
9.2	OIL FILTRATION SYSTEM TUBING AND CLAMPS KIT	44
9.3	FILTER WRENCH	45
9.4	FASTENING KIT	45
9.5	SEAL KIT	46
9.6	LIP SEAL KIT	46
9.7	OIL DRAIN VALVE KIT	46
9.8	SERVICE KIT	47
9.9	SIDE PANEL FITTING KIT	47
9.10	KF25 INLET PORT KIT	48
9.11	LIST OF SPARE PARTS FOR PUMP LESS OIL FILTRATION SYSTEM	49
<b>10</b>	<b>WARRANTY</b>	<b>50</b>
<b>11</b>	<b>EC DECLARATION</b>	<b>51</b>
<b>12</b>	<b>GLOBAL CONTACT</b>	<b>52</b>

# 1 Important Information

## 1.1 Meaning of the Warning and Information notes

Take note of the warning notes which are in the following boxes:

	<b>CAUTION ! / WARNING !</b>
<b>Hazard which may lead to serious injuries or material damage.</b>	

	<b>WARNING !</b>
<b>Hot surface which may lead to serious injuries or material damage.</b>	


Information which are only relevant of CE operation are marked in following boxes:

<b>CE</b>	<b>ONLY RELEVANT FOR CE (220-240V / 50HZ ) OPERATION</b>
Only relevant for CE 220-240V / 50Hz operation	

Information which are only relevant of UL operation are marked in following boxes:

<b>For UL</b>	<b>ONLY RELEVANT FOR UL (115V, 230V / 60HZ) OPERATION</b>
Only relevant for UL 115V, 230V / 60Hz operation	

## 1.2 General Information

	<b>CAUTION !</b>
<b>IMPORTANT SAFETY INSTRUCTIONS - SAVE THESE INSTRUCTIONS</b> <b>To reduce the risks of fire or explosion, electrical shock, and the injury to persons, read and understand all instructions included in this manual. Be familiar with the controls and the proper usage of the equipment.</b>	

The CE/UL sign is located on the rating plate. Observe the binding national and local regulations when fitting the pump into installations!

Note: The English version is the original version of the operation manual.

Our products are sold worldwide and can therefore be equipped with the typical national plugs and for the various voltages.

<b>CE</b>	<b>ONLY RELEVANT FOR CE (220-240V / 50HZ ) OPERATION</b>
The rotary vane pump conform to the following directives:	
2006/42/EC	Directive on machinery
2012/19/EU	Directive on waste electrical and electronic equipment
2011/65/EU	Directive on the restriction of the use of certain hazardous substances in electrical and electronic equipment

### 1.3 Target Groups

This operating manual is intended for the personnel planning, operating and maintaining standard, two-stage, Rotary vane pumps.

This group of people includes:

- Designers and fitters of vacuum apparatus
- Employees working on commercial laboratory and industrial vacuum technology applications
- Service personnel for Rotary vane pumps

The personnel operating and maintaining the Rotary vane pumps must have the technical competence required to perform the work that has to be done and understand the hazards involved. The user must authorize the operating personnel to do the work that has to be done. The personnel must have read and understood the complete operating manual before using the Rotary vane pumps.

The operating manual must be kept at the place of use and be available to the personnel when required.

### 1.4 Intended Use

The layout of the rotary vane pump must be appropriate for the conditions of use. The user bears the sole responsibility for this.

The rotary vane pump may only be operated under the conditions stated:

- in the "Technical Data" chapter
- on the type plate and
- in the technical specification for the order concerned

### 1.5 Use for an Unauthorized Purpose

It is forbidden to use the pump for applications deviating from the technical data stated on the type plate, in the operating manual or the conditions stated in the supply contract, or to operate it with missing or defective protective devices.

The CRVpro standard pumps are not suited for pumping liquids.

### 1.6 Product Standards, Safety Regulations


<b>CE</b>	<b>ONLY RELEVANT FOR CE (220-240V / 50HZ ) OPERATION</b>
The rotary vane pump meet the following product standards:	
EN 60204-1	Safety of machinery - Electrical equipment of machines - Part 1: General requirements

Observe the standards and regulations applying in your country when you use the rotary vane pump.

## 2 Basic Safety Instructions

IMPORTANT SAFETY INSTRUCTIONS  
SAVE THESE INSTRUCTIONS

### 2.1 General Information

	<b>CAUTION !</b>
<b>To reduce the risks of fire or explosion, electrical shock, and the injury to persons, read and understand all instructions included in this manual. Be familiar with the controls and the proper usage of the equipment</b>	

- Warning notices must be observed. Disregarding them may lead to damage to health and property.
- The Rotary vane pumps must be operated by personnel who can detect impending dangers and take action to prevent them from materializing.
- The Rotary vane pumps is intended for indoor use only.
- The manufacturer or authorized workshops will only service or maintain the rotary vane pump if it is accompanied by a fully completed damage report. Precise information about the contamination (also negative information if necessary) and thorough cleaning of the rotary vane pump are legally binding parts of the contract.
- Contaminated Rotary vane pumps and their individual parts must be disposed of in accordance with the legal regulations. The local regulations apply in foreign countries.

### 2.2 Electricity


Please note the following when connecting to the electrical power supply system:

- The electrical power supply system must have a protective connector according to IEC 60364-4-41 (for CE operation only).
- The protective connector should not have any breaks.
- The connecting cable should not be damaged.


### 2.3 Mechanical Systems

Improper use can lead to injuries or material damage. Observe the following instructions:

- Only operate the Rotary vane pumps with the specified flange-mounting components.
- Hazardous substances must be separated out as far as this is technically possible before they reach the pump.
- External mechanical stresses and vibrations must not be transmitted to the pump. Only use flexible vacuum hoses for connecting Rotary vane pumps.
- The pump should not be used to suck up fluids. Lay the exhaust pipe so that it slopes downwards, so allowing condensate to flow out of the pump. Collect the condensate and dispose of it in an environmentally compatible manner.
- Maintain a space of least 20 cm between the pump and adjacent parts in order to enable the pump to cool.

	<b>CAUTION !</b>
<b>Solid particles in the pumping medium impair the pumping action and can lead to damage. Prevent solid particles penetrating into the pump!</b>	

## 2.4 Hazardous Substances

	<b>CAUTION !</b>
<b>The operating company bears the responsibility for the use of the rotary vane pump.</b>	

Hazardous substances in the gases to be pumped can cause personal injuries and property damage. Pay attention to the warning notices for handling hazardous substances. The local regulations apply in foreign countries.

### **Combustible and explosive Gases**

Examine before switching on whether that can form gas combustible gas/air mixtures which can be promoted! Consider the regulations of the guideline 1999/92/EC. It is not permitted to pump gases that are combustible or prone to explosion.

### **Aggressive gases**

The Rotary vane pumps are not certified according to ATEX directive 2014/34/EU.

### **Poisonous gases**

Use a separator when pumping poisonous or harmful gases. Prevent such substances from leaking out of the appliance or pump. Treat these substances according to the applicable environmental protection regulations.

Test the strength and leak-tightness of the connecting lines and the connected apparatus. Prevent environmental poisons, e.g. mercury, getting into the Rotary vane pumps.

## 2.5 High Temperatures

The rotary vane pump may heat up as a result of the temperature of the gas being pumped and through intrinsic heating. In dependence on the operation mode, the casing temperature can reach 90 °C (motor). Prevent the following maximum permissible temperature from being exceeded.

- + 40 °C for the environment

The motor is protected against overload by a suitable protective device.

### 3 Description

#### 3.1 Design

The CRVpro8 CHEM is an oil-sealed, two-stage CRVpro rotary vane pumps series with integral oil filtration system. The drive motor is directly flange-mounted onto the motor cover of the pump holder and the pump shaft and the motor shaft are connected to each other by an elastic coupling. The bearings of the interior pump body are force-fed lubricated sliding bearings.

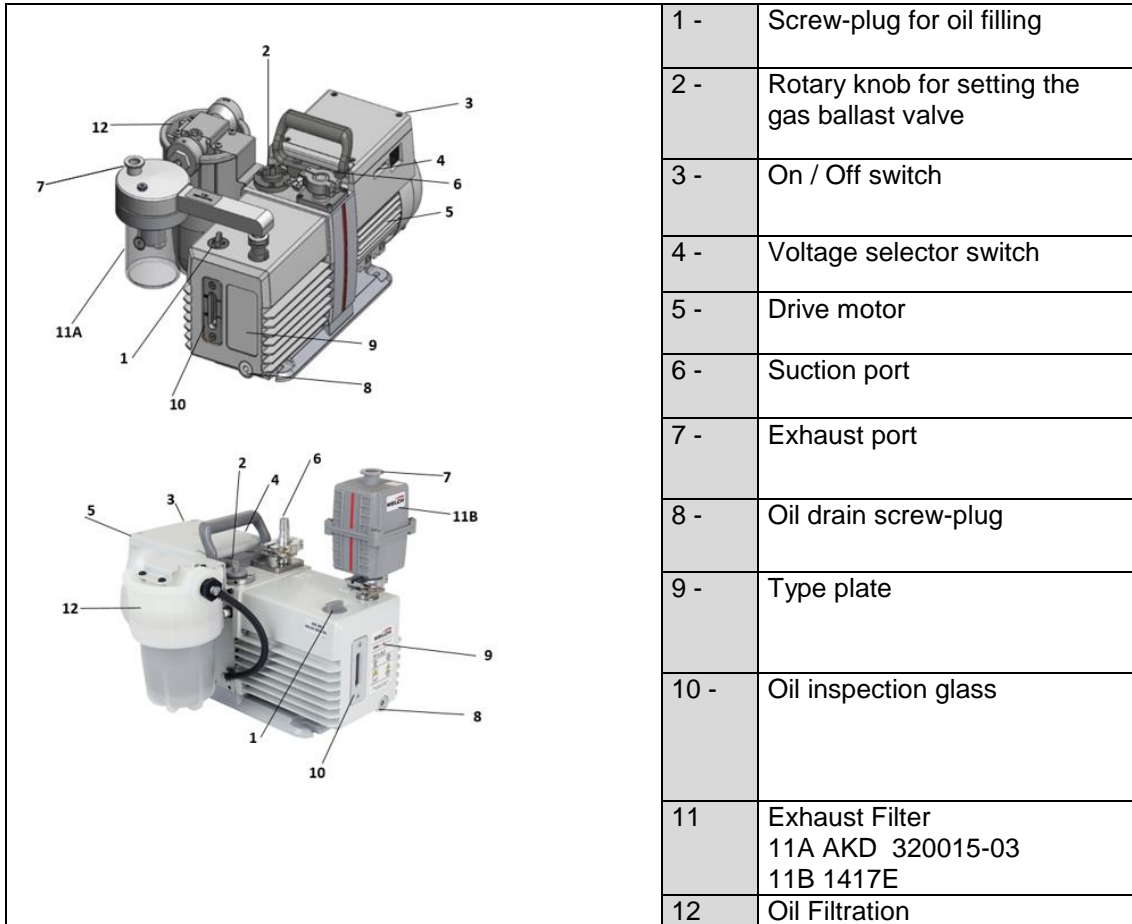


Fig. 1 Rotary vane pump (CRVpro8 CHEM)

#### 3.2 Area of Application

The CRVpro8 CHEM rotary vane pumps encompasses the entire field of vacuum technology, both for use in the laboratory and in industry.

The task is to create an ultimate pressure of  $10^{-3}$  mbar (ultimate pressure partial  $10^{-4}$  mbar):

- as a single vacuum pump

The rotary vane pump can evacuate containers or vacuum installations.

**WARNING !**

The rotary vane pump must not be used for extracting explosive gases or vapours. The rotary vane pump must not be operated in rooms which might contain explosive gases.

### 3.3 Scope of Delivery

Followed the scope of delivery for standard model numbers. The scope of delivery for other model numbers is specified in the supply contract.

	Americas		EMEA	Asia
Description	115V, Hose barb	230V, Hose barb	230V, Standard	230V, CN plug
Ordering Information	3081-80	3082-80	3082-81	3083-81
Factory wired for:	115V/60Hz	220-240/50Hz 230V/60Hz	220-240/50Hz 230V/60Hz	220-240/50Hz 230V/60Hz
Voltage switchable:	Yes	Yes	Yes	Yes
Centering ring with dirt trap	1	1	1	1
Centering ring with dirt trap	1	1	1	1
Protection cap	1	1	1	1
Plastic ring	1	1	1	1
Clamping ring (DN16KF)	1	1	1	1
1 liter vacuum oil, bottle	2	2	Pump filled with oil	2
Line cord (US-plug; 115V NEMA 5-15)	1	-	-	-
Line cord (US-plug; 230V NEMA 5-15)	-	1	-	-
Line cord(CN-plug; AS/NZS 3112)	-	-	-	1
Line cord (EU-plug; CEE 7/4)	-	1	1	-
IEC male to female	-	1	-	-
Line cord (UK-plug; B1363)	-	1	1	1
Hose barb adapter (NW16 5/8")	1	1	-	-
Manual (English)	1	1	1	1
Manual (German)	-	1	1	1
AKD Exahust filter, DN 16 KF	-	-	1	1
Exhaust filter, 1417E	1	1	-	-

### 3.4 Function

#### 3.4.1 Principles of Vacuum Pump Operation

The main purpose of a vacuum pump is to reduce the pressure in a vessel or a closed system. The degree of pressure reduction is dependent upon the requirements of the application and the type of vacuum pump employed.

#### 3.4.2 Working Principle of Rotary vane pumps

Pressure reduction in a closed system is accomplished by repeatedly removing a portion of the original volume of gas contained in the system. Removal is performed by the action of the rotating elements of the pump which cause a given space to be successfully enlarged and diminished. Figure 2 illustrates a chapter through a typical stage of rotary-vane pump. Note that this figure is not intended to illustrate exactly the internal components of the pumps; its purpose is to illustrate the general operating principles of vacuum pumps.

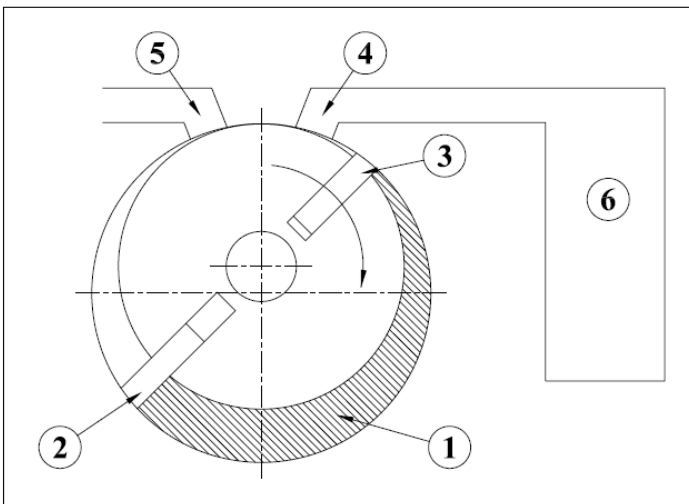


Fig. 2 Rotary vane pump Principle

The rotary action of the pump creates a hollow space of chamber (1) which expands as the pump rotates. As the chamber expands, the pressure in the chamber decreases. As a result, gas is drawn into the chamber due to the difference in pressure between the chamber and the inlet (4) to the chamber (The inlet is the only place where gas can flow into the chamber). Once the vane (3) moves past the inlet (4), it seals the inlet against the chamber (1) and the gas becomes trapped between the vanes (2 and 3). The chamber (1) formed by the enclosed space between the vanes then begins to decrease in volume as the rotor revolves, compressing the gas. The pressure of the compressed gas becomes greater than atmospheric pressure. When the vane (2) moves past the exhaust port (5) the compressed gas in the chamber is forced out through the exhaust port. This expansion/compression cycle constitutes one complete cycle of the pump operation. This cycle is repeated as the vane (2) passes the intake port and seals it against the atmosphere. Therefore, two pump cycles are performed during each revolution of the pump rotor.

### 3.4.3 Working Principle of Two-Stage Rotary vane pumps (CRVpro8 CHEM)

Two pump stages (fore-stage and high-stage) are arranged in series in order to improve the end pressure and the pumping speed at lower pressures. The intake takes place in the first stage (high-stage), the compression and the outlet in the second stage (fore-stage).

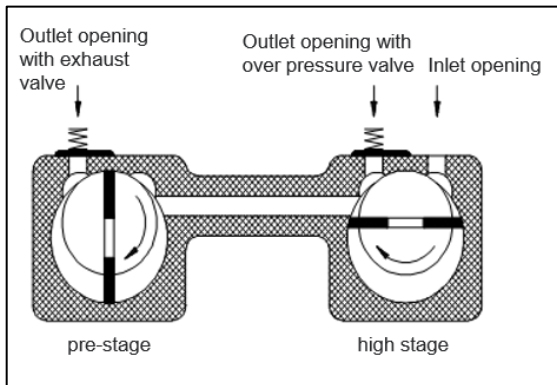


Fig. 3 Pre-stage / high stage

When in operation, the intake stage is at lower pressure and the exhaust stage is at higher pressure relative to each other. Each stage contains a rotor assembly consisting of a rotor with two vanes and a stator. The two rotors are combined on one shaft, and the two stators are combined in a common housing. The pump shaft turns the rotors, causing the vanes in each chamber to sweep the surface of their stators. The vanes are pressed against the stators by centrifugal force. Each stage has an exhaust valve. Gas expelled from the first stage exhaust passes through an interstage port to the intake of the second stage. The second stage compresses the gas further, then expels it from the second stage exhaust valve to the atmosphere. The oil carried along with the gas is separated out by a filter (available accessory).

An adjustable gas ballast valve is located in the pump's exhaust stage. The purpose of the gas ballast is to prevent vapours condensing in the vacuum pump. A dosed quantity of air (gas ballast) can be let into the pump body during the compression by opening the gas ballast valve. The function of the gas ballast valve is described more in detail in chapter 3.4.7 "Gas Ballast".

#### Effects of Continued Pressure Reduction

The quantity of gas in the vessel (6) is reduced with each evacuation cycle. The gas remaining in the vessel expands to fill the vessel and consequently with each cycle the pressure in the vessel is reduced. This is a manifestation of Boyle's Law which states that, for a constant temperature, the volume of a body of gas is inversely proportional to its pressure; i.e., if the volume is enlarged the pressure must be reduced.

As the amount of gas in the vessel is steadily diminished, its pressure is correspondingly reduced. The action of the pump must therefore compress a successively smaller quantity of gas with each cycle to something greater than atmospheric pressure in order to expel it from the pump.

At the beginning of an evacuation sequence, the compression ratio is very small. In the first cycle of operation the pump draws in a volume of gas at atmospheric pressure and expels it at approximately atmospheric pressure. Since the exhaust valve is generally spring loaded to provide a good seal, the pressure required to open it is somewhat greater than atmospheric pressure.

#### Ultimate Pressure


As described previously, a quantity of gas is removed from the system with each cycle of the pump. Therefore, the pressure of the gas remaining in the system is reduced with each pump cycle. Since the pump can remove only a small portion of the gas with each pump cycle, it is obvious that this method of evacuation can never completely remove all the gas in the vessel. In addition to this, all the components of the system contain minute sources of gas leakage which are impossible to seal completely against atmospheric pressure. Outgassing of materials within the system provide additional sources of gas. As a result, after prolonged pumping, a state of equilibrium is reached in which the gas introduced from all the leakage sources is balanced by the ability of the pump to remove gas from the system. This state of equilibrium is referred to as the ultimate pressure or blankoff pressure of the pump and its system. No matter

how much additional pumping time is provided, no further reduction in system pressure will be accomplished once ultimate pressure is attained.

### Intake Anti-suck back Protection

When power to the pump is turned off, this device closes automatically, maintaining vacuum in the system being evacuated, and vents the inside of the pump to atmospheric pressure.

### 3.4.4 Oil Functions

	<b>WARNING !</b>
<b>Vacuum pump is shipped without oil inside to prevent possible spillage during shipment. Oil must be added prior to use!</b>	

The oil fulfils the following functions in the vacuum pump:

- lubricating the sliding parts, such as rotor, vane, radial shaft seals
- sealing the moving parts against the stator wall to reduce leaks
- conducting the heat of compression to the metal walls (cooling)

The oil transports the polluted particles and corrosive media and thus effects continuous cleaning of the internal surfaces.

### 3.4.5 Pump Lubrication

To ensure efficient operation and proper maintenance, and to minimize noise and oil vapors, it is important to use the correct type and quantity of oil. Welch Gold vacuum oil has been especially developed to have the proper viscosity, exceptionally low vapor pressure, high stability in chemical environments, and no additives or inhibitors needed to produce peak pumping efficiency.

The ultimate vacuum guarantee on Welch pumps applies only when this oil is used. Each pump is supplied with sufficient oil for filling. Additional oil is available. See chapter 8 Overview of Accessories.

### 3.4.6 Exhaust Filter

Any oil-sealed vacuum pump tends to discharge oil mist from its exhaust port when the pump operates under high-flow conditions, such as when the pump's intake is at or near atmospheric pressure. Typically, oil mist in the form of a white puff of "smoke" can be seen from the exhaust port when no filter is used. Once the vacuum level and the corresponding air flow through the pump are reduced, very little, if any, oil mist will be emitted. An exhaust filter is recommended for any vacuum pump installation where the pump operates at high intake pressures for a prolonged period of time. Oil droplets entrained in the pump's exhaust are removed by the exhaust filter element. Use of an exhaust filter typically reduces or baffles pump noise as well. Exhaust filters are sometimes referred to as oil mist eliminators. An exhaust filter is included with CRVpro8 CHEM. AKD filter, part no. 320015-03, is included with EMEA and Asia pump configurations. Part no. 1417E is included with Americas configuration.

### 3.4.7 Gas Ballast


Condensates could have collected in the vacuum pump if:

- the vacuum pump is new
- it has not been used for long periods
- the pump's maximum tolerance of water vapour pressure has been exceeded

When pumping condensable vapours, they may be compressed during the compression phase above the saturated vapour pressure and condense.

This causes considerable deterioration in the vacuum pump's performance:

- ultimate pressure is not achieved
- corrosion occurs
- heavy oil contamination and formation of emulsions

	<b>CAUTION !</b>
<b>Operating with gas ballast increases the operating temperature of the vacuum pump by 5 – 10 K.</b>	

The gas ballast valve can increase the pump's water vapour tolerance. In many vacuum pump applications the gases being pumped from a system are a combination of permanent gases and undesirable vapours such as water vapour. Under some conditions, the vapours condense in the second stage of the pump and contaminate the oil. The gas ballast valve reduces oil contamination by decreasing or eliminating vapour condensation.

Vapor condensation is most likely to take place when the gas compression ratio is high, i.e. when the pump compresses a relatively large volume of gas to a small volume. Whether or not condensation takes place is dependent upon several factors, including the proportion of permanent gases to vapours at the pump intake. If the gases being pumped consist entirely of vapours, condensation will definitely occur unless the gas ballast valve is opened.

The gas ballast valve adds a small amount of air at atmospheric pressure to the gas being compressed in the second stage. This reduces the compression required to push the gas out past the exhaust valve (less reduction in volume is required), and therefore reduces or eliminates condensation.

When the gas ballast valve is open, the pump has to work a little harder, resulting in a slight increase in operating temperature. The increase in temperature is small, however, and is not harmful to the pump. Also, the pump is slightly noisier, and the pump's ultimate pressure is somewhat reduced. Therefore, the gas ballast valve should be kept closed when it is not needed. Note that the gas ballast is not equally effective on all different types of chemical vapors, so it may not always eliminate condensation completely.

Should condensate form despite actuation of the gas ballast device, the suction port must be closed and the pump operated with gas ballast for a lengthy period (about 2 hours).

#### Summary of Impact of Vapor Condensation in Pump and the Effect of the Gas Ballast

- Gas loads on 2-stage rotary vane pump at normal operating conditions contain both non-condensable gases and vapors that may condense in pump.
- Vapors can liquefy(condense) during compression inside vacuum pump and mix with the vacuum pump oil
- Condensed vapors will mix and contaminate the vacuum pump oil.
- The pump oil and condensed vapors will circulate through the pump and can cause:
  - Vacuum deterioration
  - Reduced lubrication
  - Sticky substances forming in the oil
  - Possible pump seizing and/or corrosion of pump parts
- Gas ballast open allows small amount of air (or if side port use, dry gas) to be added into the pump during compression

- Air added mixes with non-condensable gases and vapors to dilute the mixture and reduce liquification of vapors
- The ultimate vacuum pressure of pump is reduced by opening gas ballast
- Requires time to clean oil with Gas Ballast open, 2 hours or more

## 4 Technical Data

### 4.1 Dimensions

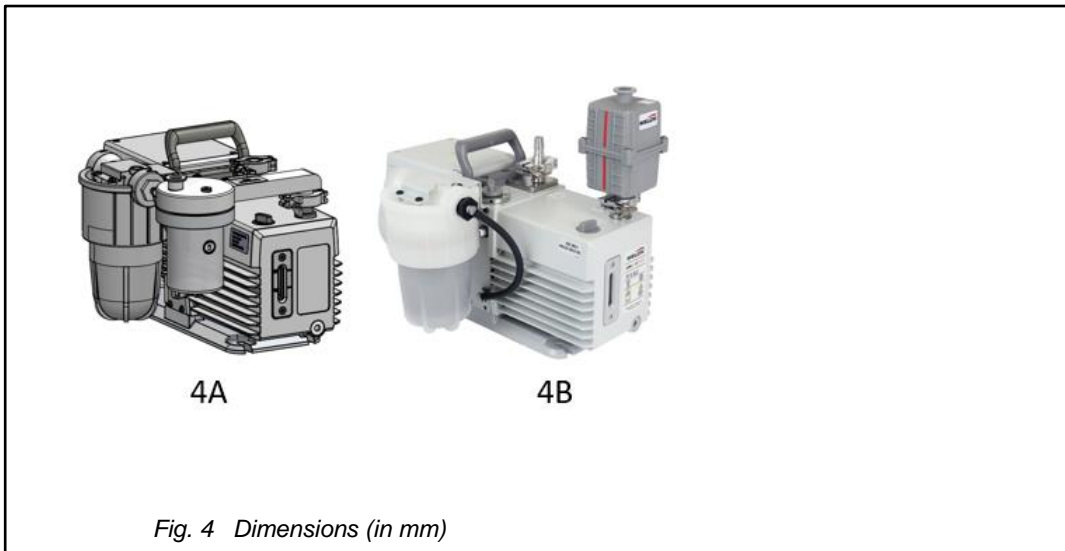


Fig. 4 Dimensions (in mm)

Dimensions, mm Hg	Length	Width	Height
CRVpro 8 CHEM (Fig. 4A)	463	282	234
CRVpro 8 CHEM (Fig. 4B)	463	282	250

## 4.2 Pumping Speed / Intake Pressure – Diagram

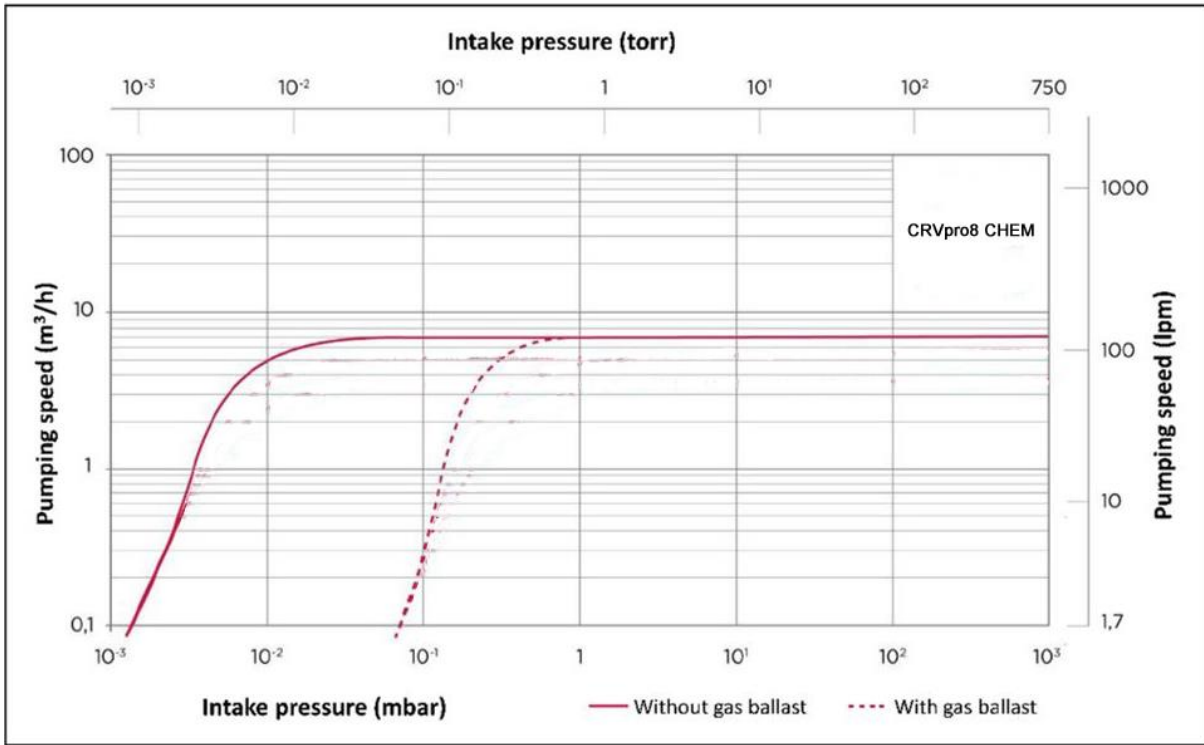


Fig. 5 Pumping Speed / Intake Pressure - Diagram CRVpro 8 CHEM

### 4.3 Device Data

Parameter	Unit	308x-xx CRVpro8 CHEM
Free Air Displacement (max. pumping speed)		
- @ 50Hz	m <sup>3</sup> /h (L/min)	8 (133)
- @ 60Hz	CFM (L/min)	5.6 (158)
Pumping speed (Ø-data 133 to 1013 mbar)		
- @ 50Hz	m <sup>3</sup> /h (L/min)	7.3 (122)
- @ 60Hz	CFM (L/min)	5.1 (143)
Ultimate pressure (ISO21360)		
- without gas ballast partial	mbar (Torr)	5×10 <sup>-4</sup> (4×10 <sup>-4</sup> )
- without gas ballast total	mbar (Torr)	2×10 <sup>-3</sup> (1.5×10 <sup>-3</sup> )
- with gas ballast total	mbar (Torr)	7×10 <sup>-2</sup> (5×10 <sup>-2</sup> )
Max. inlet pressure	bar	1
Max. outlet pressure	bar	1.35
Connection flanges	DN	16 KF
Ambient temperature	°C	10-40
Noise level (50Hz)	Db (A)	≤50
Type of protection		IP54
Oil filling	ml	2000
Dimensions (W/D/H) without exhaust filter	mm (inch)	463/282/234 (18.2/11.1x9.2)
Shipping Carton Dimensions (W/D/H)	mm (inch)	566/330/330 (22.3/13/13)
Weight	kg (lbs.)	28 (61.6)
Shipping Weight	kg (lbs.)	33 (72.6)

### 4.4 Motor Data

Parameter	Unit	115V/230 50/60Hz version	
		50 Hz	60 Hz
Frequency	Hz	Frequency 50 Hz $\text{C} \text{€}$	Frequency 60 Hz (for UL)
Voltage	V	220-240	115 / 230 (switchable)
Motor power	Kw	0.37	0.4
Nominal current	A	2.1	4.3 / 2.1
Motor speed 50/60Hz	rpm	1450	1740

### 4.5 Lubrication Data

Welch Gold vacuum pump oil is a double distilled synthetic hydrocarbon oil designed for excellent resistance when pumping corrosive gases or vapors. A synthetic base stock that has no aromatic compounds or sulfur which accelerate varnishing, sludging and carbon build-up when pumps are used to pump corrosives. Gold oil will give a longer service life and superior protection for the internal metal components of a pump in corrosive pump applications compared to standard hydrocarbon oils. The oil is clear and colorless.

<b>CAS No.</b>	<b>68037-01-4</b>
Vapor Pressure (at 25°C)	1×10 <sup>-7</sup> mbar (1×10 <sup>-7</sup> torr)
Viscosity (at 40°C)	48 cSt
Specific Gravity(at 22°C)	0.83

The technical data and operating characteristics of CRVpro8 CHEM is only guaranteed if original Welch Gold vacuum oil is used!

## 4.6 Order Numbers

### Lubrication

Description		Order no.
Gold vacuum oil:	1 liter	8995G-11
	1 gallon	8995G-15
	5 gallon	8995G-20

## 5 Installation and Operation

### 5.1 Unpacking

Carefully unpack the rotary vane pump. Keep all paperwork and inspection tags for future reference.

Check the pump for:

- Transport damage
- Conformity with the specifications of the supply contract (model, electrical supply data)
- Completeness of the delivery

Please inform us without delay if there are discrepancies between the delivery and the contractually agreed scope of delivery, or if damage is detected.

Please take note of the general terms of business of the manufacturing firm.

**In case of a claim under warranty, the device must be returned in packaging that is suitable for protecting it during transport.**

### 5.2 Pump Mounting

For more rigid mounting requirements the pump base can be bolted directly to a surface using the 2 mounting holes and 2 slots featured on the base.

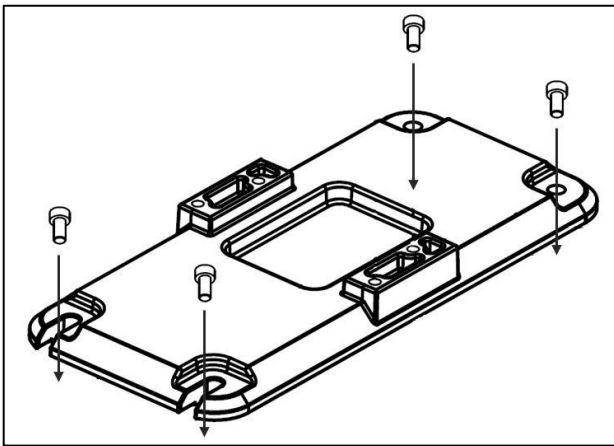


Fig. 7 Pump mounting

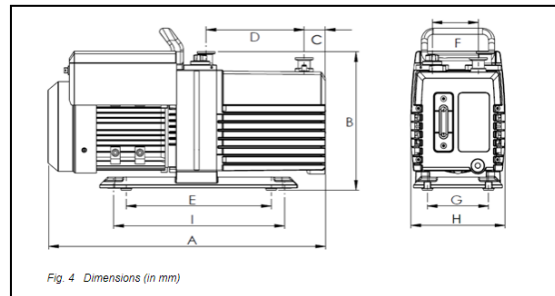



Fig. 4 Dimensions (in mm)

Pump series	A	B	C	D	E	F	G	H	I
	(in mm)								
CRVoro 8	463	230	35.5	163.5	242	88.5	102	157	284

### 5.3 Pump Location / Environmental Conditions

The pump should be located in a clean and well-ventilated area and adequate space should be provided wherever possible for routine maintenance such as oil changes. For best performance, the pump should be located as closely as possible to its system. Determining factors for pump location should include length and size of connections, the number of bends, and the type of exhaust connections.

## 5.4 General References

	CAUTION !
On continuous operation it's recommended to run the pump below 10mbar maximum vacuum pressure.	


According to its intended use the capacity of the vacuum pump depends on:

- the kind of assembly
- accessories
- the oil used
- additional connections
- vacuum piping system


In addition, fail-safe operation is determined by the mode of maintenance. Elements such as valves, filters, condensers should be provided as early as in the conception. The materials of the vacuum piping should be selected in such a way that they will be resistant to the media to be delivered!

## 5.5 Installation and Connection

1. Set the rotary vane pump on a flat and horizontal surface. If more rigid mounting is required, bolt the pump base to the surface. See chapter 5.2 Pump Mounting.
2. Remove the clamping ring and the protection cap of the suction and exhaust ports.
3. Attach the vacuum connection to the suction port and the exhaust pipe on the exhaust port. The suction and pressure ports must not be connected the wrong way round by mistake!

	<b>WARNING !</b>
<b>Never block or impede air flow from the exhaust port. High pressure can build up within the oil reservoir if the exhaust port is blocked. Check frequently, especially if exhaust is piped out of the building.</b>	

4. Depending on the order number, pump are factory wired for low voltage (LV) 115V/60Hz or high voltage (HV) 220-240V/50Hz; 230V/60Hz. If necessary the voltage setting can be changed. How to switch the mode is described in chapter 5.5.3 Change the Voltage Setting.

	<b>WARNING !</b>
<b>Consider the warning reference on the terminal box of the motor!</b>	

5. Check the AC power outlet to be sure that it is the same voltage and phase as the pump motor.
6. Recheck the oil level. If needed refill oil – see chapter section 6.2. Please note that the pump are delivered without oil filling. Initial oil filling has to be done by the user.
7. Connect the rotary vane pump to the electrical supply. Please note the explanations on chapter 5.5.1 Connecting to the Electricity Supply.
8. How to operate the pump see chapter 5.6 Starting-up.

### 5.5.1 Connecting to the Electricity Supply

The standard pump is supplied with complete electrical wiring. It is connected via an appliance cable and a power supply plug. If the supply cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified persons in order to avoid a hazard.

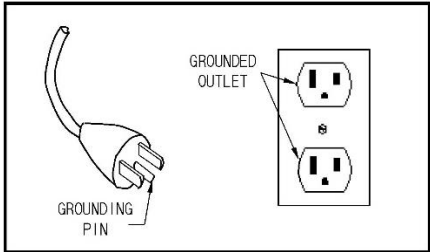



**WARNING !**

**Should the user change the electrical connection, for example for fitting into a system, then this may only be performed by an electrical specialist under observance of the accident prevention regulations.**

- It is generally suggested to protect the motor by 120 per cent of its rated power in consideration of the starting and switch-on response.
- Device connection cables and plugs must comply with the requirements of the line disconnection devices (current, output).
- The customer/user shall install the main and emergency stop switches.

## 5.5.2 Installation of the Grounding Plug

<b>For UL</b>	<b>ONLY RELEVANT FOR UL (115V, 230V / 60HZ) OPERATION</b>
<p>This product must be grounded. In the event of an electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current. This product is equipped with a cord having a grounding wire with an appropriate grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.</p> <p>Check with a qualified electrician or serviceman when the grounding instructions are not completely understood, or when in doubt as to whether the product is properly grounded. Do not modify the plug provided; if it does not fit the outlet, have the proper outlet installed by a qualified electrician.</p> <p>For 115V/60Hz version: this product is for use on a nominal 120-V circuit and has a grounding plug similar to the plug illustrated in Fig 9. Only connect the product to an outlet having the same configuration as the plug. Do not use an adapter with this product.</p>	
	
<p><i>Fig. 8 Grounding plug illustration</i></p> <p>For 230V/60Hz version: this product is for use on a circuit having a nominal rating more than 120 V and is factory-equipped with a specific electric cord and plug for connection to a proper electric circuit. Only connect the product to an outlet having the same configuration as the plug. Do not use an adapter with this product. When the product must be reconnected for use on a different type of electric circuit, the reconnection shall be made by qualified service personnel.</p> <p>Use only a 3-wire extension cord that has a 3-blade grounding plug, and a 3-slot receptacle that accepts the plug on the product. Make sure your extension cord is not damaged. When using an extension cord, be sure to use one heavy enough to carry the current your product draws. For lengths less than 25 ft, 16 AWG extension cords shall be used. An undersized cord results in a drop in line voltage and loss of power and overheating.</p>	

	<b>WARNING !</b>
<p><b>Improper installation of the grounding plug is able to result in a risk of electric shock. When repair or replacement of the cord or plug is required, do not connect the grounding wire to either flat blade terminal. The wire with insulation having an outer surface that is green with or without yellow stripes is the grounding wire.</b></p>	

### 5.5.3 Change the Voltage Setting

Depending on the order number, pump are factory wired for low voltage (LV) 115V / 60Hz or high voltage (HV) 220-240V / 50Hz; 230V / 60Hz. If necessary the voltage setting can be changed as followed:

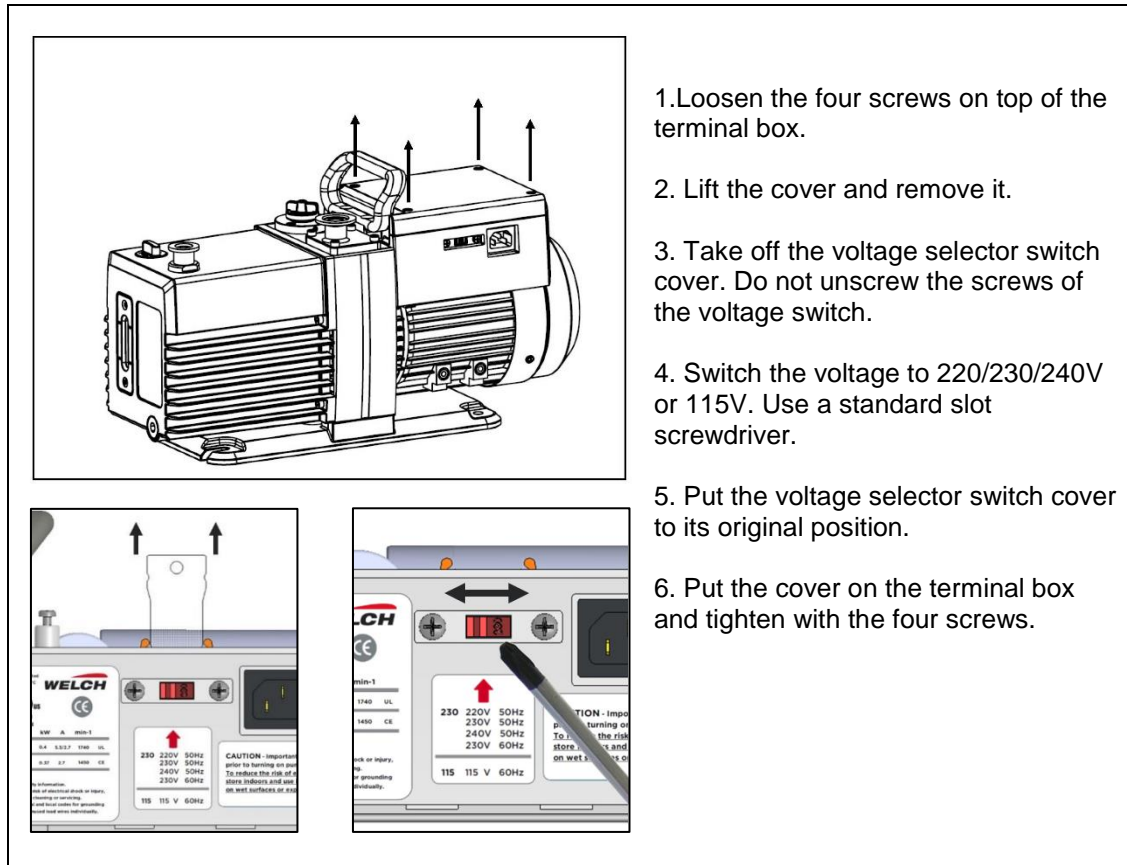


Fig. 9 Change the voltage setting

### 5.5.4 Motor Protection

All A.C. motors are provided with a thermal overload protection ex works, protecting the motor and vacuum pump from damage or destruction, respectively. The motor manufacturer makes motor thermal overload protection available as an aid to minimize motor failure. Overload protection is a standard feature on the single-phase motor. The motor have overload protection plus manual reset after cool down. Once the thermal protector operated the user must turn off the pump and restart manually after cool down.


	<b>CAUTION !</b>
<p><b>The motor has thermal overload protection plus manual reset after cool down. Once the thermal protector operated the user must turn off the pump and restart manually after cool down.</b></p>	

## 5.6 Starting-up

Observe the basic safety instructions when using the pump.


Before using the pump for the first time, it is recommended to spend a few minutes inspecting the pump and its electrical and vacuum connections. Please notice the information which are listed in chapter 5 Installation and Operation.

1. Connect the power cord to the power outlet.
2. Recheck the oil level and add or remove oil as needed. How to do this see chapter 6.2 Oil Level Control.
3. Close off the pump intake and the gas ballast valve, and run the pump at blankoff for a few minutes. The gurgling noise should go away after a few minutes of running; it is caused by the high volume of air that flows through the pump when the pump is first turned on. If the gurgling noise does not stop, check the oil level again to see if it is low. Also check the pump intake fitting to be sure that it is tight.
4. Once proper pump operation has been verified, the pump intake can be opened to the vacuum system.
5. After running the pump for a few minutes, check the oil level again. If the level is too high or too low, stop the pump, vent it to the atmosphere and add or remove oil as needed – see chapter 6.4 Oil Change.
6. Before starting the pump when connection to the vacuum system, check all vacuum connections.


	<b>CAUTION !</b>
<b>Check the oil level prior to switching on the vacuum pump!</b>	

## 5.7 Operating Temperature

The function of the vacuum pump filled with Welch Gold vacuum oil is guaranteed between ambient temperatures of 10°C and 40°C. The lowest starting temperature is 12°C. The pump must be vented on the suction-side (suction port open).

	<b>WARNING !</b>
<b>In dependence on the operation mode, the casing temperature can reach 90°C. Make sure that the vacuum pump has not been installed in an accessible area, and make provision for a guard against contacts!</b>	


## 5.8 Oil for Drawing off Oxygen

	<b>WARNING !</b>
<b>Pump should be not used for oxygen service! Oxygen at atmospheric pressure is exceptionally dangerous!</b>	

For drawing off oxygen containing mixtures or pure oxygen the following must be taken into consideration:

- Synthetic hydrocarbon oil is flammable
- The more they oxidise, the quicker they lose their properties. For this reason they only can be used up to an oxygen percentage of maximum 30 per cent in the medium to be delivered.

In order to prevent any accumulation of oxygen in the discharge space, neutral gas such as nitrogen may be let in through a special inlet assembly. The percentage of oxygen is being reduced. The added amount of gas should be 5 times as much as the percentage of oxygen.

	<b>CAUTION ! / WARNING !</b>
<b>There is a risk of explosion when pumping oxygen at a concentration above 30 percent.</b>	

## 5.9 Gas Ballast Control

The principle of the gas ballast is described in chapter 3.4.7 Gas Ballast.

To open or close the gas ballast turn the gas ballast switch to the position open or close.

### Operation with gas ballast when drawing off condensable vapours

We suggest operation with the gas ballast valve open, provided that the composition of gas in the vacuum pump to be drawn off is not known and cannot be ruled out.

If condensable gas and vapours are to be delivered, the latter or their condensates will mix with the oil. As a result of this, the pump performance will degrade.

## 5.10 Trap installation and maintenance

Where corrosive vapors or large quantities of condensable vapors are evolved from vacuum processing, a cold trap may be used in the connecting line to the pump. It will help prevent damage to the pump mechanism and reduce oil contamination. The cold trap, immersed in a suitable Dewar flask, is installed so that the vapors may come in contact with the surfaces of the trap and condense. Commonly used refrigerants are liquid nitrogen or dry ice and isopropyl alcohol. The refrigerant to be used depends upon the freezing point of the contaminants. A variety of cold traps are available – see chapter 8 Accessories.

When using a cold trap the refrigerant should be maintained at a high level in the flask to keep the trap at a uniformly low temperature. If the trap is rewarded it may allow re-evaporation of the condense. The refrigerant add tube on the liquid nitrogen trap should not be obstructed as the refrigerant boil-off can produce dangerously high pressures. If the trap becomes saturated it should be disconnected from the system, drained and cleaned. An increase in pressure in the vacuum system will normally indicate that the trap has become saturated. To clean the trap, remove the trap from the system, allow the trap to warm up and rinse off the condense with a suitable solvent in a fume hood. Thoroughly clean and dry the trap before reinstalling in the system.

## 5.11 Side Panel Fitting Port

Some applications call for a gas purge using a clean dry gas such as nitrogen. An external gas supply can be routed into the gas ballast assembly using that port.

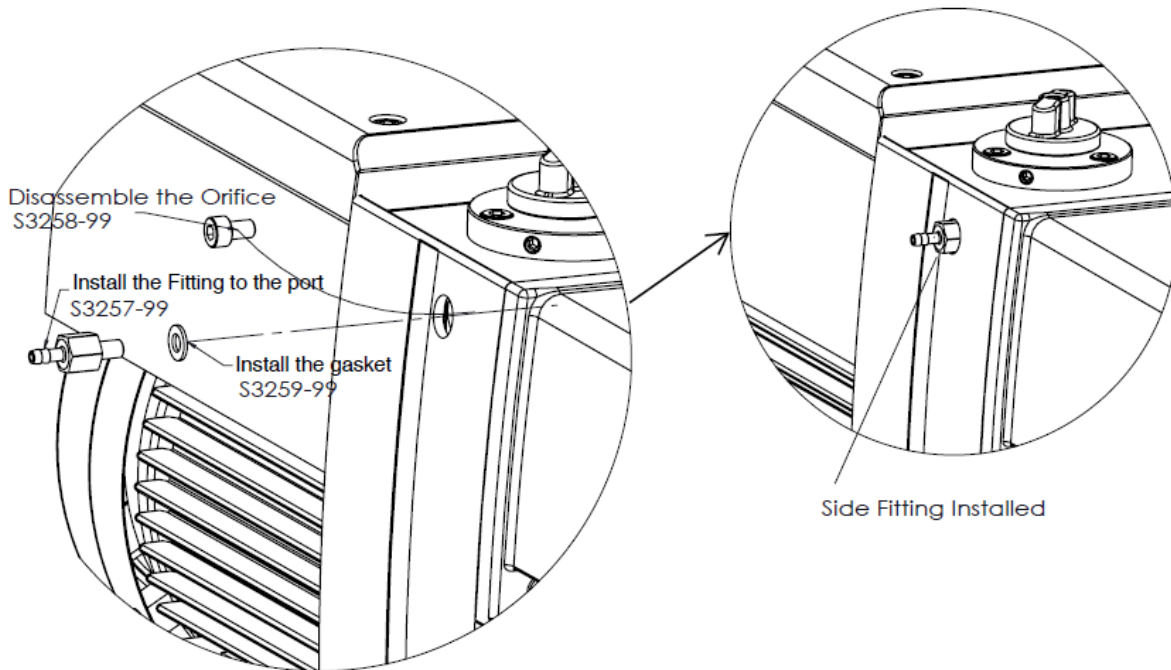



Fig. 10 Side Panel Fitting Port

## 5.12 Closing down

A few simple precautions are necessary before performing a pump shutdown.

1. If a gauge is connected to the system, first isolate the gauge, then turn off the power to the pump and open the system to the atmosphere.
2. If condensable media have been pumped, the vacuum pump must be run after pumping with the gas ballast valve open and the intake pipe closed.
3. If the vacuum pump is not going to be used for a sometime after pumping aggressive or corrosive media, or if it not going to be used for a long time, then proceed as follows:
  - If the pump oil is contaminated and the pump is going to be stored for a prolonged period, the oil should be changed before the pump is stored. Even if a pump is stored for a long period with oil initially in good condition, check the oil when the pump is restarted, and change the oil if necessary.
  - Close connecting ports with a rubber stopper or other suitable cover to protect the pump against contamination. An intake screen is furnished to prevent loose particles from entering.

	<b>WARNING !</b>
<b>Take appropriate safety measures in case of having delivered dangerous media!</b>	


### 5.13 Storage

The pumps are to be stored in a low-dust, interior room within the temperature range from + 5 to + 40 °C and at a relative air humidity < 90%.

Leave the protective elements on the suction and pressure ports. Another equally good protection may be used.

If the pump oil is contaminated and the pump is going to be stored for a prolonged period, the oil should be changed before the pump is stored. Even if a pump is stored for a long period with oil initially in good condition, check the oil when the pump is restarted, and change the oil if necessary.

### 5.14 Scrap Disposal


	<b>CAUTION !</b>
<p><b>The Rotary vane pumps must be disposed of in accordance with the 2012/19/EU directive and the specific national regulations.</b></p> <p><b>Contaminated Rotary vane pumps must be decontaminated according to the laws.</b></p>	


## 6 Maintenance and Servicing

Under normal operating conditions the maintenance of the rotary vane pump is limited to:

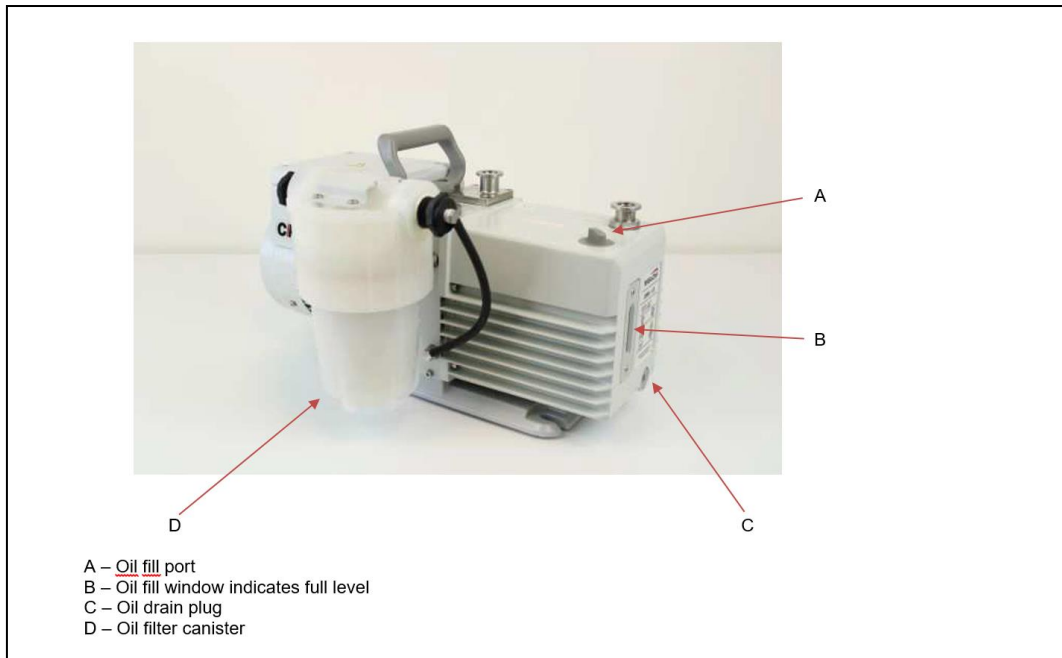
- external cleaning
- checking running noises
- checking the level and quality of the oil
- regular oil changes

These maintenance intervals must be specified according to the prevailing operating conditions and adhered to. The bearings of the drive motors are life-long lubricated and so maintenance-free.

	<b>CAUTION !</b>
<p><b>Only perform the work that is described here, and that which is permitted to be done by the user. All other maintenance and service work may only be performed by the manufacturer or a dealer authorized by him.</b></p> <p><b>Beware of the pump parts being possibly contaminated by hazardous substances. Wear protective clothing if there is contamination.</b></p>	

	<b>WARNING !</b>
<p><b>During repair or maintenance work which could endanger people because of moving or electrically live components, the vacuum pump must be made safe by removing the mains supply plug from the socket or by switching off the main contractor and preventing it from being switched on again!</b></p>	


## 6.1 Steps for Filling Oil



1. Fill the pump with Gold Oil through the oil fill port to the Full mark.
2. Turn the pump ON and watch the oil level in oil case window. The oil level will drop due to filling the filter canister.
3. Add additional oil until oil level equalizes in the sight glass to the Full mark. This takes approximately 5 minutes after initial filling.
4. The oil level should be maintained at the “Full” mark on the oil level window while the pump is operating. Add more oil if necessary to keep the oil at the full level.
5. The pump oil capacity including the filter canister is approximately 2 liters.

**Note:** CRVpro8 CHEM for EMEA (part no. 3082-81) comes filled with Welch Gold vacuum pump oil.

## 6.2 Oil Level Control

	<b>CAUTION !</b>
<b>Check the oil level regularly!</b>	

The oil consumption varies according to the vacuum pump's operating conditions. In order to keep the vacuum pump at all times in an optimum operating condition, the oil level must be inspected at the oil sight glass. The oil level must at all times be showing between the upper and lower markings on the oil sight glass. The oil must be topped up if the oil level falls to the lower mark. We recommend to operate pump with oil filling at upper marking FULL. This minimize the service needs and allows better dilution of contaminants.

When additional oil is required, use only Welch Gold vacuum oil, pump performance is not guaranteed with other brands of oil.

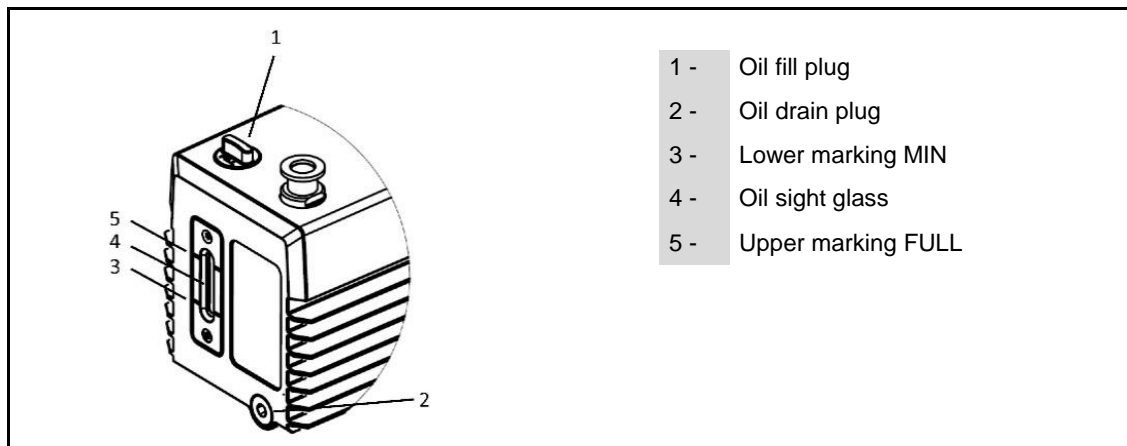



Fig. 11 Oil level control

## 6.3 Oil Color Check and Water in Oil

	<b>WARNING !</b>
<b>The condition and quality of the pump oil have a substantial effect upon the performance and operational readiness of the vacuum pump!</b>	

Comparing the colour of a sample of the pump oil with fresh oil provides an indication of the contamination of the pump oil. You obtain the oil needed for testing from the oil drain aperture with the vacuum pump switched off and at operating temperature.

Brown or black oil or oil smelling as if it has burnt must be removed from the vacuum pump. Flush the vacuum pump and fill up with fresh oil.

If droplets of water are visible in the oil sight window, the water can normally be removed by running the pump with gas ballast open. The procedure to follow is to close the suction port and operate with gas ballast open for a lengthy period (2+ hours). This process will normally clear the water out of the oil.

If running with gas ballast open doesn't remove water in oil 2+ hours, the oil needs to be changed. Refer to section 6.4.

## 6.4 Oil Change and Flushing



**WARNING !**

**If the vacuum pump has been used to pump media which are dangerous to health then all measures must be taken to protect the service and operating personnel!**

If the oil is heavily contaminated, the vacuum pump must have oil changed, e.g.:

- heavy clouding by condensates
- suspended particles such as dust, fibres, abraded particles
- dark coloration of the oil

1. Turn off and remove the power connections to the pump. Wait until the oil has thoroughly cooled until proceeding.



2. Drain the oil from the oil case by removing the oil drain plug. Tilt the pump slightly to aid draining. After completely draining oil, refit the drain plug.



**WARNING !**

**Avoid skin contact with the oil! Wear gloves that protect against chemicals ingested by pump. Dispose of the oil in accordance with the valid environmental protection regulations!**

3. With the drain pan under the canister assembly, use the supplied filter wrench to unscrew the canister from the head.



4. Remove the canister from the head and let the oil drain into the pan.



5. Remove the oil filter from canister.



**WARNING !**

**Avoid skin contact with the oil! Wear gloves that protect against the chemicals ingested by the pump. Dispose of the oil in accordance with the valid environmental protection regulations!**

6. Examine the oil filter. After heavy use pumping acidic chemical vapors, the activated alumina can be spent or clogged with particulates. When this occurs, a decline in pump performance will be seen. Replace oil filter if spent and/or clogged. Refer to Section 6.8 Extending Service Life through Proper Maintenance.



7. Drain the remaining oil from canister.



8. Clean the oil from the outside of the canister.



9. Apply a light coating of new Gold oil to the canister o-ring.



10. If oil filter spent and/or clogged, install a new filter into the canister. Apply new Gold oil to the seals on both ends of the filter.



11. Fill the canister with Gold oil to the bottom of the threads.



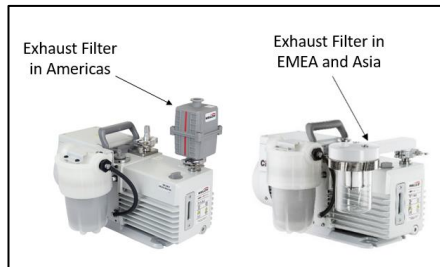
12. Reinstall the canister to the head hand tight.



13. Add Gold oil to pump. Reconnect the power, run the pump while watching the fill window and recheck the oil level. Add more Gold oil if necessary to keep the oil at the full level. Check for any leaks. The oil full capacity is approximately 2 liters.



14. After the vacuum pump has been filled with fresh oil, allow it to warm up by running it with the suction port closed. If you have established that the old oil, which you have previously drained, was contaminated by condensate (e.g. water) then the gas ballast valve should be open and pump run with suction intake close for 2 hours. This procedure will remove residual condensate in the pump oil module and oil case.
15. If the oil still appears heavily contaminated in the oil site glass, repeat step 2, to remove condensate that may have not have drained from the oil case earlier. This procedure is called flushing. It is not necessary to remove the oil canister since it has been cleaned.
16. Reattach the exhaust filter



## 6.5 Shutdown

## Procedures

A few precautions are necessary before performing a pump shut down. If a gauge is connected to the system, first isolate the gauge, then turn off the power to the pump and open the system to the atmosphere. If the pump is disconnected from the system for any length of time, cover the pump intake with a rubber

**Note:** The intake isolation valve will automatically close when power to the pump is turned off. This will maintain vacuum in the system (if the pump remains connected to the rest of the system) for a period of time.

stopper or other suitable cover to protect the pump against contamination. An intake screen is in the intake centering ring to prevent loose particles from entering.

If the exhaust port is open, that should also be covered. If the pump oil is contaminated and the pump is going to be stored for a prolonged period, the oil should be changed before the pump is stored. Even if a pump is stored for a long period with oil initially in good condition, check the oil when the pump is restarted, and change the oil if necessary.



## WARNING !

**Avoid skin contact with the oil! Wash hands thoroughly after handling. Keep out of reach of children. Dispose of the oil in accordance with the valid environmental protection regulations! Do not overfill, excess oil tends to be splashed out the pump exhaust! Use only Welch Gold vacuum oil.**

For best dilution of contaminants, especially on chemical applications, we recommend to keep always oil level at max.

## 6.6 High Pressure Operation

The CRVpro8 CHEM is designed to be most efficient when operated at or near its ultimate blank-off pressure. When operated at elevated pressures for long periods of time, the pump will run hotter. Additional cooling may be required for both the pump and the motor. At elevated ambient temperatures under these conditions, losing its ability to lubricate effectively.

During operation at these pressures, oil may be generated at the exhaust port. The exhaust filter will capture the 99 % of the mist. Running the pump at elevated pressures will lead to the element in exhaust filter to be saturated. It will then need to be replaced.

**Note:** If operating the pump for prolonged periods of time or at above 10 Torr, contact the Welch Technical Service Department for further information and precautions.

## 6.7 Vacuum Problems

Inability to attain sufficient vacuum in a system is usually due to leakage, contamination, or unusual outgassing. A system must be thoroughly clean and free from leaks to operate efficiently. If the system is found to be clean and leak-free, but vacuum problems still exist, the pump should be checked. A simple way to test the pump is to measure its ultimate pressure capability. This can be done by disconnecting the pump from the rest of the system and connecting a pressure gauge directly to the pump intake. (Be sure to seal the pump intake from the atmosphere, and be sure the gas ballast valve is closed.) The gauge can be any type that is suitable for the pressure levels expected. Run the pump until the gauge indicates no further reduction in pressure, and compare the pressure reading to the pump's ultimate pressure rating.

If the pump meets its ultimate pressure specifications only when disconnected from the rest of the system, the fault must be elsewhere in the system. If the pump's ultimate pressure is unusually high, the pump may be badly contaminated, low on oil, or mechanically defective. However, if the pressure is only slightly higher than the pump's guaranteed pressure, an oil change may be all that is needed to bring performance up to specifications. Be sure to use only Gold Vacuum Oil in the vacuum pump; the ultimate pressure guarantee does not apply if other types of oil are used.

The most common cause of efficiency loss in a vacuum pump is contamination of the oil, which is usually caused by foreign particles and/or condensed vapors. The condensate emulsifies with the oil, and when the oil is recirculated, the condensate evaporates. The resulting vapor then reduces the ultimate vacuum attainable in the system.

Some foreign particles and vapors form sludges with the oil. The presence of sludge in the oil impairs its sealing and lubricating properties, and eventually could cause pump seizure. Therefore, periodic oil changes are necessary to maintain efficient operation of the system. The interval at which oil changes are required is different for each set of operating conditions; experience will help you determine the proper interval for your system and process.

## 6.8 Extending Service Life through Proper Maintenance

### 6.8.1 Developing a Maintenance Schedule for Changing Oil and Oil Filter

After studying many examples of pump failure, Welch has found the most common reason is poor condition of the oil. This is why developing a regular maintenance schedule for the oil change is critical in obtaining the longest service life of your CRVpro8 CHEM.

Welch recommends that you examine the condition of the oil on a daily basis in the early days of a new process or experiment. Be on the lookout for discoloration of the oil. The discoloration can indicate deterioration or contamination of the oil and that the acid neutralization capacity of the alumina element has been spent.

The oil should be regularly checked for its pH during the initial start-up days of the experiment or process – and on at least a weekly basis thereafter. If the pH drops 2 units below the initial reading of new oil, the oil and acid neutralization element should be replaced.

Once you know how long it takes for the oil to breakdown or the alumina element to become spent, you can determine your oil change interval.

Other symptoms of poor condition are if the oil level is rising or decreasing. Rising oil can indicate condensation of water or organic vapors occurring in the pump. A decrease in oil level can be a result of high gas throughput where oil is lost as mist through the pump exhaust. Running the pump continuously at pressure above 10 Torr is not recommended for this reason.

For freeze dryer application, high gas throughput can be attributed to improper operation, process leaks or poor vacuum connections.

### 6.8.2 Recommendations for Pump Operation and Downtime

CRVpro8 CHEM is designed for continuous operation especially when the pump is at its ultimate pressure as when the inlet is blanked off.

For freeze dryer applications, it is for this reason that it is recommended to keep the pump running overnight and if possible over the weekends. WITH THE PUMP INLET BLOCKED OFF and gas ballast open. The advantage of this is continuous cleaning of the oil in between freeze-dryer runs.

**Note.** Pumping on the condenser of a freeze dryer when no samples are being processed is not recommended. The reason is the solid material trapped in the condenser will eventually sublime out of the condenser and the vapors will be ingested into the pump. Welch recommends the condenser be cleaned after a freeze dryer run is completed or the pump be blocked off by a valve from the condenser.

Three good operations habits that can protect the pump are :

- 1) Open the gas ballast valve for 15 to 30 minutes per day to help remove any condensed vapors from the oil.
- 2) Upon completion of freeze drying, block off the inlet of the pump and run overnight for continuous cleaning of the oil.
- 3) For extended pump shutdowns of greater than 3 days, drain the oil from the pump case and replace with fresh clean oil. This will decrease chemical attack on the internal pumping mechanisms of the vacuum pump while it is shut down.

## 6.9 Recommendations for Pumping Corrosive Gases and Vapors

Before beginning any work with corrosive gases or vapors, you need to know the chemical properties of the corrosive materials you will be working with. Welch strongly recommends you and your in-house safety committee review the chemical properties and the safe way of handling. This manual is not intended to provide this information so we recommend consulting the appropriate handbook.

### Background:

Processes that employ corrosive gases and/or vapors are well known for shortening the life of vacuum pumps. Much reason exists for this to happen:

1. Corrosive gases and vapors may decompose the pump oil leading to the vacuum pump becoming oil-starved. An oil-starved pump will eventually seize.
2. Chemical reactions occurring in the process and on various surfaces between process and vacuum pump may create new compounds. The effect of these new compounds will be determined by trial and error.

This CRVpro8 CHEM has been designed to handle vapor loads with acid concentrations ranging up to 1% by volume of the gas flow into the pump. The key feature of the pump is the integral oil filtration system, which utilizes an alumina element for continuous neutralization of acids.

When using strong hydrous acids, hydrochloric acid (HCl), Hydrogen Bromide (HBr), Sulfuric Acid (H<sub>2</sub>SO<sub>4</sub>) and Nitric Acid (HNO<sub>3</sub>) and/or Trifluoroacetic Acid (F<sub>3</sub>CCO<sub>2</sub>H), the close adherence to the recommendations made in section

## 6.10 Recommendations for Pumping Solvents

Vacuum systems containing condensable vapors are known to create vacuum pump problems. The main concern is the degradation of the pump oil affecting lubrication and deterioration of ultimate pressure.

A vapor is defined as the gaseous form of any substance that is usually a liquid or solid at standard conditions. Water, acetonitrile, and alcohol vapors are examples. Vapors or mixtures of gas and vapor are subject to condensation within the pump. The precipitated liquid may ultimately dissolve, react or become emulsified within the oil. This will lead to premature failure of the pump.

Vapor condensation usually takes place in the compression stroke of the second stage of the vacuum pump when the compression ratio between the initial pressure and the end pressure is high. Opening the gas ballast valve will admit air to the second stage of the vacuum pump thereby reducing the partial pressure of any vapor in the gas mix (Dalton's Law). Diluting the vapor with air increases the condensation pressure. Depending on the amount of air added, condensation of the vapor is either entirely avoided or substantially reduced.

Symptoms of condensed vapors in the pump are deterioration of ultimate pressure, oil level rising and discoloration of the oil. Condensed water vapor in a running pump gives the oil a milky-white discoloration with frothing and bubbles. Opening the gas ballast valve for approximately one hour or longer will remove the condensed water from the pump oil. Operating the pump with the gas ballast valve open for extended periods of time will not harm the pump. Remember that the system vacuum pressure will not be maintained if power is lost and the gas ballast valve is open.

With the gas ballast open, the sound of the exhaust is similar to that of a pump operating against a large leak. The pump must work a little harder to function because of the increased pressure introduced into the compression stroke. This results in an increased operating temperature. A higher operating temperature can also speed-up the removal of some condensed vapors.

The specific gravity of the condensed vapor will determine if it floats on top of the oil, or if it settles to the bottom of the oil reservoir, displacing the oil.

The following table lists physical data of some common solvents and pump oil at standard conditions.

Solvent	Specific Gravity	Boiling Point, deg C	Vapor Pressure Torr at 20 deg C
Water	1.00	100.0	17.6
Acetonitrile	0.79	80.0	72.8
Acetone	0.79	56.0	185.7
Isopropanol	0.79	82.3	33.0
Gold Vacuum Pump Oil	0.83	229.4	$1 \times 10^{-7}$

### 6.11 Application Note : Freeze Dryers

Vacuum pump oil can be quickly compromised by the vapors from a freeze dryer. Once oil is chemically damaged, lubrication properties diminish and vacuum pump quickly requires repair.

Organic solvents, acids, and other sublimated vapors may pass through the freeze dryer collector too rapidly to be effectively condensed. In general, better protection of your vacuum pump can be accomplished by :

- 1) Using a freeze dryer with an ultra-low refrigeration collector. Often these cool to  $-84^{\circ}\text{C}$  or colder.
- 2) Ensuring that your freeze dryer is operating vacuum tight. Too high a flow – augmented by system leakage – prevents collector from operating efficiently.

### 6.12 Shaft Seal Replacement

When the shaft seal in the mounting plate shows signs of excessive oil leakage, it should be replaced.

Before attempting replacement of the seal, the pump must be disconnected from the vacuum system and from the power outlet. A seal replacement kit is available. This kit contains the outer lip seal assembly and gasket, which can be replaced in the field. See chapter 10 “Overview of Spare Parts”.


## 6.13 Major Factory Repair

Repairs and maintenance going beyond the extent of the work described in the previous chapters or reconditioning or modification may only be performed by the manufacturer or authorized workshops. Drain the oil before dispatching the pump and dispose of the oil according to the regulations. The prerequisites for a handover are a complete and factually correct damage report, and a clean pump. Clean the pump aggregate and the pump casing after pumping media which are harmful to health and the environment. Fill up with sufficient oil to protect against corrosion during transport!

For more detailed information please visit our webpage: <https://www.welchvacuum.com/service.html>

If you should not have an entrance to the Internet, you can contact us via phone:

Europe: +49 3677 604 0  
Americas: +1 847 676 8800  
Asia: +86 21 5186 0238

	<b>WARNING !</b>
<p><b>Incomplete or incorrectly completed damage reports may endanger the service personnel!</b></p> <p><b>Provide full information about contamination, and clean the pump thoroughly before handing it over to third parties. The user shall be liable for the consequences of an incorrect damage report or a contaminated pump. The statements in the damage report are legally binding.</b></p>	

## 7 Troubleshooting

Only manufacturing firm and authorized service workshops may work on the pump and their accessories during the warranty period.

Trouble	Cause	Remedy	
		by:	with:
Vacuum pump does not start	No power supply	Qualified electrician	Check electrical installation
	Motor defective	Service workshop	Exchange
	Coupling defective		Repair and/or exchange
	Starting temperature too low	User	Put vacuum pump in a warm place corresponding to the starting temperature
	Oil is resinous after too long storage	User or Service workshop	General maintenance / cleaning
Vacuum pump does not generate a vacuum	Ultimate pressure few mbar or atmospheric pressure, oil shortage	User	Top-up oil
	Oil is dirty		Operate with gas ballast, or perform oil change with flushing
	Oil supply to pump unit interrupted or reduced	User	Check that the oil circulation is functioning, measure the oil pressure at operating temperature, 1 – 1.2 bar overpressure, check that the pipes are clear and have no leaks
	Gas ballast valve open	User	Close the gas ballast valve
	Shaft seals defective		Exchange

Trouble	Cause	Remedy	
		by:	with:
	Work or pressure control valve defective	User or Service workshop	Exchange
	Intake valve defective		Repair
	Oil supply to pump aggregate reduced, Oil superimposition interrupted by work valve		Repair
	Built-up pressure in the oil casing too high because of exhaust gas pipe or oil mist filter		Check exhaust pipe, change filter insert
Vacuum pump runs very loudly	Motor, rotary vanes and/or shaft seal rings defective, rotary vane spring broken	User or Service workshop	Repair and/or exchange
Vacuum pump runs hot	Vacuum pump oil supply interrupted		User or Service workshop
	Oil with too low a viscosity used	Oil change	
	Ambient temperature round vacuum pump too high	User	Change location
	Motor defective	User or Service workshop	Exchange
Built-up pressure in the oil casing too high (> 0.5 bar)	Check exhaust pipe, change filter insert		
Heavy loss of oil	Through oil mist emission: work or pressure control valve defective	User or Service workshop	Exchange
	Because of leak from oil casing: shaft seal defective, oil casing seals defective		Repair and/or exchange
Vacuum pump is not vacuum-tight when switched off - possible rise in oil pressure	Intake valve defective	User or Service workshop	Repair and/or exchange
	Shaft seal ring on the drive side or oil pump defective		Repair and/or exchange
	Opened gas ballast valve	User	Close the gas ballast valve
Cable(s)	defective and/or brittle	Qualified electrician	Exchange of the cable(s)

## 8 Overview of Accessories

### 8.1 Overview and Order Numbers for EMEA, Asia

Type	Product name	Description	Order no.
Exhaust Filter	Oil Mist Separator AKD 16	DN 16 KF	320015-03
	Replacement element for AKD 16	DN 16 KF	800160
Trap	Dry Ice / Liquid Nitrogen Cold Trap, Stainless Steel	1/2" OD tube, 7/16" tubing needed	1420H-14
	Carrier with 2 Cooling Traps and Dewar Vessels, DN 16 KF	DN 16 KF	110518
	Cold Trap, welded DN 25 KF (Adapter 701401 needed)	DN 25 KF	705121
Inlet Condenser	Inlet Condenser AKS 16	DN 16 KF	320016
	Condenser SS, water cooling	SKS 40/16	700261
	PVC Cord-Reinforced, Flexible Vacuum Hose	DN 16, 16mm ID, 23mm length	710058

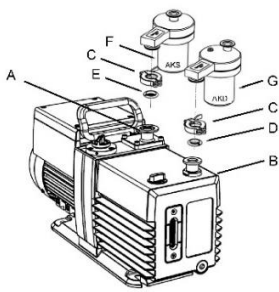
Tubing, Connector, Adapter	Chemical resistant metal hose	DN 16, 1,5m	710755
	Chemical resistant metal hose	DN 16, 1m	710764
	Hose Adapter kit	DN 16	330060
	Male Hose Adapter Al	DN 16 KF / 16mm I.D. for PVC Hose	710052
	Inlet Fitting Stainless Steel	DN 16 KF – DN 12	701702-01
	Inlet Fitting Stainless Steel	DN 16 KF – DN 20	701712-02
	Inlet Fitting Stainless Steel	DN 16 KF – DN 8	710739
	Inlet Fitting Stainless Steel	DN 16 KF – DN 10	710741
	Retrofit-Kit (Adapter) to use KF 25 for intake and exhaust	DN25/16	701401
	KF Tees, Stainless Steel	DN 16	701501
Vacuum Measurement Packages	Vacuum Measurement Kit	DN 16 KF	330051
Application and Vacuum Control Kits	Freeze Dryer Adapter Kit	DN 16 KF	330031
	Fastening Kit	For CRVpro8 CHEM	S3090-99
	Seal Kit	For CRVpro8 CHEM	S3080-99
	Lip Seal Kit	For CRVpro8 CHEM	S3091-99
	Service Kit CRVpro 8	For CRVpro8 CHEM	S3079-99
	Side Panel Fitting Kit	For CRVpro8 CHEM	S3256-99
	KF25 Inlet Port Kit	For CRVpro8 CHEM	S3271-99
<b>Type</b>	<b>Product name</b>	<b>Description</b>	<b>Order no.</b>
Oil	Welch Gold vacuum oil	1 liter	8995G-11
	Welch Gold vacuum oil	1 gallon	8995G-15
	Welch Gold vacuum oil	5 gallon	8995G-20

## 8.2 Overview and Order Numbers for Americas

Type	Product name	Description	Order no.
Exhaust Filter	Exhaust Filter	DN 16 KF	1417E
	Replacement element for 1417E	DN 16 KF	1417R
Trap	Dry Ice / Liquid Nitrogen Cold Trap, Stainless Steel	1/2" OD tube, 7/16" tubing needed	1420H-14
	Cold Trap, welded DN 25 KF (Adapter 701401 needed)	DN 25 KF	705121
Tubing, Connector, Adapter	Clamp	DN 16	302201
	Centering Ring	DN 16	303101
	Hose Clamps for Thick Wall Vacuum Rubber Hose Pk/10	5/8" ID x 1-3/8" OD, 5 FT Length	331050-5
	Hose Clamps for Thick Wall Vacuum Rubber Hose Pk/10	5/8" ID x 1-3/8" OD, 10 FT Length	331050-10
	Hose Clamps for Thick Wall Vacuum Rubber Hose Pk/10	Use with rubber hose 331050-5 or 331050-10	305350
	Retrofit-Kit (Adapter) to use KF 25 for intake and exhaust	DN25/16	701401
Inlet Condenser	Inlet Condenser AKS 16	DN 16 KF	320016
	Condenser SS, water cooling	SKS 40/16	700261
Gauges	Hand Held Vacuum Gauge – Battery Operated	Millitorr Range 10 <sup>-3</sup> to 1 torr	1526K-10

Type	Product name	Description	Order no.
	Spare sensor for Hand Held Vacuum Gauge		1526A
	Fastening Kit	For CRVpro8 CHEM	S3090-99
	Seal Kit	For CRVpro8 CHEM	S3080-99
	Lip Seal Kit	For CRVpro8 CHEM	S3091-99
	Service Kit CRVpro 8	For CRVpro8 CHEM	S3079-99
	Side Panel Fitting Kit	For CRVpro8 CHEM	S3256-99
	KF25 Inlet Port Kit	For CRVpro8 CHEM	S3271-99
Oil	Welch Gold vacuum oil	1 liter	8995G-11
	Welch Gold vacuum oil	1 gallon	8995G-15
	Welch Gold vacuum oil	5 gallon	8995G-20

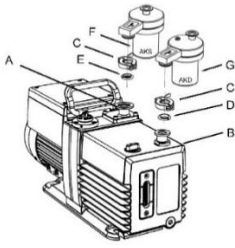
### 8.3 Inlet Condensor AKS 16

Technical Data	Order no.	320016
	Connecting flange	DN 16 KF
	Separator – basic body	Aluminium
	Collector or condensate vessel	Borosilicate glass
	Seals	FKM
	Max. filling volume	380 ml
	Order no. Beaker glass AKS	828835
	Order no. AKS	320016
Area of Application	The suction-side separator AKS prevents condensates from the vacuum systems penetrating into the rotary vane pump. The horizontal arrangement of the separator alongside the pump prevents fluids running back from the collector or condensate vessel into the pump.	
Maintenance	Maintenance of the suction-side separator AKS is limited to simply emptying the collecting vessel.	
Assembly - AKS at rotary vane pump:		<p>The suction-side separator (<b>F</b>) is flanged using a normal clamping ring ©, a centering ring with wire fabric and an O-ring (<b>E</b>) are directly flange-mounted onto the suction port (<b>A</b>) of the rotary vane pump.</p> <p>(connecting elements in DN 16 KF – see data for ordering – below)</p>

Order data for compound elements DN16KF:


for separator:	Designation	Piece	Order no.
AKS 16, AKD 16 (DN 16 KF)	KF Normal clamping ring Aluminium DN 10/16	1	701011
	KF Centering ring Aluminium with FKM-O-ring DN 16	1	701091
	KF Centering ring with fine filter Stainless steel with FKM-O-ring DN 16	1	701191

## 8.4 Oil Mist Separator AKD 16

Technical Data	Order no.	320015
	Connecting flange	DN 16 KF
	Separator – basic body	Aluminium
	Collector vessel	Borosilicate glass
	Seals	FKM
	Max. filling volume	270 ml
	Filter cartridge	Optical fiber
	Order no. Spare-filter cartridge	800160
	Order no. Beaker glass AKD	828835
	Order no. AKD	320015
Area of Application	The pressure-side separator AKD effectively reduces the oil mist emission from the rotary vane pump's pressure port at high intake pressures. The horizontal arrangement of the separator alongside the pump prevents fluids running back from the collector or condensate vessel into the pump.	
Maintenance	Maintenance of the pressure-side separator AKD is limited to simply emptying the collecting vessel and changing the saturated filter cartridge.	
Assembly - AKD at rotary vane pump:		<p>The pressure-side separator <b>(G)</b> is flanged directly to the pressure port <b>(B)</b> of the rotary vane pump, using a normal clamping ring <b>(C)</b> and a centering ring with an O-ring <b>(D)</b>.</p> <p>Connecting elements in DN 16 KF – see chapter 8.3 Inlet Condensor AKS 16.</p>

## 9 Review of Spare Parts

The overview of spare parts contain all service kits, single spare parts with all the information necessary for ordering. When ordering please quote the order number, description and quantity!

	<b>CAUTION !</b>
<b>We are not liable for any damage caused by the installation of any parts not supplied by the manufacturer.</b>	

### 9.1 Oil Filter Kit

The oil filtration system uses an activated alumina element to neutralizes acids. The element will also filter out particulates and minimizes the formation of gels in the oil.

- For the rotary vane pump CRVpro8 CHEM : Order no. 1420E-03
  - Two elements per kit

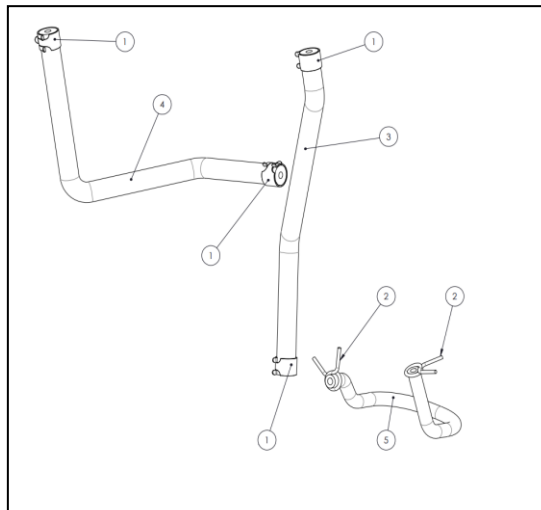
Qty	Description
2	Activated alumina element
2	O-ring gasket, FKM

### 9.2 Oil Filtration System Tubing and Clamps Kit

The tubing and clamps kit contains all the parts needed to replace tubing.

- For the rotary vane pump CRVpro8 CHEM : Order no. S4001-99

Item	Qty	Description
1	4	Clamp, tubing 3/8 in. OD
2	2	Clamp, Tubing 1/4 OD
3	1	Tubing, 6 in.
4	1	Tubing, 9 in.
5	1	Tubing, 6 in.



### 9.3 Filter Wrench

The filter wrench is used to remove sump from canistor top

- For the rotary vane pump CRVpro8 CHEM : Order no. 61-6412

### 9.4 Fastening Kit

The fastening kit contains all the fasten parts which could be replaced during a preventive maintenance or repair.

- For the rotary vane pump CRVpro8 CHEM: Order no. S3090-99

Item no.	Description	Qty	CRVpro 8 CHEM
	Consisting of :		Order no.
2	Screw	4	S3081-99
3, 100	Elastic Washer	8	S3082-99
5	Screw	2	S3083-99
7	Screw	1	S3085-99
10	Screw	4	S3086-99
15	Elastic Washer	4	S3087-99
16	Screw	4	S3088-99
23	Screw	3	S3089-99
25	Elastic Washer	1	S3092-99
26	Screw	1	S3093-99
35	Screw	4	S3094-99
41, 47	Screw	4	S3100-99
42, 48	Elastic Washer	4	S3101-99
43	Washer	1	S3102-99
64	Screw	2	S3107-99
65, 69,	Elastic Washer	5	S3108-99
68, 78	Screw	3	S3110-99
83	Screw	4	S3052-99
84	Elastic Washer	4	S3114-99
85	Flat Washer	4	S3115-99
96	Screw	2	S3117-99
99	Screw	4	S3118-99
101	Flat Washer	4	S3120-99

## 9.5 Seal Kit

The seal kit contains all the seals which must be exchanged during a preventive maintenance or repair.

- For the Rotary vane pumps CRVpro8 CHEM Order no. S3080-99

Item no.	Description	CRVpro 8 CHEM: S3080-99	
	Consisting of :	Qty.	Order no.
18	O-ring	1	S3010-99
29, 91	O-ring	2	S3018-99
30	Oil Seal	1	S3019-99
33	O-ring	1	S3022-99
37	O-ring	2	S3096-99
50	Oil Seal	1	S3027-99
51	O-ring	1	S3028-99
53	O-ring	1	S3030-99
57	Gasket	1	S3034-99
59	Oil Seal	1	S3036-99
89	Washer	1	S3055-99
93	O-ring	1	S3059-99
98	O-ring	1	S3063-99

## 9.6 Lip Seal Kit

Additionally the lip seal kit is available during a preventive maintenance or repair.

- For the Rotary vane pumps CRVpro8 CHEM Order no. S3091-99

Item no.	Description	CRVpro8 CHEM: S3091-99	
	Consisting of:	Qty.	Order no.
47	Screw	3	S3100-99
48	Elastic Washer	3	S3101-99
49	Pump Cover	1	S3026-99
50	Oil Seal	1	S3027-99
51	O-Ring	1	S3028-99
52	Washer	1	S3029-99
53	O-Ring	1	S3030-99

## 9.7 Oil Drain Valve Kit

The oil drain valve kit makes the maintenance of draining the oil easier. Details about draining the oil see 6.3.1.

- For the Rotary vane pumps CRVpro 4, 6, 8 Order no. S3222-99

Item no.	Description	CRVpro8 CHEM: S3222-99	
	Consisting of:	Qty.	Order no.
-	Oil Drain Valve BSP 3/8"	1	S3220-99
-	M16 to BSP 3/8" Adapter	1	S3221-99
-	Oil Drain Valve with Hose Barb DN8	1	S3379-99

## 9.8 Service Kit

The service kit contains, in addition to the seals, all the spare parts which are subject to high wear and tear and therefore have to be replaced.

- For the rotary vane pump CRVpro 8 / CHEM: Order no. S3079-99

Item no.	Description	Qty	CRVpro 8 / Chem
	Consisting of :		Order no.
18	O-Ring	1	S3010-99
27	Anti-Suck Back Spring	1	S3016-99
29, 91	O-Ring	2	S3018-99
30	Oil Seal	1	S3019-99
32	Anti-Suck Back Plate	1	S3021-99
33	O-Ring	1	S3022-99
37	O-Ring	2	S3096-99
44	Coupling Element	1	S3024-99
50	Oil Seal	1	S3027-99
51	O-Ring	1	S3028-99
53	O-Ring	1	S3030-99
57	Gasket	1	S3034-99
59	Oil Seal	1	S3036-99
61	Fore Vane	2	S3070-99
63, 76	Vane Spring	4	S3039-99
71	Exhaust Valve Plate	1	S3042-99
73	Spring	1	S3044-99
74	Gas Ballast Valve Head	1	S3045-99
77	Rear Vane	2	S3048-99
89	Washer	1	S3055-99
93	O-Ring	1	S3059-99
94	Glass	1	S3060-99
98	O-Ring	1	S3063-99
105	SS Screw	1	S3260-99
106	Flat Washer	1	S3261-99
107	Exhaust Diaphragm	1	S3262-99
108	Holder	1	S3263-99
109	Nut	1	S3264-99

## 9.9 Side Panel Fitting Kit

The side panel fitting kit contains all the parts could be replaced during a preventive maintenance or repair.

- For the rotary vane pumps CRVpro8 CHEM Order no. S3256-99

Item no.	Description	CRVpro8 CHEM: S3256-99	
	Consisting of :	Qty.	Order no.
102	Side Panel Fitting	1	S3257-99
103	Side Panel Orifice	1	S3258-99
104	Side Panel Fitting Gasket	2	S3259-99

## 9.10 KF25 Inlet Port Kit

The KF25 Inlet Port Kit is for the inlet interface requirement of KF25 which includes all the parts for replacing the original KF16 inlet.

- For the Rotary vane pumps CRVpro 4, 6, 8 Order no. S3271-99

Item no.	Description	CRVpro 4, 6, 8: S3271-99	
	Consisting of :	Qty.	Order no.
33	O-ring	1	S3022-99
34	Inlet Port (KF25)	1	S3266-99
35	Screw	4	S3094-99

## 9.11 List of Spare Parts for Pump less Oil Filtration System

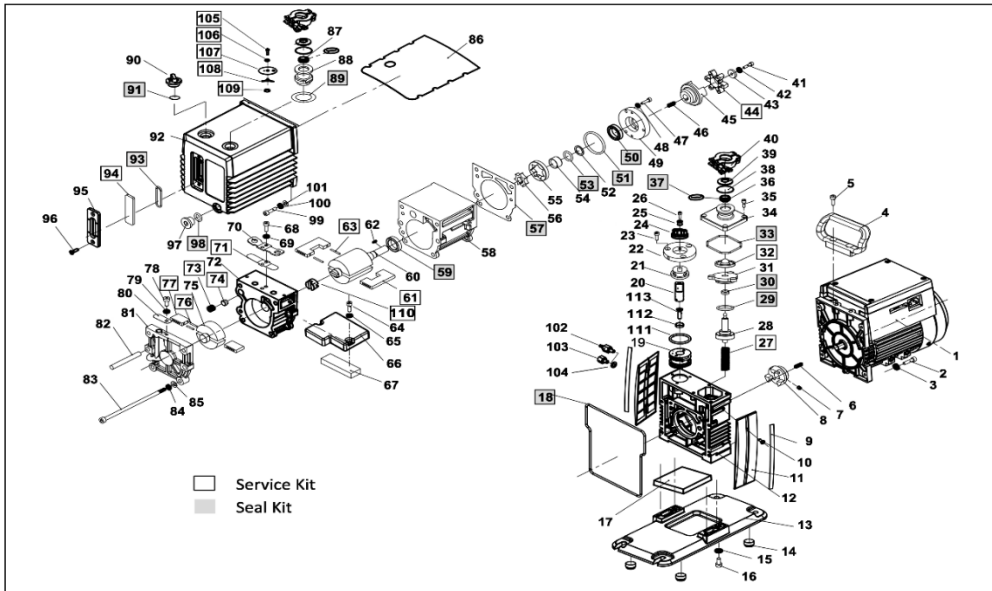


Fig. 12 Exploded view CRVpro 8 CHEM

Item no.	Description	Qty	CRVpro8 CHEM
			Order no.
1	Motor	1	S3001-99
4	Handle	1	S3002-99
6, 46	Flat Key	2	S3084-99
8	Coupling	1	S3003-99
9	Red Strip	2	S3004-99
11	Side Overlay	2	S3005-99
12	Trestle	1	S3006-99
13	Base	1	S3007-99
14	Foot Pad	4	S3008-99
17	Felt	1	S3009-99
18	O-Ring	1	S3010-99
19	Gas Ballast Valve Bush	1	S3300-99
20	Gas Ballast Valve Rod	1	S3302-99
111	O-Ring	2	S3172-99
112	Washer	1	S3301-99
113/96	Screw	3	S3117-99
21	Gas Ballast Location Bush	1	S3013-99
22	Gas Ballast Valve Ring	1	S3014-99
24	Gas Ballast Knob	1	S3015-99
27	Anti-Suck Back Spring	1	S3016-99
28	Anti-Suck Back Piston	1	S3017-99
29, 91	O-Ring	2	S3018-99
30	Oil Seal	1	S3019-99
31	Anti-Suck Back Cover	1	S3020-99
32	Anti-Suck Back Plate	1	S3021-99
33	O-Ring	1	S3022-99
34	Inlet Port	1	S3023-99
35	Screw	4	S3094-99

## 10 Warranty

This Welch product is warranted to be free from defects in material and workmanship. The liability of Gardner Denver Thomas, Inc. under this warranty is limited to servicing, adjusting, repairing or replacing any unit or component part which in the judgment of Gardner Denver Thomas, Inc. has not been misused, abused or altered in any way causing impaired performance or rendering it inoperative. No other warranties are expressed or implied. The method of executing this warranty: servicing, adjusting, repairing or replacing shall be at the discretion of Gardner Denver Thomas, Inc. Vacuum pumps that have been used for any period, however short, will be repaired under this warranty rather than replaced. The warranty is effective for one year from the date of original purchase when:

- The warranty card has been completed and returned.
- The product is returned to the factory or other designated service centers, freight prepaid.
- The product in our judgment is defective through no action or fault of the user.

If the product has become defective through misuse, abuse, or alteration, repairs will be billed regardless of the age of the product. In this event, an estimate of the repair costs will be submitted and authorization of these charges will be required before the product is repaired and returned. To reduce additional charges and delays either within or outside of the warranty period, contact Welch for a return authorization number. Products without a return authorization number will be refused by our receiving department. Before shipping, properly pack the pump, insure it against loss or damage, and on the outside of the pump packaging and the packing slip write in the return authorization number. Pumps damaged due to improper packaging are the customer's responsibility.

# 11 EC Declaration



Gardner Denver Thomas  
Pneumatic System Co., Ltd.  
No. 1 Dong An Road  
Shuo Fang Town  
Wuxi New District, Jiangsu  
PC 214142 China



**Appliance description:** Rotary Vane pump  
**Document-No.:** CRVpro-88-02  
**Series:** CRVpro 4, CRVpro 6, CRVpro 8

### EC-declaration of conformity according to Machinery Directive

We hereby declare, that the appliance described above, based on it's concept and design as well as the models distributed by us meets the basic safety and health standards of the directive 2006/42/EC.

Applied harmonized standards:

EN 60204-1: 2018                      EN 1012-2:1996+A1:2009                      EN ISO 12100: 2010

### Statement about EMC Directive

We hereby declare, that the appliance described above, when connected to a power supply in conformity with the standards, meets the directive 2014/30/EU.

Applied harmonized standards:

EN61000-6-3:2007 +A1:2011                      EN61000-6-1:2007                      EN61000-3-2:2014  
EN61000-3-3:2013

### EC-declaration of conformity according to Directive RoHS

We hereby declare, that the appliance described above is in conformity with directive 2011/65/EU, amended with Delegated Directive (EU) 2015/863

Applied harmonized standards:

EN 63000:2018

### Notice:

All modifications to this product results in cancellation of this declaration.

### Person, who is empowered to draw up this declaration on behalf of the manufacturer:

Name: Liz Cui  
Title: Manager Engineering  
CE-authorized representative

Wuxi 2/14/2023  
Place/Date/Signature

---

Authorized representative established in the European Community  
and person, who is authorized to compile the technical file:  
Gardner Denver Thomas GmbH  
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