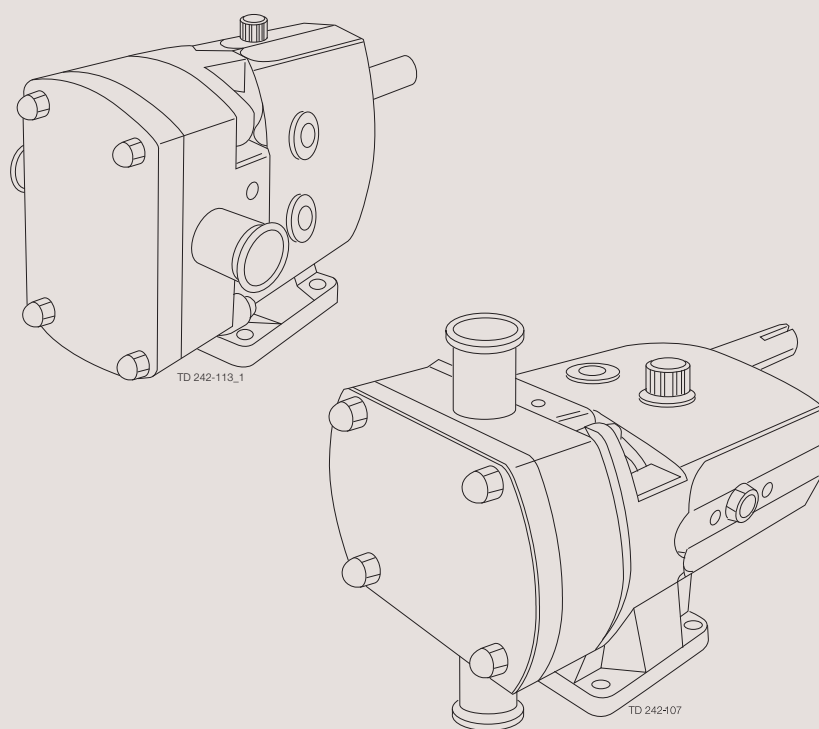




# Instruction Manual

## Rotary Lobe Pumps - SX Range



ESE00915-EN8

2017-09

Original manual



The information herein is correct at the time of issue but may be subject to change without prior notice

<b>1. EC Declaration of Conformity</b>	<b>4</b>
<b>2. General information</b>	<b>5</b>
2.1. General information	5
<b>3. Safety</b>	<b>6</b>
3.1. Important information	6
3.2. Warning signs	6
3.3. Safety precautions	7
3.4. Recycling information	8
<b>4. Installation</b>	<b>9</b>
4.1. Unpacking, Handling and Storage	9
4.2. System design and installation	10
4.3. Flushing seal arrangement and pre-start up checks	14
<b>5. Maintenance</b>	<b>15</b>
5.1. Cleaning in place (CIP)	15
5.2. Maintenance schedule	16
5.3. Dismantling	17
5.4. Assembly	20
5.5. Primary seals removal and fitting	26
5.6. Troubleshooting	29
<b>6. Technical data</b>	<b>30</b>
6.1. Technical data	30
6.2. Pumphead Clearance information	33
<b>7. Parts list</b>	<b>34</b>
7.1. SX1-3 Pump Range	34
7.2. SX4 Pump Range	36
7.3. SX5 Pump Range	38
7.4. SX6-7 Pump Range	40

# 1 EC Declaration of Conformity

Revision of Declaration of Conformity 2009-12-29

The Designated Company

Alfa Laval Eastbourne, Alfa Laval Ltd  
Company Name

Birch Road, Eastbourne, East Sussex BN23 6PQ  
Address

+44 (0) 1323 412555  
Phone No.

hereby declare that

Pump  
Designation

SX1, SX2, SX3, SX4, SX5, SX6, SX7  
Type

From serial number 10.000 to 1.000.000

is in conformity with the following directive with amendments:  
- Machinery Directive 2006/42/EC


The person authorised to compile the technical file is the signer of this document

Global Product Quality Manager  
Pump, Valves, Fittings and Tank Equipment  
Title

Lars Kruse Andersen  
Name

Kolding  
Place

2013-12-03  
Date

  
Signature

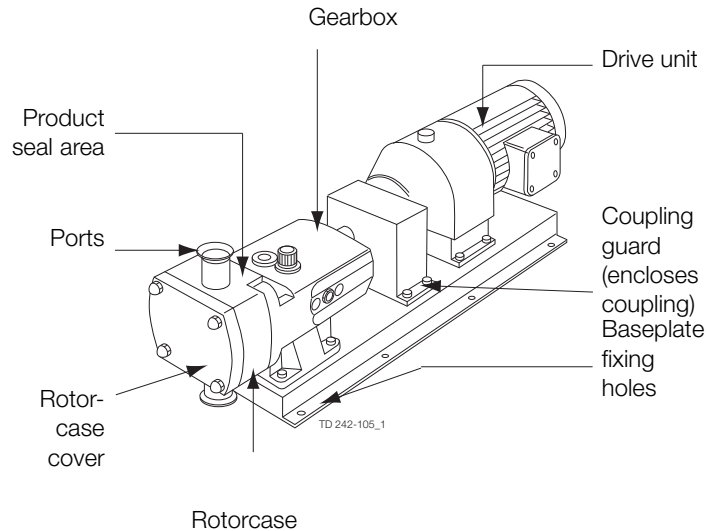


### 2.1 General information

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The SX pump is a positive displacement rotary lobe pump; it may be supplied with or without a drive unit (see drawing). The drawing shown indicates various parts of the pump unit.

The SX range has a universal gearbox design which enables the flexibility of mounting pumps with the inlet and outlet ports in either a vertical or horizontal plane. The port orientation, vertical or horizontal, may be changed by moving one of two available bolt-on feet on the gearbox. Port orientation should be specified when ordering, but the alternative foot design allows pumps that are already installed being changed should the need arise.



#### Pump Duty Conditions

The pump should only be used for the duty for which it has been specified. The operating pressure, speed and temperature limits have been selected at the time of order and **MUST NOT** be exceeded. These details are stated on the original order documentation and if not available may be obtained from your supplier quoting pump model and serial number.

#### Noise Levels

Under certain operating conditions pumps and/or drives and/or the systems within which they are installed can produce sound pressure levels in excess of 80dB[A]. When necessary, protection against noise should be taken.

#### External Cleaning

Use cleaning fluids below PH 8. Cleaning fluids above PH 8 may cause some paint discolouration.

## 3 Safety

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*Unsafe practices and other important information are emphasized in this manual.  
Warnings are emphasized by means of special signs.  
**Always read the manual before using the pump!***

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### 3.1 Important information

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#### **WARNING**

Indicates that special procedures must be followed to avoid serious personal injury.

#### **CAUTION**

Indicates that special procedures must be followed to avoid damage to the pump.

#### **NOTE**

Indicates important information to simplify or clarify procedures.

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### 3.2 Warning signs

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General warning:



Dangerous electrical voltage:



Caustic agents:



*All warnings in the manual are summarized on this page.*

*Pay special attention to the instructions below so that severe personal injury and/or damage to the pump are avoided.*

### 3.3 Safety precautions

#### Installation:

**Always** read the technical data thoroughly. (See chapter 6 Technical data)

**Never** start in the wrong direction of rotation with liquid in the pump.

**Never** put your hands or fingers inside the port connections or anywhere close to rotating shafts.



**Always** have the pump electrically connected by authorized personnel. (See the motor instruction)



#### Operation:

**Always** read the technical data thoroughly. (See chapter 6 Technical data)

**Never** touch the pump or the pipelines when pumping hot liquids or when sterilising.

**Never** stand on the pump or pipelines.

**Never** run the pump with either the suction side or the pressure side blocked.

**Never** put your hands or fingers inside the port connections or anywhere close to rotating parts.

**Never** run the pump unless fully assembled and all guards are securely fitted, i.e. pump head must not be removed from gearcase.



Only handle toxic and acidic liquids in accordance with the manufacturers instructions and recommendations.



#### Maintenance:

**Always** read the technical data thoroughly. (See chapter 6 Technical data)

**Never** service the pump when it is hot.

The pump and the pipelines must **never** be pressurised when the pump is serviced.

**Never** put your hands or fingers inside the port connections or anywhere close to rotating parts.

Installation and operation of the pump must always comply with health and safety regulations. Any hazardous and/or hot, drained or leaked, liquid shall be disposed in compliance with health and safety regulations. If requested at the time of order, the equipment can be supplied with means of safe removal of any hazardous and/or hot, drained or leaked liquid.



**Always** disconnect the power supply when servicing the pump.



#### Transportation:

##### Transportation of the pump or the pump unit:

**Never** lift or elevate in any way other than described in this manual

**Always** drain the pump head and accessories of any liquid

**Always** ensure that no leakage of lubricants can occur

**Always** transport the pump in it's upright position

**Always** ensure that the unit is securely fixed during transportation

**Always** use original packaging or similar during transportation

## 3 Safety

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### 3.4 Recycling information

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#### Recycling information.

- **Unpacking**

- Packing material consists of wood, plastics, cardboard boxes and in some cases metal straps.
- Wood and cardboard boxes can be reused, recycled or used for energy recovery.
- Plastics should be recycled or burnt at a licensed waste incineration plant.
- Metal straps should be sent for material recycling.

- **Maintenance**

- During maintenance oil and wear parts in the machine are replaced.
- All metal parts should be sent for material recycling.
- Worn out or defective electronic parts should be sent to a licensed handler for material recycling.
- Oil and all non metal wear parts must be taken care of in agreement with local regulations.

- **Scrapping**

- At end of use, the equipment shall be recycled according to relevant, local regulations. Beside the equipment itself, any hazardous residues from the process liquid must be considered and dealt with in a proper manner. When in doubt, or in the absence of local regulations, please contact the local Alfa Laval sales company.
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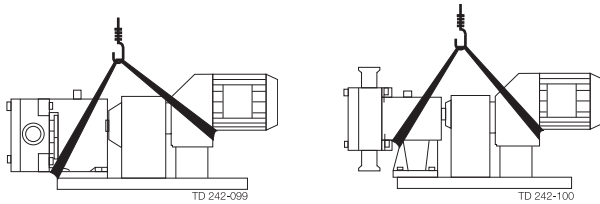
### 4.1 Unpacking, Handling and Storage

#### Step 1

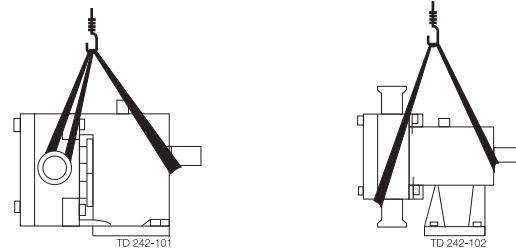
Refer to the pump weights guide (chapter 6 Technical data) before selecting and using any lifting gear. The drawing show how the pump should be lifted.

Ensure that lifting equipment is correctly rated and used within these limits.

Pump with drive unit



Bareshaft pump



#### Step 2

##### On receipt always:

- Check the delivery note against the goods received.
- If motorised, check that the drive instructions are available.
- Inspect the packing for signs of damage in transit.
- Carefully remove the packing away from the pump.
- Inspect the pump for any visible signs of damage.
- Clean away the packing from the pump port connections.
- Be careful not to discard any manuals that may be enclosed with the packaging.
- Report any damage to the carrier.

#### Step 3

After receipt and inspection, if the pump is not to be installed immediately, the pump should be repacked and placed in suitable storage. The following points should be noted:

- Plastic or gasket type port covers should be left in place.
- Pumps received wrapped with corrosion inhibiting treatment material should have wrapping replaced.
- A clean, dry storage location free from vibration should be selected. If a moist or dusty atmosphere is used for storage, further protect the pump or unit with a suitable cover.
- Rotate the pump/pump unit by hand weekly, to prevent bearing damage.
- All associated ancillary equipment should be treated similarly.

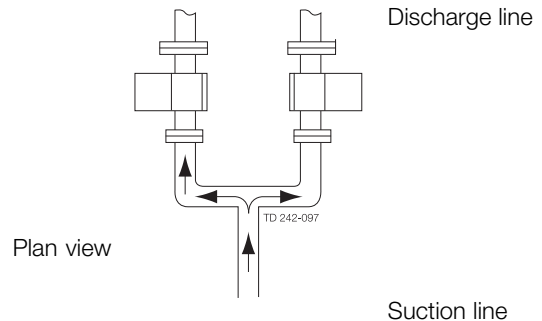
## 4 Installation

To ensure optimum operation it is important that any pump unit is installed correctly. When designing a pumping system the following should be taken into consideration.

### 4.2 System design and installation

#### Design:

- Confirm the Net Positive Suction Head (NPSH) available from the system exceeds the NPSH required by the pump, as this is crucial for ensuring the smooth operation of the pump and preventing cavitation.
- Avoid suction lifts and manifold/common suction lines for two pumps running in parallel, as this may cause vibration or cavitation.
- Protect the pump against blockage from hard solid objects e.g. nuts, bolts welding slag etc. Also protect the pump from accidental operation against a closed valve by using relief valves, pressure switches or current limiting devices.
- Fit suction and discharge monitor points for diagnostic purposes.
- Fit valves, if two pumps are to be used on manifold/common discharge lines.
- Make the necessary piping arrangements if flushing is required for the seal or if a media is required for heating/ cooling jackets and saddles.
- Allow at least 1 m for pump access/maintenance all around the pump.
- Do not subject rotary lobe pumps to rapid temperature changes, as pump seizure can result from thermal shock.



#### Pipework:

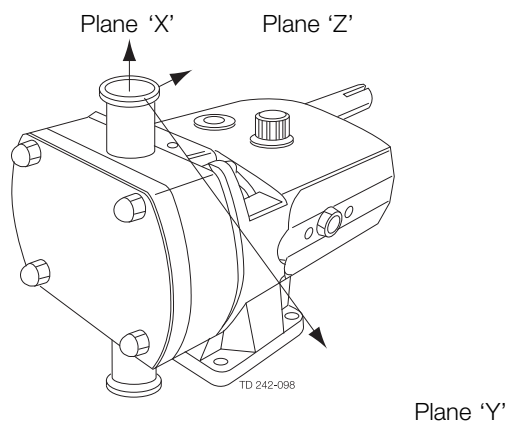
All pipework must be supported. The pump must not be allowed to support any of the pipework weight beyond the limits set in the following table.

#### Remember:

Pipework supports must also support the weight of the product being pumped.

#### Always:

- Design short straight suction lines to reduce friction losses in the pipework thereby improving the NPSH available from the system.
- Avoid bends, tees and any restrictions close to either suction or discharge side of pump. Use long radius bends wherever possible.
- Provide isolating valves on each side of the pump to isolate the pump when necessary.
- Keep pipework horizontal where applicable to reduce air locks. Include eccentric reducers on suction lines.



## 4 Installation

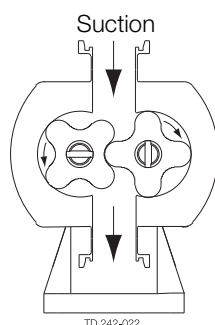
To ensure optimum operation it is important that any pump unit is installed correctly. When designing a pumping system the following should be taken into consideration.

Table of Maximum Forces and Moments

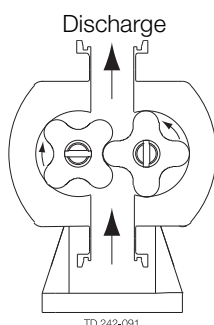
Pump Model			Forces				Moments			
			FZ	FY	FX	EF	MZ	MY	MX	EM
SX1	Forces	N	80	60	70	120				
		lbf	18	13	16	27				
	Moments	N					30	30	30	50
		lbf					22	22	22	37
SX2	Forces	N	125	100	110	190				
		lbf	28	22	25	43				
	Moments	N					60	70	75	115
		lbf					44	52	55	85
SX3/4	Forces	N	165	135	150	260				
		lbf	37	30	34	58				
	Moments	N					100	115	140	205
		lbf					74	85	103	151
SX5/6	Forces	N	300	250	250	460				
		lbf	67	56	56	103				
	Moments	N					125	145	175	260
		lbf					92	107	129	192
SX7	Forces	N	380	320	320	590				
		lbf	85	72	72	133				
	Moments	N					165	190	230	340
		lbf					122	140	170	251

### Direction of rotation

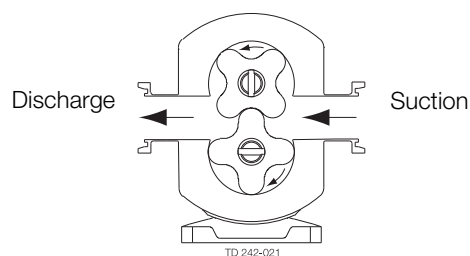
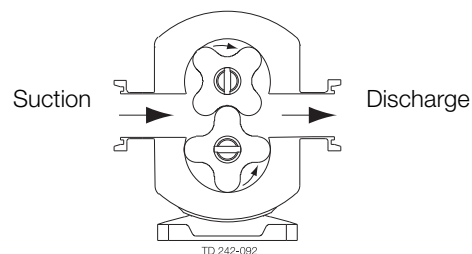
The direction of flow is dictated by the direction of rotation of the drive shaft. Reversing the direction of rotation will reverse the flow direction.



Discharge



Suction



## 4 Installation

To ensure optimum operation it is important that any pump unit is installed correctly. When designing a pumping system the following should be taken into consideration.

### Pump Lubrication:

The pump will not be supplied pre-filled with oil therefore this table must be used to select recommended oil.

Oil changing: Oil level must be checked with the pump static.

First change: After 150 hours of operation, thereafter every 3000 hours of operation.

Oil filling: Fill with oil through the filler plug to the level indicated in the sight glass.

### NOTE!

On horizontally ported pumps the sight glass must be fitted to the upper hole on the side of the gearcase.

Refer to chapter 6 Technical data for oil approximate quantities required.

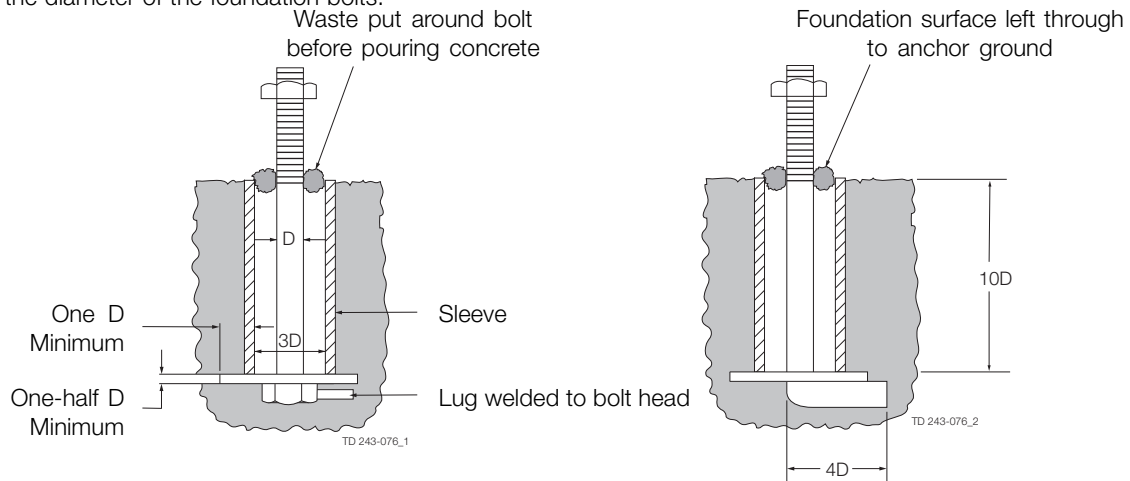
Recommended Oils		
Pump Operating Temperature -20°C to +130°C (-4°F to +266°F)	Pump Operating Temperature +130°C to 150°C (+266°F to 302°F)	Food grade oils (USDA H1) -20°C to +130°C (-4°F to +266°F)
BP Energol GR - XP150	BP Energol SG-XP150	Bel-Ray No-Tox HD Food Grade Oil 150 #62686
Castrol Alpha SP150	Castrol Alphasyn PG150	Mobil SHC Cibus 150
Mobil Mobilgear 600 XP150	Mobil Glygoyle 30	Castrol Optileb GT150
Shell Omala S2 G150	Shell Omala S4 WE150	
Texaco Meropa 150	Texaco Synlube CLP220	
Esso Spartan EP150	Mobil Glygoyle 22	

For ATEX applications refer to ATEX addendum manual.

### Baseplate Foundations

Pumps when supplied with a drive unit are normally mounted on a baseplate. Our standard baseplates have pre-drilled fixing holes to accept base retaining bolts. To provide a permanent rigid support for securing the pump unit, a foundation is required which will also absorb vibration, strain or shock on the pumping unit. Methods of anchoring the baseplate to the foundation are varied, they can be studs embedded in the concrete either at the pouring stage as shown below, or by use of epoxy type grouts. Alternatively mechanical fixings can be used.

The foundation should be approx. 150 mm longer and wider than the baseplate. The depth of the foundation should be proportional to the size of the complete pump unit. For example, a large pump unit foundation depth should be at least 20 times the diameter of the foundation bolts.



The drawing above shows two typical methods for foundation bolt retaining. The sleeve allows for "slight" lateral movement of the bolts after the foundation is poured. Rag or waste paper can be used to prevent the concrete from entering the sleeve while the foundation is poured. A minimum of 14 days is normally required to allow the curing of the concrete prior to pump unit installation.

## 4 Installation

To ensure optimum operation it is important that any pump unit is installed correctly. When designing a pumping system the following should be taken into consideration.

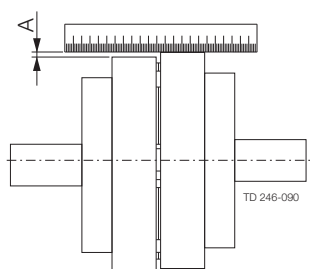
### Coupling alignment:

Before the pump unit is installed it is important to ensure that the mounting surface is flat to avoid distortion of the baseplate, which may cause pump/motor shaft misalignment and pump/motor unit damage. Once the baseplate has been secured, the pump shaft to motor shaft coupling alignment should be checked and adjusted as necessary. This is achieved by checking the maximum angular and parallel misalignment for the couplings as stated below. Shaft alignment that is outside the stated tolerances can be corrected by applying shims under the motor or pump foot, or, by moving the pump or drive sideways on the baseplate. All bolts that have been loosened should be re-tightened to the stated torque figure.

The following dimensions and tolerances apply to standard supply couplings only.

### Parallel misalignment

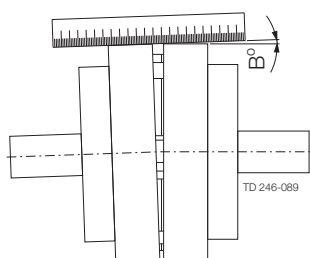
Measure 4 positions at 90° around coupling



Coupling size	Dimension A Maximum
70	0.3 mm
90	0.3 mm
110	0.3 mm
130	0.4 mm
150	0.4 mm
180	0.4 mm
230	0.5 mm
280	0.5 mm

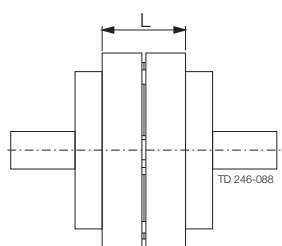
### Angular misalignment

Measure 4 positions at 90° around coupling



Coupling size	Dimension B Maximum
70	1°
90	1°
110	1°
130	1°
150	1°
180	1°
230	1°
280	1°

### Assembled length



Coupling size	Dimension L $\pm 1.0\text{mm}$
70	25
90	30.5
110	45
130	53
150	60
180	73
230	85.5
280	105.5

### Recommended bolt torques.

Thread Diameter	M6	M8	M10	M12	M16	M20	M24
Torque (Nm)	6	15	30	50	120	250	200

## 4 Installation

*This page is not applicable for ATEX applications.  
For ATEX application see ATEX addendum*

### 4.3 Flushing seal arrangement and pre-start up checks

#### Step 1

A flushed seal arrangement is fitted in order to cool or clean the seal area.

It is important that:

- The flush is correctly connected (see below).
- A compatible flushing fluid is used and supplied at the correct pressure and flow rate (see Step 5).
- The flush is turned on at the same time/prior to starting the pump, and turned off at the same time/after stopping the pump.

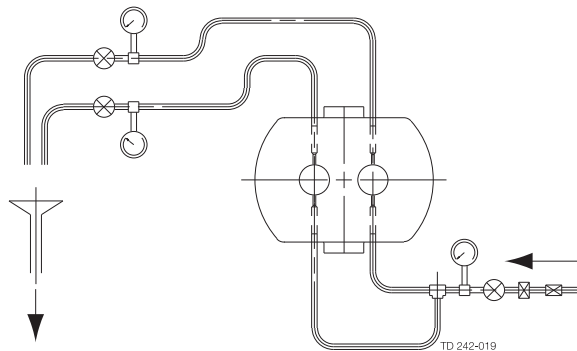
#### Step 2

The following equipment is strongly recommended when using a flushing system:

- Control valve and pressure gauge, to enable the correct flushing pressure to be obtained and monitored.
- Isolation valve and check valve, so that the flush can be turned off, and to stop any unwanted substances flowing in the wrong direction.
- A method of visibly indicating flushing fluid flow.

#### Step 3

Flushing arrangements in principle



#### Step 4

##### Flushing fluid

The choice of flushing fluid is dependent upon the fluid being pumped and duty conditions i.e. pressure and temperature. Usually water is used for cooling or flushing water soluble products. For both single and flushed mechanical seal arrangements the temperature of flush media should never be allowed to exceed the maximum temperature of the pumped media. For advice on selecting a suitable flushing fluid please contact pump supplier.

#### Step 5

##### Flushing pressure and flow rate

Single flushed mechanical seal 0.5 bar (7 psi) maximum. Any further increase in pressure will result in lip seal failure. Double mechanical seal/flushed packed gland 1.0 bar (14 psi) higher pressure than the discharge of the pump. If the discharge pressure fluctuates set the pressure to suit maximum condition.

The flushing flow rate must be adequate to ensure that the temperature limitation of the seals is not exceeded. Contact your pump supplier for further information on the recommended flow.

**Minimum flow rate required per shaft seal is 30 l/hr**

#### Step 6

Pre-start up checks

- Check the pipework system has been purged to remove debris.
- Check all obstructions have been removed from pipework and pump.
- Check pump connections and pipework joints are tight.
- Check lubrication levels are correct.
- Check seal flushing is connected if applicable.
- Check all safety guards are in place.
- Check that inlet and outlet valves are open.

### 5.1 Cleaning in place (CIP)

---

The pump can be manually cleaned or cleaned in place (CIP). The following is an example of a typical CIP procedure. However specific advice for each application should be sought from the pump supplier.

#### Typical CIP procedure

1. Flush through the system with cold water or bore water (6°C) (43°F).
2. Run hot caustic soda (70-80°C) (158-176°F) at 2.5% dilution through the system for 20-30 minutes.
3. Final flush through with cold water again.

---

#### Warnings

- **Never** touch the pump or the pipelines as they will be extremely **hot!**
- **Do not** subject the pump to rapid temperature changes during CIP procedures, as pump seizure can result from thermal shock. A suitable by-pass is recommended.
- **Always** rinse well with clean water after using a cleaning agent.
- 
- **Always** use rubber gloves and protective goggles when handling caustic agents.
- **Always** store/discharge cleaning agents in accordance with current rules/directives.



## 5 Maintenance

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### 5.2 Maintenance schedule

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It is advisable to install pressure gauges on both sides of the pump so that any problems within the pump/pipework can be monitored.

#### Maintenance schedule

Your weekly schedule should include:

- Checking the oil level in the gearcase with the pump stationary
- Checking the seals for leakage.
- Checking the oil seals for leakage.
- Check pumping pressures.

In certain operational circumstances the pump will pose a thermal hazard and as such should not be touched during operation. After shutdown the pump unit should be allowed time to cool.

Oil should be changed every 3000 hours of operation or a period of 2 years, whichever is the soonest.

---

#### Recommended Spare Parts

The table shows recommended spare parts that should be retained within your maintenance schedule.

Part description	Quantity
Lip seal drive end	1
Compression joint rotorcase cover	1
Lip seal gland end	2
Cup seal, rotor retainers	2
Primary seals	2

---

#### Rotor retainer cup seal Replacement Interval

It is recommended that the rotor retainer cup seal is replaced every 12 months to maintain a bacteria tight seal.

#### Rotor retainer cup seal Inspection

Periodically inspect the rotor retainer cup seal for any discoloration, nicks, or cracks. If any of the defects above are noticed, the rotor retainer cup seal must be replaced. Inspection and replacement refer to the seal replacement procedure below.

#### Seal Replacement Procedure

1. Remove rotor case cover (see 5.3 Dismantling, Step 1).
2. Undo rotor retainer and ensure components are dry before servicing.
3. With a penlight, inspect rotor retainer blind tapped hole for contamination. If soiled, refer to cleaning procedure below.
4. Remove and discard rotor retainer cup seal.
5. Fit new rotor retainer cup seal.
6. Fit rotor retainer and use a torque wrench to tighten to correct torque value (see table 6.1.3 on page 30).
7. Fit the rotor case cover.

#### Cleaning Procedure for Soiled Rotor Nut Tapped Hole

1. Remove rotor retainer from the shaft.
2. Submerge and soak nut for 5 minutes in COP tank with 2% caustic wash.
3. Scrub the hole with internal thread vigorously by plunging a clean sanitary bristle pipe brush in and out of the hole for two minutes while submerged.
4. Soak rotor retainer in acid sanitizer for 5 minutes, and then scrub the hole again with the pipe brush for two minutes.
5. Rinse well with clean water and blow-dry blind tapped hole with clean air.
6. Swab test the inside of the tapped hole to determine cleanliness.
7. Should the swab test fail, repeat steps 2 thru 6 above until swab test is passed.

Should swab testing continue to fail, or time is of the essence, install a new rotor retainer.

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### 5.3 Dismantling

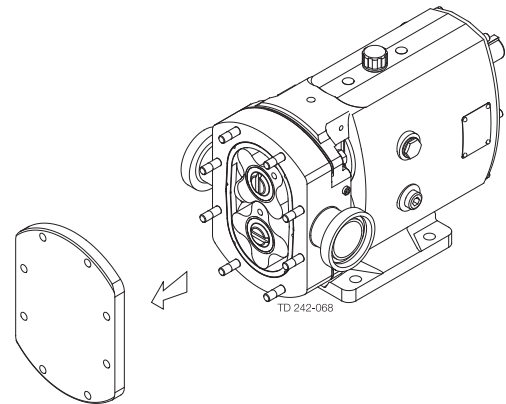
#### Step 1

Before disassembling the pump refer to safety precautions.

See exploded view drawings in chapter 7 Parts list.

#### Removing rotorcase cover.

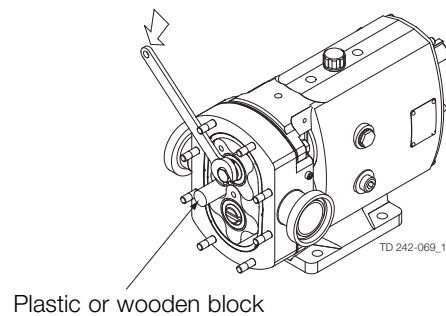
Remove rotorcase cover nuts (13) and cover (12).



#### Step 2

#### Removing rotors

Insert a plastic/wooden block between the two rotors (17) to stop them turning.

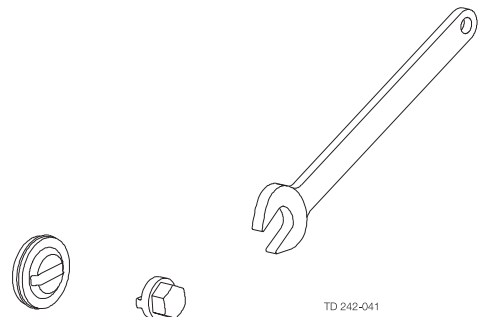


#### Step 3

Remove rotor retainer (22) and rotors. A rotor retainer removal tool (supplied with all new pumps) is used for this purpose by sliding the tool into the rotor retainer slot and turning in an anti-clockwise direction.

Pump series 6 and 7 rotors are retained by torque locking assemblies, TLA's (19) and can be removed by:

- loosen each TLA screw in several stages in a diametrically opposite sequence.
- use bolts to screw into two of the TLA holes (fitted with washers) and extract the TLA's.



Rotor retainer removal tool

#### Step 4

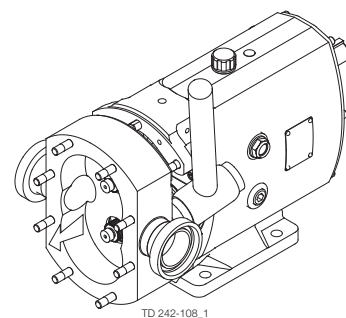
#### Removing static seal components

Please see section 5.5 Primary seals removal and fitting.

#### Step 5

#### Removing rotorcase

1. For flushed mechanical seal arrangements, remove the seal housing retaining nuts and ease the seal housing from the rotorcase.
2. Remove the rotorcase retaining nuts (4) and washers (4A).
3. Tap both sides of the rotorcase (9) with a soft mallet.
4. The rotorcase must not be allowed to drop onto the shafts (24 and 25) during the removal process.
5. Shims (8) should not be removed unless rotor clearances require resetting.



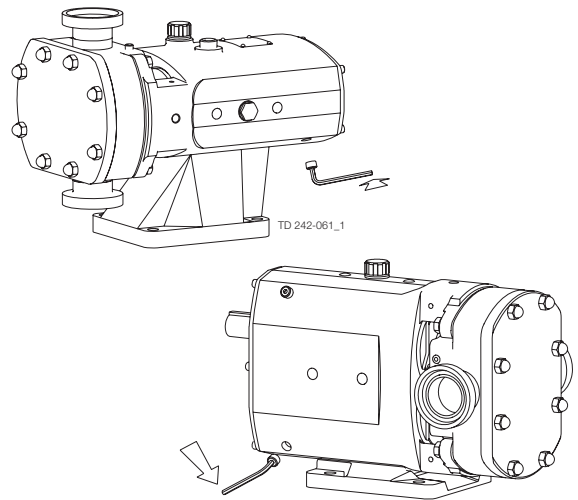
## 5 Maintenance

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### Step 6

#### Draining pump lubrication

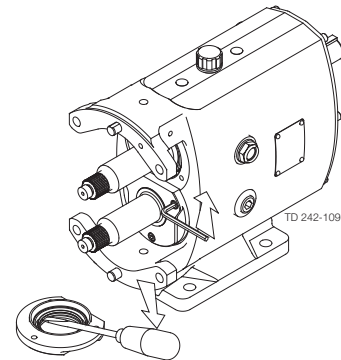
1. Place a tray under the gearcase to collect the waste lubricating oil.
2. Remove the lower drain plug (45) at the side of the gearcase (1).



### Step 7

#### Removing seal retainers

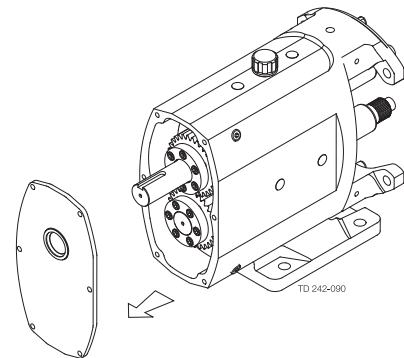
1. Remove screws (15).
2. Then remove seal retainers (14) - as a liquid sealant has been used a lever may be required to remove retainers.
3. The lip seals (16) can be removed using a screwdriver/ lever once the seal retainers are removed. It is essential to renew the lip seals and it is recommended that new gaskets or sealant be used prior to reassembly.



### Step 8

#### Removing Gearcase Cover

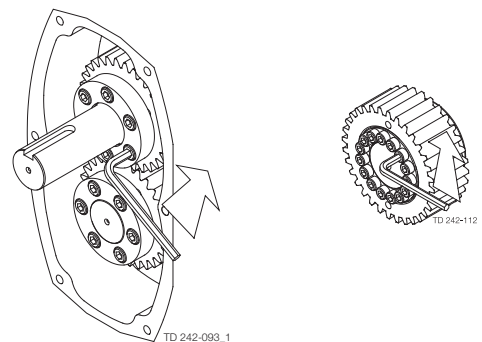
1. Remove screws (6).
2. Remove gearcase cover (5) after breaking the gasket seal then press out the lip seal (7). It is essential to renew the lip seal prior to reassembly.



### Step 9

#### Removing timing gears

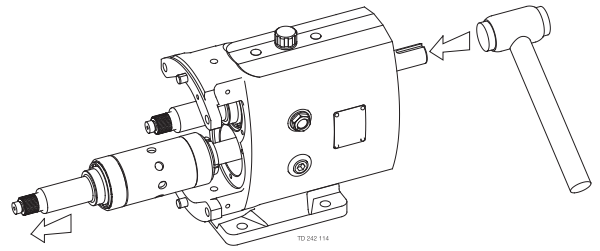
1. Release clamp plate screws (40) on pump series 1, 2 and 3. For pump series 4, 5, 6 and 7 remove the torque locking assembly screw in several stages.
2. Remove gears (36) using the tapped extraction holes provided, or remove shaft assembly as shown in step 10 below.



### Step 10

#### Shaft assembly removal

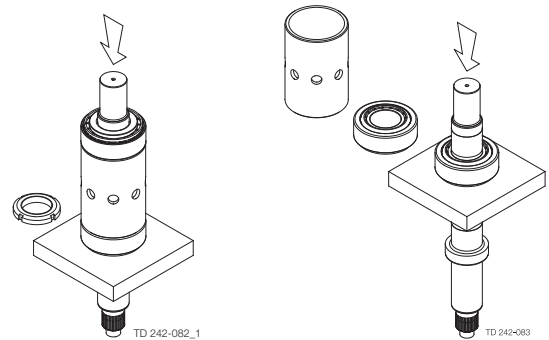
1. Using a soft mallet gently tap the rear end of each shaft (24 and 25), to remove through the front of the gearcase (1).
2. Support each shaft during removal from the gearcase.
3. Remove the shaft abutment spacer (27):
  - For vertically ported pumps this is placed in the right hand bearing bore when viewed on the front face of the gearcase.
  - For horizontally ported pumps the shaft abutment spacer is placed in the top bearing bore.



### Step 11

#### Bearing removal

1. Hold the shafts (24 and 25) in a vice using soft jaws to protect the areas where the seals will be located.
2. Remove the bearing nuts (30) with a 'sharp tap' on a 'C' spanner. The nuts may be tight all the way off as they are fitted with thread locking adhesive.
3. Mount the shaft vertically in a press with a tool positively located against the bearing inner as shown and apply pressure to the top of the shaft so that the shaft moves through the bearings (26 and 31).
4. Remove each bearing set (inner and outer). Good engineering practice suggests that if bearings are removed from the shafts they should be renewed. Clean and examine all components for wear or damage. Renew where necessary.



## 5 Maintenance

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### 5.4 Assembly

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#### 5.4.1 Fitting bearings to shafts

Take care not to damage shaft surfaces, in particular where the seals will be located.  
Ensure all fastenings are tightened to torque settings as shown in chapter 6 Technical data).

On series 1, 2 and 3 pumps, bearings do not require heating. For series 4, 5, 6 and 7 pumps, heat the bearing inner cones to 110°C (230°F).

**Do not use any form of live flame when heating, as this will damage bearings.**

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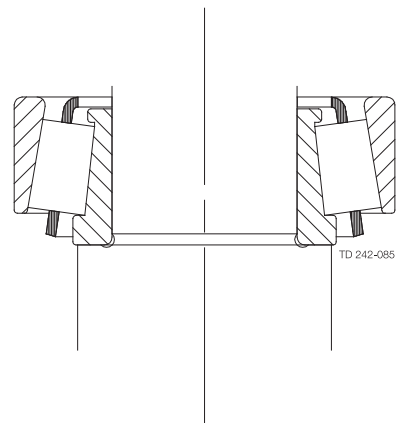
#### Step 1

Position shaft (24 and 25) vertically in a vice using soft jaws and apply anti-seize compound to the bearing diameters.

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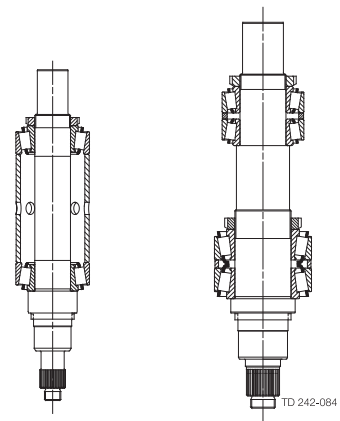
#### Step 2

Place the inner cone on the shaft ensuring a positive fit against the shaft shoulder.



#### Step 3

Locate outer cup, bearing spacer (32) and rear bearing cup.



#### Step 4

Allow bearings to cool (series 4, 5, 6 and 7 pumps only). Failure to do so will result in incorrectly set bearings.

1. Apply PermaBond Grade 145 or equivalent locking compound to the bearing nut thread.
  2. Tighten the bearing nut (30), whilst at the same time rotating the bearings (26 and 31) and spacer (32). The bearings are correctly adjusted when the spacer can only be moved with a light tap of a mallet.
  3. Repeat the above for double bearing assemblies.
  4. Apply oil to the bearings.
-

### Step 1

#### 5.4.2 Fitting Shaft Assemblies

Replace the shaft abutment spacer (27):

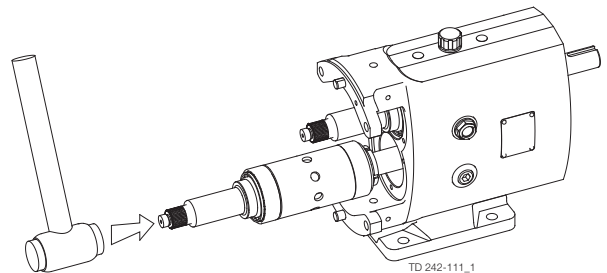
- For vertically ported pumps this is placed in the right hand bearing bore when viewed on the front face of the gearcase.
- For horizontally ported pumps the shaft abutment spacer is placed in the top bearing bore.

### Step 2

Identify drive and auxillary shaft positions according to gearcase cover (5) orientation.

### Step 3

1. Using a soft faced mallet tap the shafts (24 and 25) into the gearcase (1).
2. If the bearings have been replaced, a new abutment spacer will probably be needed. It is vital to ensure the rotor alignments is within the limits set in section 4.4.4.



### Step 1

#### 5.4.3 Fitting seal retainers

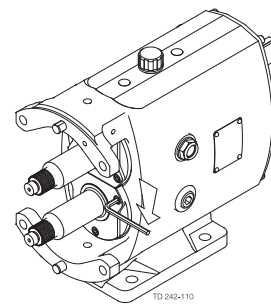
1. Clean the rear face of the seal retainers (14), fit in position and tighten.

### Step 2

1. Check rotor alignment is correct by referring to the rotor abutment alignment in section 4.4.4.
2. When rotor alignment is correct remove seal retainers and press new lip seals (16) into seal retainers.
3. Apply liquid sealant onto the front of the gearcase (1) and push the seal retainers into position. Make sure lip seals are not damaged when sliding them onto the shafts.

### Step 3

Replace and tighten the screws (15).



### Step 1

#### 5.4.4 Checking rotor abutment alignment

**Incorrect setting of rotor alignment will damage the pump.**

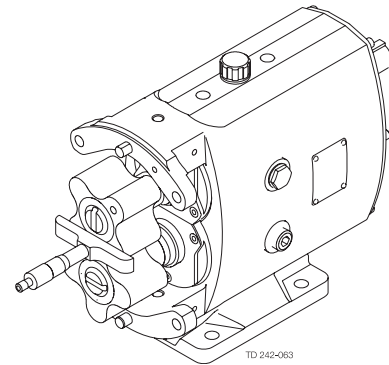
Fit rotors onto shafts (24 and 25) and tighten rotor retainers (22).

## 5 Maintenance

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### Step 2

1. Using a depth micrometer ensure axial alignment is within tolerance of 0.012mm (0.0005 in).
2. If the alignment is incorrect, the shaft abutment spacer (27) must be replaced/machined.



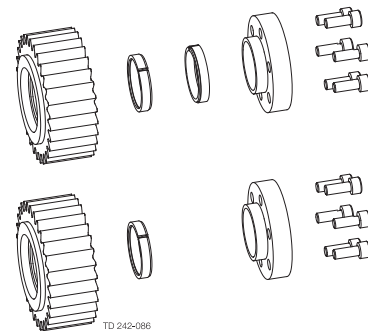
### Step 1

#### 5.4.5 Fitting timing gears

Slide timing gears (36) onto shafts (24 and 25), realigning timing marks.

### Step 2

1. Before fitting the torque locking devices (38) lubricate them with gear oil. Series 1, 2 and 3 have two sets of elements.
2. Series 4, 5, 6 and 7 pumps have torque locking assemblies.



### Step 3

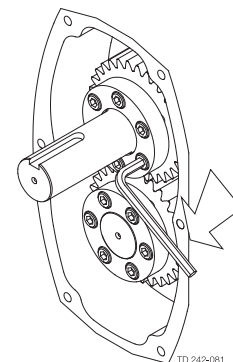
Fit timing gear clamp plates (39) - series 1, 2 and 3 only.

Fit torque locking assemblies (37) - series 4, 5, 6 and 7 only.

### Step 4

Timing adjustment is now required:

Tighten one clamp plate/torque locking assembly only, allowing rotation of the shaft in the other gear for timing adjustment. See Adjusting Rotor Timing section 4.4.6.



### Step 1

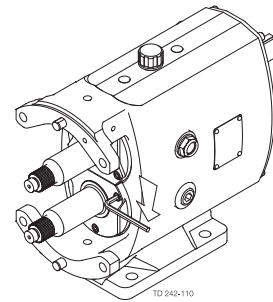
#### 5.4.6 Adjusting rotor timing

If the rotor timing requires adjustment (and assuming the pump has not yet been re-built), it is important to establish the cause for the rotors mistiming before proceeding.

To allow timing adjustment ensure that one shaft is able to rotate within the torque locking assembly/element. The other torque locking assembly/element should be tightened to the recommended torque.

### Step 2

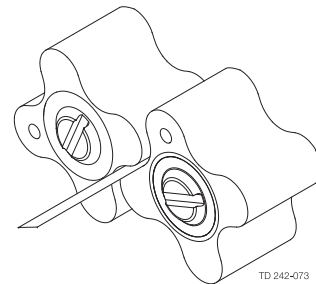
Locate one rotor (17) on to the drive shaft (24) with the dimple at the top. Turn the rotor through 45°. Fit the second rotor on to the auxillary shaft (25) with its dimple at the top as shown.



Dimples

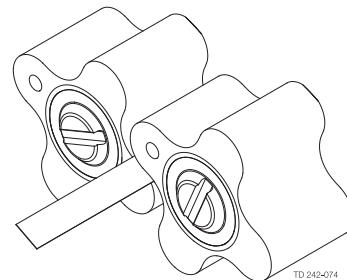
### Step 3

Turn the shaft so that the rotors are in the new positions as shown.



### Step 4

Using feeler gauges measure between the points indicated, turning the shaft as required.



### Step 5

If the measurement points are unequal tap the rotor which is on the free turning shaft until equal measurement through 8 points is achieved.

### Step 6

Tighten the torque locking assemblies or clamp plate screws. Confirm timing is still correct. Remove the rotors.

### Step 1

#### 5.4.7 Fitting gearcase cover

Clean the gearcase cover bore and remove all gasket material from the face. Press a new lip seal (7) into the cover (5).

### Step 2

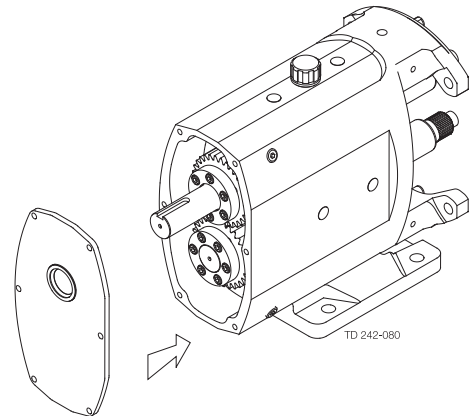
Apply liquid gasket to the face of the cover where it mates with the gearcase.

## 5 Maintenance

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### Step 3

Smear oil on the inner lip of the lip seal and carefully slide the cover over the shaft ensuring the lip seal is centred and not cut or damaged. Tighten the screws (6).



### 5.4.8 Fitting and shimming rotorcase

The rotorcase may require re-shimming if new components have been fitted. Back clearances must be checked before operating the pump.

#### NOTE!

Your supplier can advise the correct clearances from the pump serial number. Should they need adjustment follow steps below. Any incorrect setting of clearances is likely to damage the pump in operation. Plastic shims vary in colour for different thickness, and are grouped in equal packs at the top and bottom of the rotorcase held in place by shim retainers. For ATEX applications stainless steel shims are fitted. Shims can be stacked unequally providing the clearances are achieved.

### Step 1

1. Remove the shim retainers (8A) and fit one of the thinnest shims (8) to top and bottom position.
2. Replace shim retainers and screws (8B).
3. Fit the rotorcase (9) to the gearcase (1), tighten the rotorcase retaining nuts (4) and fit the rotors (17).

### Step 2

The back clearances can now be measured using feeler gauges. The additional shimming required to bring the clearances within tolerance can be determined, fit additional shims and re-check the clearances.

### Step 1

#### 5.4.9 Fitting primary seals

Refer to section 4.5 for seal fitting instructions.

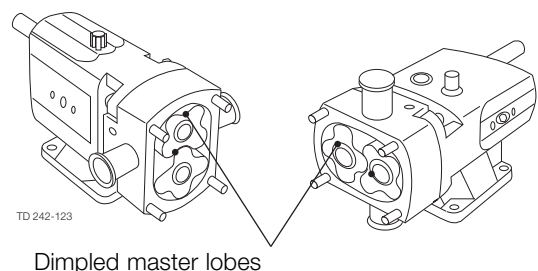
### Step 1

#### 5.4.10 Fitting rotors

If fitted, carefully slide the O rings (18) over the shaft spline until they fit tightly against the shaft shoulder.

### Step 2

Locate one rotor (17) on to the drive shaft (24) with the dimple at the top. Turn the rotor through 45°. Fit the second rotor on to the auxiliary shaft (25) with its dimple at the top as shown. For series 6 and 7 pumps the rotors are retained by torque locking assemblies, TLA's. Slide the TLA assembly onto the shaft. Locate the clamp plate tool and tighten to the recommended torque figure. Tighten the TLA screws to the recommended torque figure. Unscrew the clamp plate tool and remove. Replace the rotor cap and tighten to the recommended torque figure.



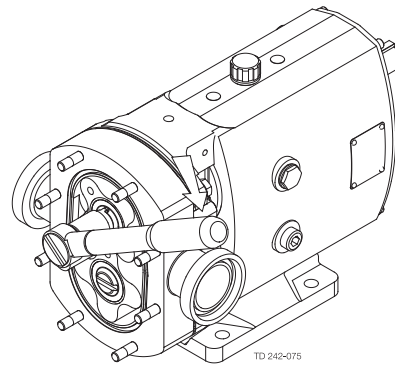
Dimpled master lobes



### Step 3

Fit new rotor retainer cup seals (20) to rotor retainers (22). Use a wooden/plastic block between the rotors to stop them turning whilst tightening the rotor retainers to the recommended torque settings shown in chapter 6 Technical data.

Check cup seal is fully seated and below the surface of the rotor - if necessary apply finger pressure to the seal to ensure it is correctly positioned.



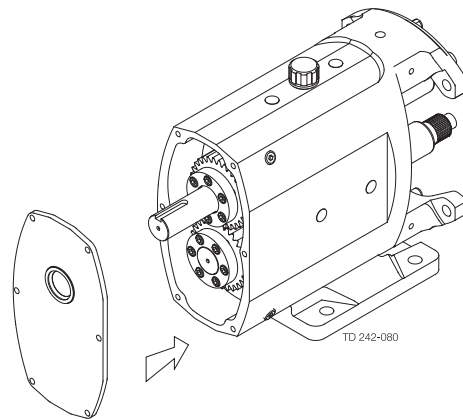
### Step 4

To check rotors are correctly synchronised turn the drive shaft (24) by hand and check meshing clearances with feeler gauges to ensure that equal measurement through all eight points has been attained.

### Step 1

#### 5.4.11 Fitting rotorcase cover

1. Fit new rotorcase cover compression joint (11).
2. Fit rotorcase cover onto rotorcase (9) and tighten rotorcase cover nuts (13).
3. Refer to pump start up checks prior to operation.



## 5 Maintenance

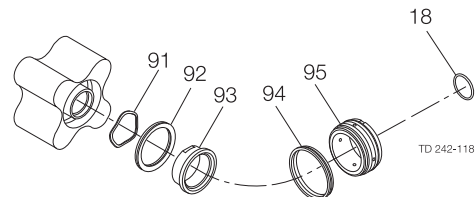
### 5.5 Primary seals removal and fitting

#### 5.5.1 R00 Single mechanical seal

Mechanical seals are fragile. Take extreme care when handling. Clean components before fitting, checking there is no damage to sealing faces. New elastomeric parts should be fitted during assembly.

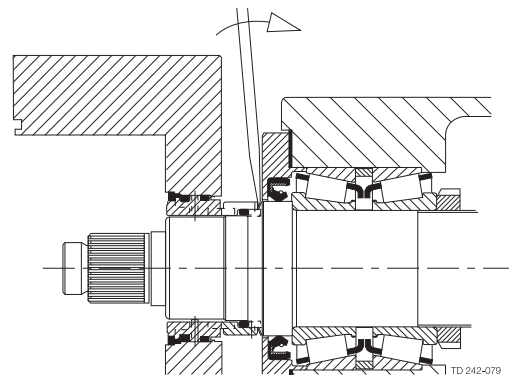
The R00 mechanical seal is completely front loading without need of removing rotorcase for access or replacement. The seal setting distance is pre-set.

Item	Description
91	Wave spring
92	Squad ring
93	Rotary seal ring
94	Cup seal
95	Stationary seal ring
18	Rotor sealing O-ring



#### Seal removal

1. Remove rotorcase cover, rotors and rotor sealing O-ring (18).
2. Extract the rotary seal ring (93), squad ring (92) and wave spring (91) from the rear of the rotors.
3. Gently ease the stationary seal ring (95) and cup seal (94) from the rotorcase using a suitable lever on the rear of the seal as illustrated.



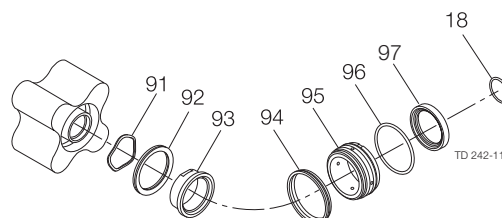
#### Seal fitting

1. Lightly lubricate cup seal (94) and fit to stationary seal ring (95).
2. Carefully aligning the slots in the stationary seal ring with the anti rotation dogs in the rotorcase, gently press the stationary seal ring assembly into the rotorcase bore until the stop is reached.
3. Fit wave spring (91) into the rear bore of the rotor.
4. Lightly lubricate squad ring (92) with appropriate grease and fit to rotary seal ring (93).
5. For SX1-5 align the two flats on the rotary seal ring with the drive flats in the rotor and gently push the rotary seal ring assembly into the rear bore of the rotor.  
For SX6-7 align the two slots on the rotary seal ring with the drive pins in the rotor and gently push the rotary seal ring assembly into the rear bore of the rotor.
6. Wipe clean the sealing faces with solvent
7. Lightly lubricate rotor sealing O-ring (18) and slide onto shaft up to the shoulder.
8. Refit the rotors and rotorcase cover.

### 5.5.2 R00 Single flushed/quench mechanical seal

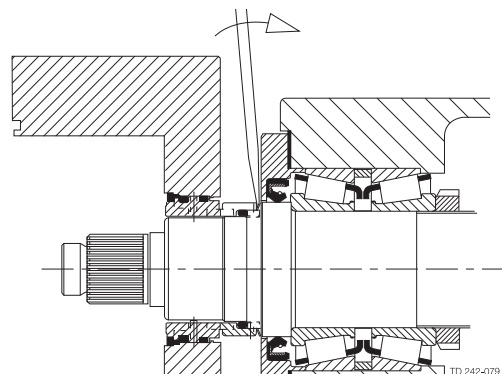
The R00 mechanical seal is completely front loading without need of removing rotorcase for access or replacement. The seal setting distance is pre-set.

Item	Description
91	Wave spring
92	Squad ring
93	Rotary seal ring
94	Cup seal
95	Stationary seal ring
96	Stationary seal ring O-ring
97	Lip seal
18	Rotor sealing O-ring



#### Seal removal

1. Isolate the flush media.
2. Remove rotorcase cover, rotors and rotor sealing O-ring (18).
3. Extract the rotary seal ring (93), wave spring (91) and squad ring (92) from the rear of the rotor.
4. Gently ease the lip seal (97), O-ring (96), stationary seal ring (95) and cup seal (94) from the rotorcase using a suitable lever on the rear of the seal as illustrated.



#### Seal fitting

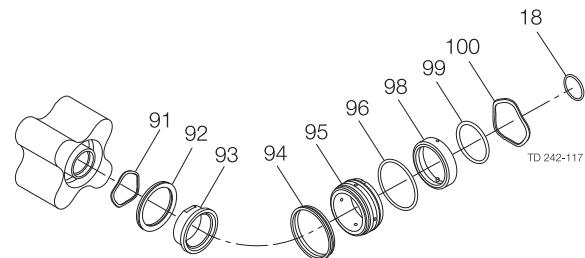
1. Lightly lubricate cup seals (94) with appropriate grease and fit to stationary seal rings (95).
2. Fit cup seal and O-ring (96) to stationary seal assembly.
3. Fit lip seal (97) into stationary seal assembly.
4. Carefully aligning the slots of the stationary seal ring with the anti rotation dogs in the rotorcase, gently press the stationary seal ring assembly into the rotorcase bore until the stop is reached.
5. Fit wave spring (91) into the rear bore of the rotor.
6. Lightly lubricate squad rings (92) with appropriate grease and fit to rotary seal rings (93).
7. For SX1-5 align the two flats on the rotary seal ring with the drive flats in the rotor and gently push the rotary seal ring assembly into the rear bore of the rotor.  
For SX6-7 align the two slots on the rotary seal ring with the drive pins in the rotor and gently push the rotary seal ring assembly into the rear bore of the rotor.
8. Wipe clean the sealing faces with solvent.
9. Lightly lubricate rotor sealing O-ring (18) and slide onto shaft up to shoulder.
10. Refit the rotors and rotorcase cover.

## 5 Maintenance

### 5.5.3 R00 Double flushed mechanical seal

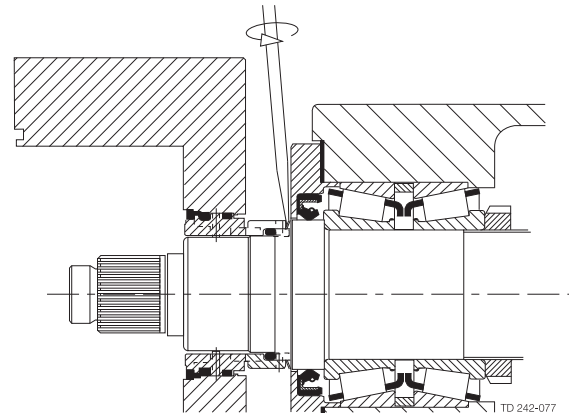
The R00 mechanical seal is completely front loading without need of removing rotorcase for access or replacement. The seal setting distance is pre-set.

Item	Description
91	Wave spring
92	Squad ring
93	Rotary seal ring (inboard)
94	Cup seal
95	Stationary seal ring
96	Stationary seal ring O-ring
98	Rotary seal ring (outboard)
99	Rotary seal ring O-ring
100	Wave spring
18	Rotor sealing O-ring



#### Seal removal

1. Isolate the flush Media.
2. Remove rotorcase cover, rotors and rotor sealing O-ring (18)
3. Extract the rotary seal ring (93), wave spring (91) and squad ring (92) from the rear of the rotor.
4. Gently ease all other seal components from the rotorcase using a suitable lever on the rear of the seal as illustrated.



#### Seal fitting

1. Lightly lubricate cup seals (94) and stationary seal O-rings (96) with appropriate grease.
2. Fit cup seal (94) and O-ring (96) to stationary seal ring (95).
3. Lubricate and fit rotary seal ring O-ring (99) into outboard rotary seal ring (98).
4. Slide wave spring (100) along shaft through the rotorcase bore until located on the shaft shoulder.
5. Wipe clean the sealing faces with solvent.
6. Carefully aligning the slots in the stationary seal rings with the anti rotation dogs in the rotorcase, gently press the stationary seal ring assembly into the rotorcase bore until the stop is reached.
7. Fit wave spring (91) into the rear bore of the rotor.
8. Lightly lubricate squad rings (92) with appropriate grease and fit to rotary seal rings (93).
9. For SX1-5 align the two flats on the rotary seal ring with the drive flats in the rotor and gently push the rotary seal ring assembly into the rear bore of the rotor.  
For SX6-7 align the two slots on the rotary seal ring with the drive pins in the rotor and gently push the rotary seal ring assembly into the rear bore of the rotor.
10. Lightly lubricate rotor sealing O-ring (18) and slide onto shaft up to the shoulder.
11. Refit the rotors and rotorcase cover.

**NOTE!** If the flushing pressure is in excess of 5 bar above the discharge pressure an O-ring is specified in place of the squad ring.

## 5.6 Troubleshooting

Problem														Probable Causes		Solutions		
No flow	Under capacity	Irregular discharge	Low discharge pressure	Pump will not prime	Prime lost after starting	Pump stalls when starting	Pump overheats	Motor overheats	Excessive power absorbed	Noise and vibration	Pump element wear	Syphoning	Seizure					Mechanical seal leakage
✓				✓												Incorrect direction of rotation.	Reverse motor.	
✓																Pump not primed.	Expel gas from suction line and pumping chamber and introduce fluid.	
																	Increase suction line diameter.	
✓	✓	✓	✓		✓					✓						Insufficient NPSH available.	Increase suction head.	
																	Simplify suction line configuration and reduce length.	
																	Reduce pump speed.	
		✓	✓	✓		✓				✓							Increase suction line diameter.	
																	Increase suction head.	
																	Simplify suction line configuration and reduce length.	
																	Reduce pump speed.	
✓	✓	✓	✓	✓	✓									✓		Air entering suction line.	Remake pipework joints.	
		✓	✓	✓	✓					✓						Strainer or filter blocked.	Service fittings.	
		✓			✓	✓	✓	✓	✓	✓					✓	Fluid viscosity above rated figure.	Increase fluid temperature.	
																	Decrease pump speed.	
																	Check seal face viscosity limitations.	
✓	✓		✓													Fluid viscosity below rated figure.	Decrease fluid temperature.	
																	Increase pump speed.	
							✓			✓	✓			✓	✓	Fluid temp. above rated figure.	Cool the pump casing.	
																	Reduce fluid temperature.	
																	Check seal face and elastomer temp. limitations.	
						✓		✓	✓							Fluid temp. below rated figure.	Heat the pump casing.	
																	Increase fluid temperature.	
										✓	✓			✓	✓	Unexpected solids in fluid.	Clean the system.	
																	Fit strainer to suction line.	
																	If solids cannot be eliminated, consider fitting double mechanical seals.	
✓	✓	✓			✓	✓	✓	✓	✓	✓	✓			✓	✓	✓	Discharge pressure above rated figure	Check for obstructions i.e. closed valve.
							✓	✓	✓					✓			Service system and change to prevent problem recurring.	
		✓	✓		✓					✓							Simplify discharge line to decrease pressure.	
																	Gland over-tightened	
		✓	✓		✓					✓						✓	Gland under-tightened	
																✓	Seal flushing inadequate.	
																	Increase flush flow rate.	
	✓	✓						✓	✓	✓							Check that flush fluid flows freely into seal area.	
✓	✓																Pump speed above rated figure.	
																	Decrease pump speed.	
																	Increase pump speed.	
		✓					✓	✓	✓	✓	✓			✓			Pump casing strained by pipework.	
																	Check alignment of pipes.	
																	Fit flexible pipes or expansion fittings.	
																	Support pipework.	
							✓			✓	✓			✓			Flexible coupling misaligned.	
							✓	✓	✓	✓	✓			✓			Check alignment and adjust mountings accordingly.	
								✓	✓	✓	✓			✓			Fit lock washers to slack fasteners and re-tighten.	
							✓	✓	✓	✓	✓			✓	✓		Refer to pump maker for advice and replacement parts.	
							✓	✓	✓	✓	✓			✓			Insufficient gearcase lubrication.	
																	Refer to pump maker's instructions.	
✓	✓							✓	✓	✓	✓	✓		✓			Check rated and duty pressures.	
✓	✓		✓														Refer to pump maker.	
✓	✓																Check pressure setting and re-adjust if necessary.	
✓	✓									✓							Examine and clean seating surfaces.	
																	Replace worn parts.	
✓										✓							Check for wear on sealing surfaces, guides etc.	
																	Replace if necessary.	
✓	✓																Check for wear on sealing surfaces, guides etc.	
✓					✓												Re-adjust spring compression - valve should lift approx. 10% above duty pressure.	
																	Lower pump or raise liquid level.	
																✓	Fluid pumped not compatible with materials used.	
																✓	Use optional materials.	
																✓	No barrier in system to prevent flow passing.	
																	Ensure discharge pipework higher than suction tank.	
																✓	Ensure system operation prevents this.	
																✓	Fit single or double flushed mechanical seals.	
																	Fit flushed packed gland.	
										✓	✓						Check and replace motor bearings.	
✓																	Fit pumping element.	

## 6 Technical data

### 6.1 Technical data

#### 6.1.1 Oil capacities

Pump model	Port orientation Vertical litres	Horizontal litres	Port orientation Vertical US pints	Horizontal US pints
SX1	0.30	0.40	0.60	0.80
SX2	0.60	0.70	1.20	1.40
SX3	1.10	1.50	2.20	3.10
SX4	1.50	2.00	3.20	4.20
SX5	3.00	4.00	6.30	8.40
SX6	4.50	7.00	9.50	14.80
SX7	9.00	12.00	19.00	25.40

#### 6.1.2 Weights

Pump model	Bare Shaft Pump kg (lb)		Pump with drive unit kg (lb)	
	Port Orientation Horizontal	Port Orientation Vertical	Horizontal	Vertical
SX1/005	15 (33)	16 (35)	46 (101)	49 (108)
SX1/007	16 (35)	17 (37)	55 (121)	58 (128)
SX2/013	32 (71)	33 (73)	80 (176)	81 (179)
SX2/018	33 (73)	34 (75)	85 (187)	86 (190)
SX3/027	57 (126)	59 (130)	147 (324)	150 (331)
SX3/035	59 (130)	61 (134)	152 (335)	155 (342)
SX4/046	107 (236)	110 (243)	271 (597)	274 (604)
SX4/063	113 (249)	116 (256)	277 (611)	280 (617)
SX5/082	155 (342)	155 (342)	295 (650)	295 (650)
SX5/115	165 (364)	165 (364)	310 (683)	310 (683)
SX6/140	278 (613)	278 (613)	545 (1202)	545 (1202)
SX6/190	290 (639)	290 (639)	570 (1257)	570 (1257)
SX7/250	336(741)	344 (759)	652(1438)	660 (1455)
SX7/380	358(789)	366(807)	677(1493)	685 (1510)




The above weights are for guidance purposes only and will vary dependent upon specification of pump, baseplate and drive unit.

### 6.1.3 Tool requirements

Description	Tool required	Pump Model						
		SX1	SX2	SX3	SX4	SX5	SX6	SX7
Rotorcase cover nut (13)	Socket Size (mm)	13	17	17	17	17	19	19
	Torque Setting (Nm)	20	39	39	39	39	105	105
	Torque Setting (lbft)	14.8	28.8	28.8	28.8	28.8	77.4	77.4
Rotor retainer (22)	Socket Size (mm)	19	19	19	24	24	24	24
	Torque Setting (Nm)	20	60	80	120	160	160	160
	Torque Setting (lbft)	14.8	44.3	59.0	88.5	118.0	118.0	118.0
Rotor TLA (19)	Key Size (mm)	-	-	-	-	-	-	5.5
	Torque Setting (Nm)	-	-	-	-	-	8	8
	Torque Setting (lbft)	-	-	-	-	-	5.9	5.9
Rotorcase retaining nut (4)	Spanner Size (mm)	13	17	17	19	19	24	24
	Torque Setting (Nm)	20	40	40	64	64	175	175
	Torque Setting (lbft)	14.8	29.5	29.5	47.2	47.2	129.1	129.1
Seal retainer screw (15)	Key Size (mm)	5	5	5	6	6	6	8
	Torque Setting (Nm)	10	10	10	25	25	25	40
	Torque Setting (lbft)	7.4	7.4	7.4	18.4	18.4	18.4	29.5
Gearcase cover screw (6)	Key Size (mm)	5	5	5	6	6	6	6
	Torque Setting (Nm)	10	10	10	25	25	25	25
	Torque Setting (lbft)	7.4	7.4	7.4	18.4	18.4	18.4	18.4
TLA/Clamp plate screw (40)	Key Size (mm)	5	5	5	6	6	6	6
	Torque Setting (Nm)	12	17	12	14	35	35	35
	Torque Setting (lbft)	8.9	12.5	8.9	10.3	25.8	25.8	25.8
Drain plug (45)	Key Size (mm)	¼	¼	¼	¼	½	½	½
Foot bolt (58)	Key Size (mm)	5	6	6	8	10	10	24
	Torque Setting (Nm)	15	30	30	60	50	50	120
	Torque Setting (lbft)	11.1	22.1	22.1	44.3	37	37	89
Sight glass (46)	Socket size (mm)	22	22	22	22	22	22	22
	Torque Setting (Nm)	2	2	2	2	2	2	2
	Torque Setting (lbft)	0.9	0.9	0.9	0.9	0.9	0.9	0.9

## 6 Technical data

### 6.1.4 Pump Data Table

Model	Displacement			Suction & Discharge				Differential		Maximum	Max.
	litres/rev 100 rev	Imp gal/ 100 rev	US gal/ Dia- meter	Connection Size Nominal Bore (International Std) (Standard)		Pressure Connection Size		Pressure Max Speed 		Capacity at rev/min 	Capacity at max. rpm m3/hr 
				mm	inches	mm	inches	bar	psi		
SX1/005	0.050	1.1	1.3	22	0.87	25	1.0	12	174	1200	3.60
SX1/007	0.070	1.5	1.8	35	1.38	40	1.5	7	101	1200	5.04
SX2/013	0.128	2.8	3.4	35	1.38	40	1.5	15	217	1000	7.68
SX2/018	0.181	4.0	4.8	47	1.85	50	2.0	7	101	1000	10.86
SX3/027	0.266	5.9	7.0	47	1.85	50	2.0	15	217	1000	15.96
SX3/035	0.350	7.7	9.2	62	2.44	65	2.5	7	101	1000	21.00
SX4/046	0.460	10.1	12.2	47	1.85	50	2.0	15	217	1000	27.60
SX4/063	0.630	13.9	16.6	62	2.44	65	2.5	10	145	1000	37.80
SX5/082	0.820	18.0	21.7	62	2.44	65	2.5	15	217	600	29.52
SX5/115	1.150	25.3	30.4	73	2.87	80	3.0	10	145	600	41.40
SX6/140	1.400	30.8	37.0	73	2.87	80	3.0	15	217	500	42.00
SX6/190	1.900	41.8	50.2	96	3.78	100	4.0	10	145	500	57.00
SX7/250	2.500	55.0	66.0	96	3.78	100	4.0	15	217	500	75.00
SX7/380	3.800	83.6	100.4	140	5.51	150	6.0	10	145	500	114.00

**Please note:**

Maximum differential pressure capability of the pump does not apply to the pressure rating of the mechanical seals which is 15 bar, and the selected port connection as stated below:

SMS - 10 bar (all sizes)

RJT - 10 bar (all sizes)

DIN11851 - 40 bar (25-50mm), 25 bar (50-100mm), 16 bar (150mm)

IDF/ISS - 16 bar (25-50mm), 10 bar (65-150mm) providing provision for support ring is to be made.

Tri-clamp (BS4825) - Pressure rating is dictated by the clamp band used. Refer to clamp band supplier.

For size 150mm on SX7/380 pumps, only DIN11851, SRJT or Tri-clamp connections are available.

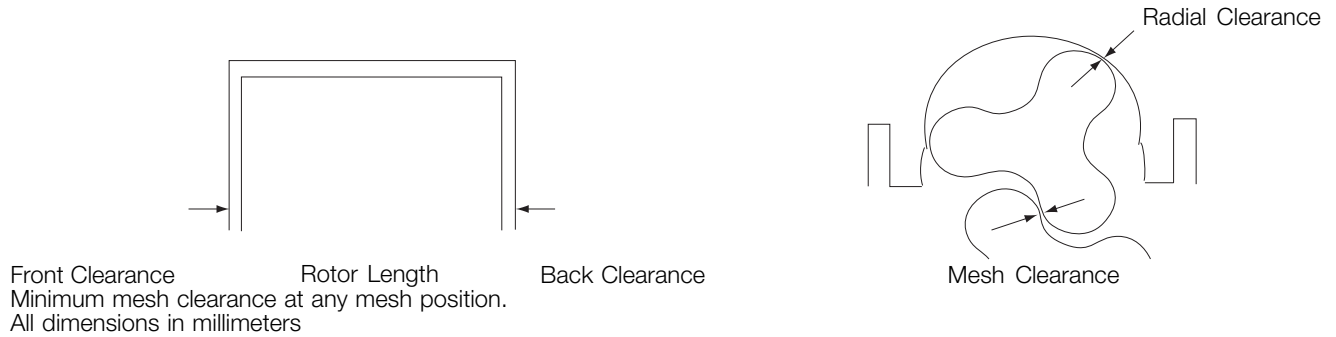
**Note:**



ATEX applications: Differential pressure, Max. speed and Max. capacity are not applicable for ATEX applications.



## 6.2 Pumphead Clearance information

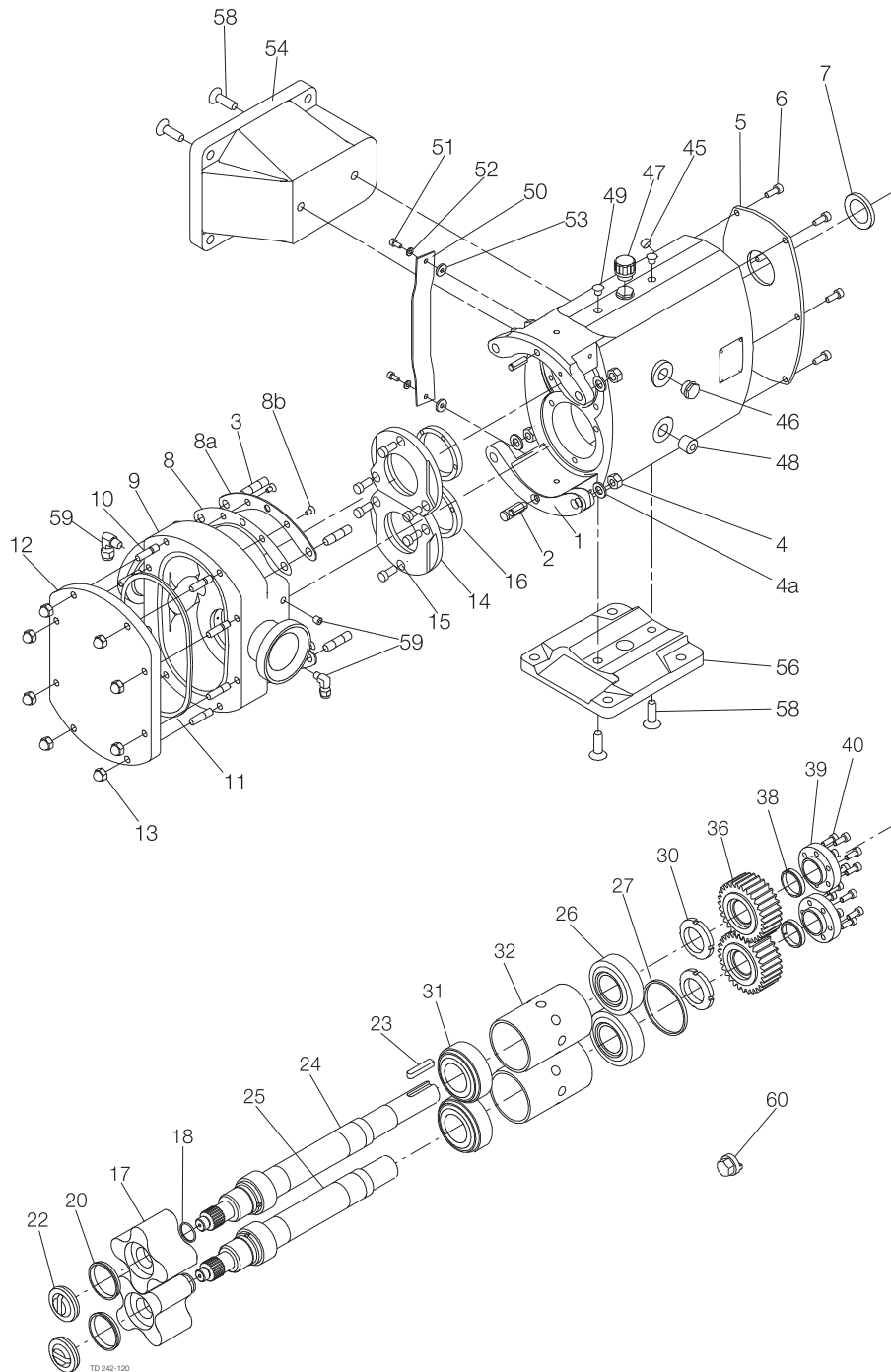


Pump Model	Pressure bar	Rotor Length	Front Clearance Min.	Back Clearance Min.	Rotor Diameter Min.	Radial Clearance Min.	Mesh Clearance Min.
SX1/005	6	28.88 - 28.91	0.11	0.05	57.85	0.16	0.06
SX1/007	12	28.80 - 28.83	0.16	0.08	57.75	0.21	0.15
SX1/007	7	41.74 - 41.77	0.19	0.11	57.65	0.23	0.21
SX2/013	5	38.30 - 38.33	0.10	0.05	80.34	0.10	0.09
SX2/013	15	38.18 - 38.21	0.16	0.11	80.06	0.24	0.17
SX2/018	7	54.08 - 54.11	0.14	0.09	80.22	0.16	0.17
SX3/027	5	52.36 - 52.39	0.11	0.10	95.50	0.13	0.24
SX3/027	15	52.22 - 52.25	0.21	0.14	95.14	0.28	0.24
SX3/035	7	68.81 - 68.84	0.19	0.11	95.20	0.28	0.24
SX4/046	5	51.96 - 51.99	0.08	0.05	124.91	0.11	0.22
SX4/046	15	51.89 - 51.92	0.13	0.07	124.75	0.19	0.22
SX4/063	5	71.18 - 71.21	0.09	0.05	124.81	0.16	0.20
SX4/063	10	71.06 - 71.09	0.16	0.10	124.73	0.20	0.20
SX5/082	15	67.25 - 67.30	0.20	0.15	150.04	0.23	0.25
SX5/115	10	94.55 - 94.60	0.20	0.15	150.04	0.23	0.25
SX6/140	15	79.55 - 79.60	0.20	0.15	177.22	0.24	0.38
SX6/190	10	107.82 - 107.87	0.25	0.15	177.22	0.24	0.38
SX7/250	15	104.64 - 104.69	0.33	0.28	205.78	0.56	0.50
SX7/380	10	158.89 - 158.94	0.38	0.30	205.78	0.56	0.50

## 7 Parts list

The drawing shows exploded view of the SX1 - 3 pump range.  
The drawing includes all items of the pump.

### 7.1 SX1-3 Pump Range



*The drawing shows exploded view of the SX1 - 3 pump range.  
The drawing includes all items of the pump.*

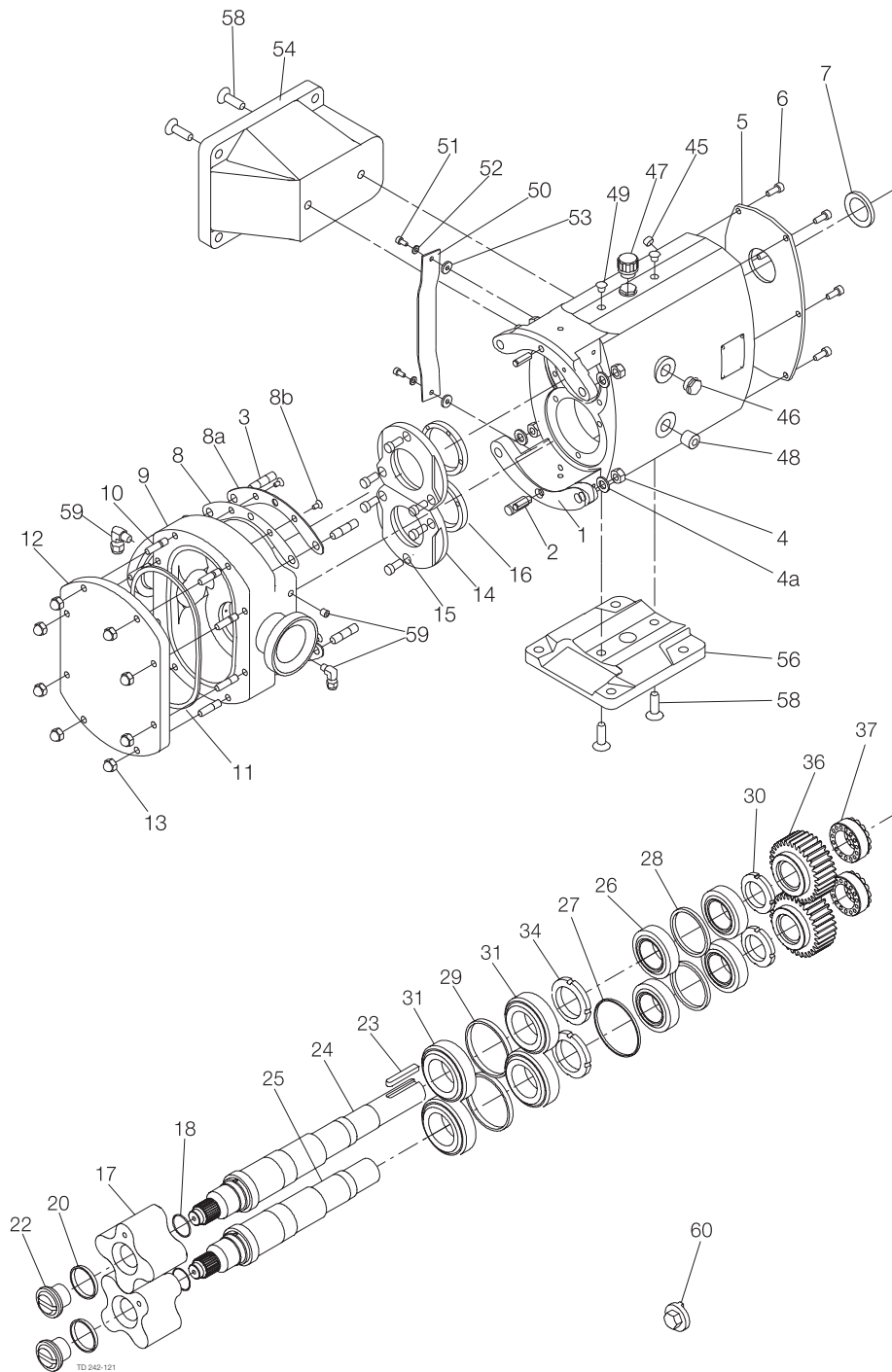
### Parts list

Pos.	Qty	Denomination
1	1	Gearcase
2	2	Dowel
3	4	Stud, rotorcase retention
4	4	Nut, rotorcase retention
4A	4	Washer, rotorcase retention
5	1	Cover, gearcase
6	6	Screw, gearcase cover
7	1	Lip seal, drive end
8	2	Shim
8A	2	Shim retainer
8B	4	Screw, shim retainer
9	1	Rotorcase
10	4/8	Stud, rotorcase/cover retention (Qty 4 for X1/2 - Qty 8 for X3)
11	1	Compression joint
12	1	Cover, rotorcase
13	4/8	Dome nut, rotorcase cover (Qty 4 for X1/2 - Qty 8 for X3)
14	2	Retainer, seal
15	6	Screw, seal retainer
16	2	Lip seal, gland end
17	2	Rotors
18	2	O-Ring, rotor sealing shaft end
19	2	Torque locking assembly, rotor
20	2	Cup seal, rotor retainer
22	2	Rotor retainer
23	1	Key
24	1	Shaft, drive
25	1	Shaft, auxiliary
26	2	Bearing, rear
27	1	Spacer, shaft abutment
30	2	Nut, bearing front
31	2	Bearing, front
34	2	Nut, bearing front
36	2	Timing gear
38	2	Torque locking element
39	2	Clamp plate
40	12	Screw, clamp plate
45	2	Drain plug
46	1	Sight glass
47	1	Filler plug
49	4	Blanking plug
50	2	Gland guard
51	4	Screw, gland guard
52	4	Washer, gland guard screw
53	4	Washer, gland guard screw
54	1	Foot, vertical port
56	1	Foot, horizontal port
58	2	Bolt, Foot
60	1	Rotor removal tool

## 7 Parts list

The drawing shows exploded view of the SX4 pump range.  
The drawing includes all items of the pump.

### 7.2 SX4 Pump Range



*The drawing shows exploded view of the SX4 pump range.  
The drawing includes all items of the pump.*

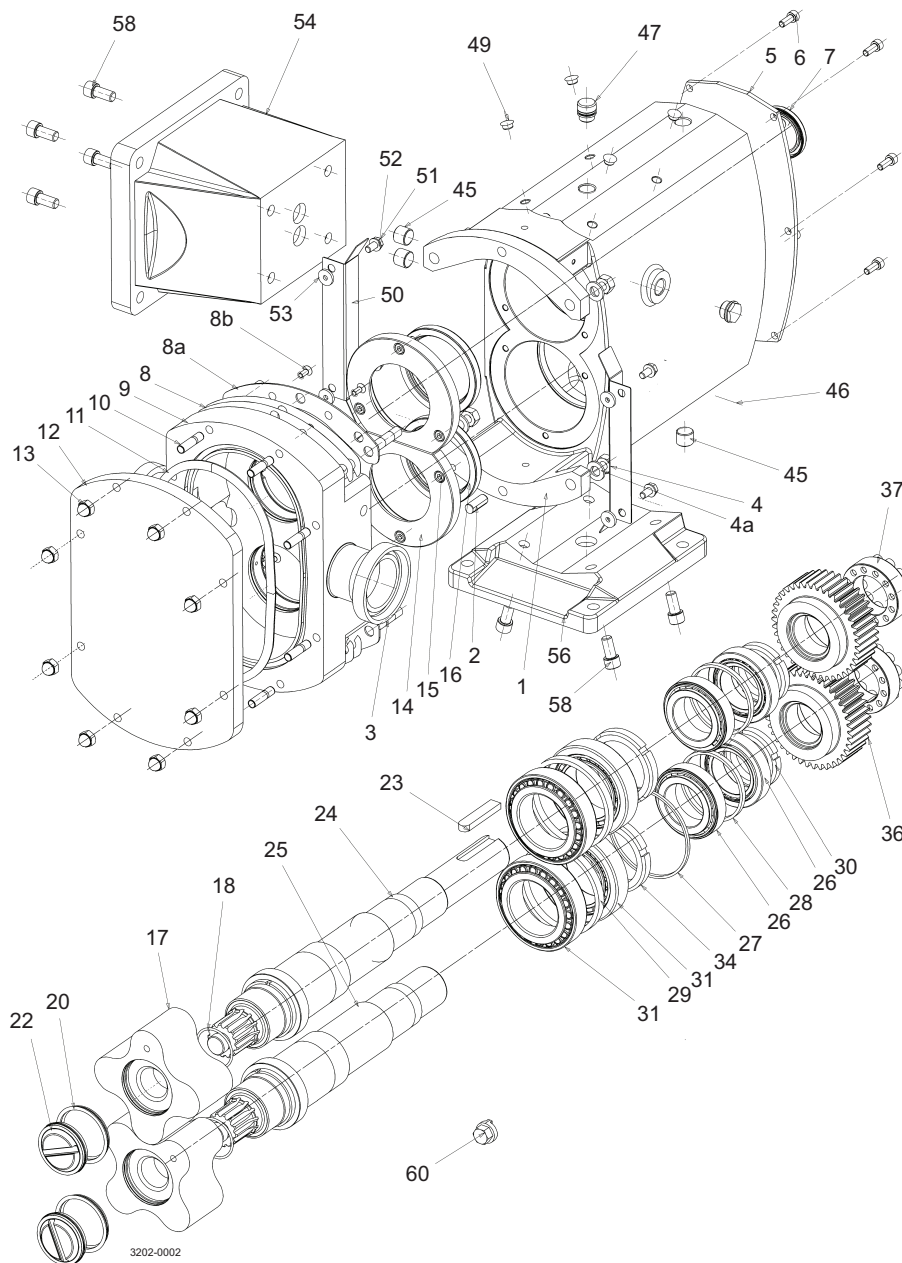
### Parts list

Pos.	Qty	Denomination
1	1	Gearcase
2	2	Dowel
3	4	Stud, rotorcase retention
4	4	Nut, rotorcase retention
4A	4	Washer, rotorcase retention
5	1	Cover, gearcase
6	6	Screw, gearcase cover
7	1	Lip seal, drive end
8	2	Shim
8A	2	Shim retainer
8B	4	Screw, shim retainer
9	1	Rotorcase
10	8	Stud, rotorcase/cover retention
11	1	Compression joint
12	1	Cover, rotorcase
13	8	Dome nut, rotorcase cover
14	2	Retainer, seal
15	6	Screw, seal retainer
16	2	Lip seal, gland end
17	2	Rotors
18	2	O-Ring, rotor sealing shaft end
19	2	Torque locking assembly, rotor
20	2	Cup seal, rotor retainer
22	2	Rotor retainer
23	1	Key
24	1	Shaft, drive
25	1	Shaft, auxiliary
26	4	Bearing, rear
27	1	Spacer, shaft abutment
28	2	Spacer, bearing drive end
29	2	Spacer, bearing gland end
30	2	Nut, bearing front
31	4	Bearing, front
34	2	Nut, bearing front
36	2	Timing gear
37	2	Torque locking assembly
45	2	Drain plug
46	1	Sight glass
47	1	Filler plug
48	2	Plug
49	4	Blanking plug
50	2	Gland guard
51	4	Screw, gland guard
52	4	Washer, gland guard screw
53	4	Washer, gland guard screw
54	1	Foot, vertical port
56	1	Foot, horizontal port
58	2	Bolt, foot
60	1	Rotor removal tool

## 7 Parts list

The drawing shows exploded view of the SX5 pump range.  
The drawing includes all items of the pump.

### 7.3 SX5 Pump Range



*The drawing shows exploded view of the SX5 pump range.  
The drawing includes all items of the pump.*

### Parts list

Pos.	Qty	Denomination
1	1	Gearcase
2	2	Dowel
3	4	Stud, rotorcase retention
4	4	Nut, rotorcase retention
4A	4	Washer, rotorcase retention
5	1	Cover, gearcase
6	6	Screw, gearcase cover
7	1	Lip seal, drive end
8	2	Shim
8A	2	Shim retainer
8B	4	Screw, shim retainer
9	1	Rotorcase
10	8	Stud, rotorcase/cover retention
11	1	Compression joint
12	1	Cover, rotorcase
13	8	Dome nut, rotorcase cover
14	2	Retainer, seal
15	6	Screw, seal retainer
16	2	Lip seal, gland end
17	2	Rotors
18	2	O-ring, rotor sealing shaft end
20	2	Cup seal, rotor retainer
22	2	Rotor retainer
23	1	Key
24	1	Shaft, drive
25	1	Shaft, auxiliary
26	4	Bearing, rear
27	1	Spacer, shaft abutment
28	2	Spacer, bearing drive end
29	2	Spacer, bearing gland end
30	2	Nut, bearing front
31	4	Bearing, front
34	2	Nut, bearing front
36	2	Timing gear
37	2	Torque locking assembly
45	7	Drain Plug
46	1	Sight glass
47	1	Filler plug
49	8	Blanking plug
50	2	Gland guard
51	4	Screw, gland guard
52	4	Washer, gland guard screw
53	4	Washer, gland guard screw
54	1	Foot, vertical port
56	1	Foot, horizontal port
58	4	Bolt, foot
60	1	Rotor removal tool





*The drawing shows exploded view of the SX6-7 pump range.  
The drawing includes all items of the pump.*

### Parts list

Pos.	Qty	Denomination
1	1	Gearcase
2	2	Dowel
3	4	Stud, rotorcase retention
4	4	Nut, rotorcase retention
4A	4	Washer, rotorcase retention
5	1	Cover, gearcase
6	6	Screw, gearcase cover
7	1	Lip seal, drive end
8	2	Shim
8A	2	Shim Retainer
8B	4	Screw, shim retainer
9	1	Rotorcase
10	8	Stud, rotorcase/cover retention
11	1	Compression joint
12	1	Cover, rotorcase
13	8	Dome nut, rotorcase cover
14	2	Retainer, seal
15	6	Screw, seal retainer
16	2	Lip seal, gland end
17	2	Rotors
18	2	O-ring, rotor sealing shaft end
19	2	Torque locking assembly, rotor
20	2	Cup seal, rotor retainer
22	2	Rotor retainer
23	1	Key
24	1	Shaft, drive
25	1	Shaft, auxiliary
26	4	Bearing, rear
27	1	Spacer, shaft abutment
28	2	Spacer, bearing drive end
29	2	Spacer, bearing gland end
30	2	Nut, bearing front
31	4	Bearing, front
34	2	Nut, bearing front
36	2	Timing gear
37	2	Torque locking assembly
45	7	Drain plug
46	1	Sight glass
47	1	Filler plug
49	8	Blanking plug
50	2	Gland guard
51	4	Screw, gland guard
52	4	Washer, gland guard screw
53	4	Washer, gland guard screw
54	1	Foot, vertical port
56	1	Foot, horizontal port
58	4	Bolt, foot
60	1	Rotor removal tool

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