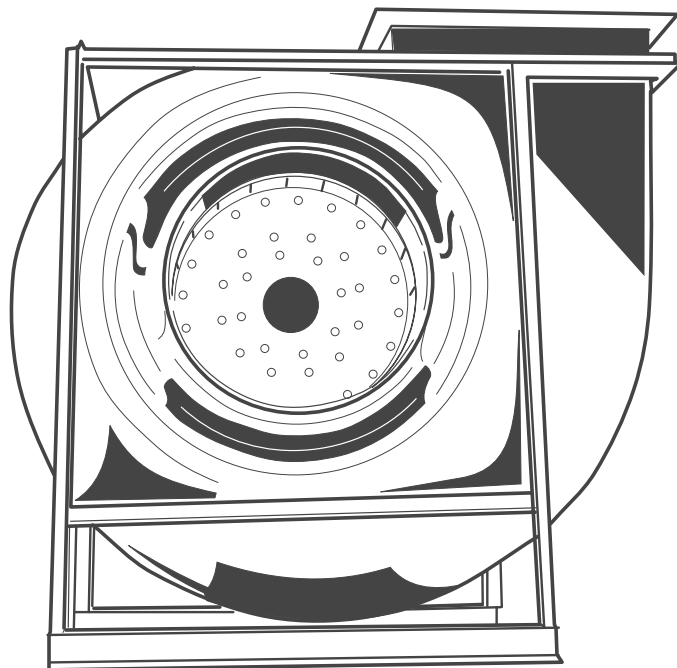




**Maintenance and Installation Manual**

**For**

***Chemical Resistant Centrifugal Plastic Fans***



# MAINTENANCE AND INSTALLATION MANUAL

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## GENERAL INFORMATION

This bulletin has been developed as a guide for installation of WOLTER plastic fans. The purchasers are to ensure for proper installation, maintenance and safety precautions. The instructions are not complete within themselves, but should be considered as supplementing good erection techniques.

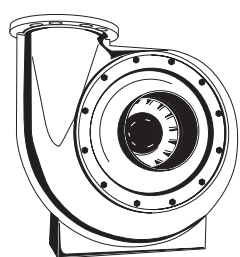
It is generally advisable to have the installation and initial start up of the equipment supervised or checked by an experienced erection superintendent. If in doubt, the purchaser should contact WOLTER local representative for assistance.

## SAFETY PRECAUTIONS

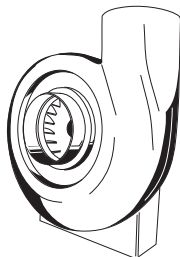
The plastic fan, which you have purchased, is a rotating piece of equipment and can become a source of danger to life and can cause injury if not properly applied.



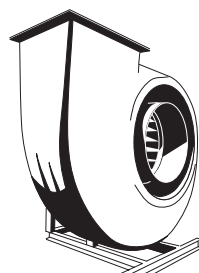
The **maximum operating speed** for which this fan is designed should **not be exceeded**. Suitable **guards** should be placed over the inlets and outlets of the fans to prevent the entrance of **any loose material object**. The fan should be kept within a room or protective enclosure **isolate away** from people and expensive equipment.



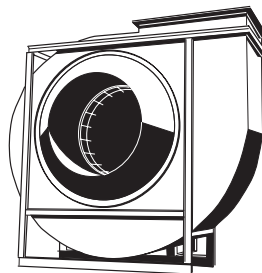
CHEM 125 to 400PP



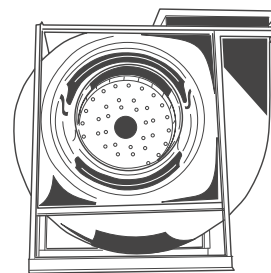
CHEM 200 to 400GRP



CHEM 450 to 710GRP



CHEM 450 to 1250PP



CHEM 450 to 1250GRP

Within the fan area, the temperature of the medium to be extracted must not exceed the following values:

| Type     | Max.Temp.    | Type      | Max.Temp.    |
|----------|--------------|-----------|--------------|
| PVC fans | 60 degree C  | PP fans   | 80 degree C  |
| GRP fans | 100 degree C | PVDF fans | 120 degree C |

The plastic material used for the individual fans must be checked for its chemical resistance to the medium. Not every plastic material is resistant to every medium.

Personnel, who will operate this fan, or those who will perform maintenance thereon, should be warned of the potential hazards of the equipment. Strict adherence to installation instructions is the responsibility of the user and is necessary to the safe operation of this fan. Proper protection from electrical start of the fan during maintenance is required. A disconnect switch installed by qualify electrical contractor with means of installing a padlock to prevent operation of the fan switch is desirable. In addition, a disconnect switch should be located at the fan for use by personnel working on the fan.

## RECEIVING

Examine the equipment and report immediately any damage or shortage. If installation, operating and maintenance instructions are provided, these should be handed as soon as possible to the appropriate persons.

## STORAGE

Protect fans against weather, excess heat, damp or dust. Particularly cover and protect bearings, shaft and motor. Inspect fan periodically and in the case of ball or roller bearings, rotate weekly to prevent damaging the races. Do not store near vibrating machinery or fan bearings might suffer damage of the same kind. Always store the right way up.

## UNLOADING AND HANDLING



The WOLTER plastic fans are designed with sufficient strength for operating conditions. Do not drop or jar. For safe lifting purposes, **two standard holes** are specially designed for hoisting. **Do not lift a fan by the shaft, motor or, impeller.** Care must be exercised in handling the equipment during installation to prevent damage or distortion, which will seriously affect operation.

## FOUNDATIONS & DUCT CONNECTION

All essential dimensions are on the fan assembly drawing and should be studied carefully. This fan is a rotating piece of machinery and should be mounted on a rigid and substantial foundation. All fans should be mounted on VIBRATION damping devices. Anti vibration mountings should be selected in consultation with the manufacturer. This ensures smoother operation and longer service life.

Installation should locate as near as possible to main supporting columns structural beams, or walls. Make sure that when the bolts are fully tightened the fan structure is not strained. Check with spirit level that the fan shaft is horizontal where this is applicable.

Effective anti vibration requires **flexible duct** connections and **flexible electrical conduit**. These flexible sleeves or connectors, must be chemical resistance, are use to connect ducting to the fan suction (inlet) and fan thrust sides (outlet). Fan housing should not support heavy ducting except by prior arrangement with the manufacturer.

## DIRECT DRIVE (DD)

Electric motors and other driving equipment must be properly aligned and mounted on the flat base with 2 side locating screws as per figure1 to prevent distortion and allow easy relocation.

Alignment of motor is important and must be checked at all planes. Upon proper alignment, locating pins are inserted as per figure 2 for easy servicing.



Figure 1

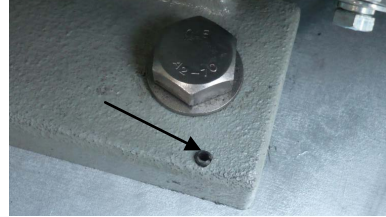


Figure 2

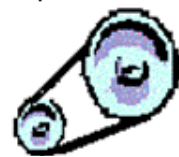
## BELTS DRIVE (BD)

Electric motors and other driving equipment must be properly aligned and mounted on the flat base free from distortion. Slide rails must be positioned so that sufficient allowance is made for adjustment of drive center and changing of belts. Before fitting a pulley, the bore, the shaft and taper bush must be thoroughly cleaned.

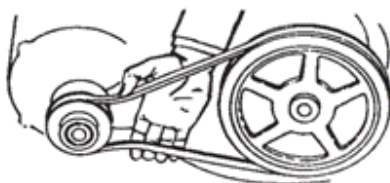
Alignment of belts and pulleys is important and must be checked in all planes.

- 1) Align the sheaves carefully to avoid axial thrust on the bearing.
- 2) Adjust the belt tension to just prevent slippage when the motor is running at full load. Excessive belt tensions will cause unnecessary loading on the bearing.
- 3) On high inertia load applications, belts may be tightened to prevent squealing and slipping during acceleration. Generally, belts should be allowed to slip during acceleration to avoid the possibility of overloading the motor bearing.
- 4) It is essential that all the belts be practically of the same length, as one or two belts longer than the rest will mean that the remainders must carry the entire load. A slight variation is permissible as this will work itself out after a few days and the motor can be tightened by moving it along the slide rails.
- 5) They should be re tighten after the fan has been running for a few days (36hrs) and periodically checked for tension.
- 6) Regular control of belt tension is very important. In any case, the belt tension has to be controlled after the first 100 operating hours, and then every 1000 operating hours or at least once a year. The belt tension is controlled by "pressing the belt with the fingers" (See drawing 1). A good tension is achieved by a total bending of approx. 2-3 cm. Used belts have to be replaced by belts of the same type. Control at the same time the fixation of the belt disc at the axis and the alignment of the belt. (See drawing 2)

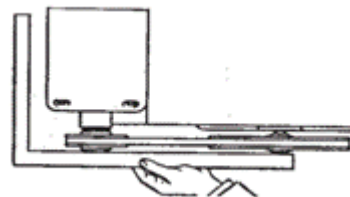
After 36 hours  
of operation



Belts must be  
re-tensioned



1) Max bending allowed is approx. 2-3 cm

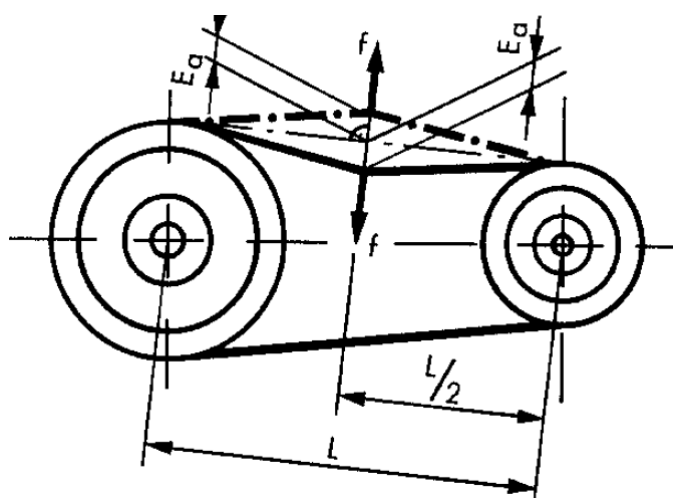


2) Alignment of the belt disc

Belts will be stretched in the course of time, especially during the initial operating phase. Therefore regular checks and re-tightening of the belts are necessary. The values given in the table below as well as those in the separate documentation must be observed. Very high tension increases the bearing load (risk of damage to the bearings), while a very low tension leads to belt slip, and a very low tension leads to belt slip, creaking and additional wear. Re-tightening is possible by parallel shifting of the motor in its rails or lifting the motor pivot. Care has to be taken to see that the

pulleys remain strictly parallel to each other (use a ruler or a piece of string). The correct belt tension can be determined by measuring the deflection  $E_a$  using a spring balance.

If belts are to be replaced it should always be done intermittently (equal length). Replacing a single belt is strictly not permitted. New belts must be fitted with extreme care to avoid overstretching. For new belts the initial tension should be set higher, so that the deflection measures  $0.75 \times$  the tabular value. For re-tightening, the tabular value or the value from the special documentation should be used.



Impression depth per belt  $E_a$  in mm  
Test force per belt  $f$  in N  
Centric distance  $L$  in mm

### 3) Belt tension for standard V-belt types

We recommend the following intervals for re-stretching:

1. Check: 2 to 3 hours after start-up,
  2. Check: 8 to 12 hours after start-up,
  3. Check: 1 week after start-up,
- Further checks according to requirements and operating conditions.

### Pretension for V-belts

The centric distance  $L$  between the pulleys is measured and a defined force  $f$  (see table) is applied at the middle of the belts. Then the deflection  $E_a$  is measured and the tension is adjusted until the  $E_a$  value from the table is reached.

### Example:

A belt drive has 180 Ø as the smallest pulley diameter, a SPB profile and  $L = 1000$  mm.

For a force of 75 N/belt the deflection

$$\text{For re-tightening } E_a = \frac{3,32 \times 1000}{100} = 33,2 \text{ mm}$$

For the initial set up with new belts  $E_a$  should be  $E_a = 0,75 \times 33,2 = 24,9 \text{ mm}$ .

Table 1

| Profile | Test force $f$<br>per V-belt<br><br>$f(N)$ | Diameter<br>of the smallest pulley<br><br>$(d_k \text{ mm})$ | Deflection depth $E_a$<br>Per 10mm center distance<br>$E_a \text{ (mm)}$<br>Standard |
|---------|--------------------------------------------|--------------------------------------------------------------|--------------------------------------------------------------------------------------|
| SPZ     | 25                                         | $56 \leq 71$                                                 | 3,19                                                                                 |
|         |                                            | $> 71 \leq 90$                                               | 2,86                                                                                 |
|         |                                            | $> 90 \leq 125$                                              | 2,67                                                                                 |
|         |                                            | $> 125$                                                      | 2,47                                                                                 |
| SPA     | 50                                         | $71 \leq 100$                                                | 4,16                                                                                 |
|         |                                            | $> 100 \leq 140$                                             | 3,58                                                                                 |
|         |                                            | $> 140 \leq 200$                                             | 3,33                                                                                 |
|         |                                            | $> 200$                                                      | 3,19                                                                                 |
| SPB     | 75                                         | $112 \leq 160$                                               | 3,90                                                                                 |
|         |                                            | $> 160 \leq 224$                                             | 3,32                                                                                 |
|         |                                            | $> 224 \leq 355$                                             | 2,89                                                                                 |
|         |                                            | $> 355$                                                      | 2,73                                                                                 |

The V belt drives, which connect the driving mechanism to the fan, create potential DANGER to the personnel and suitable guards should be provided. Bearing assemblies should be covered so that no rotating element can snag clothing or skin. Any open sheaves, pulleys, belts and other similar transmission device should be enclosed by guards.

## WIRING AND GROUNDING



- 1) Electric starting equipment should include fuses; overload and under voltage protection selected to suit starting time and full load current and should conform fully to local electrical regulations.
- 2) Stators winding connections should be made according to the connection diagram shown on the nameplate or in accordance with the wiring diagram attached inside the terminal box.
- 3) Cables used should be capable of carrying the full load current of motor. Terminal \ screw should be properly tightened.

## BEFORE STARTING UP OF FAN

Before starting the motor for the first time, check that the wiring, fusing and grounding have been made properly. Check also the insulation resistance, power supply and mechanical freedom of the motor.

### NOTE:

Had the motor been stored for a long time, check the stators winding insulation resistance with 500 V DC Megger before installation. If the resistance has dropped below 10 Mega ohms, dry up the motor in an ambient air temperature of 85 degrees C and continue the process until the resistance increases again.

Assuming that the equipment has been enclosed, properly installed and that a check has been made for tightness of all hardware and mounting bolts, the plastic fan will be ready to operate after some final safety checks to prevent injury to personnel or damage to equipment.



- 1) Check the fan and motor nameplate for voltage and frequency values.
- 2) Check the motor connections with the connection diagrams.
- 3) Check the motor (DD)/bearing (BD) alignment, proper lubrication, tolerance, locking collars tight, cleanliness, burrs, or corrosion, and water connections and cooling, if required.
- 4) Check keys and wheel set screws for tightness. Check foundation bolts for tightness.
- 5) Check housing, impeller and duct work for extraneous and debris. Secure all access doors.
- 6) Check wheel position for proper clearance at inlet.
- 7) Turn wheel over by hand, if possible, to see that it rotates freely without hitting the housing.
- 8) Shaft motion may exhibit some resistance in the beginning due to the tight chemical resistance seals but this must be regarded as normal.
- 9) Cover the outlet flange by means of a board to lessen starting load on the driver. The inlet should be left open unless Inlet Volume Control or Damper is available.
- 10) "Bump" with driver, check for rotation in proper direction.

Another potential hazard is the ability of the fan to suck loose material as well as air. Loose material in the air stream can be a projectile. Suitable guards should be placed over the inlets and outlets of the fans to prevent the entrance of clothing or flesh into the rotation parts.

## STARTING UP OF FAN

- 1) Allow unit to reach full speed, then shut down. During this short period check for vibration or any unusual noise. If any are observed, locate the cause and correct. Do not operate until cause has been corrected.
- 2) Lock the power source in "OFF" position.
- 3) Recheck for tightness of hold down bolts, all set screws and keys, tighten if necessary. Initial start up has a tendency to relieve the tightness of nuts, bolts and set-screws. For BD, pulleys and drive must be checked.
- 4) Assuming the fan operates satisfactorily, the run in period should be at least eight hours. For BD, bearing should be observed a minimum of once each hour during the first eight hours of operation. Friction may cause bearings to heat up. There need be no concern if the bare hand can be held on the bearing for five seconds.
- 5) When the motor has been operated under load for a short period of time, check that the operating current tally with the name plate current.
- 6) Any access door in the housing should not be opened when the fan is in operation.
- 7) For BD, re check the belts tension after 24 hours and 1 week.

## FAN MAINTENANCE

To insure long life and trouble free service, a frequent and regular check of all lubricants on bearings BD / couplings DD should be made. Sleeve bearings should be drained, flushed and refilled with clean oil after the first month and each six-months thereafter.

Inspection of parts for wear should be made at regular intervals but not less than three times each year.

Should excessive noise or vibration develop, check the following possibilities:

- 1) Build up of dirt or foreign matter on the wheel.
- 2) Bolts on bearings housings and driver loose.



- 3) V belt drives improperly aligned, belts must have proper tension (BD).
- 4) Pulleys must be balanced and accurately bored to suit fan and motor shafts diameter (BD).
- 5) Check bearing clearance and alignment (BD).
- 6) Check coupling alignment (DD).
- 7) Check wheel for tightness on the drive shaft.
- 8) Has foreign matter entered fan, causing damage to wheel?
- 9) Is the vibration coming from a source other than the fan?
- 10) Stop the fan and determine if the vibration still exists.
- 11) Disconnect the driver from the fan and operate it by itself to determine if it produces vibration.
- 12) Is there a proper clearance between the wheel and inlets?
- 13) The housing inlet cover on the suction side must be removed with a screwdriver to permit cleaning of those parts.

## FAN BEARINGS (BD only)

One of the important features in the successful operation of a fan is its bearings and lubrication.

- 1) SKF flanged bearings for CHEM 125 to CHEM 400 are provided with permanently lubricated deep groove ball bearings with single row and do not require any maintenance.
- 2) Plummer block units with cast housing (CHEM 450 to CHEM 710) are provided with PEER / NSK self aligning Y-bearing or equivalent are self-lubricated at the factory with special ball bearing grease for 3,000 - 4,000 operating hours to allow run-in and to avoid unnecessarily increase of bearing temperature. Therefore these bearing must be fully re-greased after 3 to 4 months operation.
- 3) SNH-Plummer block housings (CHEM 800 to CHEM 1250 and all CHEM LS series) for SKF / NSK bearing with adapter sleeve or equivalent self aligning roller bearings housing are lubricated at the factory must only be filled to approximately 1/3 with special roller bearing grease for first 36 hours to allow run-in and to avoid unnecessarily increase of bearing temperature. Therefore these bearing must be **fully re-greased at site by maintenance contractor** after installation and commissioning.
- 4) It is advisable to clean the bearings with gasoline prior to refilling. Excessive filling will unnecessarily increases bearing temperature, which should not exceed 80 degrees C.
- 5) Trained personnel shall only carry out bearing maintenance.
- 6) Lubrication intervals depend on the speed of the motors and will vary between approximately 1000 hours for 2 pole (2800 / 3600RPM) motors to approximately 3000 hours for 4~8 pole (750~1750RPM) motors, based on correctly fitted bearings, no overload, running under good, clean conditions and under normal ambient temperatures.
- 7) The grease recommended is Shell Oil Co. production Shell GADUS S2 V100 3 for Class E Insulation. Re-lubrication intervals for normal types of services are 6 months.



## CLEANING AND REPLACING BEARINGS (BD only)

When dismantle the housing, the bearings should be cleaned off old grease by washing with a grease dissolving solvent.

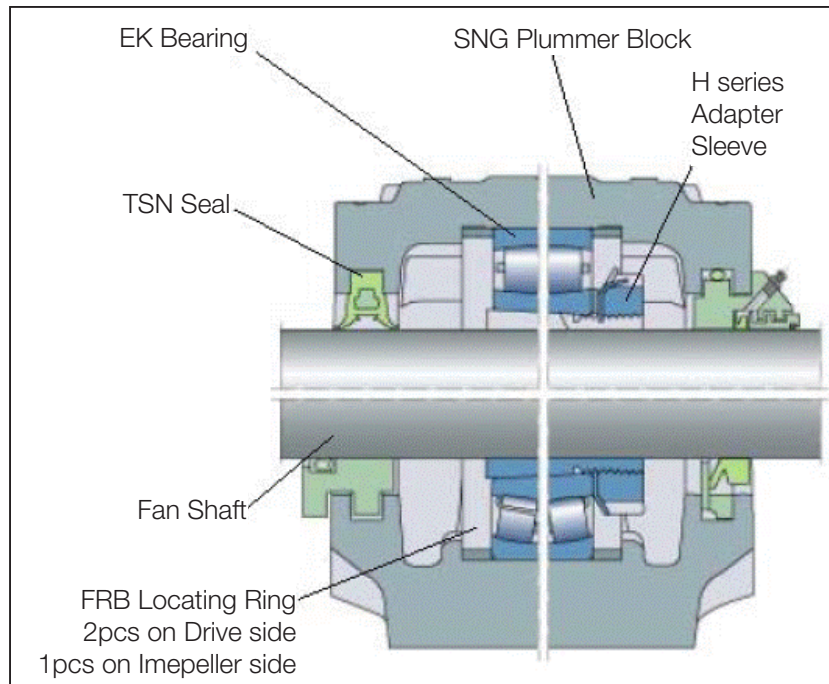
In the event of bearing replacements, the bearing fitted should be of the same size as that shown on the nameplate. The bearing should be an easy and smooth fit in the housing and on the shaft. Care must be taken to ensure that the contacting surfaces are parallel, otherwise damages may result.

## MOUNTING SNL HOUSINGS WITH DOUBLE-LIP SEALS

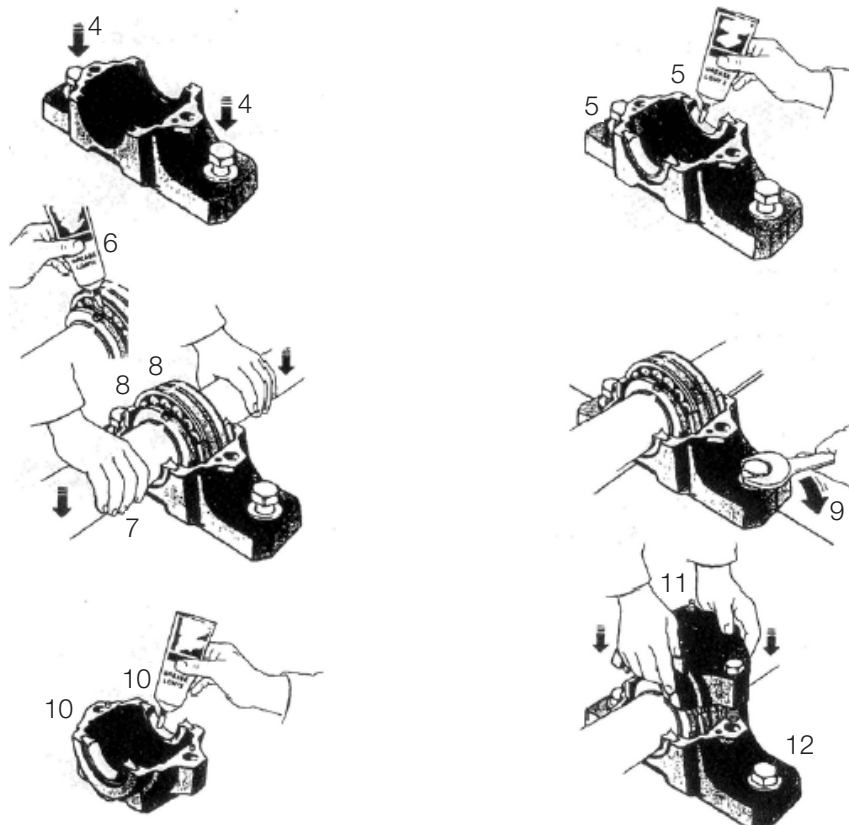
Before starting installation work, the following instructions should be carefully read.

1. Ensure that the environment is clean. Check the dimensional and form accuracy of the shaft seating.
2. Check that the surface roughness of the support surface  $R \leq 12.5\mu\text{m}$ . The flatness (planicity) tolerance should be to IT7. For moderate demands IT8 may be satisfactory.
3. If the bearing is mounted on an adapter sleeve, determine the position of the housing. The grease nipple arranged at one side of the housing cap (for improved lubrication) should always be at the side opposite to the sleeve nut. It is necessary to consider the complete housing as the base and cap will only fit together as supplied.
4. Position the housing on the support surface. Fit the attachment bolts but do not tighten them.
5. Insert one seal half in each of the grooves in the housing base. Fill the space between the two sealing lips with grease. If the housing is to be used at the end of a shaft, insert an end cover at one side instead of the seal half.
6. Mount the bearing on the shaft-either directly on a stepped shaft or using an adapter sleeve. Completely fill the bearing with grease. The remainder of the recommended grease quantity should be put in the housing base at the sides.

7. Lay the shaft with bearing in the housing base.
8. Put one locating ring (when needed) at each side of the bearing.  
NB. Locating rings are only used for locating bearing arrangements, except for CARB bearings which, although always non-locating, must always be mounted with locating rings.
9. Carefully align the housing base. Vertical markings at the middle of the side faces and ends of the housing base can facilitate this. Then lightly tighten the attachment bolts.
10. The remaining seal halves should be inserted in the seal grooves in the housing cap and the space between the sealing lips filled with grease.
11. The housing cap should be placed over the base and the cap bolts (to join cap and base) tightened to the torque specified in picture. The cap and base of one housing are not interchangeable with those of other housings. The cap and base should be checked to see that they bear the same identification.
12. Fully tighten the attachment bolts in the housing base. Recommended tightening torques are given in picture.



### CHEM 800~1250 Plummer Block Bearing Mounting





## MOTOR (For DD and BD)

### MOTOR AND TEMPERATURE RISE

Standard motors have a unity service factor. Temperature rise of class B insulation motors' (TEFC) stators windings, measured by resistance method, should not exceed 80 degrees C, at the ambient temperature of 40 degrees C.

Permissible temperature rise (measured by resistance method) for other classes of Insulation motors are:

| INSULATION CLASS | PERMISSIBLE TEMP. RISE (DEGREE C) |
|------------------|-----------------------------------|
| A                | 60                                |
| E                | 75                                |
| F                | 100                               |
| H                | 125                               |

## MOTOR MAINTENANCE

Normal maintenance consists of inspection, cleaning and lubrication at regular intervals.

Efficient operation of a motor depends heavily on correct installation and regular maintenance.

During the first few months of service, careful observance of the new motor in the following areas may help prevent service breakdown.

### MOTOR MECHANICAL MAINTENANCE

- 1) Ensure that all external cables are adequately cleaned and secured and that there is no evidence of chafing.
- 2) Check that all terminals are clean and tight.
- 3) Ensure that all bearing are not overheated and that the motor runs smoothly and quietly. Also ensure that these are in good conditions and are lubricated properly.
- 4) Check that fixing bolts and/or slide rails, pulleys, couplings, etc. are securely fixed.
- 5) Ensure that there is no mechanical obstruction to prevent rotation.
- 6) Keep the motor free from oil, dirt and dust. Do not allow tools, oilcans, pieces of rags, etc. to lie around or on the motor.

### MOTOR ELECTRICAL MAINTENANCE

- 1) Ensure that all windings are not overheated.
- 2) Compare the actual load current with the full load current given on the nameplate to ensure that the motor is not excessively overloaded.
- 3) Ensure that the phases are balanced, i.e., no single phasing defects are present.

### **WARNING:**

Prior to any mechanical maintenance procedures, disconnect all power sources to the motor and its accessories.

## ROUTINE MOTOR INSPECTIONS

- 1) Check the motor's mechanical connections every three to six months, as well as conductor connections, and the resistance of winding insulation coatings.
- 2) Hold a general inspection as indicated above, recommended at three yearly intervals for motor operation in normal service conditions.
- 3) Following an inspection or repair, give the motor a test run to check its specifications against an objective standard.

## GREASING

- 1) Wipe the hand operated grease gun fittings and the regions around the motor and bearing fitting clean.
- 2) Remove the Relief Plug and free the Relief hole of any hardened grease.
- 3) Add grease with the motor or bearing stationary until new grease is expelled through the relief hole (or grease discharge port).
- 4) Run the motor for about ten minutes with the relief plug removed to expel excess grease.
- 5) Clean and replace the relief plug.

### **WARNING:**

Do not allow any grit to enter with the grease, as this will ruin the bearing.

Do not over grease or under grease, as the former will cause unnecessary over heating of the bearings while the latter will cause running trouble.

Bearings should not be driven off the shaft, as this will damage either the shaft or the bearing itself. It is recommend that bearings once removed should not be used again.

## MOTOR BEARING SERVICE INTERVALS

The roller bearings of the standard AC motors are basically equipped with a permanently sealed lubrication system consisting of a high-quality, temperature-resistant, lithium-based roller bearing grease (melting point approximately 160°C). The amount of lubricant supplied to the bearing by the motor manufacturer is sufficient for 10,000 to 20,000 operating hours.

Unfavourable operating conditions, such as permanently lengthy operating periods, changes in bearing loads etc., will require careful monitoring of the motor bearings. The service intervals or lubrication deadlines and amounts is dependent upon the motor's operating conditions, the rotary speed and size of bearing.

Since only the construction size and rotary speed of the motors are usually known, the service intervals specified in the adjacent table should be applied. They refer to a coolant temperature of 40° C in the case of horizontal fitting (construction form B3). The service intervals are to be put back by 1/3 in the case of vertical fitting. You should consult the manufacturer without fail in the event that motor repairs are required within the warranty period.

| Motor<br>size | Service intervals operating hours for |                        |                                | Kind of Grease<br>Model                                                       |
|---------------|---------------------------------------|------------------------|--------------------------------|-------------------------------------------------------------------------------|
|               | 3000 min <sup>-1</sup>                | 1500 min <sup>-1</sup> | 1000 and 750 min <sup>-1</sup> |                                                                               |
| 56            | 20000                                 | 20000                  | 20000                          | Shell Alvania RL3<br>or Mobil Polyrex<br>or Li-Base Grease<br>eg. MOBILUX EP2 |
| 63            | 20000                                 | 20000                  | 20000                          |                                                                               |
| 71            | 20000                                 | 20000                  | 20000                          |                                                                               |
| 80            | 18000                                 | 20000                  | 20000                          |                                                                               |
| 90            | 16000                                 | 20000                  | 20000                          |                                                                               |
| 100           | 14000                                 | 20000                  | 20000                          |                                                                               |
| 112           | 14000                                 | 20000                  | 20000                          |                                                                               |
| 132           | 11000                                 | 20000                  | 20000                          |                                                                               |
| 160           |                                       | 20000                  | 20000                          |                                                                               |
| 180           |                                       | 20000                  | 20000                          |                                                                               |
| 200           |                                       | 18000                  | 20000                          |                                                                               |
| 225           |                                       | 18000                  | 20000                          |                                                                               |
| 250           |                                       | 18000                  | 20000                          |                                                                               |
| 280           |                                       | 18000                  | 20000                          |                                                                               |

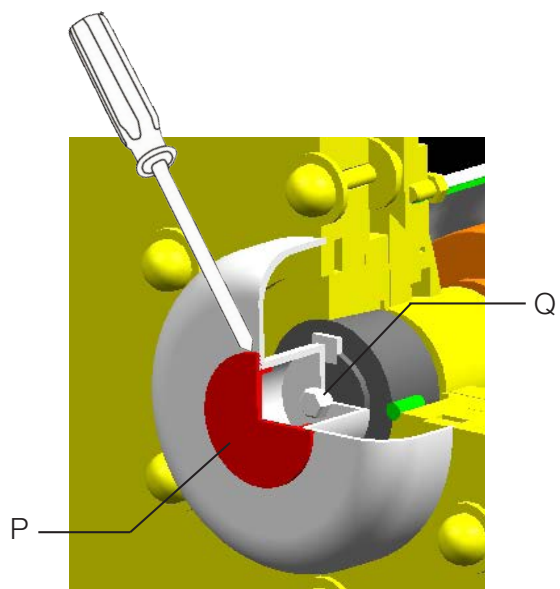
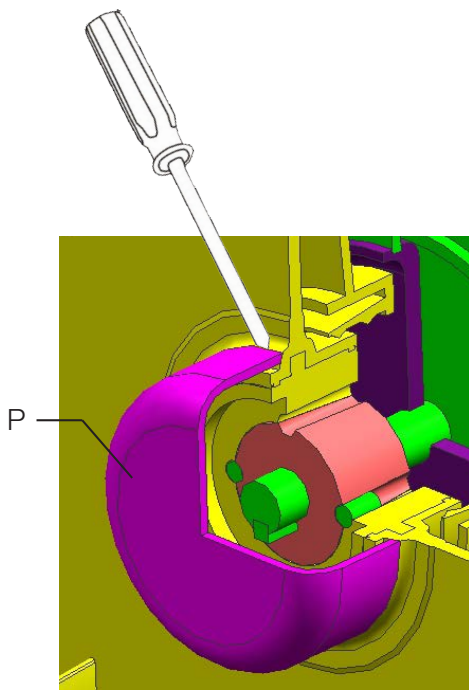
Service intervals for motor bearings

## TO REMOVE AND TO RE-INSTALL IMPELLER

(To be carried out by WOLTER service agent only)

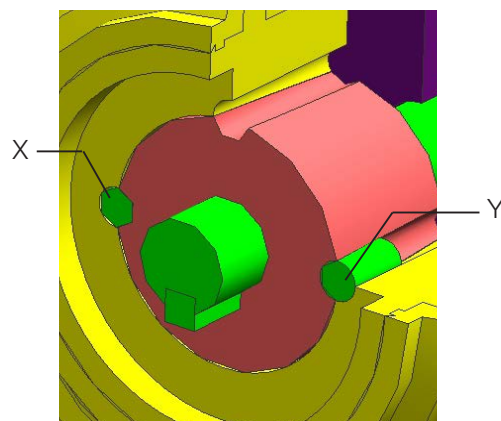
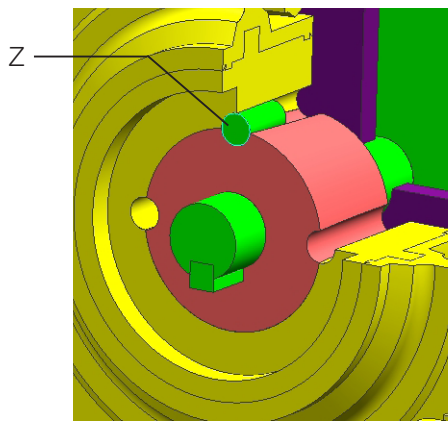
### To Remove "Hub Cover"

- Carefully remove the "cap" (P) with a screwdriver. Dented or damaged Cap must be replaced.
- Loosen the Stainless Steel bolt to remove the "Hub cover" (Q). (CHEM450 to 1250 only)



### To unlock / loosen the Taper Bush

- Loosen the 2 setscrews (X&Y) with Allen keys.
- Use one of the setscrews (Z), to eject the bush to loose position. If in doubt, check with taper bush supplier on removing taper bush.



### To lock / tighten the Taper Bush

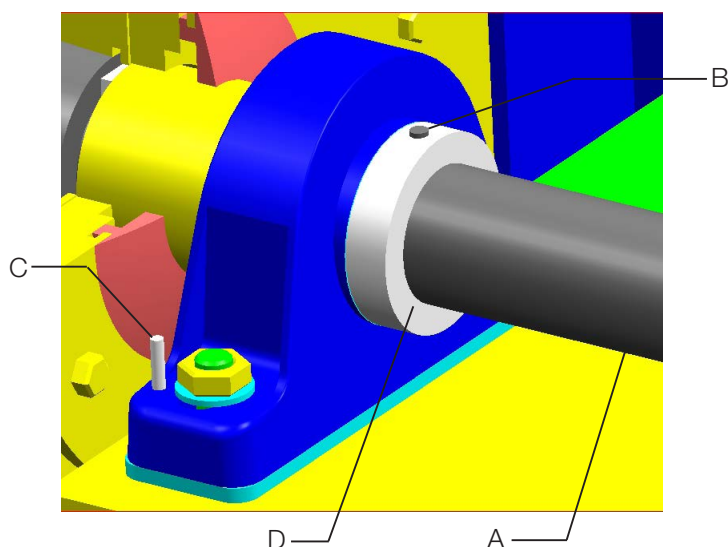
- Ensure all surfaces are properly cleaned.
- REMOVE the ejecting setscrew (Z).
- With the other setscrew (X&Y), lock it properly but allow shaft to protrude a correct depth for "Hub Cover" sitting (CHEM450 to 1250). TIGHTEN the setscrews (X&Y) to lock the Shaft and Taper Bush. If in doubt, check with taper bush supplier on tightening taper bush.

## TO REMOVE THE PILLOW BLOCK OR FAN / COUPLING SHAFT

- Remove the fan impeller and carefully place in safe location to avoid damage.
- Apply "thinner" to the shaft (A) to dilute and clean the black epoxy paint near the drive end. (CHEM 450 to 1250 only). Polish if necessary.
- Apply "de-bonded" on both the bearing setscrew (B). Unscrew the ring (CHEM 450 to 710 only).
- Remove locating Pins (C) and loosen the front and back Pillow blocks bolts and nuts. Marking on (D) may be necessary to identify the front and back Pillow block position.
- Slide and remove both the pillow blocks. Front pillow block toward the impeller side and the other toward the drive side.

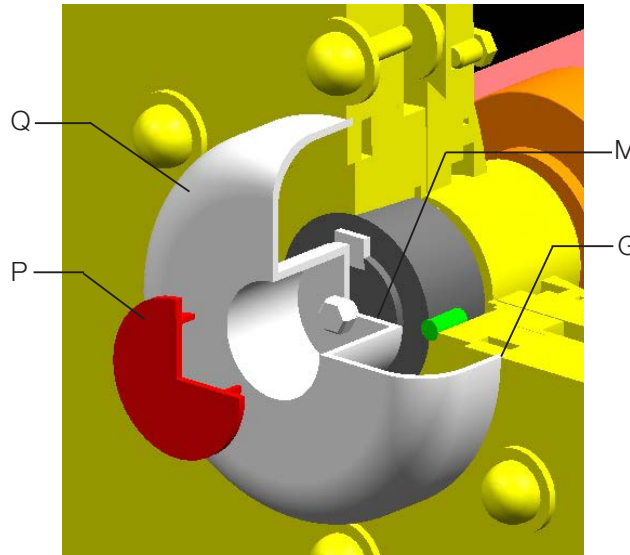
### To replace the Pillow Blocks and Fan shaft in Position.

- Ensure the Steel Pedestal, Plastic Shims, Pillow Blocks, bearing and shaft are properly cleaned.
- Slide the front and back Pillow Blocks onto the shaft in correct position (D) as marked.
- Place the plastic shims (if any) on the steel pedestal. Use the locating pins (C) secure the pillow block onto the pedestal and loosely secure them with bolts and nuts.
- If using the original shaft (A), tighten the bearing locking ring & setscrew (B) to the shaft locating holes. If using new shaft, locating hole need to be mark and drill at correct position and tighten with setscrew. Later to apply a layer of **quick dry glue** to the top of the set -screws.



## TO RE-PLUG THE "HUB COVER" AND "CAP" (CHEM400 TO CHEM1250 ONLY)

- Re-check the "Hub Cover" sit correctly on the shaft end with maximum **1-mm** gap (M).
- Impeller groove (G) must be properly cleaned and filled with **sealant**.
- Place the "Cover" (Q) and tighten with a Stainless steel blot and spring washer.
- Ensure surfaces are cleaned and "Cap" (P) **is not damaged** (Replace as necessary). Plug in the "Cap" with a thumb push.



## RECOMMENDED SAFETY CHECKS

**VISUAL INSPECTION** (At least every six months, more often at the initial stage)

Proper inspection for damage and corrosion of silencers, impeller, motor, cable, connections, suspension and vibration dampers. Damages, especially to the surface protection, must be eliminated, before the damage becomes worse.

**NOISE CHECK** (every 6 months, more often at the initial stage)

The smooth functioning can be ascertained by checking noise and heating. The noises generated at the start and while stopping can be compared with those of similar fans.

**INSPECTION OF MOUNTING** (Every 6 months, more often at the initial stage)

Careful inspection of all bearing / coupling parts and screw connections. All nuts must be secured against loosening and fixed with correct torque. Damaged surface protection at the screw connections should be rectified.

## STANDARDS SPARE PARTS - BEARING

| Model             | Shaft Dia (mm) | Bearing Replacement Model No.                                |
|-------------------|----------------|--------------------------------------------------------------|
| CHEM 125 to 400   | 24             | Flange bearing block c/w 6305-2RS1                           |
| CHEM 450 to 560   | 45             | HCP209-45mm c/w rubber seal (2RS1)                           |
| CHEM 630 to 710   | 60             | HCP212-60mm c/w rubber seal (2RS1)                           |
| CHEM 800 to 1000  | 70             | SNH/SNG 516 –70 mm, 22216EK, H316, TSN516G, 2 x FRB12.5/140  |
| CHEM 1120 to 1250 | 80             | SNH/SNG 518 – 80 mm, 22218EK, H318, TSN518G, 2 x FRB12.5/160 |

## Status - and Standard Maintenance Protocol

|                                                                                                                                                                             |                         |                 |             |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|-----------------|-------------|
| <b>Profile Name:</b>                                                                                                                                                        | <b>Maintenance No.:</b> |                 |             |
| <b>Working Step</b>                                                                                                                                                         | <b>Machine No.:</b>     |                 |             |
| <b>Maintenance &amp; Visual Checking (at least every 3 months)</b>                                                                                                          |                         | <b>Examiner</b> | <b>Date</b> |
| - Bearing status checked / re-greased                                                                                                                                       | √ / X                   |                 |             |
| - Shaft seal checked / re-greased                                                                                                                                           | √ / X                   |                 |             |
| - Belt tension checked                                                                                                                                                      | √ / X                   |                 |             |
| - Flexible connections checked for leakage                                                                                                                                  | √ / X                   |                 |             |
| - Vibration values of motor B-bearing measured:<br>horizontal / vertical / axial<br>.....mm/s .....mm/s .....mm/s                                                           | √ / X                   |                 |             |
| - Vibration values of casing measured: (≤ 4,5 mm/s: good)<br>horizontal / vertical / axial (≥ 9,0 mm/s: caution)<br>.....mm/s .....mm/s .....mm/s (≥ 12,5 mm/s: switch off) | √ / X                   |                 |             |
| - Sound pressure level measured (3 m / 45° removed from suction)<br>.....dB(A)                                                                                              | √ / X                   |                 |             |
| - Electrical values measured:<br>Voltage / Frequency.....V / ..... Hz<br>Current Phase U / V / W ..... A / ..... A / ..... A                                                | √ / X                   |                 |             |
| - Visual check for corrosion (possible rectification of surface damages)<br>- Casing<br>- Impeller                                                                          | √ / X                   |                 |             |
| - Visual check for corrosion<br>- Motor                                                                                                                                     | √ / X                   |                 |             |
| Damages checked<br>- Casing<br>- Impeller                                                                                                                                   | √ / X                   |                 |             |

## Commissioning checklist

|                                                                                                                             |                                                                             |                        |             |
|-----------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------|------------------------|-------------|
| <b>Name of Project / Machine Number:</b>                                                                                    |                                                                             | <b>Maintenance No.</b> |             |
| <b>WORKING STEPS</b>                                                                                                        | <b>FAN TYPE</b>                                                             | <b>EXAMINER</b>        | <b>DATE</b> |
|                                                                                                                             | <b>Radial</b>                                                               |                        |             |
| <b>Maintenance (at least every 1 months)</b>                                                                                |                                                                             |                        |             |
| - Bearing status checked / re-greased                                                                                       | X                                                                           |                        |             |
| - Shaft seal checked / re-greased                                                                                           | X                                                                           |                        |             |
| - Belt tension checked                                                                                                      | X                                                                           |                        |             |
| - Flexible connections checked for leakage                                                                                  | X                                                                           |                        |             |
| - Start-up coupling checked                                                                                                 | X                                                                           |                        |             |
| - Coupling checked (Alignment / rubber elements)                                                                            | X                                                                           |                        |             |
| - Vibration values of casing measured<br>horizontal / vertical / axial<br>.....mm/s      mm/s      mm/s                     | < = 4,5 mm/s : good<br>> = 9,0 mm/s : caution<br>> = 12,5 mm/s : switch off | X                      |             |
| - Sound pressure level measured (3 m / 45° removed from suction)<br>.....dB(A)                                              | X                                                                           |                        |             |
| - Electrical values measured<br>voltage / Frequency.....V / ..... Hz<br>Current Phase U / V / W ..... A / ..... A / ..... A | X                                                                           |                        |             |
| - Visual check for corrosion (possible rectification of paint damages)<br>- Blower<br>- Vibration damper<br>- Impeller      | X                                                                           |                        |             |
| - Visual check for corrosion<br>- Motor                                                                                     | X                                                                           |                        |             |
| - damages checked<br>- Blower<br>- Vibration damper<br>- Impeller                                                           | X                                                                           |                        |             |
| - Check all screw connections                                                                                               |                                                                             |                        |             |



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