

SERVICE & OPERATING MANUAL

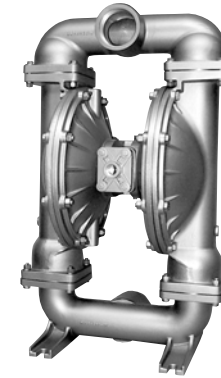


Model S30 Metallic Design Level 1

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****Note: Not ATEX Compliant**



U.S. Patent #
5,996,627; 6,241,487
Other U.S. Patents
Applied for



I M2 c/b T5
II 2GD b T5

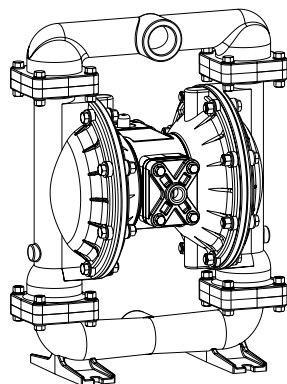


**WARREN
RUPP®**

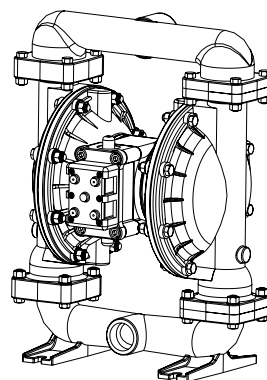
Quality System
ISO9001 Certified

Environmental
Management System
ISO14001 Certified

IDEX
IDEX CORPORATION



Air Inlet Side View



Air Exhaust Side View



I M2 c/b T5
II 2GD b T5

U.S. Patent #
5,996,627; 6,241,487
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SANDPIPER®
A WARREN RUPP PUMP BRAND

S30 Metallic Design Level 1 Ball Valve

**Air-Powered
Double-Diaphragm Pump**

ENGINEERING, PERFORMANCE
& CONSTRUCTION DATA

INTAKE/DISCHARGE PIPE SIZE 3" NPT(internal) / 3" ANSI Flange 3" BSPT Tapered (internal)	CAPACITY 0 to 235 gallons per minute (0 to 889 liters per minute)	AIR VALVE No-lube, no-stall design	SOLIDS-HANDLING Up to .25 in. (6mm)	HEADS UP TO 125 psi or 289 ft. of water (8.6 Kg/cm ² or 86 meters)	DISPLACEMENT/STROKE .94 Gallon / 3.56 liter
⚠ CAUTION! Operating temperature limitations are as follows:					
Materials				Operating Temperatures	
				Maximum	Minimum
Buna N General purpose, oil-resistant. Shows good solvent, oil, water and hydraulic fluid resistance. Should not be used with highly polar solvents like acetone and MEK, ozone, chlorinated hydrocarbons and nitro hydrocarbons.				190°F 88°C	-10°F -23°C
EPDM Shows very good water and chemical resistance. Has poor resistance to oil and solvents, but is fair in ketones and alcohols.				280°F 138°C	-40°F -40°C
Neoprene All purpose. Resistant to vegetable oil. Generally not affected by moderate chemicals, fats, greases and many oils and solvents. Generally attacked by strong oxidizing acids, ketones, esters, nitro hydrocarbons and chlorinated aromatic hydrocarbons.				200°F 93°C	-10°F -23°C
Santoprene® Injection molded thermoplastic elastomer with no fabric layer. Long mechanical flex life. Excellent abrasion resistance.				275°F 135°C	-40°F -40°C
Virgin PTFE Chemically inert, virtually impervious. Very few chemicals are known to react chemically with PTFE: molten alkali metals, turbulent liquid or gaseous fluorine and a few fluoro-chemicals such as chlorine trifluoride or oxygen difluoride which readily liberate free fluorine at elevated temperatures.				220°F 104°C	-35°F -37°C
Viton® Shows good resistance to a wide range of oils and solvents; especially all aliphatic, aromatic and halogenated hydrocarbons, acids, animal and vegetable oils. Hot water or hot aqueous solutions (over 70°F) will attack Viton.				350°F 177°C	-40°F -40°C
Polypropylene				180°F 82°C	32°F 0°C

For specific applications, always consult The Warren Rupp Chemical Resistance Chart

SANDPIPER® pumps are designed to be powered only by compressed air.

Explanation of Pump Nomenclature

S30 Metallic · Design Level 1· Ball Valve

MODEL	Pump Brand	Pump Size	Check Valve Type	Design Level	Wetted Material	Diaphragm/ Check Valve Materials	Check Valve Seat	Non-Wetted Material Options	Porting Options	Pump Style	Pump Options	Kit Options	Shipping Weight lbs. (kg)
S30B1ABBANS000.	S	30	B	1	A	B	B	A	N	S	0	00.	116 (53)
S30B1AEEANS000.	S	30	B	1	A	E	E	A	N	S	0	00.	116 (53)
S30B1AGTANS000.	S	30	B	1	A	G	T	A	N	S	0	00.	116 (53)
S30B1ANNANS000.	S	30	B	1	A	N	N	A	N	S	0	00.	116 (53)
S30B1A1EANS000.	S	30	B	1	A	1	E	A	N	S	0	00.	116 (53)
S30B1AVTANS000.	S	30	B	1	A	V	T	A	N	S	0	00.	116 (53)
S30B1IBBANS000.	S	30	B	1	I	B	B	A	N	S	0	00.	215 (98)
S30B1IEEANS000.	S	30	B	1	I	E	E	A	N	S	0	00.	215 (98)
S30B1IGTANS000.	S	30	B	1	I	G	T	A	N	S	0	00.	215 (98)
S30B1INNANS000.	S	30	B	1	I	N	N	A	N	S	0	00.	215 (98)
S30B1I1EANS000.	S	30	B	1	I	1	E	A	N	S	0	00.	215 (98)
S30B1IVTANS000.	S	30	B	1	I	V	T	A	N	S	0	00.	215 (98)
S30B1IEEANS000.	S	30	B	1	I	E	E	A	N	S	0	00.	215 (98)
S30B1SBBANS000.	S	30	B	1	S	B	B	A	N	S	0	00.	194 (87)
S30B1SGTANS000.	S	30	B	1	S	G	T	A	N	S	0	00.	194 (87)
S30B1SNNANS000.	S	30	B	1	S	N	N	A	N	S	0	00.	194 (87)
S30B1S1EANS000.	S	30	B	1	S	1	E	A	N	S	0	00.	194 (87)
S30B1SVTANS000.	S	30	B	1	S	V	T	A	N	S	0	00.	194 (87)
S30B1HGTANS000.	S	30	B	1	H	G	T	A	N	S	0	00.	235 (107)

Pump Brand

S= SandPIPER®

Pump Size

30=3"

Check Valve Type

B= Ball

Design Level

1= Design Level

Wetted Material

A= Aluminum

I = Cast Iron

S= Stainless Steel

H= Alloy C

Diaphragm Check Valve Materials

1= Santoprene/Santoprene

B= Buna/Buna

C=Viton/PTFE

E=EPDM/EPDM

G=PTFE -Neoprene/PTFE

I= EPDM/Santoprene

N=Neoprene/Neoprene

V=Viton/Viton

Check Valve Seat

A= Aluminum

B=Buna

C= Carbon Steel

E=EPDM

N=Neoprene

S=Stainless Steel

T= PTFE

V=Viton

Non-Wetted Material Options

A= Painted Aluminum

I= Cast Iron

J= Painted Aluminum w/PTFE

Coated Hardware

Y= Painted Aluminum w/

Stainless Steel Hardware

Z= Cast Iron with Stainless

Steel Hardware

Porting Options

N=NPT Threads

B= BSPT (Tapered) Threads

Pump Style

S= Standard

Pump Options

0= None

1= Sound Dampening Muffler

2= Mesh Muffler

3= High temperature Air Valve

w/Encapsulated Muffler

4= High temperature Air Valve

w/Sound Dampening Muffler

5= High temperature Air

Valve w/Mesh Muffler

6= Metal Muffler** ⚠

Kit Options

00.=None** ⚠

P0.=0-30VDC Pulse Output Kit

P1.=Intrinsically-Safe 10-30VDC

Pulse Output Kit

P2.=110/120 or 220/240VAC

Pulse Output Kit

P3.=Intrinsically-Safe 110/120VAC

Pulse Output Kit

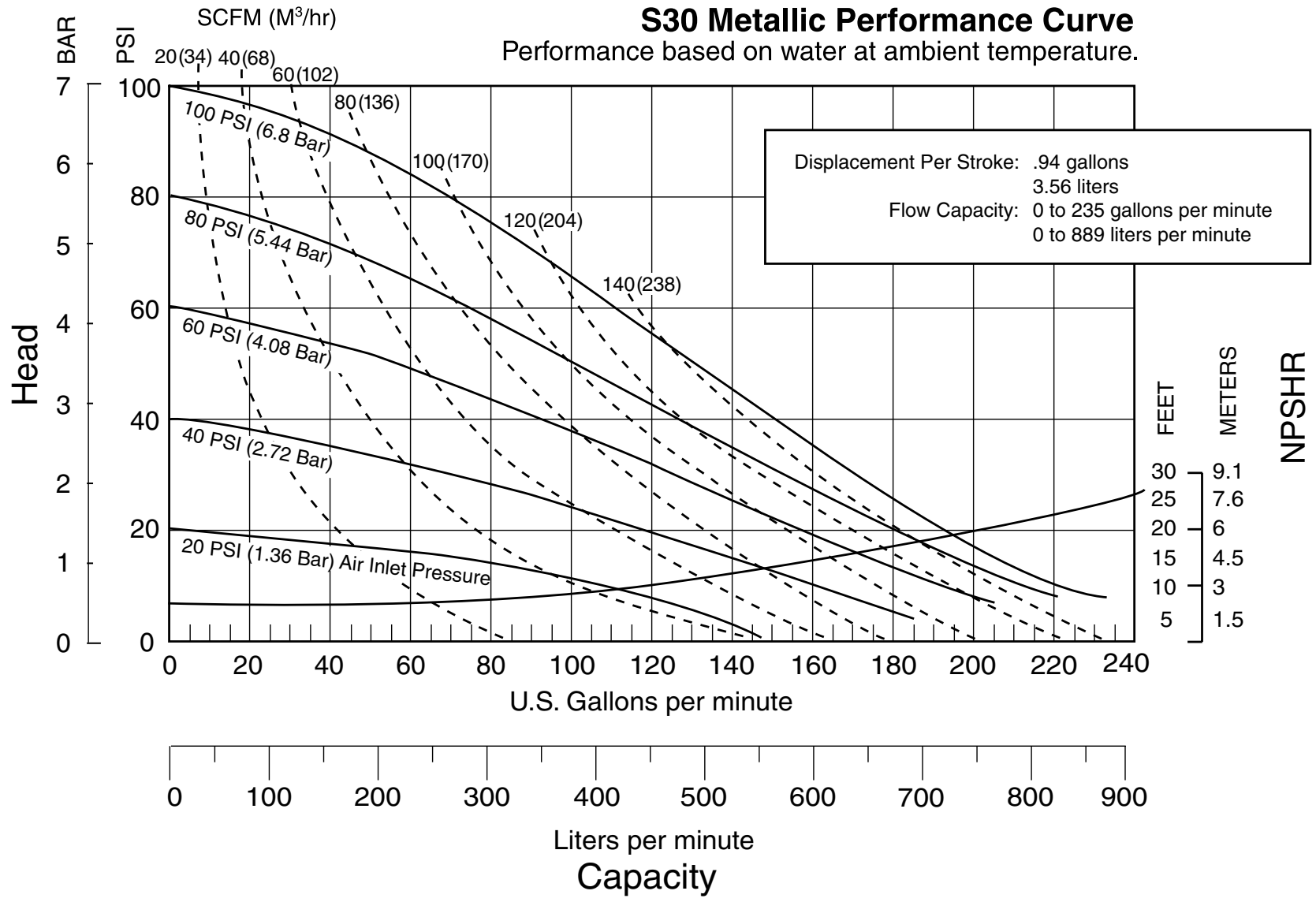
P4.=Intrinsically-Safe 220/240VAC

Pulse Output Kit

SP.=Stroke Indicator Pins

** ⚠ Note: ATEX compliant pumps must be ordered with a metal muffler and no kit options ⚠

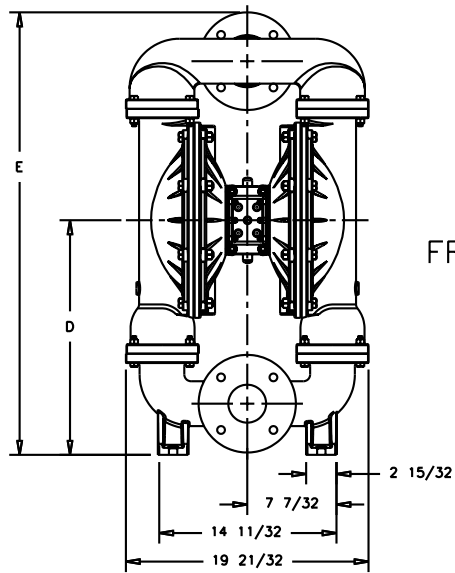
Performance Curve, S30 Metallic Design Level 1



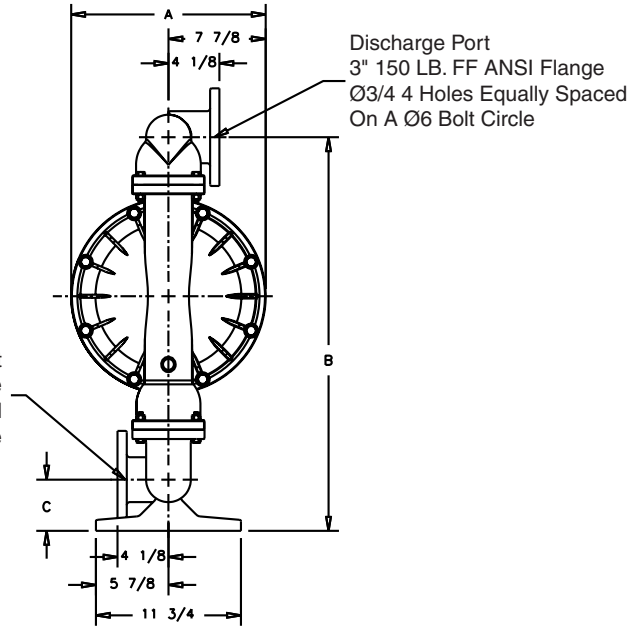
Dimensions: S30 Metallic (Flanged)

Dimensions in Inches

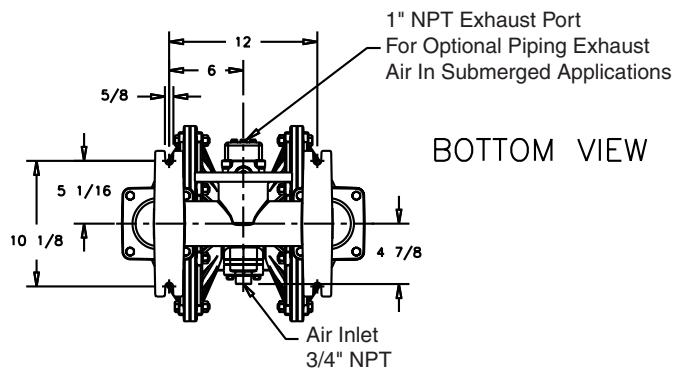
Dimensional Tolerance: $\pm 1/8"$



FRONT VIEW



SIDE VIEW

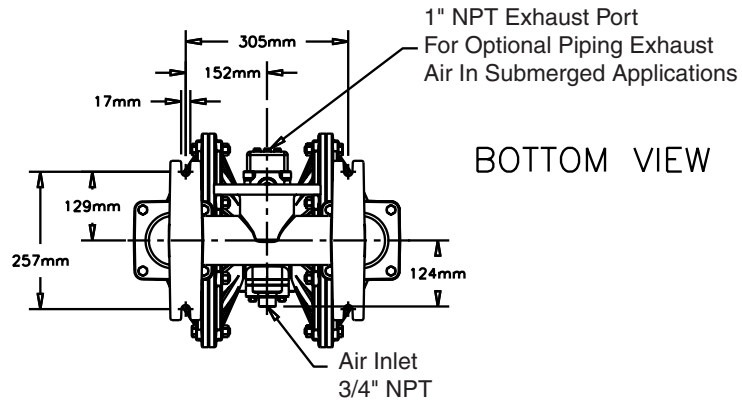
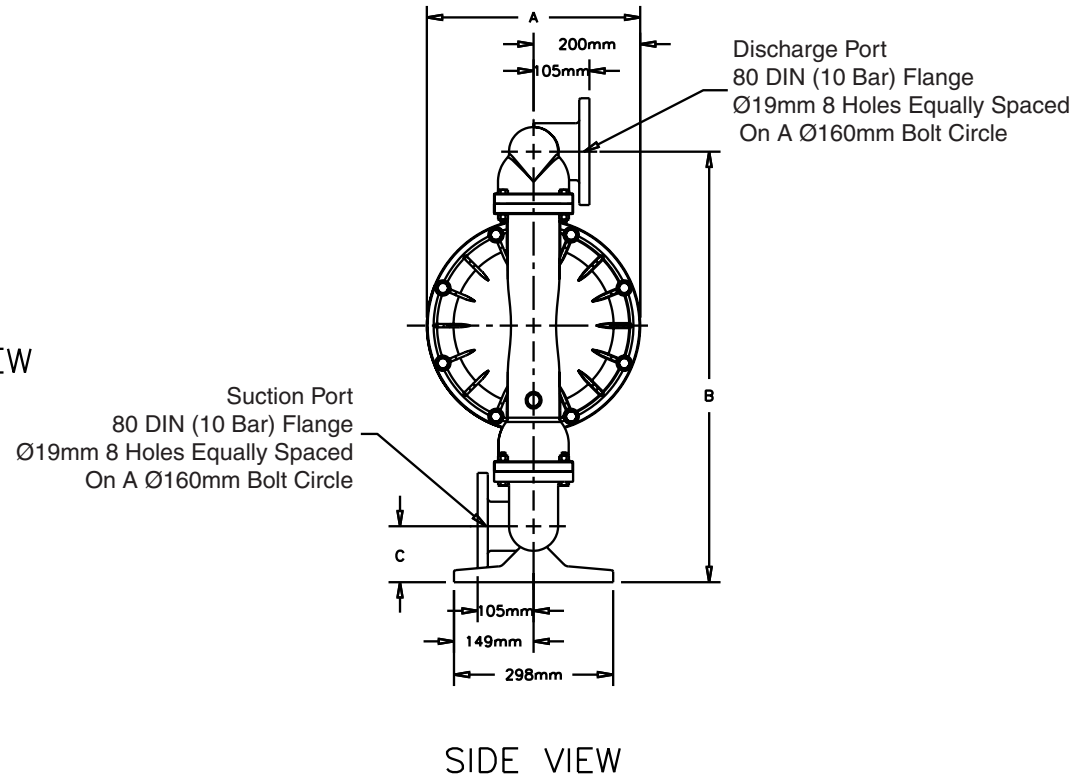
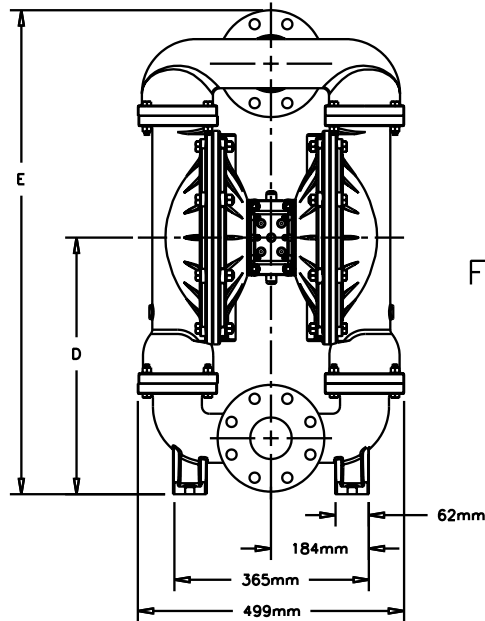


BOTTOM VIEW

DIMENSION	A	B	C	D	E
Encapsulated Muffler	$15 \frac{3}{4}$				
Pulse Output Kit	$16 \frac{1}{32}$				
Aluminum		$31 \frac{3}{4}$	$4 \frac{1}{8}$	$18 \frac{29}{32}$	$35 \frac{11}{16}$
Stainless Steel		$30 \frac{27}{32}$	$4 \frac{7}{32}$	19	$35 \frac{25}{32}$
Mesh Muffler	$16 \frac{5}{8}$				
Sound Dampening Muffler	$16 \frac{5}{8}$				
Metal Muffler	$16 \frac{1}{8}$				

Metric Dimensions: S30 Metallic (Flanged)

Dimensions in Millimeters
Dimensional Tolerance: ± 3mm

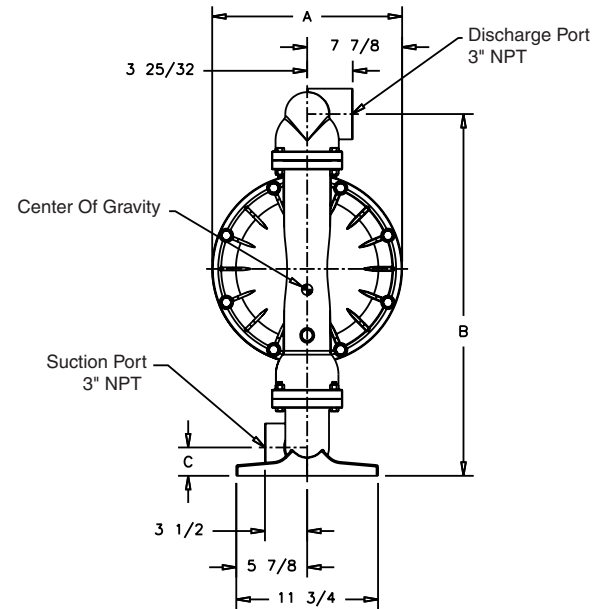
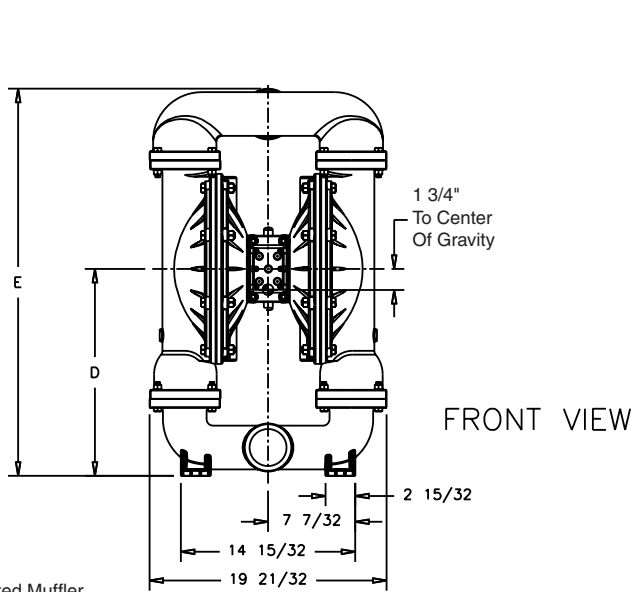


DIMENSION	A	B	C	D	E
Encapsulated Muffler	400				
Pulse Output Kit	407				
Aluminum		806	105	481	906
Stainless Steel		808	107	483	908
Mesh Muffler	422				
Sound Dampening Muffler	422				
Metal Muffler	410				

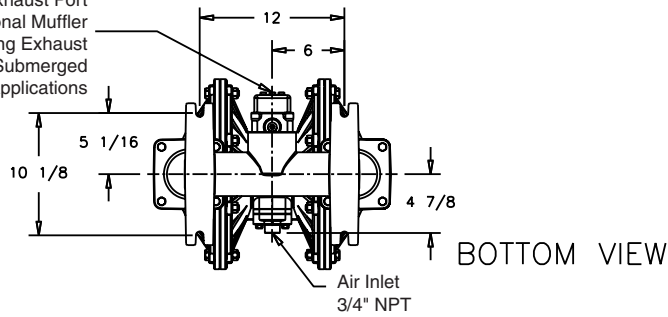
Dimensions: S30 Metallic

Dimensions in Inches

Dimensional Tolerance: $\pm 1/8$ "



Standard Encapsulated Muffler
1" NPT Exhaust Port
For Optional Muffler
Styles Or Piping Exhaust
Air In Submerged
Applications

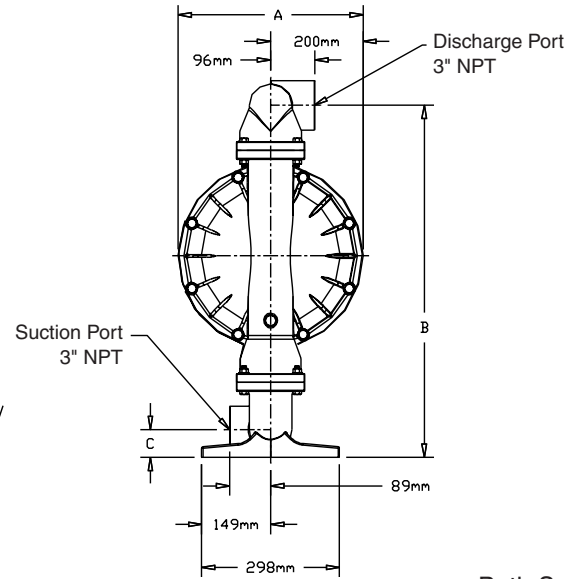
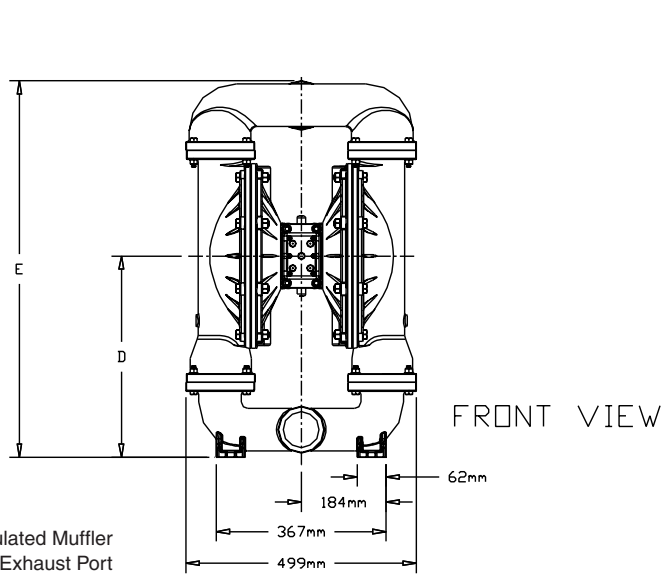


Both Suction And
Discharge Ports Are
Available With
3" BSP Tapered Connection

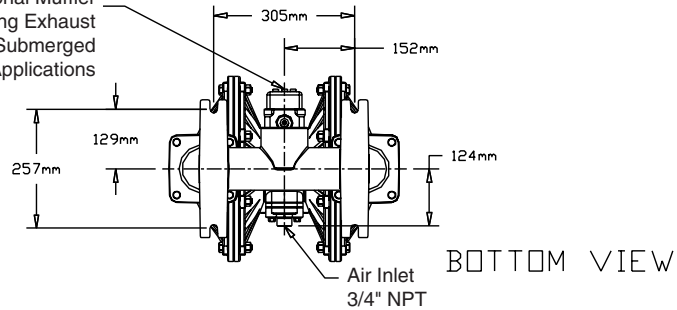
DIMENSION	A	B	C	D	E
Encapsulated Muffler	15 3/4				
Pulse Output Kit	16 1/32				
Aluminum		29 31/32	2 11/32	17 9/64	32 1/16
Stainless Steel		30 3/16	2 9/16	17 23/64	32 9/32
Mesh Muffler	17 3/16				
Sound Dampening Muffler	17 3/16				
Metal Muffler	16 3/4				

Metric Dimensions: S30 Metallic

Dimensions in Millimeters
Dimensional Tolerance: $\pm 3\text{mm}$



Standard Encapsulated Muffler
1" NPT Exhaust Port
For Optional Muffler
Styles Or Piping Exhaust
Air In Submerged
Applications



Both Suction And
Discharge Ports Are
Available With
3" BSP Tapered Connection

DIMENSION	A	B	C	D	E
Encapsulated Muffler	400				
Pulse Output Kit	407				
Aluminum		761	60	435	815
Stainless Steel		767	66	441	821
Mesh Muffler	437				
Sound Dampening Muffler	437				
Metal Muffler	425				

PRINCIPLE OF PUMP OPERATION

This ball type check valve pump is powered by compressed air and is a 1:1 ratio design. The inner side of one diaphragm chamber is alternately pressurized while simultaneously exhausting the other inner chamber. This causes the diaphragms, which are connected by a common rod secured by plates to the centers of the diaphragms, to move in a reciprocating action. (As one diaphragm performs the discharge stroke the other diaphragm is pulled to perform the suction stroke in the opposite chamber.) Air pressure is applied over the entire inner surface of the diaphragm while liquid is discharged from the opposite side of the diaphragm. The diaphragm operates in a balanced condition during the discharge stroke which allows the pump to be operated at discharge heads over 200 feet (61 meters) of water.

For maximum diaphragm life, keep the pump as close to the liquid being pumped as possible. Positive suction head in excess of 10 feet of liquid (3.048 meters) may require a back pressure regulating device to maximize diaphragm life.

Alternate pressurizing and exhausting of the diaphragm chamber is performed by an externally mounted, pilot operated, four way spool type air distribution valve. When the spool shifts to one end of the valve body, inlet pressure is applied to one diaphragm chamber and the other diaphragm chamber exhausts. When the spool

shifts to the opposite end of the valve body, the pressure to the chambers is reversed. The air distribution valve spool is moved by an internal pilot valve which alternately pressurizes one end of the air distribution valve spool while exhausting the other end. The pilot valve is shifted at each end of the diaphragm stroke when an actuator plunger is contacted by the diaphragm plate. This actuator plunger then pushes the end of the pilot valve spool into position to activate the air distribution valve.

The chambers are connected with manifolds with a suction and discharge check valve for each chamber, maintaining flow in one direction through the pump.

INSTALLATION AND START-UP

Locate the pump as close to the product being pumped as possible. Keep the suction line length and number of fittings to a minimum. Do not reduce the suction line diameter.

For installations of rigid piping, short sections of flexible hose should be installed between the pump and the piping. The flexible hose reduces vibration and strain to the pumping system. A Warren Rupp Tranquilizer® surge suppressor is recommended to further reduce pulsation in flow.

AIR SUPPLY

Air supply pressure cannot exceed 125 psi (8.6 bar). Connect the pump air inlet to an air supply of sufficient capacity and pressure required for desired performance. When the air

supply line is solid piping, use a short length of flexible hose not less than 1/2" (13mm) in diameter between the pump and the piping to reduce strain to the piping. The weight of the air supply line, regulators and filters must be supported by some means other than the air inlet cap. Failure to provide support for the piping may result in damage to the pump. A pressure regulating valve should be installed to insure air supply pressure does not exceed recommended limits.

AIR VALVE LUBRICATION

The air distribution valve and the pilot valve are designed to operate WITHOUT lubrication. This is the preferred mode of operation. There may be instances of personal preference or poor quality air supplies when lubrication of the compressed air supply is required. The pump air system will operate with properly lubricated compressed air supply. Proper lubrication requires the use of an air line lubricator (available from Warren Rupp) set to deliver one drop of SAE 10 non-detergent oil for every 20 SCFM (9.4 liters/sec.) of air the pump consumes at the point of operation. Consult the pump's published Performance Curve to determine this.

AIR LINE MOISTURE

Water in the compressed air supply can create problems such as icing or freezing of the exhaust air, causing the pump to cycle erratically or stop operating. Water in the air supply can be reduced by using a point-of-use air dryer

to supplement the user's air drying equipment. This device removes water from the compressed air supply and alleviates the icing or freezing problems.

AIR INLET AND PRIMING

To start the pump, open the air valve approximately 1/2" to 3/4" turn. After the pump primes, the air valve can be opened to increase air flow as desired. If opening the valve increases cycling rate, but does not increase the rate of flow, cavitation has occurred. The valve should be closed slightly to obtain the most efficient air flow to pump flow ratio.

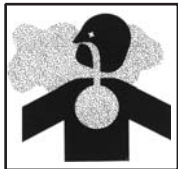
BETWEEN USES

When the pump is used for materials that tend to settle out or solidify when not in motion, the pump should be flushed after each use to prevent damage. (Product remaining in the pump between uses could dry out or settle out. This could cause problems with the diaphragms and check valves at restart.) In freezing temperatures the pump must be completely drained between uses in all cases.

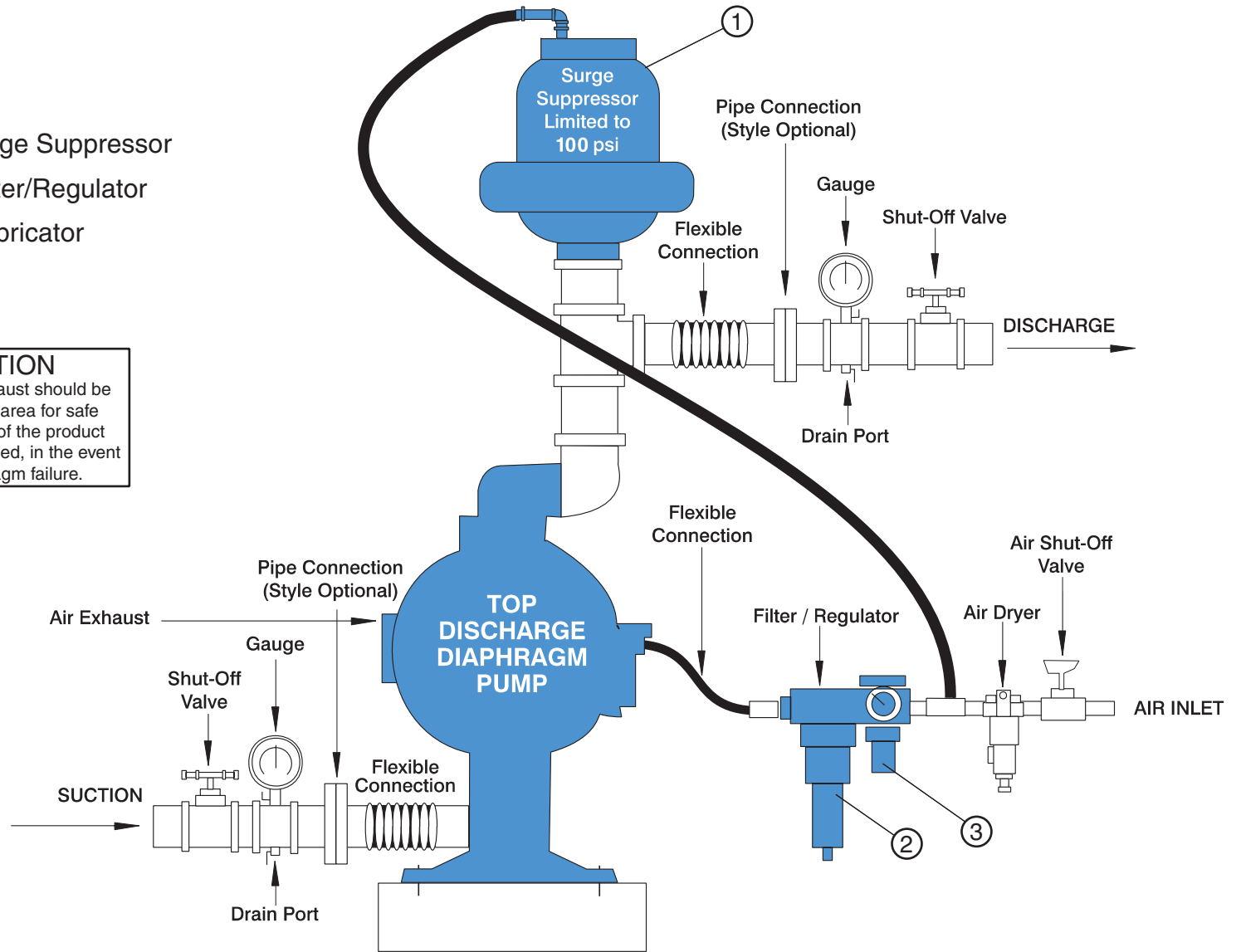
INSTALLATION GUIDE Top Discharge Ball Valve Unit

Available from
Warren Rupp

- ① TA3 or TA80 Surge Suppressor
- ② 020-051-000 Filter/Regulator
- ③ 020-051-001 Lubricator



CAUTION
The air exhaust should be piped to an area for safe disposition of the product being pumped, in the event of a diaphragm failure.



TROUBLESHOOTING

Possible Symptoms:

- Pump will not cycle.
- Pump cycles, but produces no flow.
- Pump cycles, but flow rate is unsatisfactory.
- Pump cycle seems unbalanced.
- Pump cycle seems to produce excessive vibration.

What to Check: Excessive suction lift in system.

Corrective Action: For lifts exceeding 20 feet (6 meters), filling the pumping chambers with liquid will prime the pump in most cases.

What to Check: Excessive flooded suction in system.

Corrective Action: For flooded conditions exceeding 10 feet (3 meters) of liquid, install a back pressure device.

What to Check: System head exceeds air supply pressure.

Corrective Action: Increase the inlet air pressure to the pump. Most diaphragm pumps are designed for 1:1 pressure ratio at zero flow.

What to Check: Air supply pressure or volume exceeds system head.

Corrective Action: Decrease inlet air pressure and volume to the pump as calculated on the published PERFORMANCE CURVE. Pump is cavitating the fluid by fast cycling.

What to Check: Undersized suction line.

Corrective Action: Meet or exceed pump connection recommendations shown on the DIMENSIONAL DRAWING.

What to Check: Restricted or undersized air line.

Corrective Action: Install a larger air line and connection. Refer to air inlet recommendations shown in your pump's SERVICE MANUAL.

What to Check: Check ESADS, the Externally Serviceable Air Distribution System of the pump.

Corrective Action: Disassemble and inspect the main air distribution valve, pilot valve and pilot valve actuators. Refer to the parts drawing and air valve section of the SERVICE MANUAL. Check for clogged discharge or closed valve before reassembly.

What to Check: Rigid pipe connections to pump.

Corrective Action: Install flexible connectors and a Warren Rupp Tranquillizer® surge suppressor.

What to Check: Blocked air exhaust muffler.

Corrective Action: Remove muffler screen, clean or de-ice and reinstall. Refer to the Air Exhaust section of your pump SERVICE MANUAL.

What to Check: Pumped fluid in air exhaust muffler.

Corrective Action: Disassemble pump chambers. Inspect for diaphragm rupture or loose diaphragm plate assembly. Refer to the Diaphragm Replacement section of your pump SERVICE MANUAL.

What to Check: Suction side air leakage or air in product.

Corrective Action: Visually inspect all suction side gaskets and pipe connections.

What to Check: Obstructed check valve.

Corrective Action: Disassemble the wet end of the pump and manually dislodge obstruction in the check valve pocket. Refer to the Check Valve section of the pump SERVICE MANUAL for disassembly instructions.

What to Check: Worn or misaligned check valve or check valve seat.

Corrective Action: Inspect check valves and seats for wear and proper seating. Replace if necessary. Refer to Check Valve section of the pump SERVICE MANUAL for disassembly instructions.

What to Check: Blocked suction line.

Corrective Action: Remove or flush obstruction. Check and clear all suction screens and strainers.

What to Check: Blocked discharge line.

Corrective Action: Check for obstruction or closed discharge line valves.

What to Check: Blocked pumping chamber.

Corrective Action: Disassemble and inspect the wetted chambers of the pump. Remove or flush any obstructions. Refer to the pump SERVICE MANUAL for disassembly instructions.

What to Check: Entrained air or vapor lock in one or both pumping chambers.

Corrective Action: Purge chambers through tapped chamber vent plugs. PURGING THE CHAMBERS OF AIR CAN BE DANGEROUS! Contact the Warren Rupp Technical Services Group before performing this procedure. Any model with top-ported discharge will reduce or eliminate problems with entrained air.

If your pump continues to perform below your expectations, contact your local Warren Rupp Distributor or factory Technical Services Group for a service evaluation.

WARRANTY

Refer to the enclosed Warren Rupp Warranty Certificate.

RECYCLING


Many components of SANDPIPER® Metallic AODD pumps are made of recyclable materials (see chart on page 10 for material specifications). We encourage pump users to recycle worn out parts and pumps whenever possible, after any hazardous pumped fluids are thoroughly flushed.

 I M2 c/b T5
II 2GD b T5




Pump complies with EN809 Pumping Directive and Directive 98/37/EC Safety of Machinery, and ATEX 100a Directive 94/9/EC Equipment for use in Potentially Explosive Environments. For reference to the directive certificates visit: www.warrenrupp.com

IMPORTANT SAFETY INFORMATION



! IMPORTANT
Read these safety warnings and instructions in this manual completely, before installation and start-up of the pump. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.




! CAUTION
Before pump operation, inspect all gasketed fasteners for looseness caused by gasket creep. Re-torque loose fasteners to prevent leakage. Follow recommended torques stated in this manual.




! WARNING
Before maintenance or repair, shut off the compressed air line, bleed the pressure, and disconnect the air line from the pump. The discharge line may be pressurized and must be bled of its pressure.



! WARNING
In the event of diaphragm rupture, pumped material may enter the air end of the pump, and be discharged into the atmosphere. If pumping a product which is hazardous or toxic, the air exhaust must be piped to an appropriate area for safe disposition.




! WARNING
Take action to prevent static sparking. Fire or explosion can result, especially when handling flammable liquids. The pump, piping, valves, containers or other miscellaneous equipment must be grounded. (See page 28)



! WARNING
This pump is pressurized internally with air pressure during operation. Always make certain that all bolting is in good condition and that all of the correct bolting is reinstalled during assembly.



! WARNING
When used for toxic or aggressive fluids, the pump should always be flushed clean prior to disassembly.



! WARNING
Before doing any maintenance on the pump, be certain all pressure is completely vented from the pump, suction, discharge, piping, and all other openings and connections. Be certain the air supply is locked out or made non-operational, so that it cannot be started while work is being done on the pump. Be certain that approved eye protection and protective clothing are worn all times in the vicinity of the pump. Failure to follow these recommendations may result in serious injury or death.



! WARNING
Airborne particles and loud noise hazards. Wear ear and eye protection.

MATERIAL CODES

The Last 3 Digits of Part Number

000 Assembly, sub-assembly; and some purchased items	175 Die Cast Zinc	375 Fluorinated Nitrile	606 PTFE
010 Cast Iron	180 Copper Alloy	378 High Density Polypropylene	607 Envelon
012 Powered Metal	305 Carbon Steel, Black Epoxy Coated	379 Conductive Nitrile	608 Conductive PTFE
015 Ductile Iron	306 Carbon Steel, Black PTFE Coated	405 Cellulose Fibre	610 PTFE Encapsulated Silicon
020 Ferritic Malleable Iron	307 Aluminum, Black Epoxy Coated	408 Cork and Neoprene	611 PTFE Encapsulated Viton
025 Music Wire	308 Stainless Steel, Black PTFE Coated	425 Compressed Fibre	632 Neoprene/Hytrel
080 Carbon Steel, AISI B-1112	309 Aluminum, Black PTFE Coated	426 Blue Gard	633 Viton/PTFE
100 Alloy 20	310 Kynar® Coated	440 Vegetable Fibre	634 EPDM/PTFE
110 Alloy Type 316 Stainless Steel	330 Zinc Plated Steel	465 Fibre	635 Neoprene/PTFE
111 Alloy Type 316 Stainless Steel (Electro Polished)	331 Chrome Plated Steel	500 Delrin 500	637 PTFE , Viton/PTFE
112 Alloy "C" (Hastelloy equivalent)	332 Aluminum, Electroless Nickel Plated	501 Delrin 570	638 PTFE , Hytrel/PTFE
113 Alloy Type 316 Stainless Steel (Hand Polished)	333 Carbon Steel, Electroless Nickel Plated	502 Conductive Acetal, ESD-800	639 Buna-N/TFE
114 303 Stainless Steel	335 Galvanized Steel	503 Conductive Acetal, Glass-Filled	643 Santoprene®/EPDM
115 302/304 Stainless Steel	336 Zinc Plated Yellow Brass	505 Acrylic Resin Plastic	644 Santoprene®/PTFE
117 440-C Stainless Steel (Martensitic)	337 Silver Plated Steel	506 Delrin 150	656 Santoprene Diaphragm and Check Balls/EPDM Seats
120 416 Stainless Steel (Wrought Martensitic)	340 Nickel Plated	520 Injection Molded PVDF Natural color	
123 410 Stainless Steel (Wrought Martensitic)	342 Filled Nylon	540 Nylon	
148 Hardcoat Anodized Aluminum	353 Geolast; Color: Black	541 Nylon	
149 2024-T4 Aluminum	354 Injection Molded #203-40 Santoprene- Duro 40D +/-5; Color: RED	542 Nylon	
150 6061-T6 Aluminum	355 Thermal Plastic	544 Nylon Injection Molded	
151 6063-T6 Aluminum	356 Hytrel	550 Polyethylene	Delrin, Viton and Hytrel are registered tradenames of E.I. DuPont.
152 2024-T4 Aluminum (2023-T351)	357 Injection Molded Polyurethane	551 Glass Filled Polypropylene	Gylon is a registered tradename of Garlock, Inc.
154 Almag 35 Aluminum	358 Urethane Rubber (Some Applications) (Compression Mold)	552 Unfilled Polypropylene	Nylatron is a registered tradename of Polymer Corp.
155 356-T6 Aluminum	359 Urethane Rubber	553 Unfilled Polypropylene	Santoprene is a registered tradename of Monsanto Corp.
156 356-T6 Aluminum	360 Buna-N Rubber. Color coded: RED	555 Polyvinyl Chloride	Rulon II is a registered tradename of Dixion Industries Corp.
157 Die Cast Aluminum Alloy #380	361 Buna-N	556 Black Vinyl	Hastelloy-C is a registered tradename of Cabot Corp.
158 Aluminum Alloy SR-319	363 Viton (Fluorel). Color coded: YELLOW	558 Conductive HDPE	Ryton is a registered tradename of Phillips Chemical Co.
159 Anodized Aluminum	364 E.P.D.M. Rubber. Color coded: BLUE	570 Rulon II	Valox is a registered tradename of General Electric Co.
162 Brass, Yellow, Screw Machine Stock	365 Neoprene Rubber. Color coded: GREEN	580 Ryton	Kynar® is a registered tradename of ATOFINA Chemicals, Inc.
165 Cast Bronze, 85-5-5-5	366 Food Grade Nitrile	590 Valox	Warren Rupp, SANDPIPER, Portapump, Tranquilizer and SludgeMaster are registered tradenames of Warren Rupp, Inc.
166 Bronze, SAE 660	368 Food Grade EPDM	591 Nylatron G-S	
170 Bronze, Bearing Type, Oil Impregnated	370 Butyl Rubber. Color coded: BROWN	592 Nylatron NSB	
	371 Philthane (Tuftane)	600 PTFE (virgin material) Tetrafluorocarbon (TFE)	
	374 Carboxylated Nitrile	601 PTFE (Bronze and moly filled)	
		602 Filled PTFE	
		603 Blue Gylon	
		604 PTFE	

Composite Repair Parts Drawing

AVAILABLE SERVICE AND CONVERSION KITS

- 476-227-000 AIR END KIT (Use with Aluminum Centers)**
Air Valve Assembly, Pilot Valve Assembly, Seals, O-rings, Gaskets, Plungers
- **476-170-000 AIR END KIT (Air Valve with Stroke Indicator Pin)**
Seals, O-ring, Gaskets, Retaining Rings, Air Valve Sleeve and Spool Set, and Pilot Valve Assembly
- 476-171-360 WET END KIT**
Buna Diaphragms, Balls, and Seats.
- 476-171-656 WET END KIT**
Santoprene Diaphragms, Balls and EPDM Seats.
- 476-171-364 WET END KIT**
EPDM Diaphragms, Balls and Seats.
- 476-171-365 WET END KIT**
Neoprene Diaphragms, Balls, and Seats.
- 476-171-633 WET END KIT**
Viton Diaphragms, PTFE Balls and PTFE Seats.
- 476-171-635 WET END KIT**
Neoprene Diaphragms, PTFE Overlay, PTFE Balls and PTFE Seats.
- 475-217-000 MIDSECTION CONVERSION KIT**
(Replaces Aluminum Midsection with Cast Iron Components) Air Inlet Cap, Intermediate Bracket, Inner Chambers, and Inner Diaphragm Plates

HARDWARE KITS

- 475-197-330 Zinc Plated Capscrews, Washers, and Hex Nuts
475-197-115 Stainless Steel Capscrews, Washers, and Hex Nuts

**PULSE OUTPUT KITS

(For use with 530-010-000 mufflers, or piped exhaust)

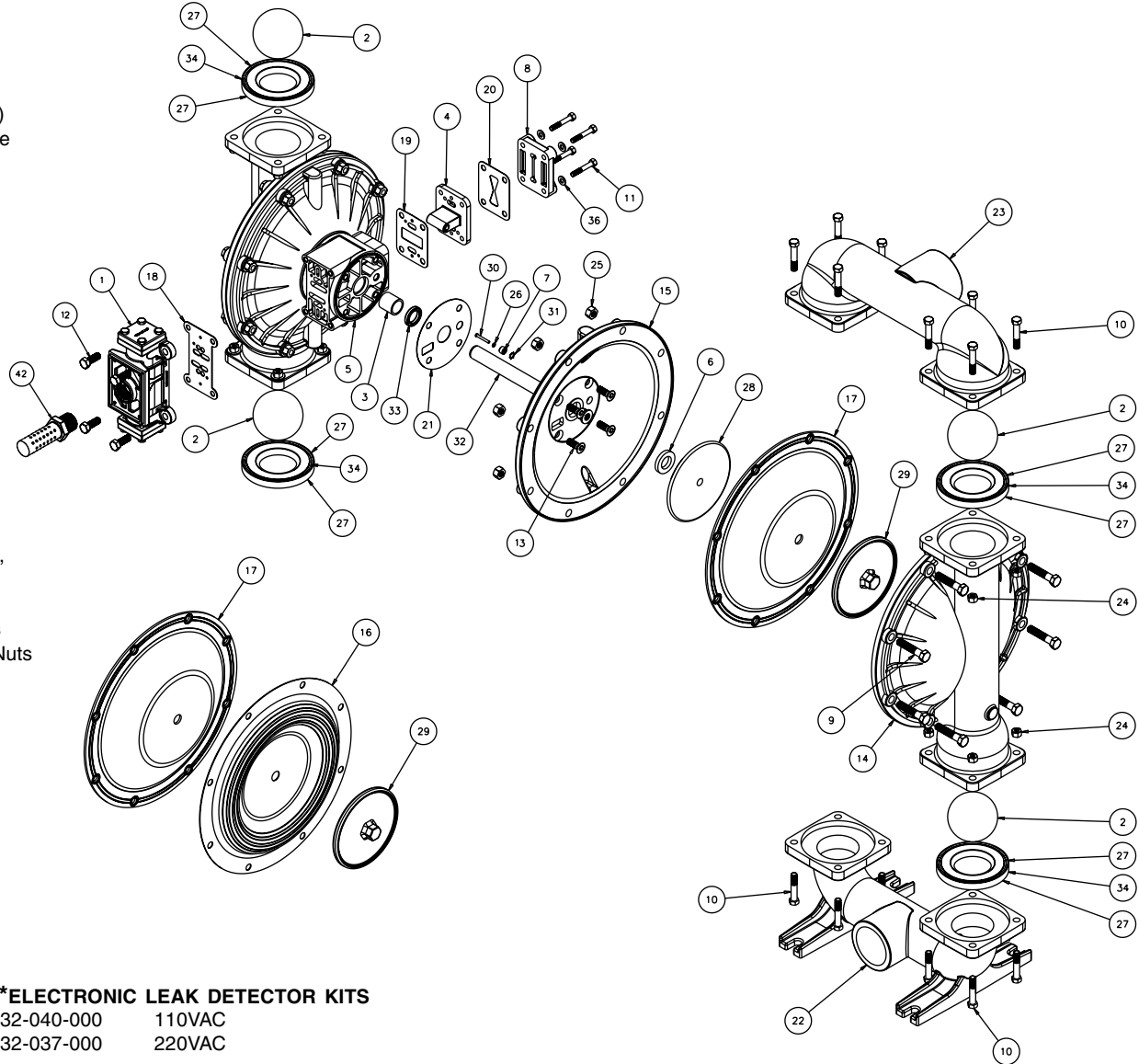
- 475-198-001 DC Kit
475-198-002 DC Intrinsically Safe Kit
475-198-003 110/120VAC or 220/240VAC Kit
475-198-004 110/120VAC Intrinsically Safe Kit
475-198-005 220/240VAC Intrinsically Safe Kit

(For use with encapsulated 530-028-550 muffler)

- 475-198-006 DC Kit
475-198-007 DC Intrinsically Safe Kit
475-198-008 110/120VAC or 220/240VAC Kit
475-198-009 110/120VAC Intrinsically Safe Kit
475-198-010 220/240VAC Intrinsically Safe Kit

**ELECTRONIC LEAK DETECTOR KITS

- 032-040-000 110VAC
032-037-000 220VAC



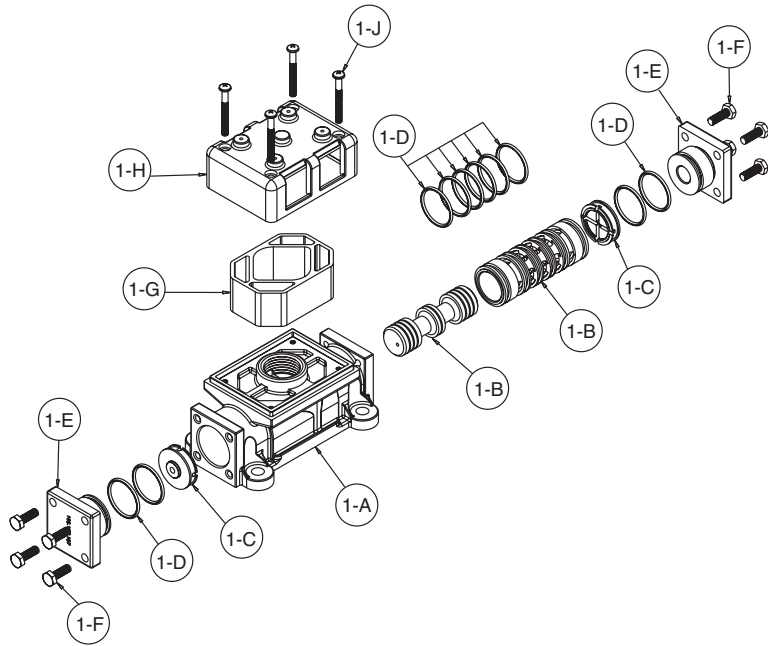
****Note: Pumps equipped with these components are not ATEX compliant**

ITEM	PART NUMBER	DESCRIPTION	QTY	ITEM	PART NUMBER	DESCRIPTION	QTY
1	**031-146-000	Air Valve Assembly	1		518-143-010E	Manifold, Suction 3" BSPT	1
	**031-147-000	Air Valve Assembly	1		518-143-110	Manifold, Suction	1
	**031-173-000	Air Valve Assembly	1		518-143-110E	Manifold, Suction 3" BSPT	1
	031-183-000	Air Valve Assembly	1		518-143-112	Manifold, Suction	1
	031-179-000	Air Valve Assembly (Cast Iron Centers Only)	1		518-143-112E	Manifold, Suction 3" BSPT	1
2	050-014-354	Ball, Check	4	23	518-144-156	Manifold, Discharge	1
	050-014-360	Ball, Check	4		518-144-156E	Manifold, Discharge 3" BSPT	1
	050-014-364	Ball, Check	4		518-144-010	Manifold, Discharge	1
	050-014-365	Ball, Check	4		518-144-010E	Manifold, Discharge 3" BSPT	1
	050-015-600	Ball, Check	4		518-144-110	Manifold, Discharge	1
3	070-006-170	Bushing	2		518-144-110E	Manifold, Discharge 3" BSPT	1
4	095-110-558	Pilot Valve Assembly	1		518-144-112	Manifold, Discharge	1
	095-110-110	Pilot Valve Assembly (Cast Iron Centers Only)	1		518-144-112E	Manifold, Discharge 3" BSPT	1
5	114-024-157	Intermediate Bracket	1	24	545-007-115	Nut, Hex 7/16-14	16
	114-024-010	Intermediate Bracket	1		545-007-330	Nut, Hex 7/16-14	16
6	132-035-360	Bumper, Diaphragm	2	25	545-008-115	Nut, Hex 1/2-13	16
7	135-034-506	Bushing, Plunger	2		545-008-330	Nut, Hex 1/2-13	16
8	165-113-157	Cap, Air Inlet Assembly	1	26	560-001-360	O-Ring	2
	165-113-010	Cap, Air Inlet Assembly	1	27	560-105-360	Seal (O-Ring) (See item 34)	8
9	170-055-115	Capscrew, Hex Hd 1/2-13 X 2.50	16		560-105-363	Seal (O-Ring) (See item 34)	8
	170-055-330	Capscrew, Hex Hd 1/2-13 X 2.50	16		560-105-364	Seal (O-Ring) (See item 34)	8
10	170-060-115	Capscrew, Hex Hd 7/16-14 X 2.00	16		560-105-365	Seal (O-Ring) (See item 34)	8
	170-060-330	Capscrew, Hex Hd 7/16-14 X 2.00	16		720-055-608	Seal (O-Ring) (See item 34)	8
11	170-069-115	Capscrew, Hex Hd 5/16-18 X 1.75	4	28	612-192-157	Plate, Inner Diaphragm Assembly	2
	170-069-330	Capscrew, Hex Hd 5/16-18 X 1.75	4		612-192-010	Plate, Inner Diaphragm Assembly	2
12	171-053-115	Capscrew, Soc Hd 3/8-16 X 2.50 (Stroke Indicator Only)	4	29	612-194-157	Plate, Outer Diaphragm Assembly	2
	171-053-330	Capscrew, Soc Hd 3/8-16 X 2.50 (Stroke Indicator Only)	4		612-194-010	Plate, Outer Diaphragm Assembly	2
	170-006-115	Capscrew, Hex HD 3/8-16 X 1.00	4		612-194-110	Plate, Outer Diaphragm Assembly	2
	170-006-330	Capscrew, Hex HD 3/8-16 X 1.00	4		612-194-112	Plate, Outer Diaphragm Assembly	2
13	171-059-115	Capscrew, Soc Hd 7/16-14 X 1.25	8	30	620-020-115	Plunger, Actuator	2
	171-059-330	Capscrew, Soc Hd 7/16-14 X 1.25	8	31	675-042-115	Ring, Retaining	2
14	196-164-156	Chamber, Outer	2	32	685-040-120	Rod, Diaphragm	1
	196-164-015	Chamber, Outer	2	33	720-004-360	Seal, Diaphragm Rod	2
	196-164-110	Chamber, Outer	2	34	722-090-360	Seat, Check Ball	4
	196-164-112	Chamber, Outer	2		722-090-363	Seat, Check Ball	4
15	196-165-156	Chamber, Inner	2		722-090-364	Seat, Check Ball	4
	196-165-010	Chamber, Inner	2		722-090-365	Seat, Check Ball	4
16	286-098-604	Diaphragm, Overlay	2		722-090-600	Seat, Check Ball	4
17	286-098-360	Diaphragm	2		722-090-080	Seat, Check Ball (seals required see item 27)	4
	286-098-363	Diaphragm	2		722-090-110	Seat, Check Ball (seals required see item 27)	4
	286-098-354	Diaphragm	2		722-090-150	Seat, Check Ball (seals required see item 27)	4
	286-098-365	Diaphragm	2	35	901-038-115	5/16 Flat Washer	4
18	360-093-360	Gasket, Air Valve	1		901-038-330	5/16 Flat Washer	4
19	360-103-360	Gasket, Pilot Valve	1	36	901-048-115	3/8 Flat Washer (Stroke Indicator Only)	4
20	360-104-379	Gasket, Air Inlet	1		901-048-330	3/8 Flat Washer (Stroke Indicator Only)	4
21	360-105-360	Gasket, Inner Chamber	2	42	530-033-000	Metal Muffler	1
22	518-143-156	Manifold, Suction	1			(for other muffler options see pg. 26)	
	518-143-156E	Manifold, Suction 3" BSPT	1				
	518-143-010	Manifold, Suction	1				

****Note: Pumps equipped with these components are not ATEX compliant**

Air Valve Servicing, Assembly Drawing & Parts List

(Use With Aluminum Centers Only)



****Note: Pumps equipped with this valve assembly are not ATEX compliant**

Air Valve Assembly Parts List

Item	Part Number	Description	Qty
1	031-173-000	Air Valve Assembly	1
1-A	095-109-157	Body, Air Valve	1
1-B	031-139-000	Sleeve and Spool Set	1
1-C	132-029-357	Bumper	2
1-D	560-020-360	O-Ring	10
1-E	165-127-157	Cap, End	2
1-F	170-032-330	Hex Head Capscrew 1/4-20 x .75	8
1-G	530-028-550	Muffler	1
1-H	165-096-551	Muffler Cap	1
1-J	706-026-330	Machine Screw	4

Air Distribution Valve Servicing

To service the air valve first shut off the compressed air, bleed pressure from the pump, and disconnect the air supply line from the pump.

Step #1: See COMPOSITE REPAIR PARTS DRAWING.

Using a 9/16" wrench or socket, remove the four hex capscrews (items 12). Remove the air valve assembly from the pump.

Remove and inspect gasket (item 18) for cracks or damage. Replace gasket if needed.

Step #2: Disassembly of the air valve.

Using a 7/16" wrench or socket, remove the eight hex capscrews (items 1-F) that

fasten the end caps to the valve body. Next remove the two end caps (items 1-E). Inspect the two o-rings (items 1-D) on each end cap for damage or wear. Replace the o-rings as needed.

Remove the bumpers (items 1-C). Inspect the bumpers for damage or wear. Replace the bumpers as needed.

Remove the spool (part of item 1-B) from the sleeve. Be careful not to scratch or damage the outer diameter of the spool. Wipe spool with a soft cloth and inspect for scratches or wear.

Inspect the inner diameter of the sleeve (part of item 1-B) for dirt, scratches, or other contaminants. Remove the sleeve if needed and replace with a new sleeve and spool set (item 1-B).


Step #3: Reassembly of the air valve.

Install one bumper (item 1-C) and one end cap (item 1-E), with two o-rings (items 1-D), and fasten with four hex capscrews (items 1-F) to the valve body (item 1-A).

Remove the new sleeve and spool set (item 1-B) from the plastic bag. Carefully remove the spool from the sleeve. Install the six o-rings (item 1-D) into the six grooves on the sleeve. Apply a light coating of grease to the o-rings before installing the sleeve into the valve body (item 1-A), align the slots in the sleeve with the slots in the valve body. Insert the spool into the sleeve. Be careful not to scratch or damage the spool during installation. Carefully insert the sleeve into the bumper and end cap

(with o-rings) and fasten with the remaining hex capscrews.

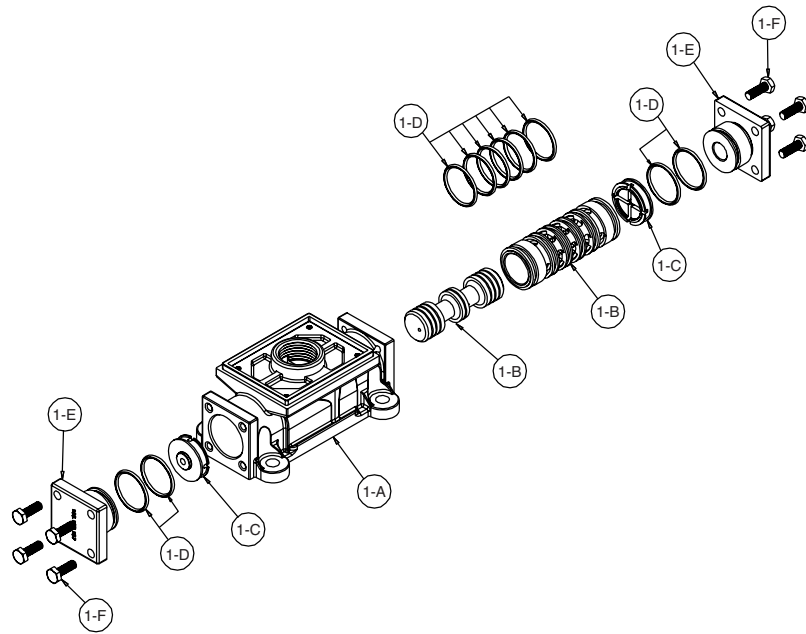
Fasten the air valve assembly (item 1) and gasket to the pump. Connect the compressed air line to the pump. The pump is now ready for operation.



! IMPORTANT

Read these instructions completely, before installation and start-up. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.

Air Valve Servicing, Assembly Drawing & Parts List



Air Valve Assembly Parts List (Use w/Aluminum centers only)

Item	Part Number	Description	Qty
1	031-183-000	Air Valve Assembly	1
1-A	095-109-157	Body, Air Valve	1
1-B	031-139-000	Sleeve and Spool Set	1
1-C	132-029-357	Bumper	2
1-D	560-020-360	O-Ring	10
1-E	165-127-157	Cap, End	2
1-F	170-032-330	Hex Head Capscrew 1/4-20 x .75	8

Air Valve Assembly Parts List (Use w/Cast Iron centers only)

Item	Part Number	Description	Qty
1	031-179-000	Air Valve Assembly	1
1-A	095-109-110	Body, Air Valve	1
1-B	031-139-000	Sleeve and Spool Set	1
1-C	132-029-357	Bumper	2
1-D	560-020-379	O-Ring	10
1-E	165-127-110	Cap, End	2
1-F	170-032-115	Hex Head Capscrew 1/4-20 x .75	8

Air Distribution Valve Servicing

To service the air valve first shut off the compressed air, bleed pressure from the pump, and disconnect the air supply line from the pump.

Step #1: See COMPOSITE REPAIR PARTS DRAWING.

Using a 9/16" wrench or socket, remove the four hex capscrews (items 12). Remove the air valve assembly from the pump.

Remove and inspect gasket (item 18) for cracks or damage. Replace gasket if needed.

Step #2: Disassembly of the air valve.

Using a 7/16" wrench or socket, remove the eight hex capscrews (items 1-F) that

fasten the end caps to the valve body. Next remove the two end caps (items 1-E). Inspect the two o-rings (items 1-D) on each end cap for damage or wear. Replace the bumpers as needed.

Remove the bumpers (items 1-C). Inspect the bumpers for damage or wear. Replace the bumpers as needed.

Remove the spool (part of item 1-B) from the sleeve. Be careful not to scratch or damage the outer diameter of the spool. Wipe spool with a soft cloth and inspect for scratches or wear.

Inspect the inner diameter of the sleeve (part of item 1-B) for dirt, scratches, or other contaminants. Remove the sleeve if needed and replace with a new sleeve and spool set (item 1-B).


Step #3: Reassembly of the air valve.

Install one bumper (item 1-C) and one end cap (item 1-E), with two o-rings (items 1-D), and fasten with four hex capscrews (items 1-F) to the valve body (item 1-A).

Remove the new sleeve and spool set (item 1-B) from the plastic bag. Carefully remove the spool from the sleeve. Install the six o-rings (item 1-D) into the six grooves on the sleeve. Apply a light coating of grease to the o-rings before installing the sleeve into the valve body (item 1-A), align the slots in the sleeve with the slots in the valve body. Insert the spool into the sleeve. Be careful not to scratch or damage the spool during installation. Carefully insert the sleeve into the bumper and end cap

(with o-rings) and fasten with the remaining hex capscrews.

Fasten the air valve assembly (item 1) and gasket to the pump. Connect the compressed air line to the pump. The pump is now ready for operation.

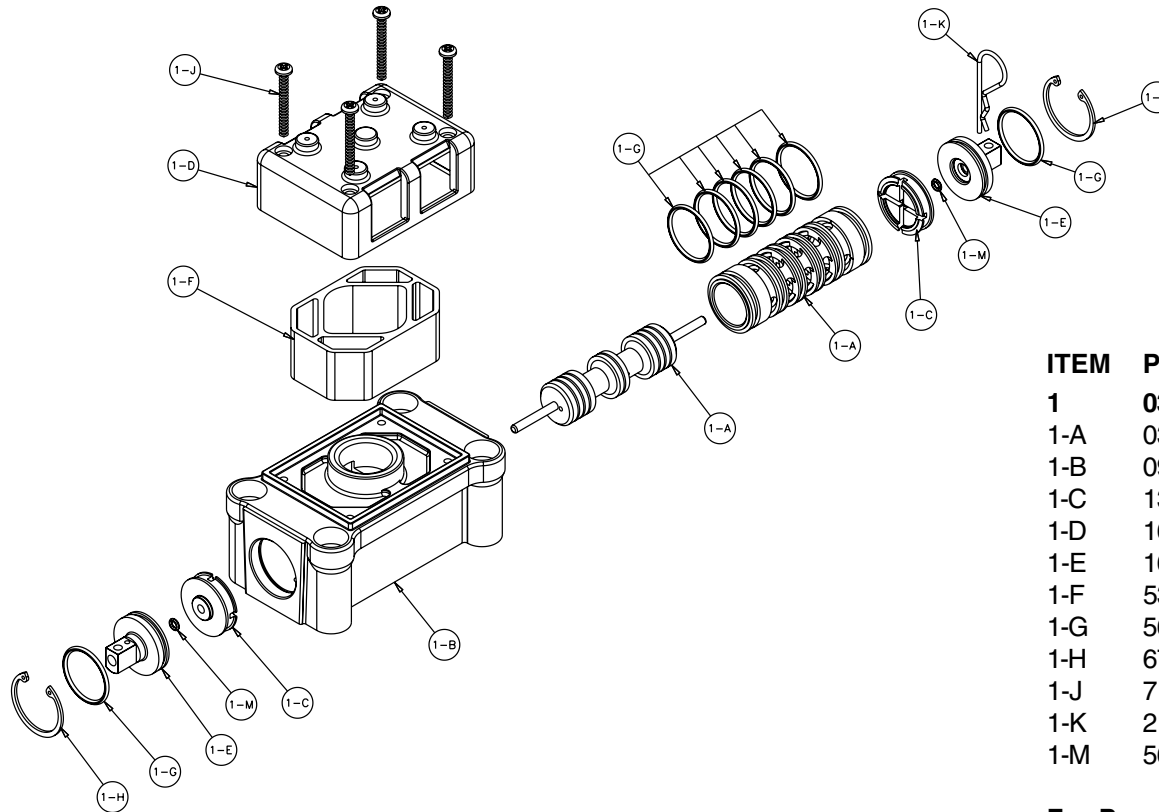


IMPORTANT

Read these instructions completely, before installation and start-up. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.

Air Valve with Stroke Indicator Assembly Drawing, Parts List

****Note: Pumps equipped with this valve assembly are not ATEX compliant**



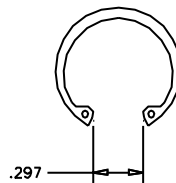
AIR VALVE ASSEMBLY PARTS LIST

ITEM	PART NUMBER	DESCRIPTION	QTY
1	031-146-000	Air Valve Assembly	1
1-A	031-143-000	Sleeve and Spool Set	1
1-B	095-094-551	Body, Air Valve	1
1-C	132-029-552	Bumper	2
1-D	165-096-551	Cap, Muffler	1
1-E	165-098-147	Cap, End	2
1-F	530-028-550	Muffler	1
1-G	560-020-360	O-Ring	8
1-H	675-044-115	Ring, Retaining	2
1-J	710-015-115	Screw, Self Tapping	4
1-K	210-008-330	Clip, Safety	1
1-M	560-001-360	O-Ring	2

For Pumps with Alternate Mesh, Sound Dampening Mufflers or Piped Exhaust:

1	031-147-000	Air Valve Assembly	1
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(includes all items on 031-146-000 minus 1-D, 1-F, & 1-J).



NOTE: CHECK GAP AFTER ASSEMBLY TO INSURE COMPLETE INSTALLATION OF RETAINING RING

AIR DISTRIBUTION VALVE WITH STROKE INDICATOR OPTION SERVICING

To service the air valve first shut off the compressed air supply, bleed the pressure from the pump, and disconnect the air supply line from the pump.

Step #1: See COMPOSITE REPAIR PARTS DRAWING.

Using a 5/16" Allen wrench, remove the four hex socket capscrews (item 12) and four flat washers (item 38). Remove the air valve assembly from the pump.

Remove and inspect gasket (item 18) for cracks or damage. Replace gasket if needed.

Step #2: Disassembly of the air valve.

To access the internal air valve components first remove the two retaining rings (item 1-H) from each end of the air valve assembly using clip ring pliers.

Next remove the two end caps (item 1-E). Inspect the o-ring (items 1-G) and 1-M) for cuts or wear. Replace the o-rings if necessary.

Remove the two bumpers (item 1-C). Inspect the bumpers for cut, wear or abrasion. Replace if necessary.

Remove the spool (part of item 1-A) from the sleeve. Be careful not to scratch or damage the outer diameter of the spool. Wipe spool with a soft cloth and inspect for scratches or wear.

Inspect the inner diameter of the sleeve (part of item 1-A) for dirt, scratches, or other contaminants. Remove the sleeve if needed and replace with a new sleeve and spool set (item 1-A).

Step #3: Re-assembly of the air valve.

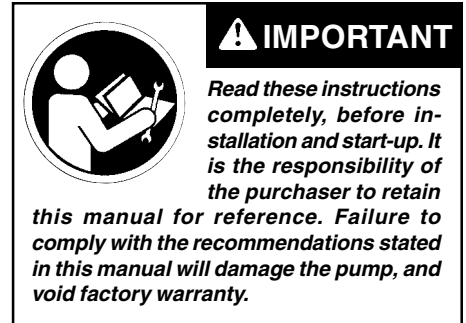
Install one bumper (item 1-C) and one end cap (item 1-E) with o-rings (item 1-G and 1-M) into one end of the air valve body (item 1-B). Install one retaining ring (item 1-H), into the groove on the same end. Insert the safety clip (item 1-K) through the smaller unthreaded hole in the endcap.

Remove the new sleeve and spool set (item 1-A) from the plastic bag. Carefully remove the spool from the sleeve. Install the six o-rings (item 1-G) into the six grooves on the sleeve. Apply a light coating of grease to the o-rings before installing the sleeve into the valve body (item 1-B). Align the slots in the sleeve with the slots in the valve body. Insert the spool into the sleeve. Be careful not to scratch or damage the spool during installation. Push the spool in until the pin touches the safety clip on the opposite end.

Install the remaining bumper, end cap with o-rings and retaining ring.

Fasten the air valve assembly (item 1) and gasket (item 18) to the pump.

Connect the compressed air line to the pump. Remove the safety clip. The pump is now ready for operation.



**Solenoid Shifted Air Valve Drawing

**Note: Pumps equipped with Integral Solenoid Valves are not ATEX compliant

SOLENOID SHIFTED AIR VALVE PARTS LIST

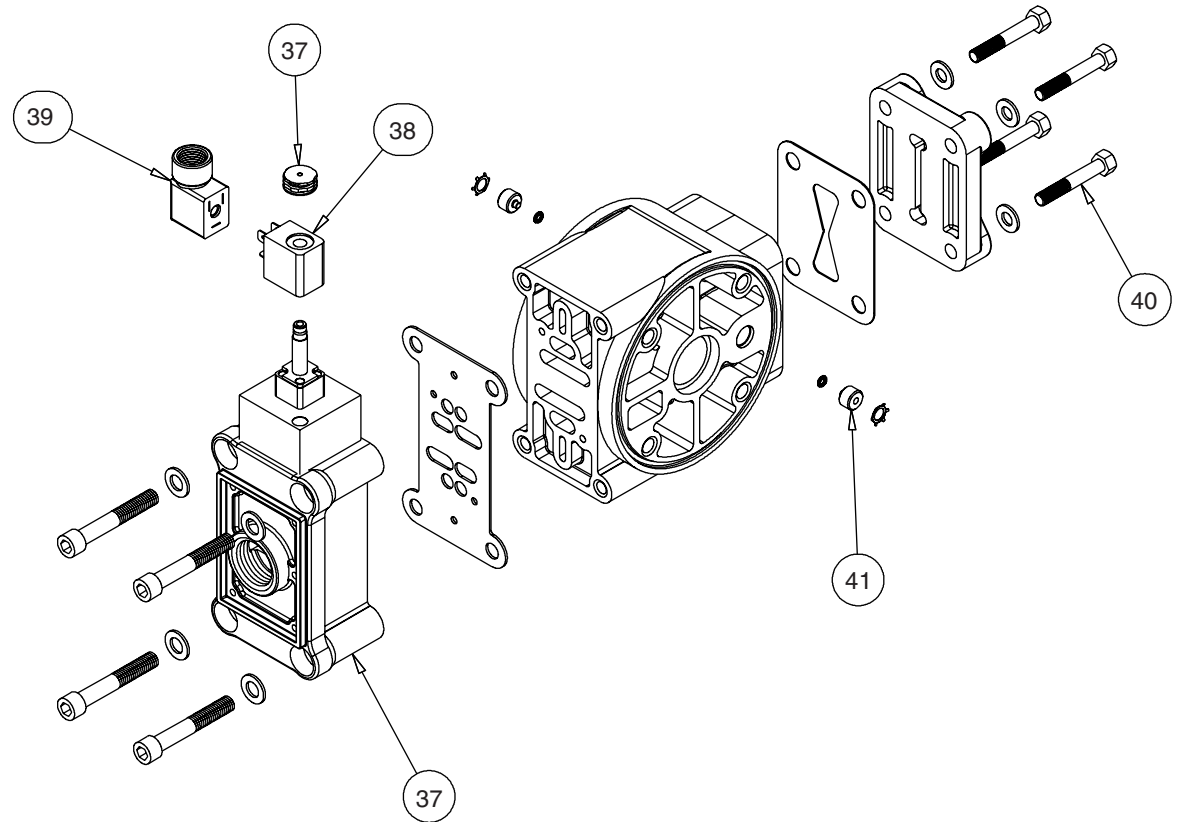
(Includes all items used on Composite Repair Parts List except as shown)

ITEM	PART NUMBER	DESCRIPTION	QTY
37	893-097-000	Solenoid Valve, NEMA4	1
38	219-001-000	Solenoid Coil, 24VDC	1
	219-004-000	Solenoid Coil, 24VAC/12VDC	1
	219-002-000	Solenoid Coil, 120VAC	1
	219-003-000	Solenoid Coil, 240VAC	1
39	241-001-000	Connector, conduit	1
	241-003-000	Conduit Connector with Suppression Diode (DC Only)	1
40	170-029-330	Capscrew, Hex HD 5/16-18 x 1.50	4
41	618-051-150	Plug	2

For Explosion Proof Solenoid Valve

(Connector not required for explosion proof coil; coil is integral with valve)

37	893-098-001	Solenoid Valve, NEMA 7/9, 24VDC	1
	893-098-002	Solenoid Valve, NEMA 7/9, 24VAC/12VDC	1
	893-098-003	Solenoid Valve, NEMA 7/9, 120VAC	1
	893-098-004	Solenoid Valve, NEMA 7/9, 220VAC	1



SOLENOID SHIFTED AIR DISTRIBUTION VALVE OPTION

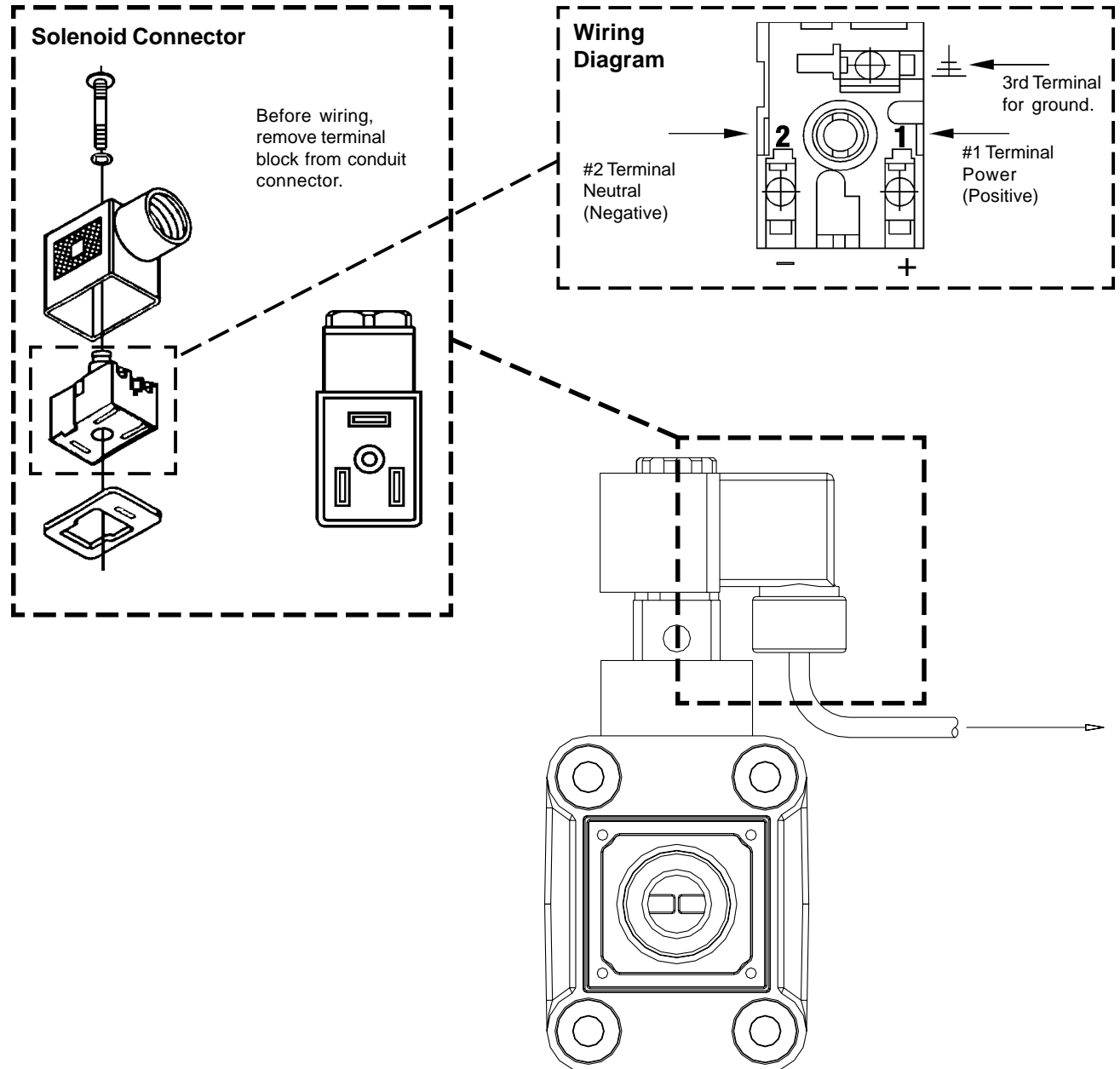
Warren Rupp's solenoid shifted, air distribution valve option utilizes electrical signals to precisely control your SANDPIPER's speed. The solenoid coil is connected to a customer - supplied control. Compressed air provides the pumping power, while electrical signals control pump speed (pumping rate).

OPERATION

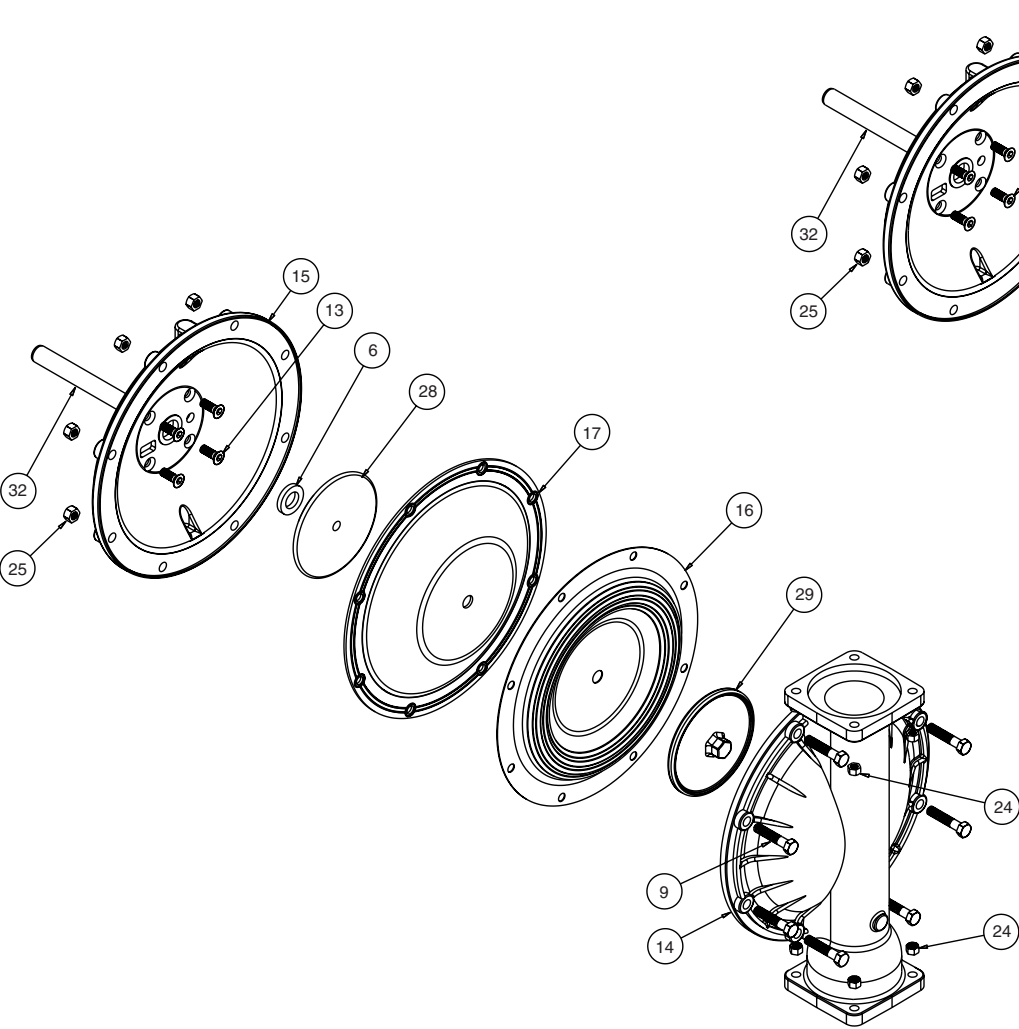
The Solenoid Shifted SANDPIPER has a solenoid operated, air distribution valve in place of the standard SANDPIPER's pilot operated, air distribution valve. Where a pilot valve is normally utilized to cycle the pump's air distribution valve, an electric solenoid is utilized. As the solenoid is powered, one of the pump's air chambers is pressurized while the other chamber is exhausted. When electric power is turned off, the solenoid shifts and the pressurized chamber is exhausted while the other chamber is pressurized. By alternately applying and removing power to the solenoid, the pump cycles much like a standard SANDPIPER pump, with one exception. This option provides a way to precisely control and monitor pump speed.

BEFORE INSTALLATION

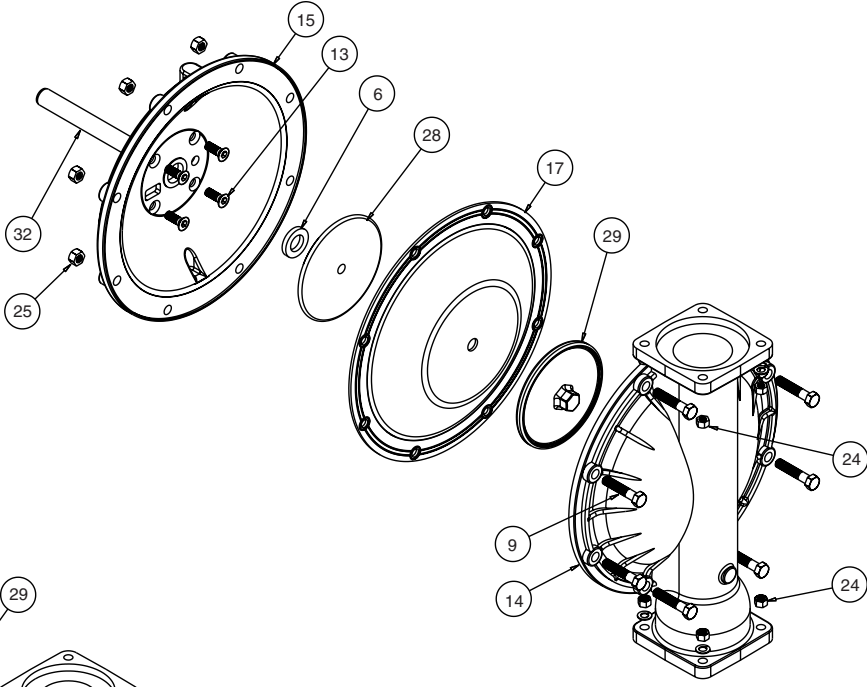
Before wiring the solenoid, make certain it is compatible with your system voltage.



Diaphragm Service Drawing, with Overlay



Diaphragm Service Drawing, Non-Overlay



DIAPHRAGM SERVICING

To service the diaphragms first shut off the suction, then shut off the discharge lines to the pump. Shut off the compressed air supply, bleed the pressure from the pump, and disconnect the air supply line from the pump. Drain any remaining liquid from the pump.

Step #1: See the pump assembly drawing, and the diaphragm servicing illustration.

Using a 9/16" wrench or socket, remove the 16 capscrews (item 10), and hex nuts that fasten the manifolds (items 22 & 23) to the outer chambers (item 14).

Step #2: Removing the outer chambers.

Using a 11/16" and a 5/8" wrench or socket, remove the 16 capscrews (items 9), and hex nuts that fasten the outer chambers, diaphragms, and inner chambers (items 15) together.

Step #3: Removing the diaphragm assemblies.

Use a 1¹/₁₆" (27mm) wrench or six pointed socket to remove the diaphragm assemblies (outer plate, diaphragm, and inner plate) from the diaphragm rod (item 32) by turning counterclockwise.

NOTE: To uninstall the diaphragm plates from the diaphragm, hold the inner diaphragm plate using one of two methods:

Preferred Method: Place the assembled plates and diaphragm in a large vise, gripping on the exterior cast diameter of the inner diaphragm plate (see the drawing at far right).

Alternate Method: When a larger vise is not available, insert a 1/4 - 20UNC hex capscrew or setscrew (standard hardware) into the tapped hole in the inner diaphragm plate. Insert the assembled plates and diaphragm into a vise with the stud from the outer plate and the 1/4 - 20 fastener loosely between the jaws of the vise (see illustration at right).

Use a 1¹/₁₆" wrench or socket to remove the outer diaphragm plate (item 29) by turning counterclockwise. Inspect the diaphragm (item 17) for cuts, punctures, abrasive wear or chemical attack. Replace the diaphragms if necessary.

Step #4: Installing the diaphragms.

Push the threaded stud of the outer diaphragm plate through the center hole of the diaphragm. Thread the inner plate clockwise onto the stud. Use one of the two methods for holding the inner diaphragm plate that was described in prior note in step #3. Use a torque wrench to tighten the diaphragm assembly together to 50 ft. lbs. (67.79 Newton meters). Allow a minimum of 15 minutes to elapse after torquing, then re-torque the assembly to compensate for stress relaxation in the clamped assembly.

Step #5: Installing the diaphragm assemblies to the pump.

Make sure the bumper (item 6) is installed over the diaphragm rod.

Thread the stud of the one diaphragm assembly clockwise into the tapped hole at the end of the diaphragm rod (item 32) until the inner diaphragm plate is flush to the end of the rod. Insert rod into pump.

Align the bolt holes in the diaphragm with the bolt pattern in the inner chamber (item 15).

Fasten the outer chamber (item 14) to the pump, using the capscrews (items 9), and hex nuts.

On the opposite side of the pump, pull the diaphragm rod out as far as possible. Make sure the bumper (item 6) is installed over the diaphragm rod.

Thread the stud of the remaining diaphragm assembly clockwise into the tapped hole at the end of the diaphragm rod (item 32) as far as possible and still allow for alignment of the bolt holes in the diaphragm with the bolt pattern in the inner chamber (item 15).

Fasten the remaining outer chamber (item 14) to the pump, using the capscrews (items 9), and hex nuts.

Step #6: Re-install the manifolds to the pump, using the capscrews (items 10), hex nuts and flat washers.



IMPORTANT

Read these instructions completely, before installation and start-up. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.

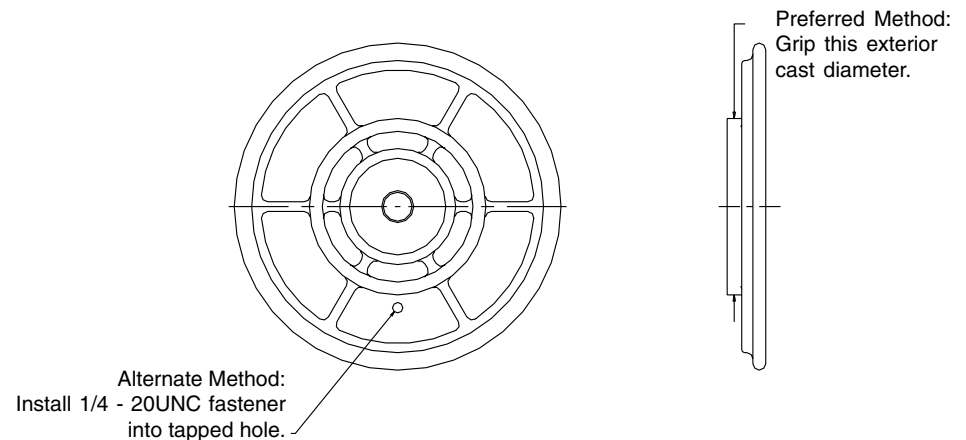
The pump is now ready to be re-installed, connected and returned to operation.

OVERLAY DIAPHRAGM SERVICING

The overlay diaphragm (item 16) is designed to fit over the exterior of the standard TPE diaphragm (item 17).

The molded directional arrows on the overlay diaphragm must point vertically.

Follow the same procedures described for the standard diaphragm for removal and installation.



ACTUATOR PLUNGER SERVICING

To service the actuator plunger first shut off the compressed air supply, bleed the pressure from the pump, and disconnect the air supply line from the pump.

Step #1: See PUMP ASSEMBLY DRAWING.

Using a 1/2" wrench or socket, remove the four capscrews (items 11). Remove the air inlet cap (item 8) and air inlet gasket (item 20). The pilot valve assembly (item 4) can now be removed.

Step #2: Inspect the actuator plungers.

See ILLUSTRATION AT RIGHT.

The actuator plungers (items 30) can be reached through the pilot valve cavity in the intermediate assembly (item 5).

Remove the plungers (item 30) from the bushings (item 7) in each end of the cavity. Inspect the installed o-ring (items 26) for cuts and/or wear. Replace the o-rings if necessary. Apply a light coating of grease to each o-ring and re-install the plungers in to the bushings. Push the plungers in as far as they will go.

To remove the bushings (item 7), first remove the retaining rings (item 31) by using a flat screwdriver.

NOTE: It is recommended that new retaining rings be installed.

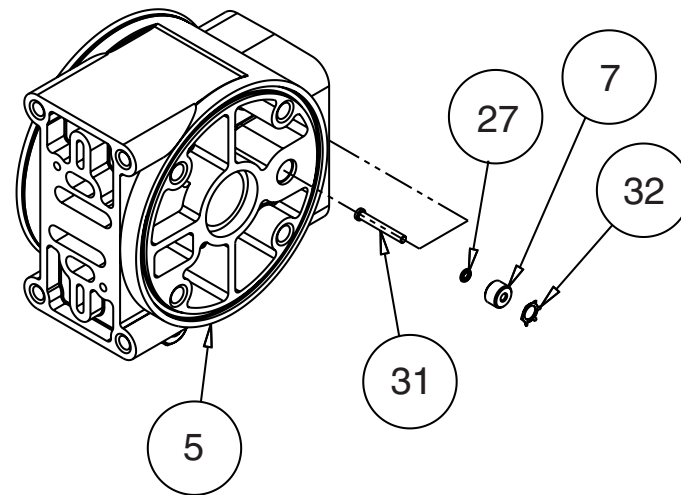
Step #3: Re-install the pilot valve assembly into the intermediate assembly.


Be careful to align the ends of the stem between the plungers when inserting the stem of the pilot valve into the cavity of the intermediate.

Re-install the gasket (item 20), air inlet cap (item 8) and capscrews (item 11).

Connect the air supply to the pump. The pump is now ready for operation.

ACTUATOR PLUNGER SERVICING





! IMPORTANT

Read these instructions completely, before installation and start-up. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.

CHECK VALVE SERVICING

Before servicing the check valve components, first shut off the suction line and then the discharge line to the pump. Next, shut off the compressed air supply, bleed air pressure from the pump, and disconnect the air supply line from the pump. Drain any remaining fluid from the pump. The pump can now be removed for service.

To access the check valve components, remove the manifold (item 23 or item 22 not shown). Use a 9/16" wrench or socket to remove the fasteners. Once the manifold is removed, the check valve components can be seen.

Inspect the check balls (items 2) for wear, abrasion, or cuts on the spherical surface. The check valve seats (item 34) should be inspected for cuts, abrasive wear, or embedded material on the surfaces of both the external and internal chambers. The spherical surface of the check balls must seat flush to the surface of the check valve seats for the pump to operate to peak efficiency. Replace any worn or damaged parts as necessary.

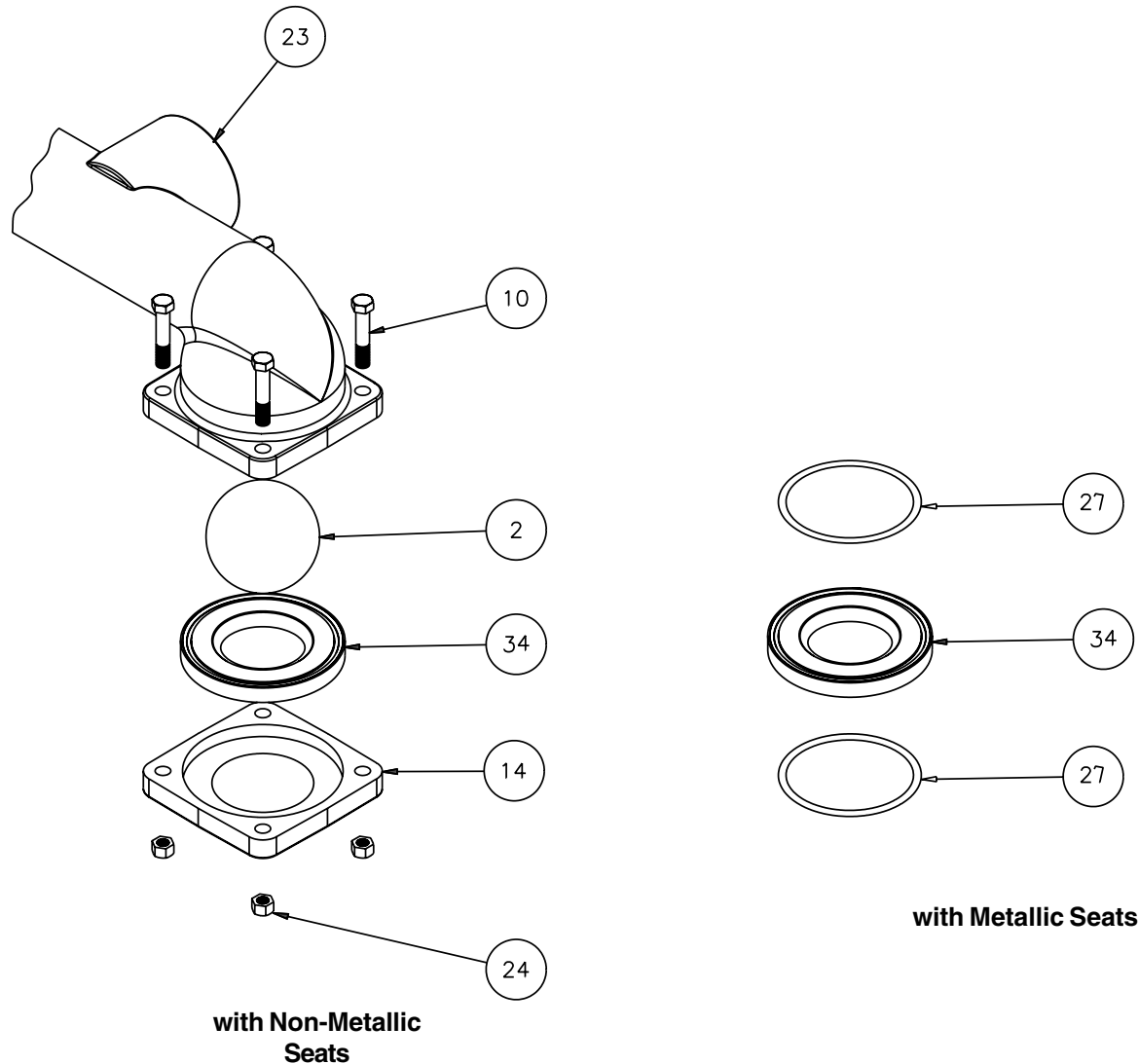
Re-assemble the check valve components. The seat should fit into the counter bore of the outer chamber.

The pump can now be reassembled, reconnected and returned to operation.

METALLIC SEATS

Two o-rings (or conductive PTFE seals) (item 27) are required for metallic seats.

Check Valve Drawing



****Optional Muffler Configurations, Drawing**

****Note the pump is built with a metal muffler for static electric dissipation, to meet ATEX requirements. The options shown on this page are not ATEX compliant.**

****Configuration A**

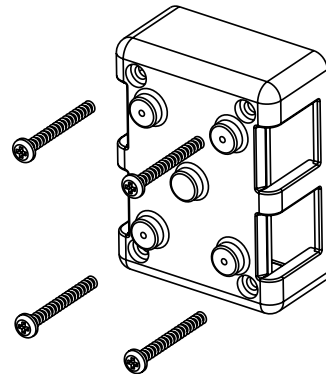
530-028-550 Encapsulated Muffler uses (1) 165-096-551 Cap and (4) 710-015-115 Self Tapping Screws (Non-metallic valves), or (4) 706-026-330 Machine Screws (Aluminum valves) to hold it in place.

****Configuration B**

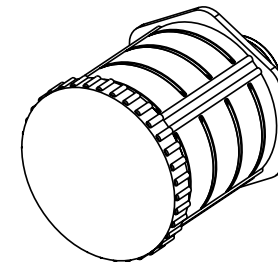
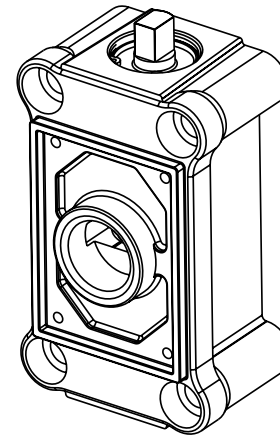
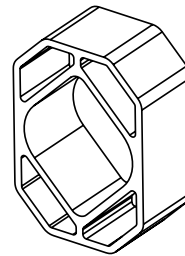
530-010-000 Mesh Muffler screws directly into the Air Valve Body. This muffler is equipped with a metal element.

****Configuration C**

530-027-000 Sound Dampening Muffler screws directly into the Air Valve body. This muffler is equipped with a porous plastic element.



Configuration A



Configuration B and C

PUMPING HAZARDOUS LIQUIDS

When a diaphragm fails, the pumped liquid or fumes enter the air end of the pump. Fumes are exhausted into the surrounding environment. When pumping hazardous or toxic materials, the exhaust air must be piped to an appropriate area for safe disposal. See illustration #1 at right.

This pump can be submerged if the pump materials of construction are compatible with the liquid being pumped. The air exhaust must be piped above the liquid level. See illustration #2 at right. Piping used for the air exhaust must not be smaller than 1" (2.54 cm) diameter. Reducing the pipe size will restrict air flow and reduce pump performance. When the pumped product source is at a higher level than the pump (flooded suction condition), pipe the exhaust higher than the product source to prevent siphoning spills. See illustration #3 at right.

CONVERTING THE PUMP FOR PIPING THE EXHAUST AIR

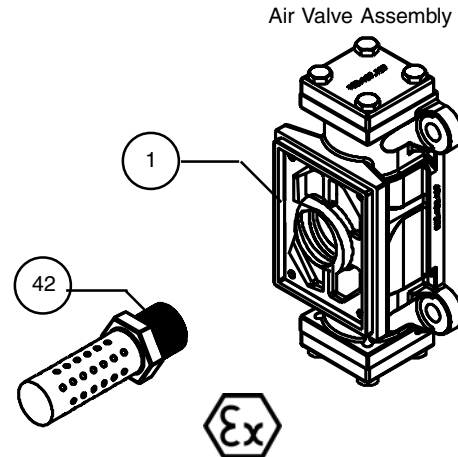
The following steps are necessary to convert the pump to pipe the exhaust air away from the pump.

Remove the muffler (item 42). The air distribution valve (item 1) has 1" NPT threads for piped exhaust.

IMPORTANT INSTALLATION

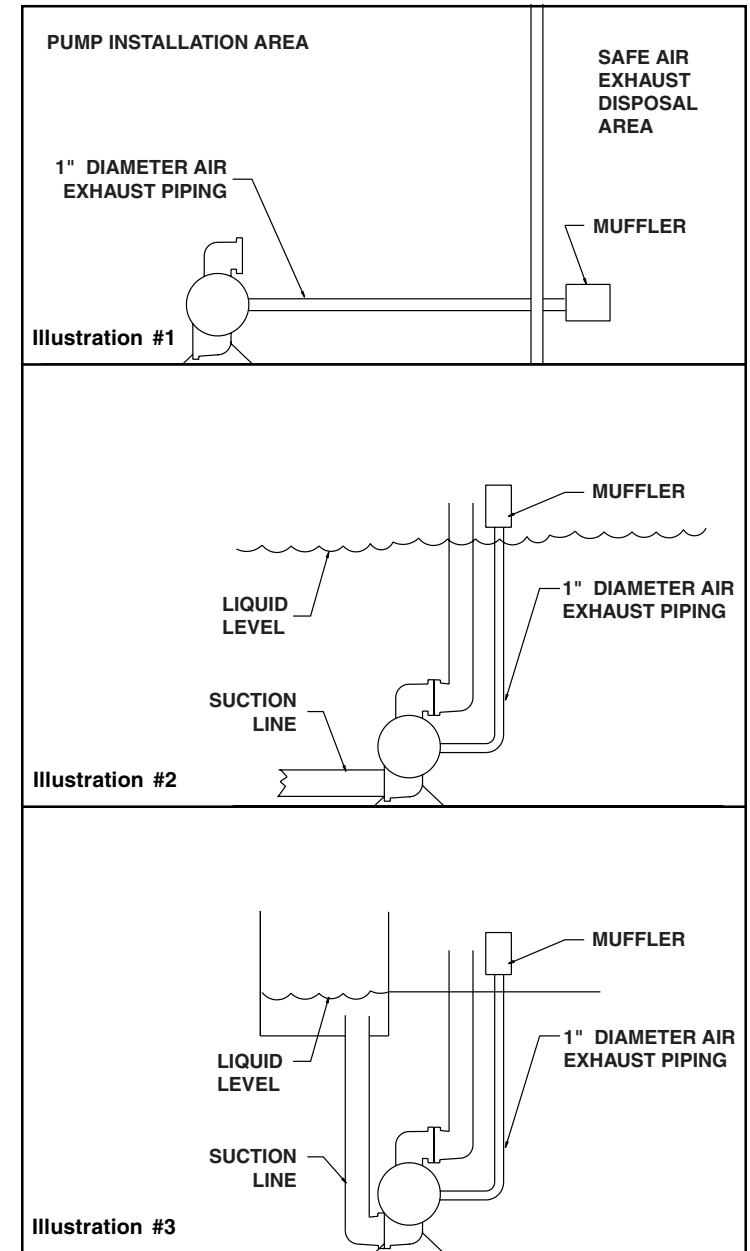
NOTE: The manufacturer recommends installing a flexible conductive hose or connection between the pump and any rigid plumbing. This reduces stresses on the molded threads of the air exhaust port. Failure to do so may result in damage to the air distribution valve body.

Any piping or hose connected to the pump's air exhaust port must be conductive and physically supported. Failure to support these connections could also result in damage to the air distribution valve body.



On ATEX compliant units the pump comes equipped with a standard metal muffler

CONVERTED EXHAUST ILLUSTRATION



**RuppTech® Leak Detection Options, Drawing

**Note: Pumps equipped with these options are not ATEX compliant.

RuppTech® Electronic Leak Detector

Kit 032-037-000	100VAC	50Hz
	or 110-120VAC	50/60Hz
	or 220-240VAC	50/60Hz
Kit 032-045-000	12-32VDC	

Configuration A

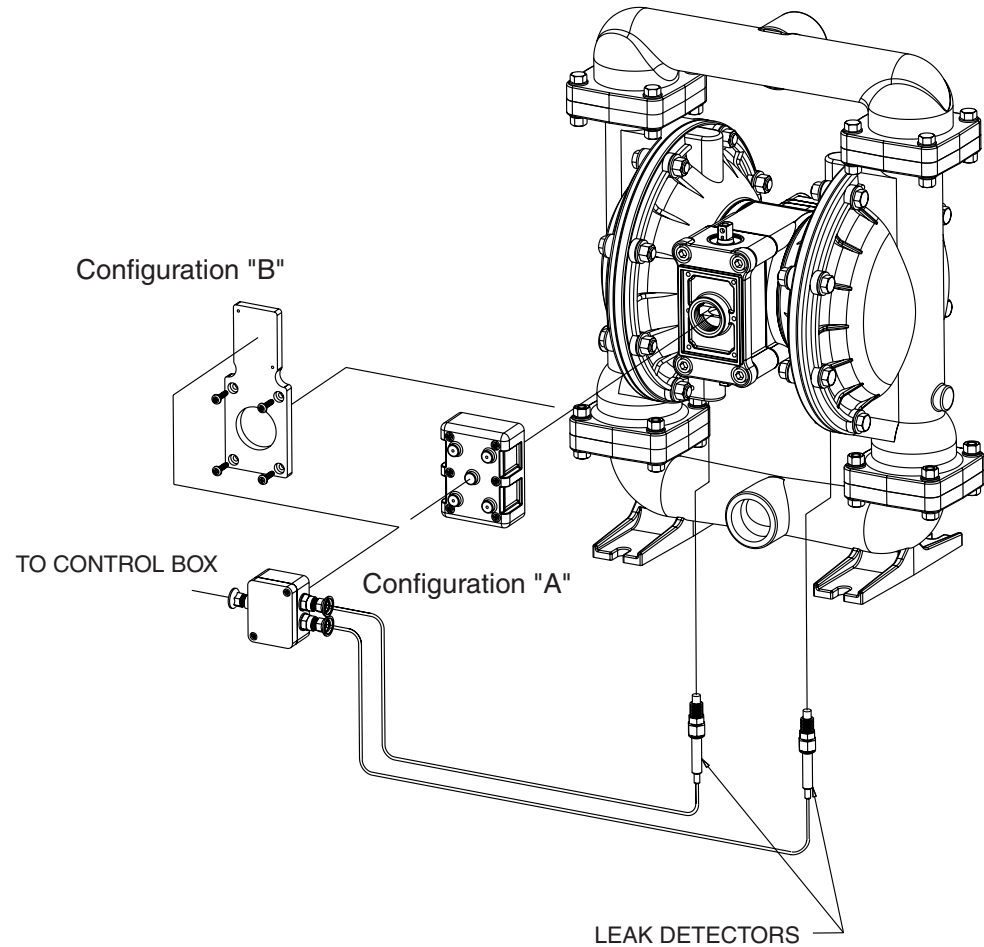
To be used with the Encapsulated muffler option. You will need to mount the terminal box directly to the muffler cap on the air valve using the (2) 710-014-330 self tapping screws. Then insert the leak detectors into the bottom port in the inner chambers.

Configuration B

To be used with either of the muffler options or if your exhaust is piped away. You will need to mount the terminal box to the 612-185-552 mounting plate using the (2) 710-014-330 self tapping screws. Then mount the mounting plate directly to the air valve body using the (4) 710-009-115 self tapping screws. Then insert the leak detectors into the bottom port in the inner chambers.

Mechanical Leak Detector

Kit 031-023-110
Insert the leak detectors into the bottom part in the inner chambers.



****RuppTech® Pulse Output Kit Drawing & Options**

****Note: Pumps equipped with Pulse Output Kits are not ATEX compliant.**

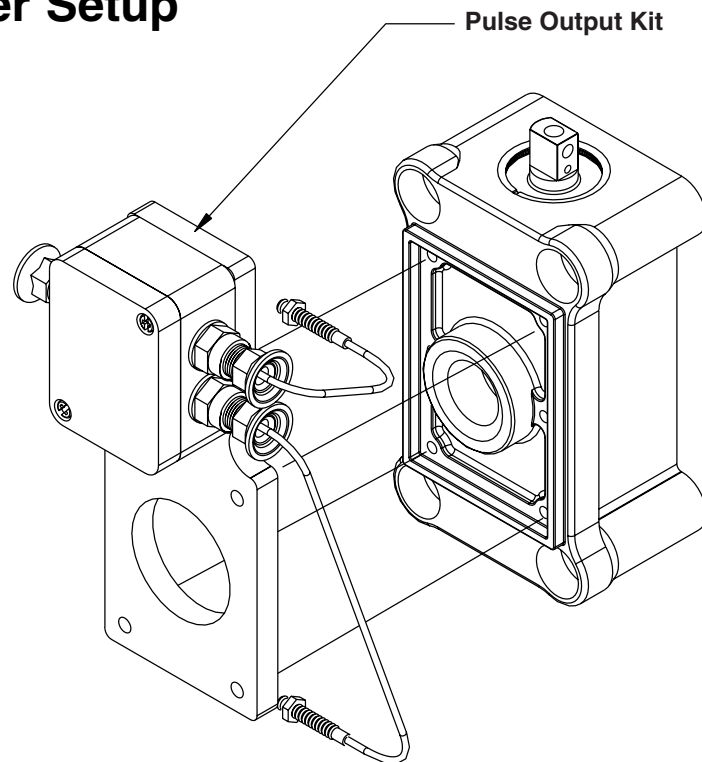
RuppTech® PULSE OUTPUT KIT OPTION

This pump can be fitted with a Pulse Output Kit. This converts the mechanical strokes of the pump to an electrical signal which interfaces with the RuppTech® Stroke Counter/ Batch Controller or user control devices such as a PLC.

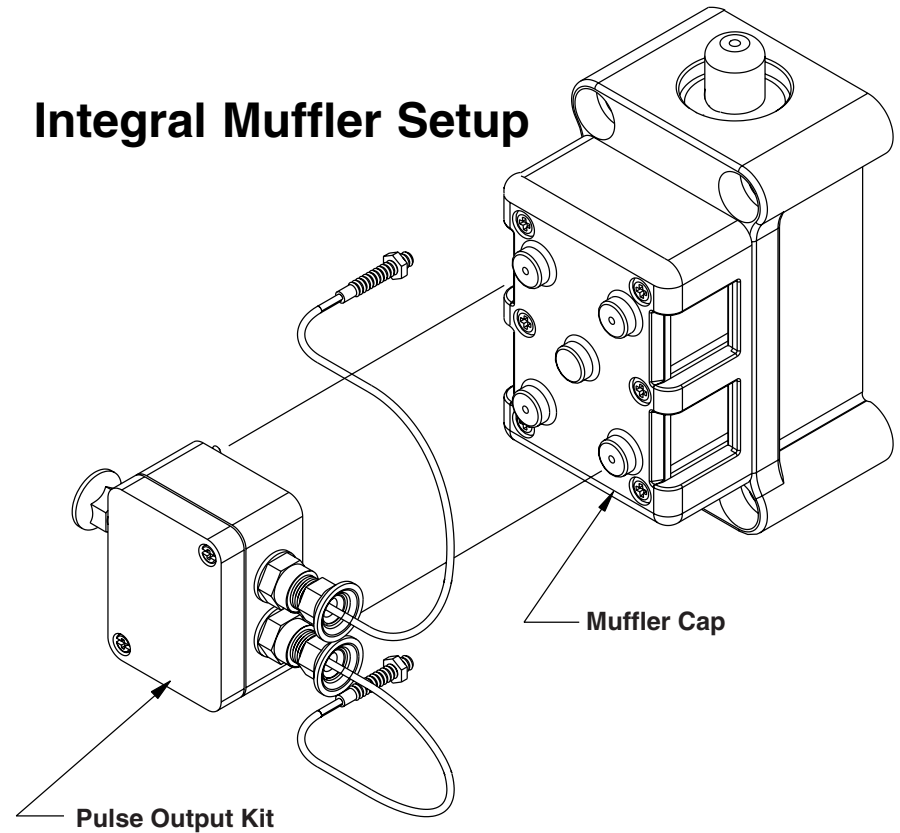
The Pulse Output Kits mount directly onto the Muffler Cap on the Air Distribution Valve Assembly or onto the Air Distribution Valve Assembly when the threaded exhaust port or an auxiliary muffler is being used.

See the individual kits listed on the Pump Repair Parts List for further information.

Exhaust Port or Auxiliary Muffler Setup

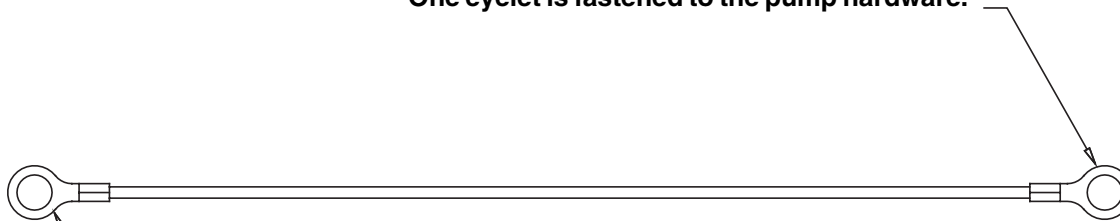


Integral Muffler Setup

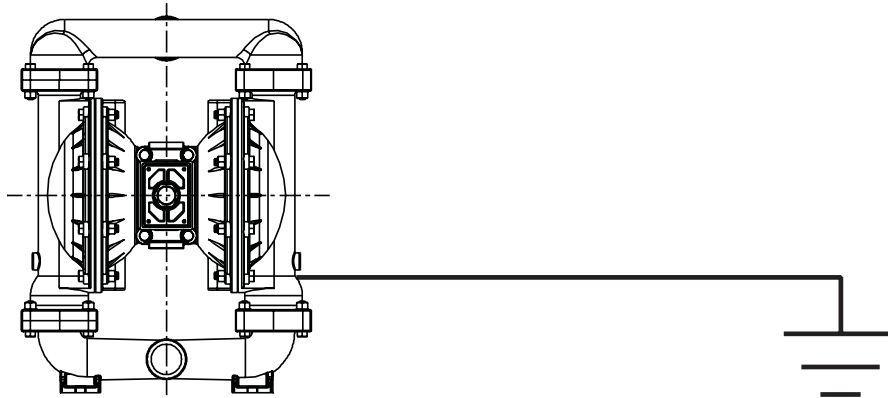


Grounding The Pump

One eyelet is fastened to the pump hardware.




One eyelet is installed to a true earth ground.
(Requires a 5/16 or 8mm maximum diameter bolt)



This 8 foot long (244 centimeters) Ground Strap, part number 920-025-000, can be ordered as a service part.

To reduce the risk of static electrical sparking, this pump must be grounded. Check the local electrical code for detailed grounding instruction and the type of equipment required.

	! WARNING
	<i>Take action to prevent static sparking. Fire or explosion can result, especially when handling flammable liquids. The pump, piping, valves, containers or other miscellaneous equipment must be grounded.</i>