

Operation and Maintenance Manual
for the
ACS-1200
Air Compressor System



Thunder Scientific Corporation

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TABLE OF CONTENTS

1	INTRODUCTION.....	2
2	SPECIFICATIONS and ENVIRONMENTAL CONDITIONS.....	2
	2.1 Specifications.....	2
	2.2 Environmental Conditions.....	2
	2.3 Warranty.....	2
3	SAFETY GUIDELINES.....	3
4	INSTALLATION.....	3
	4.1 Unpacking.....	3
	4.2 Location.....	3
	4.3 Hose Assembly.....	4
	4.4 Power.....	4
	4.4.1 Extension Cord.....	4
5	COMPONENTS and CONTROLS.....	4
	5.1 Power Entry Module.....	4
	5.2 Hour Meter.....	4
	5.3 Outlet Pressure Gauge.....	4
	5.4 Outlet Pressure Regulator.....	4
	5.5 Air Compressor.....	5
	5.6 Membrane Air Dryer.....	5
	5.7 Safety Valve.....	5
	5.8 Dimensional Drawing.....	5
	5.9 Component Locations.....	6
6	GENERAL OPERATION.....	7
	6.1 Set-up.....	7
	6.2 Pressure Adjustment.....	7
	6.3 Shut-down.....	7
7	INSPECTION and MAINTENANCE.....	7
	7.1 Recommended Maintenance Schedule.....	7
	7.2 Filter Inspection and Replacement.....	7
	7.3 Shutdown and Storage Procedures.....	8
	7.4 Service Kit.....	8
8	SCHEMATICS.....	9
	8.1 Pneumatic Schematic.....	9
	8.2 Electrical Schematic.....	9
9	TROUBLESHOOTING GUIDE.....	10
10	PARTS LIST.....	10
11	OPTION INDICATORS.....	10

WARNING

To ensure the safety of operating personnel, and to avoid damage to this equipment:

DO NOT operate this unit without a properly grounded, properly polarized power cord.
DO NOT connect this unit to a non-grounded, non-polarized outlet.

WARNING

HIGH VOLTAGE

is used in the operation of this equipment.

SEVERE INJURY OR DEATH

may result if personnel fail to observe safety precautions.
Before working inside the equipment, turn power off and disconnect power cord.

WARNING

HIGH TEMPERATURES

is this equipment.

FIRE and SEVERE BURNS

may result if personnel fail to observe safety precautions.

1 INTRODUCTION

The ACS-1200 Oil-Less Compressed Air System is designed to be used as the air supply for a Thunder Scientific Model 1200 humidity generator. The ACS-1200 consists of a vibration isolated oil-less rocking piston compressor, membrane style air dryer, and output regulator, all incorporated into a sound muffling cabinet. The ACS-1200 is ideal for laboratory use because of its high pressure capability, 100% duty cycle capability, low sound level of less than 70 decibels, and long service life.

2 SPECIFICATIONS and ENVIRONMENTAL CONDITIONS

2.1 Specifications

Electrical Power: 100/100-120, 7 A, 50/60 Hz, single phase
Electrical Power (optional): 220-240, 3.5 A, 50 Hz, single phase
Pressure Rating (MAWP): 175 psiG
Pressure Dew Point approximately 0 °C at 170 psiG
Flow Rate: 10 L/m
Duty Cycle: 100%
Physical Dimensions: 24 w" x 14 d" x 11.75 h" (61 cm x 35.6 cm x 29.9 cm)
Dry Weight: 40 lbs.

2.2 Environmental Conditions

Operating Temperature: 15 to 30 °C
Storage Temperature: > 0 to 50 °C
Humidity: 5 to 90% Non-condensing

2.3 Warranty

Thunder Scientific Corporation (TSC) warrants this product to be free of defects in material and workmanship under normal use and service when operated within the specified design limitations for a period of 1 year from date of shipment or 5000 operating hours, whichever ever comes first. TSC's obligation under this warranty shall be limited to the following: the Product is returned to TSC with transportation charges prepaid and that TSC's examination reveals the Product to be defective, TSC, at its option, shall repair or replace at TSC's plant, any part or parts of the Product which is or are defective. This warranty shall not apply to any Product that has become damaged or inoperative because of ordinary wear, misuse, cold, heat, rain, excessive humidity, freeze damage, use of improper chemicals, negligence, accident, failure to operate the product in accordance with the instructions provided in the Owners Manual(s) supplied with the product, improper maintenance, the use of accessories or attachments not recommended by TSC or unauthorized repair or alterations.

THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ANY WARRANTY OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, WHETHER EXPRESS OR IMPLIED, AND ALL OTHER LIABILITIES AND OBLIGATIONS ON THE PART OF TSC; TSC SHALL NOT BE LIABLE FOR ANY INCIDENTAL, INDIRECT OR CONSEQUENTIAL LOSS, DAMAGE, OR EXPENSE THAT MAY RESULT FROM ANY DEFECT, FAILURE OR MALFUNCTION OF THE PRODUCT.

All warranties, express or implied, with respect to any device or component not manufactured by TSC but incorporated into its Product are the responsibility of the original manufacturer and shall not affect or apply to TSC.

3 SAFETY GUIDELINES

All compressed gases, including air, can be dangerous. Know and follow all safety rules when using compressed air and especially when disconnecting and venting compressed air lines to install or modify equipment.

Always operate the ACS-1200 system in a clean, dry, well ventilated area, free of combustible materials, or solvent vapors. Operate the ACS-1200 in an open area at least 12 inches away from any wall or obstruction that would restrict the flow of fresh air to the ventilation openings. Restricting any of the ACS-1200 housing openings will cause serious overheating leading to probable failure or possible fire.

Your ACS-1200 system is powered by electricity. Like any other electrically powered device, if not used properly it may cause electric shock. Never operate in wet conditions and never operate with cover removed. Failure to provide adequate grounding could result in serious injury or death from electrocution. Make certain that the electrical circuit to which the ACS-1200 is connected provides proper electrical grounding, correct voltage and adequate fuse protection.

Attempting to operate the ACS-1200 with damaged or missing parts or attempting to repair the ACS-1200 with protective cover removed can expose you to moving parts and can result in serious injury. Any repair required should be performed by authorized personnel. Repairs attempted by unqualified personnel can result in serious injury or death by electrocution.

The compressed air directly from the ACS-1200 is not safe for breathing, and should never be used to supply air for human consumption. The dried air from a membrane dryer will contain less oxygen than normal air and under some conditions the dried air will not meet breathing air standards for oxygen content. The air stream may also contain carbon monoxide, toxic vapors, or solid particles. Breathing these contaminants can cause serious injury or death.

This ACS-1200 can fall from a table or workbench causing damage to the compressor and could result in serious injury. Always operate the ACS-1200 in a stable secure position to prevent accidental movement of the unit.

Refer to attached 71R Series Rocking Piston Pump Operating and Maintenance Manual for additional safety guidelines, hazard and warning information.

4 INSTALLATION

4.1 Unpacking

Unpack the ACS-1200 carefully and inspect it for any damage that may have occurred during shipment. If there is shipping damage, notify the carrier immediately. Verify that the power cord, air hose, and manual are present. If possible, save shipping container for future use.

4.2 Location

Locate the ACS-1200 in a clean, dry and well ventilated area. The system should be located at least 12 inches away from the wall or other obstructions that will restrict the flow of air to the ventilation openings. The compressor enclosure is designed to allow for proper cooling, therefore ventilation openings must remain unrestricted to maintain proper operating temperature.

4.3 Hose Assembly

Apply Teflon tape (1 thread back from end of fitting) to hose fitting and assemble hose fitting to air outlet of ACS-1200 using appropriate wrenches. Connect hose to fitting. Connect other end of hose to the 1200 humidity generator.

Important: 1) The hex fittings on the air outlet of the ACS-1200 and the 1200 humidity generator **MUST** be held in place with a wrench when tightening the fitting and hose.

2) When tightening Swagelok tube fittings, tighten Swagelok nut only 1/4 turn past finger tight.

4.4 Power

The ACS-1200 is equipped with a power receptacle and cord having a grounding wire with an appropriate grounding plug. The plug must be used with an outlet that has the same configuration as the grounded plug and has been installed and grounded in accordance with all local codes and ordinances.

Power of the appropriate voltage, frequency, and current capacity, is applied via power cord to the ACS-1200 power entry module.

4.4.1 Extension Cord

If an extension cord must be used, be sure it is a 3-wire extension cord that has a 3-blade grounding plug, and a 3-slot receptacle that will accept the plug on the ACS-1200 and is 14 gauge or larger and no longer than 50 feet.

5 COMPONENTS and CONTROLS

5.1 Power Entry Module

The Power Entry Module (PEM) allows insertion of the removable power cord, houses the On/Off power switch, and also houses the 10 amp time-delay fuse (FS1).

5.2 Hour Meter

The Hour Meter (HM1) tracks total run time of the ACS-1200 air compressing system.

5.3 Outlet Pressure Gauge

The Outlet Pressure Gauge (G1) indicates the regulated pressure available at the outlet of the ACS-1200 air compressing system. This pressure is controlled by the outlet pressure regulator.

5.4 Outlet Pressure Regulator

The Output Pressure Regulator (REG) controls the pressure available at the ACS-1200 outlet which is indicated on the outlet pressure gauge. Turn slotted adjustment screw clockwise to increase pressure and counterclockwise to decrease pressure.

Note: Pressures higher than 175 psi will be indicated by the "popping off" of the safety valve and should be avoided.

5.5 Air Compressor

The Oil-less Air Compressor (COMP) provides a maximum pressure of 175 psiG at a flow rate of 10 liters per minute or more.

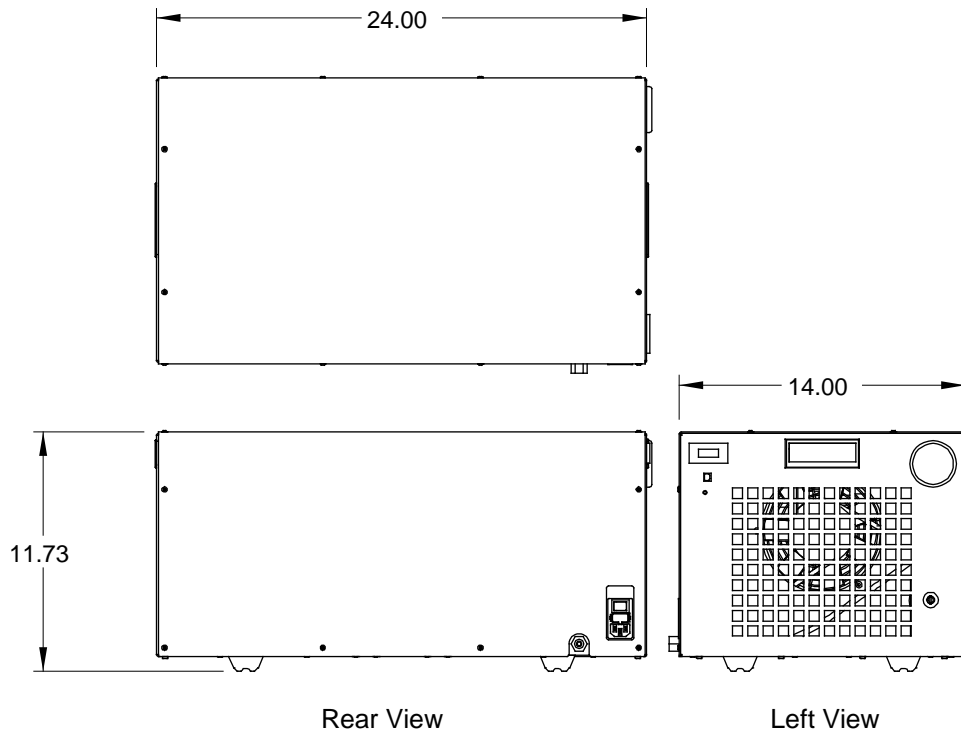
5.6 Membrane Compressed Air Dryer

The Membrane Compressed Air Dryer (AD1) is located after the air compressor and is specifically designed to remove water vapor from the compressed air stream. Typical pressure dew points of 0 °C or less are maintained.

5.7 Safety Valve

The Safety Valve (mounted on compressor) protects the system against pressures above 175 psiG. Pressures higher than 175 psi will be indicated by the "popping off" sound of the safety valve.

5.8 Dimensional Drawing



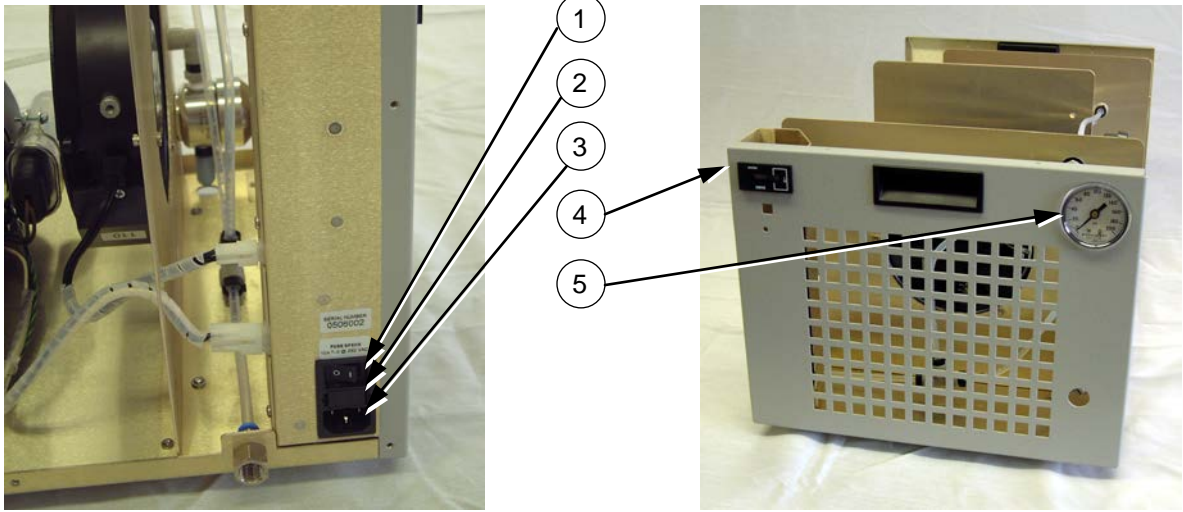
5.9 Component Locations

ITEM DESCRIPTION

1. On / Off Switch
2. Fuse (FS1)
3. Power Cord Receptacle
4. Hour Meter (HM1)
5. Pressure Gauge (G1)
6. Regulator (REG)

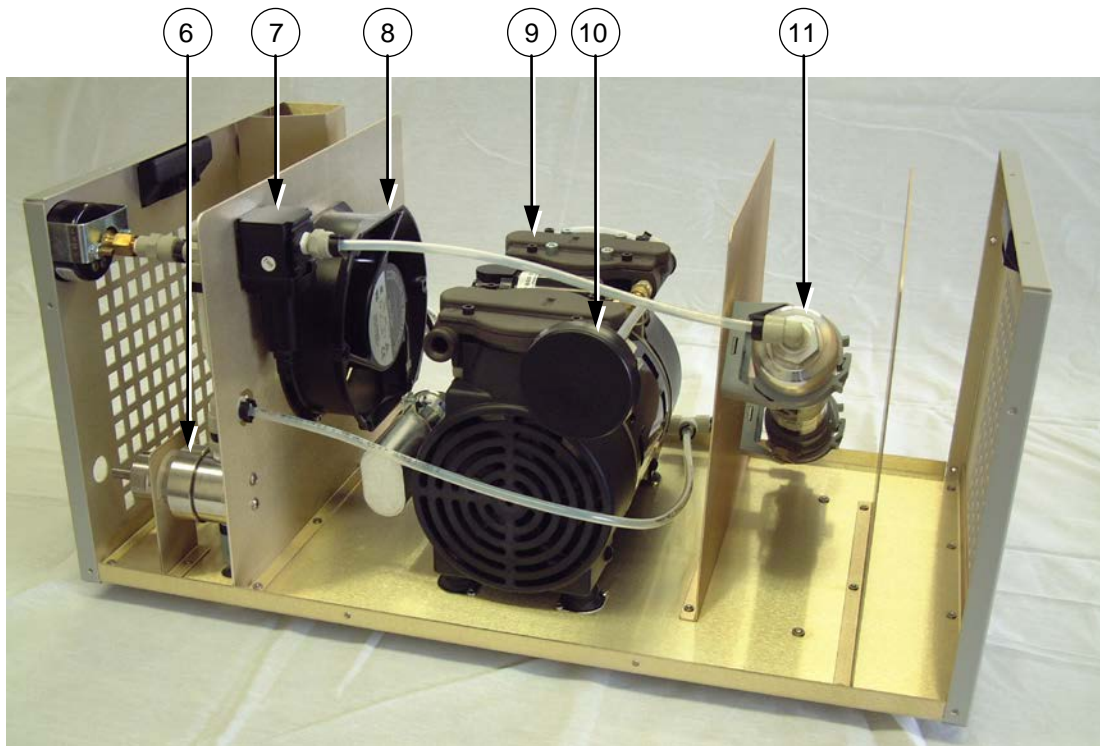
ITEM DESCRIPTION

7. Outlet Filter (LF2)
8. Circulation Fan (CF1)
9. Air Compressor (COMP)
10. Air Intake Filter (LF1)
11. Air Dryer (AD1)



Rear View

Left View



Front View

6 GENERAL OPERATION

6.1 Start-up

Be sure the "Hose Assembly" of paragraph 4.3 has been completed before proceeding.

Insert the power cord into the ACS-1200 power receptacle. With the ACS-1200 power switch in the off position, plug the power cord into an AC mains outlet of the appropriate voltage, frequency, and current capacity.

Apply power to the ACS-1200 using the On/Off power switch. The compressor will start and the outlet pressure gauge will indicate approximately 170 psiG.

6.2 Pressure Adjustment

If pressure adjustment is required adjust the output pressure to 170 psiG, during no-flow conditions, by turning the slotted adjustment screw on the regulator clockwise to increase pressure and counterclockwise to decrease pressure.

6.3 Shut-down

Disconnect power to the ACS-1200 using the On/Off power switch. The compressor will shut-down and the pressure will slowly vent as indicated by the outlet pressure gauge.

Important: All pressure MUST be vented before applying power again to the ACS-1200 or the compressor will not start and will possibly blow the power input fuse. All pressure must also be vented before disconnecting the air supply hose or severe personal injury may result.

7 INSPECTION and MAINTENANCE

7.1 Recommended Maintenance Schedule

<u>Periodic Maintenance</u>	<u>Hours 100% Duty Cycle</u>
Initial Inlet/Outlet Filter Inspection To establish service period	1st 500
Inlet/Outlet Filter Inspection Clean with water when necessary	User Determined
Minor Service Kit	15,000

7.2 Filter Inspection and Replacement

The Intake Filter and Outlet Filter require periodic inspection and cleaning. Initial inspection is suggested at 500 hours, then user should determine the frequency thereafter. Most problems can be prevented by keeping the filters clean. A dirty intake filter will decrease pump performance and can decrease pump life.

Warning: Disconnect power and be sure all pressure has been vented before service!

1. Intake Filter (LF1)
 - a. Remove the snap-fit cover.
 - b. Clean felt filter with water.
 - c. Replace snap-fit cover.

2. Outlet Filter (LF2)
 - a. Remove bowl by turning counterclockwise.
 - b. Unscrew baffle by turning counterclockwise.
 - c. Remove filter and clean with water.
 - d. Inspect bowl and seal. If bowl is dirty, clean by wiping the bowl with a soft dry cloth.
 - e. Insure seal is clean and in place then re-install bowl and rotate clockwise to lock securely in place.

7.3 Shutdown and Storage Procedures

Proper shutdown procedures must be followed to prevent pump damage. Failure to do so may result in premature pump failure. The non-lubricated compressor is constructed of ferrous metals and/or aluminum which are treated for corrosion protection but are still subject to possible rust and corrosion when pumping condensable vapors such as water.

Follow the steps below to assure correct shutdown and storage between use:

1. **NEVER** oil this non-lubricated compressor as damage will result.

2. For long term storage of the ACS-1200, disconnect the air hose and apply power allowing the compressor to run "open" for at least five minutes. After five minutes remove power and plug/cap outlet to prevent contaminants from entering. The ACS-1200 is now ready for storage.

Warning: All pressure **MUST** be vented before disconnecting air supply hose!

7.4 Compressor Service Kit

Refer to Gast 72R operating and maintenance manual for parts and procedures.

8 SCHEMATICS

8.1 Pneumatic Schematic

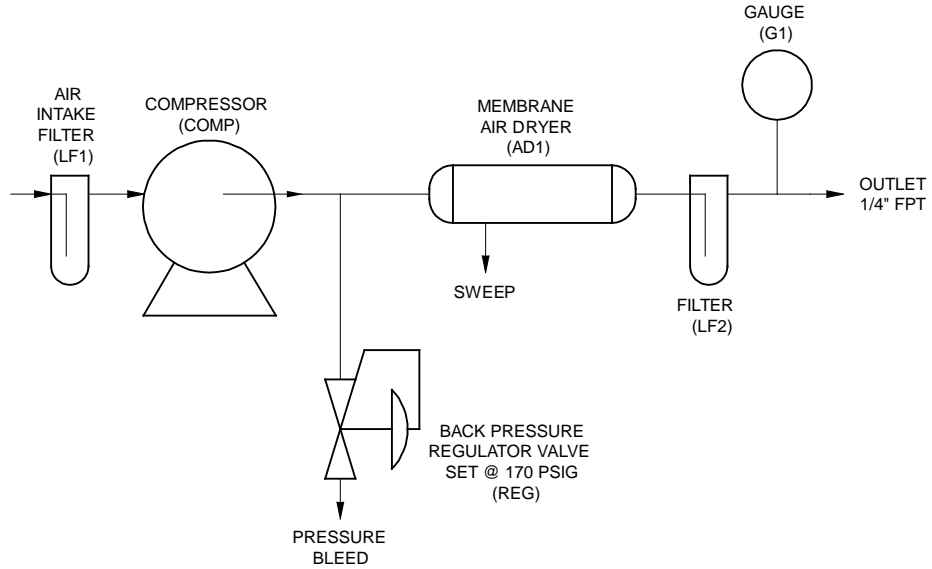


Figure 1-1

8.2 Electrical Schematic

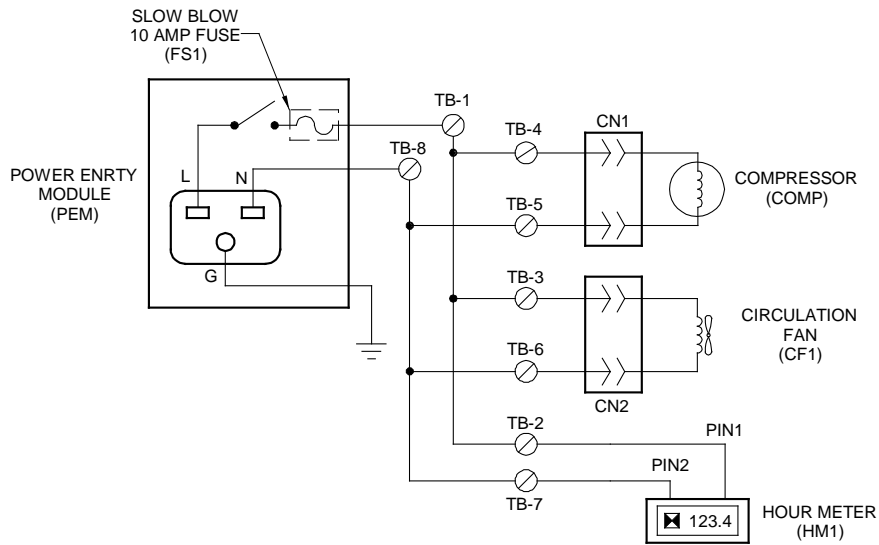


Figure 1-2

9 TROUBLESHOOTING GUIDE

Possible Reason	No / Low Pressure	High Pressure	Excessive Noise	Over Heating	Won't Start
Dirty Intake Filter	X				
Hose Leak	X				
Regulator Adjustment	X	X	X		
Worn or Damaged Compressor	X		X		X
Worn or Damaged Fan			X	X	
Safety Valve Leak	X				
Safety Valve "Popping Off"		X	X		
Plugged Pressure Line	X				X
Low Voltage				X	X
Blown Fuse	X				X
Blocked Ventilation Opening	X			X	X
High Outlet Pressure					X
Overheating		X			X

10 PARTS LIST

Find #	Qty	Description	Mfgr.	Part Number
PEM	1	Power Entry Module	Schurter	PEM-1205
				* PEM-1105
FS1	1	Fuse, 10 Amp Time Delay	Littlefuse	GMC10
	2	Fuse, 6.3 Amp Time Delay		* GDC6.3
HM1	1	Hour Meter	Curtis	HRMETERACS
COMP	1	Compressor, Air	Gast	GASTUNIV
G1	1	Gauge, Pressure	Ashcroft	G1X510
REG	1	Regulator, Back Pressure	Swagelok	JBPREG
AD1	1	Air Dryer, Membrane	Hankison	RHD001
CF1	1	Fan, Circulation	Comair Rotron	MR2B3
				* MR77B3
LF1	1	Filter Element, Inlet	Thomas	C87713
LF2	1	Filter Element, Outlet	Wilkerson	G6B225

11 OPTION INDICATORS

Asterisk Indicates Optional Parts

- * High Voltage (HV) Option Parts

71R & 72R SERIES ROCKING PISTON OIL-LESS PUMPS

OPERATION & MAINTENANCE MANUAL



Single Cylinder Model Shown



Twin Cylinder Model Shown

Thank you for purchasing this Gast product. It is manufactured to the highest standards using quality materials. Please follow all recommended maintenance, operational and safety instructions and you will receive years of trouble free service.



WARNING



PLEASE READ THIS MANUAL COMPLETELY BEFORE INSTALLING AND USING THIS PRODUCT. SAVE THIS MANUAL FOR FUTURE REFERENCE AND KEEP IN THE VICINITY OF THE PRODUCT.

Product Use Criteria:

- Pump only clean, dry air.
- Operate at 32°F - 104°F (0°C - 40°C).
- Protect unit from dirt & moisture.
- Do not pump flammable or explosive gases or use in an atmosphere that contains such gases.
- Protect all surrounding items from exhaust air. This exhaust air can become very hot.
- Corrosive gases and particulate material will damage unit. Water vapor, oil-based contaminants or other liquids must be filtered out.
- Consult your Gast Distributor/Representative before using at high altitudes.
- This pump is oil-less and requires NO lubrication.



ISO 9001 & 14001 CERTIFIED

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Your safety and the safety of others is extremely important.

We have provided many important safety messages in this manual and on your product. Always read and obey all safety messages.



This is the safety alert symbol. This symbol alerts you to hazards that can kill or hurt you and others. The safety alert symbol and the words “DANGER” and “WARNING” will precede all safety messages. These words mean:

DANGER

You **will** be killed or seriously injured if you don't follow instructions.

WARNING

You **can** be killed or seriously injured if you don't follow instructions.

All safety messages will identify the hazard, tell you how to reduce the chance of injury, and tell you what can happen if the safety instructions are not followed.

INSTALLATION

WARNING



Electrical Shock Hazard

Disconnect electrical power at the circuit breaker or fuse box before installing this product.

Install this product where it will not come into contact with water or other liquids.

Install this product where it will be weather protected.

Electrically ground this product.

Failure to follow these instructions can result in death, fire or electrical shock.

Correct installation is your responsibility. Make sure you have the proper installation conditions and that installation clearances do not block air flow.

Blocking air flow over the product in any way can cause the product to overheat.

Mounting

This product can be installed in any orientation. Mounting the product to a stable, rigid operating surface and using shock mounts will reduce noise and vibration.

Plumbing

Remove plugs from the IN and OUT ports. Connect with pipe and fittings that are the same size or larger than the product's threaded ports. Be sure to connect the intake and exhaust plumbing to the correct inlet and outlet ports. Ports will not support plumbing.

Accessories

The product's external intake and exhaust muffler will provide adequate filtration in most applications. Check filters periodically and replace when necessary. Consult your Gast Distributor/Representative for additional filter recommendations.

Install relief valves and gauges at inlet or outlet or both, to monitor performance. Check valves may be required to prevent back streaming through the pump.

Motor Control

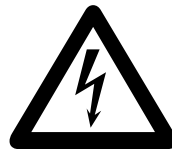
It is your responsibility to contact a qualified electrician and assure that the electrical installation is adequate and in conformance with all national and local codes and ordinances. The metal capacitor must be grounded.

Determine the correct overload setting required to protect the motor (see motor starter manufacturer's recommendations). Select fuses, motor protective switches or thermal protective switches to provide protection. Fuses act as short circuit protection for the motor, not as protection against overload. Incoming line fuses must be able to withstand the motor's starting current. Motor starters with thermal magnetic overload or circuit breakers protect motor from overload or reduced voltage conditions.

The wiring diagram supplied with the product provides required electrical information. Check that power source is correct to properly operate the dual-voltage motors.

Electrical Connection

WARNING



Electrical Shock Hazard

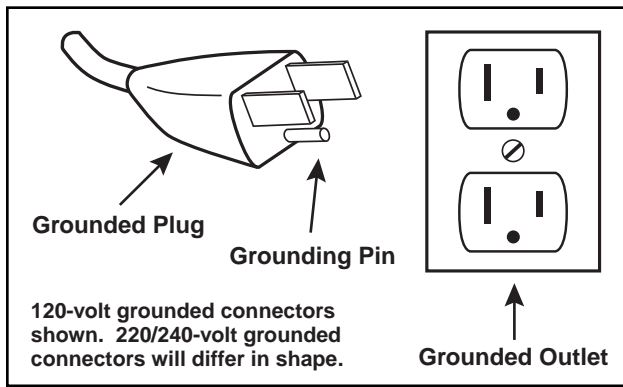
This product must be properly grounded.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

If repair or replacement of the cord or plug is necessary, do not connect the grounding wire to either flat blade terminal. The wire with insulation that is green or green with yellow stripes is the grounding wire.

Check the condition of the power supply wiring. Do not permanently connect this product to wiring that is not in good condition or is inadequate for the requirements of this product.

Failure to follow these instructions can result in death, fire or electrical shock.



Model with a power supply cord:

This product must be grounded. For either 120-volt or 220/240-volt circuits connect power supply cord grounding plug to a matching grounded outlet. Do not use an adapter. (See above diagram.)

In the event of an electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current. This product may be equipped with a power supply cord having a grounding wire with an appropriate grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if you are not sure whether the product is properly grounded. Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Model that is permanently wired:

This product must be connected to a grounded, metallic, permanent wiring system, or an equipment grounding terminal or lead on the product.

Power supply wiring must conform to all required safety codes and be installed by a qualified person. Check that supply voltage agrees with that listed on product nameplate.

Extension cords:

Use only a 3-wire extension cord that has a 3-blade grounding plug. Connect extension cord plug to a matching 3-slot receptacle. Do not use an adapter. Make sure your extension cord is in good condition. Check that the gage wire of the extension cord is the correct size wire to carry the current this product will draw.

An undersized cord is a potential fire hazard, and will cause a drop in line voltage resulting in loss of power causing the product to overheat. The following table indicates the correct size cord for length required and the ampere rating listed on the product nameplate. **If in doubt, use the next heavier gage cord. The smaller the gage number, the heavier the wire gage.**

Minimum gage for extension cords										
Amps	Volts	Length of cord in feet								
	120v	25	50	100	150	200	250	300	400	500
	240v	50	100	200	300	400	500	600	800	1000
0-2		18	18	18	16	16	14	14	12	12
2-3		18	18	16	14	14	12	12	10	10
3-4		18	18	16	14	12	12	10	10	8
4-5		18	18	14	12	12	10	10	8	8
5-6		18	16	14	12	10	10	8	8	8
6-8		18	16	12	10	10	8	6	6	6
8-10		18	14	12	10	8	8	6	6	4
10-12		16	14	10	8	8	6	6	4	4
12-14		16	12	10	8	6	6	6	4	2
14-16		16	12	10	8	6	6	4	4	2
16-18		14	12	8	8	6	4	4	2	2
18-20		14	12	8	6	6	4	4	2	2

OPERATION

WARNING

Injury Hazard
Install proper safety guards as needed.
Keep fingers and objects away from openings and rotating parts.
When provided, motor terminal covers must be in place for safe operation.
Product surfaces become very hot during operation, allow product surfaces to cool before handling.
Air stream from product may contain solid or liquid material that can result in eye or skin damage, wear proper eye protection.
Wear hearing protection. Sound level from motor may exceed 70 dBA.
Failure to follow these instructions can result in burns, eye injury or other serious injury.

It is your responsibility to operate this product at recommended pressures or vacuum duties and room ambient temperatures. Do not start against a vacuum or pressure load.

Start Up
 If motor fails to start or slows down significantly under load, shut off and disconnect from power supply. Check that the voltage is correct for motor and that motor is turning in the proper direction. Check the plug, cord and switch for damage. If so equipped, the thermal protection switch has tripped, the motor can restart after cooling.

MAINTENANCE

WARNING



Electrical Shock Hazard

Disconnect electrical power supply cord before performing maintenance on this product.

If product is hard wired into system, disconnect electrical power at the circuit breaker or fuse box before performing maintenance on this product.

Failure to follow these instructions can result in death, fire or electrical shock.

WARNING

Injury Hazard

Product surfaces become very hot during operation, allow product surfaces to cool before handling.

Air stream from product may contain solid or liquid material that can result in eye or skin damage, wear proper eye protection.

Clean this product in a well ventilated area.

Failure to follow these instructions can result in burns, eye injury or other serious injury.

It is your responsibility to:

- Regularly inspect and make necessary repairs to product in order to maintain proper operation.
- Make sure that pressure is released from product before starting maintenance.

Check intake and exhaust filters after first 500 hours of operation. Clean filters and determine how frequently filters should be checked during future operation. This one procedure will help to assure the product's performance and service life.

1. Remove filter cover.
2. Remove filters and felt (some filters are held together with a snap fitting). Clean filters by washing in a non-petroleum based solvent or soap and water. After cleaning, dry with compressed air to make sure all moisture is removed before reinstalling filters.
3. Reinstall felt and filters.
4. Reinstall cover.

Check that all external accessories such as relief valves and gauges are attached to cover and are not damaged before re-operating product.

SHUTDOWN PROCEDURES

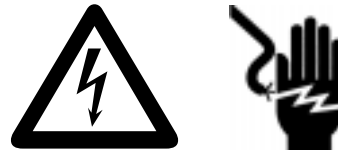
It is your responsibility to follow proper shutdown procedures to prevent product damage. NEVER ADD OIL TO THIS OIL-LESS PUMP.

Proper shutdown procedures must be followed to prevent pump damage. Failure to do so may result in premature pump failure. Gast Manufacturing Rocking Piston Oil-Less Pumps are constructed of ferrous metals or aluminum which are subject to rust and corrosion when pumping condensable vapors such as water. Follow the steps below to assure correct storage and shutdown between operating periods.

1. Disconnect plumbing.
2. Operate product for at least 5 minutes without plumbing.
3. Run at maximum vacuum for 10 to 15 minutes.
4. Repeat step 2.
5. Disconnect power supply.
6. Plug open ports to prevent dirt or other contaminants from entering product.

SERVICE KIT INSTALLATION

WARNING



Electrical Shock Hazard

Disconnect electrical power supply cord before installing Service Kit.

If product is hard wired into system, disconnect electrical power at the circuit breaker or fuse box before installing Service Kit.

Vent all air lines to release pressure or vacuum.

Failure to follow these instructions can result in death, fire or electrical shock.

Gast will NOT guarantee field-rebuilt product performance. For performance guarantee, the product must be returned to a Gast Authorized Service Facility.

Service Kit contents vary. Most contain gasket and filter parts.

1. Disconnect electrical power to pump.
2. Disconnect air supply and vent all air lines to release pressure or vacuum.
3. Mark the orientation of the ports so cover will be reinstalled correctly.
4. Remove screws from the head of the pump. Remove the head of the pump.
5. Mark orientation of valve plate(s). Remove valve plate(s).
6. Remove and discard old cups(s), retainer screws, cylinder O-ring(s), head O-ring(s), valves and valve retainers.
7. Install new cup(s) on rod(s) facing up.
8. Reinstall retainer plates.
9. Apply a thread locking compound (Loctite 222) to retainer screws. Torque screws to 34-38 in. lbs.
10. Carefully install cylinder(s) over cup(s) at an angle to avoid damaging cup(s).
11. Clean valve plates with water based solvent. Take care to not scratch valve seats.
12. Install valves and valve retainers. Check that the orientation with the ports is correct.
13. Apply a thread locking compound (Loctite 222) to retainer screws. Torque screws to 10-13 in. lbs.
14. Install cylinder O-ring(s) in the bottom of valve plate(s).
15. Check that the orientation of valve plate(s) with the ports is correct.
16. Install head O-rings in the O-ring grooves on top of valve plate.
17. Reinstall head over valve plate(s) checking that orientation with ports is correct.
18. Torque screws to 50 in. lbs.

Check that all external accessories such as relief valves and gauges are not damaged before re-operating product.

If pump still does not produce proper vacuum or pressure, send unit to a Gast Authorized Service Facility for repair.

WARRANTY

Gast finished products, when properly installed and operated under normal conditions of use, are warranted by Gast to be free from defects in material and workmanship for a period of twelve (12) months from the date of purchase from Gast or an authorized Gast Representative or Distributor. In order to obtain performance under this warranty, the buyer must promptly (in no event later than thirty (30) days after discovery of the defect) give written notice of the defect to Gast Manufacturing Incorporated, PO Box 97, Benton Harbor Michigan USA 49023-0097 or an authorized Service Center (unless specifically agreed upon in writing signed by both parties or specified in writing as part of a Gast OEM Quotation). Buyer is responsible for freight charges both to and from Gast in all cases.

This warranty does not apply to electric motors, electrical controls, and gasoline engines not supplied by Gast. Gast's warranties also do not extend to any goods or parts which have been subjected to misuse, lack of maintenance, neglect, damage by accident or transit damage.

THIS EXPRESS WARRANTY EXCLUDES ALL OTHER WARRANTIES OR REPRESENTATIONS EXPRESSED OR IMPLIED BY ANY LITERATURE, DATA, OR PERSON. GAST'S MAXIMUM LIABILITY UNDER THIS EXCLUSIVE REMEDY SHALL NEVER EXCEED THE COST OF THE SUBJECT PRODUCT AND GAST RESERVES THE RIGHT, AT ITS SOLE DISCRETION, TO REFUND THE PURCHASE PRICE IN LIEU OF REPAIR OR REPLACEMENT.

GAST WILL NOT BE RESPONSIBLE OR LIABLE FOR INDIRECT OR CONSEQUENTIAL DAMAGES OF ANY KIND, however arising, including but not limited to those for use of any products, loss of time, inconvenience, lost profit, labor charges, or other incidental or consequential damages with respect to persons, business, or property, whether as a result of breach of warranty, negligence or otherwise. Notwithstanding any other provision of this warranty, BUYER'S REMEDY AGAINST GAST FOR GOODS SUPPLIED OR FOR NON-DELIVERED GOODS OR FAILURE TO FURNISH GOODS, WHETHER OR NOT BASED ON NEGLIGENCE, STRICT LIABILITY OR BREACH OF EXPRESS OR IMPLIED WARRANTY IS LIMITED SOLELY, AT GAST'S OPTION, TO REPLACEMENT OF OR CURE OF SUCH NONCONFORMING OR NON-DELIVERED GOODS OR RETURN OF THE PURCHASE PRICE FOR SUCH GOODS AND IN NO EVENT SHALL EXCEED THE PRICE OR CHARGE FOR SUCH GOODS. GAST EXPRESSLY DISCLAIMS ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR PURPOSE WITH RESPECT TO THE GOODS SOLD. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTIONS SET FORTH IN THIS WARRANTY, notwithstanding any knowledge of Gast regarding the use or uses intended to be made of goods, proposed changes or additions to goods, or any assistance or suggestions that may have been made by Gast personnel.

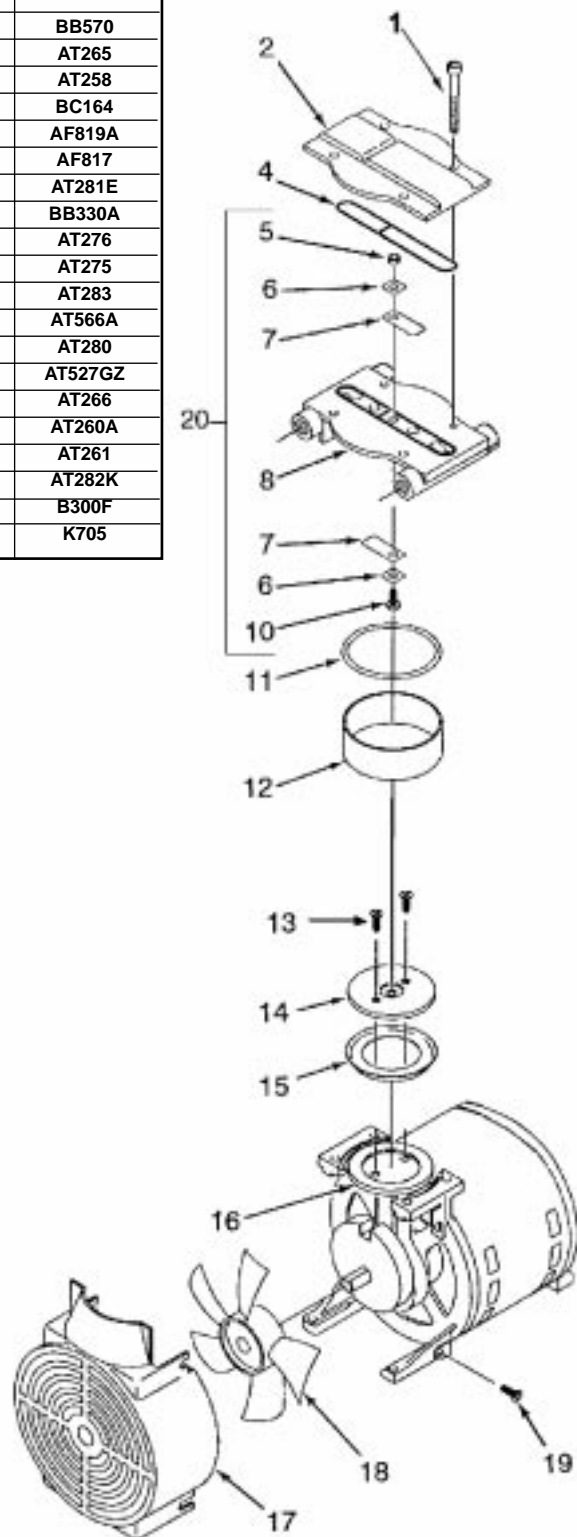
Unauthorized extensions of warranties by the customer shall remain the customer's responsibility.

CUSTOMER IS RESPONSIBLE FOR DETERMINING THE SUITABILITY OF GAST PRODUCTS FOR CUSTOMER'S USE OR RESALE, OR FOR INCORPORATING THEM INTO OBJECTS OR APPLICATIONS WHICH CUSTOMER DESIGNS, ASSEMBLES, CONSTRUCTS OR MANUFACTURES.

This warranty can be modified only by authorized Gast personnel by signing a specific, written description of any modifications.

EXPLODED PRODUCT VIEW, PARTS & ORDERING INFORMATION

REF	DESCRIPTION	QTY	71R135-P001B	71R142-P001B	72R142-P001B
1	CAP SCREWS	4	BB570	BB570	BB570
2	HEAD	1	AT265G	AT265G	AT265
4 Δ	HEAD O-RING	1	AT258	AT258	AT258
5	HEX NUT	1	BC164	BC164	BC164
6 Δ	VALVE RETAINER	2	AF819A	AF819A	AF819A
7 Δ	LEAF VALVE	2	AF817	AF817	AF817
8	VALVE PLATE	1	AT631E	AT631E	AT281E
10	VALVE SCREW	1	BB330B	BB330B	BB330A
11 Δ	CYLINDER O-RING	1	AT256	AT256	AT276
12 Δ	CYLINDER	1	AT272	AT272	AT275
13 Δ	RETAINER SCREW	2	AT283	AT283	AT283
14	RETAINER PLATE	1	AT715	AT715	AT566A
15 Δ	PISTON CUP	1	AT329	AT329	AT280
16	ROD ASSEMBLY	1	AT526KZ	AT526GZ	AT527GZ
17	SHROUD	1	AT266	AT266	AT266
18	FAN	1	AT260A	AT260A	AT260A
19	SHROUD SCREW	4	AT261	AT261	AT261
20	VALVE PLATE ASSEMBLY	1	AT633K	AT633K	AT282K
***	FILTER	1	B300F	B300F	B300F
***	SERVICE KIT	1	K704	K704	K705

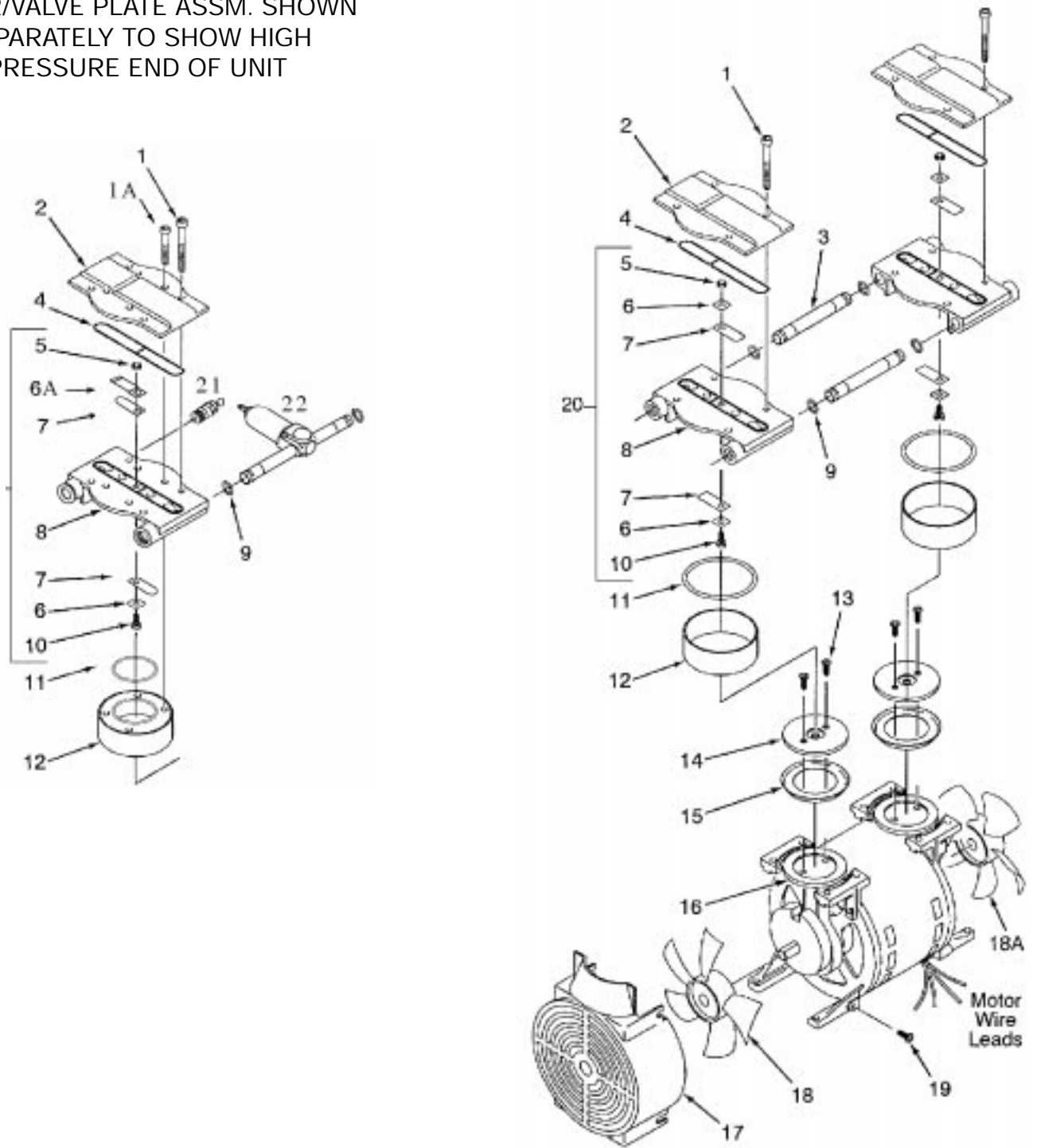


*** Item not shown.

Δ Denotes parts included in the Service Kit.

Parts listed are for stock models. For specific OEM models, please consult the factory.
When corresponding or ordering parts, please give complete model and serial numbers.

(FIG 1)
FOR MODELS 71R545-P315B
COVER/VALVE PLATE ASSM. SHOWN
SEPARATELY TO SHOW HIGH
PRESSURE END OF UNIT



EXPLODED PRODUCT VIEW, PARTS & ORDERING INFORMATION

REF	DESCRIPTION	QTY	71R645-P112 71R645-V114	71R655-P112 71R655-V114	72R645-P112 72R645-V114	72R655-P112 72R655-V114	71R545-P315B
1	CAP SCREWS	8	BB570	BB570	BB570	BB570	(4) BB570
1A	CAP SCREWS	4					(4) BB614B
2	HEAD	2	AT265G	AT265G	AT265G	AT265G	(1) AT265G (1) AT265H
4 Δ	HEAD O-RING	2	AT258	AT258	AT258	AT258	AT258
5	HEX NUT	2	BC164	BC164	BC164	BC164	BC164
6 Δ	VALVE RETAINER	2	AF819A	AF819A	AF819A	AF819A	(3) AF819A
6A	VALVE LIMITER	1					(1) AH406
7 Δ	LEAF VALVE	2	AF817	AF817	AF817	AF817	(2) AF817 (2) AJ827A
8	VALVE PLATE	1	AT631	AT631	AT632	AT632	(1) AT631C (1) AT632X
9 Δ	TUBE O-RING	4	AK846	AK846	AK846	AK846	(2) AT528
10	VALVE SCREW	2	BB330	BB330	BB330	BB330	BB330B
11 Δ	CYLINDER O-RING	1	AT256	AT256	AT276	AT276	(1) AT256 (1) AJ787
12 Δ	CYLINDER	2	AT272	AT272	AT275	AT275	(1) AT272 (1) AT291
13 Δ	RETAINER SCREW	4	BB557	BB557	AT283	AT283	(2) AT283 (2) BB557
14	RETAINER PLATE	2	AT273	AT273	AT274C	AT274C	(1) AT715 (1) AT443A
15 Δ	PISTON CUP	2	AT329	AT329	AT280	AT280	(1) AT329 (1) AT299A
16	ROD ASSEMBLY (pressure models)	2	AT465FZ	AT547BZ	AT467FZ	AT584BZ	(1) AT453FZ (1) AT459QZ
	ROD ASSEMBLY (vacuum models)	2	AT466FVZ	AT560BVZ	AT469FVZ	AT493BVZ	
17	SHROUD	2	AT266	AT266	AT266	AT266	AT266
18	FAN	1	AT260A	AT260A	AT260A	AT260A	AT260A
18A	FAN-LEAD END	1	AT259A	AT259A	AT259A	AT259A	AT259A
19	SHROUD SCREW	8	AT261	AT261	AT261	AT261	AT261
20	VALVE PLATE ASSEMBLY	1	AT633	AT633	AT634	AT634	AT633G
		1	AT633A	AT633A	AT634A	AT634A	AT634X
21	RELIEF VALVE	1					AT471
22	FILTER	1					AT441
***	RUBBER FEET	4	AB319	AB319	AB319	AB319	AB319
***	SERVICE KIT	1	K557	K557	K558	K558	K634

*** Item not shown.

Δ Denotes parts included in the Service Kit.

Parts listed are for stock models. For specific OEM models, please consult the factory.

When corresponding or ordering parts, please give complete model and serial numbers.

TROUBLESHOOTING CHART

Low		High		Pump Overheat	Won't Start	Excess Noise	Reason and remedy for problem.
Vacuum	Pressure	Vacuum	Pressure				
•	•	•		•	•		Filter dirty. Clean or replace.
•	•		•	•	•		Muffler dirty. Clean or replace.
•	•						Valves dirty or valves bent. Clean or replace.
•	•						Worn cup. Repair or replace.
			•	•	•		Relief valve set too high. Inspect and adjust.
•	•						Relief valve set too low. Inspect and adjust.
•	•	•	•	•	•		Plugged vacuum/pressure line. Inspect and repair.
•		•					Collapsed vacuum line. Inspect and repair.
				•	•		Low voltage, won't start. Check power source.
				•	•	•	Voltage wrong. Check power source.
•	•					•	Worn cup/piston hitting cylinder. Replace.
				•		•	Cylinder misadjustment. Realign.
•	•				•		Leaky hose or check valve. Replace.
•	•			•	•	•	Dirt or liquid on top of piston. Inspect and clean.
•	•			•	•	•	Motor not wired correctly. Check wiring diagram/line voltage.
•	•					•	Blown head gasket. Replace.



GAST MANUFACTURING, INC.
 A Unit of IDEX Corporation
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PART NO.:

RTD672

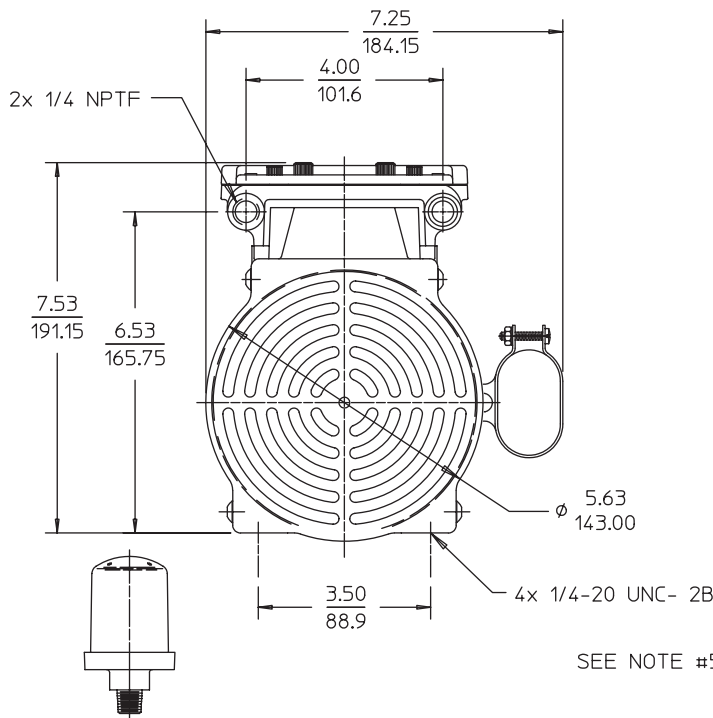
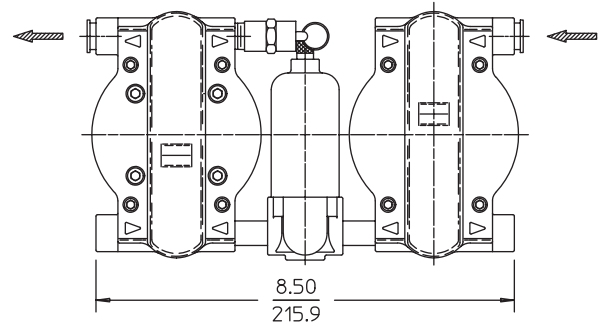
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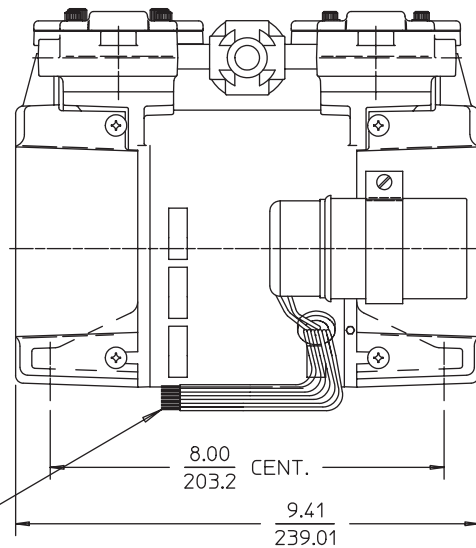
NOTES:

1. ALL DIMENSIONS ARE FOR REFERENCE USE ONLY.
2. PRODUCT DIMENSIONS: U.S. IMPERIAL (inches) METRIC (mm).
3. * = TECHNICAL DATA SUBJECT TO CHANGE WITHOUT NOTICE.
4. INSTALLATION: THIS PUMP MUST BE INSTALLED IN AN ENCLOSURE.
5. 7X #18 GA. LEADS TO BE 28-30" LONG
 "STRIPPED .32-.44" CLASS "B" INSULATION"

SOUND LEVEL	Less Than 70 dB(A)
NORMAL AMBIENT	+5 degC - +40 degC
RELATIVE HUMIDITY	20% - 80%
ENVIRONMENT	Clean Dust Free



FILTER UNATTACHED

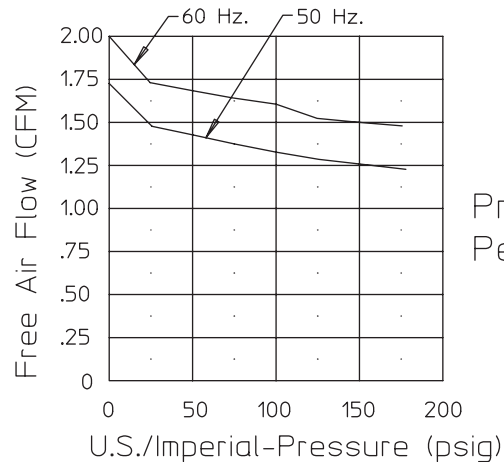


LOW VOLTAGE

- BRN. ——— CAP
- BRN./WHITE ——— CAP
- WHT. ——— LINE
- BLK. ——— LINE
- BLU. ——— LINE
- ORG. ——— LINE
- RED ——— LINE

HIGH VOLTAGE

- BRN. ——— CAP
- BRN./WHT. ——— CAP
- WHT. ——— LINE
- BLU. ——— LINE
- BLK. ——— LINE
- RED ——— LINE
- ORG. NOT USED



Product Performance

Product Specifications

Model Number	Motor	RPM		HP	kW	Net Wt.		CAPACITOR mfd. - volts
		60 cycle	50 cycle			lbs.	kg	
71R545-P315C-D425CX	100-115/230 60Hz. 100/220-240 50Hz.	1675	1400	1/2	0,37	16.0	7,25	15 - 370 v

