

VERDERFLEX[®]

Peristaltic Hose Pump

Operating manual

Dura 80

Version 00





Version 00



The information in this document is essential for the safe operation and servicing of Verderflex® Dura pumps. This document must be read and understood thoroughly prior to installation of unit, electrical connection and commissioning.

Table of Contents

- 1. Declaration of Conformity 5**
- 2. About This Document 7**
 - 2.1 Target groups7
 - 2.2 Warnings and symbols7
- 3. Safety 8**
 - 3.1 Intended use8
 - 3.2 General safety instructions.....8
 - 3.2.1 Product safety8
 - 3.2.2 Obligation of the operating company8
 - 3.2.3 Obligation of personnel9
 - 3.3 Specific hazards.....9
 - 3.3.1 Hazardous pumped liquids9
 - 3.3.2 Sharp edges.....9
 - 3.3.3 ATEX environment9
- 4. Transport, Storage and Disposal 10**
 - 4.1 Transport10
 - 4.1.1 Unpacking and inspection on delivery10
 - 4.1.2 Lifting10
 - 4.2 Storage conditions10
 - 4.3 Interim storage after using the pump10
 - 4.4 Interim storage before using the pump10
 - 4.5 Disposal11
- 5. Layout and Function 11**
 - 5.1 Design details.....11
 - 5.2 Labelling.....11
 - 5.2.1 Name plate.....11
 - 5.3 Layout12
- 6. Installation and Connection 13**
 - 6.1 Preparing for installation13
 - 6.1.1 Checking the ambient conditions13
 - 6.1.2 Preparing the installation site13
 - 6.1.3 Preparing the foundation and surface.....13
 - 6.2 Installation at site13
 - 6.3 Planning the pipes.....14
 - 6.3.1 Specifying supports and flange connections.....14
 - 6.3.2 Specifying nominal diameters14
 - 6.3.3 Specifying pipe lengths14
 - 6.3.4 Optimizing cross-section of pipework14
 - 6.3.5 Providing safety and control devices (recommended)14
 - 6.3.6 Solids size14
 - 6.4 Installing the motor and gearbox (where not supplied)15
 - 6.4.1 Connecting to a power supply.....15
 - 6.5 Shimming16
 - 6.6 Fitting the inspection window16
 - 6.7 Installing the hose16
 - 6.8 Flange assembly17
 - 6.8.1 Port flange assembly without insert17
 - 6.8.2 Port flange assembly with insert17
 - 6.9 Filling the pump with lubricant.....18
 - 6.10 Connecting the pipes18



Table of Contents

6.10.1	Installing the piping	19
7.	Operation	19
7.1	Pre-commissioning the pump.....	19
7.1.1	Checking the direction of rotation with dry pump	19
7.1.2	Starting the Pump	19
7.1.3	Switching OFF the pump	19
7.2	Commissioning the pump.....	20
7.2.1	Switching ON the Pump.....	20
7.2.2	Switching OFF the pump (refer to 7.1.3).....	20
7.3	Shutting down the pump	20
7.4	Start-up following a shutdown period	20
7.5	Operating the standby pump.....	21
8.	Inspection, Maintenance and Repair	22
8.1	Inspection.....	22
8.2	Maintenance.....	22
8.2.1	Cleaning the pump	22
8.2.2	Cleaning protocol for hoses	23
8.2.3	Maintenance schedule	24
8.3	Repair.....	25
8.3.1	Preparations for dismounting	25
8.3.1	Returning the pump to the manufacturer	25
8.3.2	Rebuild / Repair	25
8.4	Drain/change the lubricant	26
8.5	Grease the gearbox adaptor/bearing carrier	26
8.6	Hose change.....	26
8.7	Replace the rotor shoe.....	27
8.8	Replace the rotor.....	28
9.	Troubleshooting	29
9.1	Pump malfunctions.....	29
10.	List of Tables and Figures	32
11.	Technical specifications	33
11.1	Pump specifications	33
11.2	Ambient conditions.....	33
11.3	Tightening torques	33
11.4	Preservatives	33
11.5	Cleaning agents (after hose is removed).....	33
11.6	Lubricants.....	33
11.7	Solids size handling	33
11.8	Shimming chart	34
12.	Trademarks	35
13.	Document History	35

1. Declaration of Conformity (EC)



EC declaration of conformity according to machinery directive, appendix II A

We,
 VERDER Ltd., Unit 3 California Drive, Castleford
 hereby declare that the following machine adheres to the relevant EC directives detailed below:

Designation
Dura 80

EC directives:

- Machinery Directive (2006/42/EC)
- Low-voltage Directive (2014/35/EU)
- RoHS Directive (2011/65/EU) and Delegated Directive (2015/863/EU)

Applicable harmonized standards:

- BS EN ISO 12100:2010 - Safety of machinery - General principles for design - Risk assessment and risk reduction

The pump, to which this declaration refers, may only be put into operation after it has been installed in the way prescribed by the manufacturer and, as the case may be, after the complete system of which this pump forms part, has been made to fulfil the requirements of Machinery Directive 2006/42/EC.

<p>Manufacturer VERDER Ltd. Unit 3 California Drive Castleford WF10 5QH UK</p>	<p>Authorised Representative Established in EU (in accordance with Article 4, Regulation (EU) 2019/1020) Verder Liquids B.V Utrechtseweg 4a 3451 GG Utrecht Netherlands</p>
<p>Date: 24/ 11/ 2022</p>	<p>Company Stamp / Signature:  Anthony Beckwith Head of Engineering</p>

Declaration of Conformity (UK)



In accordance with the UK Supply of Machinery (Safety) Regulations 2008, No 1597 ANNEX II, Part I, Section B

We,
 VERDER Ltd., Unit 3 California Drive, Castleford
 hereby declare that the following machine adheres to the relevant UK legislation detailed below:

Designation
Dura 80

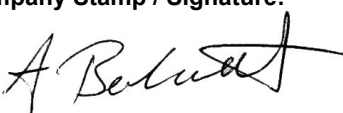
UK Legislation:

- Supply of Machinery (Safety) Regulations 2008
- The Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012
- Electrical Equipment (Safety) Regulations 2016

The following designated standard(s) has been applied:

- BS EN ISO 12100:2010 - Safety of machinery - General principles for design - Risk assessment and risk reduction

The pump, to which this declaration refers, may only be put into operation after it has been installed in the way prescribed by the manufacturer and, as the case may be, after the complete system of which this pump forms part, has been made to fulfil the requirements of The Supply of Machinery (Safety) Regulations 2008.

<p>Manufacturer</p>	<p>VERDER Ltd. Unit 3 California Drive Castleford WF10 5QH UK</p>
<p>Date: 24/ 11/ 2022</p>	<p>Company Stamp / Signature:</p>  <p>Anthony Beckwith Head of Engineering</p>

2. About This Document

The Verderflex Dura 80 is one of a range of peristaltic pumps which has been developed using the latest technology and subject to continuous quality control. These operating instructions are intended to facilitate familiarisation with the pump and its designed use. This manual will act as a guide for operating the pump. You are advised to follow these guidelines to operate the pump correctly. These operating instructions do not take local regulations into account. The operator must ensure that such regulations are strictly observed by all, including the personnel responsible for installation.

2.1 Target groups

Target Groups	Duty
Operating company	<ul style="list-style-type: none"> ▶ Keep this manual available at the operating site of the pump. ▶ Ensure that personnel read and follow the instructions in this manual and any other applicable documents, especially all safety instructions and warnings. ▶ Observe any additional rules and regulations referring to the system.
Qualified personnel, fitter	<ul style="list-style-type: none"> ▶ Read, observe and follow this manual and the other applicable documents, especially all safety instructions and warnings.

Table 1. - Target groups

2.2 Warnings and symbols




Warning	Risk Level	Consequences of disregard
 DANGER	Immediate risk	Death, serious bodily harm
 WARNING	Potential acute risk	Death, serious bodily harm
 CAUTION	Potential hazardous situation	Potential damage to the pump
Note	For information	Possible incorrect use maintenance of pump

Table 2. - Warnings used in the manual




Symbol	Meaning
	Safety warning sign in accordance with DIN 4844-W9 <ul style="list-style-type: none"> ▶ Take note of all information highlighted by the safety warning sign and follow the instructions to avoid injury or death.
▶	Instruction
1., 2.,	Multiple-step instructions
☐	Checklist
→	Cross-reference
	Information

Table 3. - Symbols used in the manual

3. Safety

 The manufacturer does not accept any liability for damage resulting from disregard of this documentation.

3.1 Intended use

- ▶ Only use the pump to handle compatible fluids as recommended by the manufacturer (→11. Technical specifications).
- ▶ Adhere to the operating limits.
- ▶ Consult the manufacturer regarding any other use of the pump.
- ▶ Pumps delivered without a motor must be fitted with a motor in accordance with the provisions of EC Machinery Directive 2006/42/EC.
- ▶ Note the operating limits of the pump with regard to temperature, pressure, flow rate and motor speed (→11. Technical specifications)


Prevention of obvious misuse (examples)

- ▶ Do not operate the pump with any inlet/outlet valves closed
- ▶ Only install the pump as recommended in this manual.

For example, the following are not allowed:

- Installing the pump without proper support.
- Installation in the immediate vicinity of extreme hot or cold sources.

3.2 General safety instructions

 Observe the following before carrying out any work:

3.2.1 Product safety

- These operating instructions contain fundamental information which must be complied with during installation, operation and maintenance. Therefore, this operating manual must be read and understood both by the installing personnel and the responsible trained personnel / operators prior to installation and commissioning, and it must always be kept easily accessible within the operating premises of the machine.
- Not only must the general safety instructions laid down in this chapter on "Safety" be complied with, but also the safety instructions outlined under specific headings.
- Operate the pump only if it and all associated systems are in good functional condition.
- Only use the pump as intended, fully aware of safety and risk factors involved and the instructions in this manual.
- Keep this manual and all other applicable documents complete, legible and accessible to personnel at all times.
- Refrain from any procedure or action that would pose a risk to personnel or third parties.
- In the event of any safety-relevant faults, shut down the pump immediately and have the malfunction corrected by qualified personnel.

- The installation of the pump must comply with the requirements of installation given in this manual and any local, national or regional health and safety regulations.

3.2.2 Obligation of the operating company

Safety-conscious operation

- Ensure that the following safety aspects are observed and monitored:
 - Adherence to intended use
 - Statutory or other safety and accident-prevention regulations
 - Safety regulations governing the handling of hazardous substances if applicable
 - Applicable standards and guidelines in the country where the pump is operated
- Make personal protective equipment available pertinent to operation of the pump.

Qualified personnel

- Ensure that all personnel tasked with work on the pump have read and understood this manual and all other applicable documents, including the safety, maintenance and repair information, prior to use or installation of the pump.
- Organise responsibilities, areas of competence and the supervision of personnel.
- Have all work carried out by specialist technicians only.
- Ensure that trainee personnel are under the supervision of specialist technicians at all times when working with the pump.

Safety equipment

Provide the following safety equipment and verify its functionality:

- For hot, cold and moving parts: safety guarding should be provided by the operating company.
- For potential build-up of electrostatic charge: ensure appropriate grounding if and when required.


Warranty

The warranty is void if the customer fails to follow any Instruction, Warning or Caution in this document. Verder has made every effort to illustrate and describe the product in this document. Such illustrations and descriptions are, however, for the sole purpose of identification and do not express or imply a warranty that the products are merchantable or fit for a particular purpose, or that the products will necessarily conform to the illustration or descriptions.

Obtain the manufacturer's approval prior to carrying out any modifications, repairs or alterations during the warranty period. Only use genuine parts or parts that have been approved by the manufacturer.

For further details regarding warranty, refer to terms and conditions.

3.2.3 Obligation of personnel

 It is imperative that the instructions contained in this manual are complied with by the operating personnel at all times.

- ▶ Pump and associated components:
 - Do not lean or step on them or use as a climbing aid
 - Do not use them to support boards, ramps or beams
 - Do not use them as a fixing point for winches or supports
 - Do not de-ice using gas burners or similar tools
- ▶ Do not remove the safety guarding for hot, cold or moving parts during operation.
- ▶ Reinstall the safety equipment on the pump as required by regulations after any repair / maintenance work on the pump.

3.3 Specific hazards

3.3.1 Hazardous pumped liquids

Follow the statutory safety regulations when handling hazardous pumped liquids (e.g., hot, flammable, poisonous or potentially harmful).

Use appropriate Personal Protective Equipment when carrying out any work on the pump.

3.3.2 Sharp edges

Pump parts, such as the shims, can be sharp.

- Use protective gloves when carrying out any work on the pump


3.3.3 ATEX environment

Failure to implement the necessary safety procedures and failure to disclose the intended use of a pump within an explosive atmosphere as laid down in latest EC Atex Directive 2014/34/EU will void all warranty for the product (refer to warranty terms and conditions for more details).

Verder shall not be liable for any injuries, losses or damages including, but not limited to, any personal injuries, anticipated or lost profits, incidental damages, consequential damages, costs, time charges, or other damages or losses, in connection with the instrument, its use or any replacement parts if the customer fails to follow any Instruction, Warning or Caution in this document.

4. Transport, Storage and Disposal

4.1 Transport

 Always transport the pump in a stable position and ensure that the pump is securely attached to the pallet.

4.1.1 Unpacking and inspection on delivery

1. Report any transport damage to the manufacturer/distributor immediately.
2. Retain the pallet if any further transport is required.

4.1.2 Lifting



DANGER

Death or crushing of limbs can be caused by falling loads!

1. Use lifting apparatus appropriate for the total weight to be transported.
2. Make sure the pump and accessories are lifted and moved by qualified lifting personnel equipped with suitable lifting apparatus.
3. Fasten the lifting apparatus to the lifting eye as shown in the following illustration.
4. Do not stand under suspended loads.

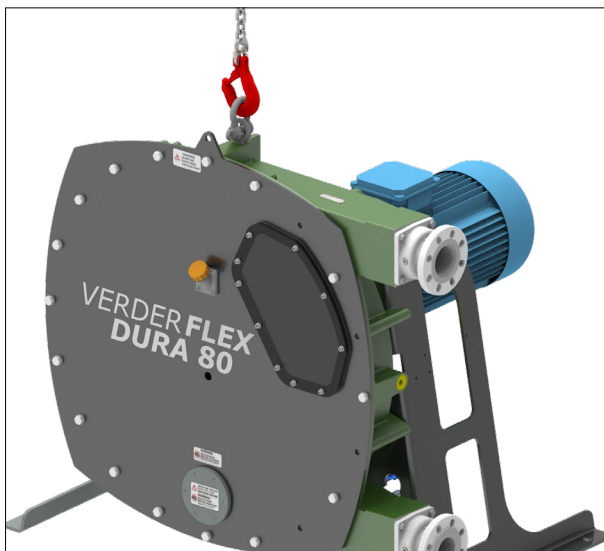


Figure 1. - Fastening apparatus gear to pump

4.2 Storage conditions

1. Make sure the storage location meets the following conditions:
 - Dry, humidity not to exceed 85%, non-condensing
 - Out of direct sunlight
 - Frost-free; temperature range -5 °C to +45 °C
 - Vibration-free
 - Dust-free
2. Depending on these conditions, it may be advisable to place a moisture-absorbing product, such as Silica gel, inside the pump's housing or to coat the pump's inner surfaces with moisture-repelling oil, such as WD40, whilst the pump is stored.
3. Hoses should be stored as supplied in their wrapper and should be stored away from direct sunlight, flat without any bends or kinks and at room temperature with end caps fitted.
4. Lubricants should be stored under normal warehouse conditions with their caps securely fastened.
5. Gearboxes may require intermittent attention as indicated by the gearbox manufacturer's recommendations.

4.3 Interim storage after using the pump

- ▶ The hose should be removed from the pump.
- ▶ The pump housing lubricant should be drained.
- ▶ The pump housing should be washed out, allowed to dry and any external build-up of product removed.

4.4 Interim storage before using the pump



CAUTION

Pump damage caused by interim storage!

- ▶ Allow the pump to reach ambient temperature before use.
- ▶ Please observe the storage recommendations and use by dates which apply to the hose you may wish to bring into service after storage.

4.5 Disposal

With prolonged use, pump parts can be contaminated by hazardous pumped liquids to such an extent that cleaning may be insufficient.




WARNING


Risk of poisoning and environmental damage by the pumped liquid or oil!

- ▶ Use suitable personal protective equipment when carrying out any work on the pump.
- ▶ Prior to disposal of the pump:
 - Drain and dispose of the lubricant in accordance with local regulations.
 - Collect and dispose of any leaking pumped liquid or oil in accordance with local regulations.
 - Neutralize residues of pumped liquid in the pump.
- ▶ Dispose of the pump and associated parts in accordance with local regulations.

5. Layout and Function

 The medium to be pumped does not come into contact with any moving parts and is totally contained within the hose. A rotor passes along the length of the hose, compressing it. This motion forces the contents of the hose directly in front of the rotor to move forward along the length of the hose in a 'positive displacement' peristaltic movement. In the wake of the rotor's compressing action, the natural elasticity of the polymer reinforced rubber forces the hose to open and regain its round profile, creating suction pressure, which recharges the pump.

5.1 Design details

 The Verderflex Dura 80 is a twin lobe, single rotor, peristaltic pump with 1/4 port flange design which clamps and seals in one easy movement to speed up hose replacement.

5.2 Labelling

5.2.1 Name plate

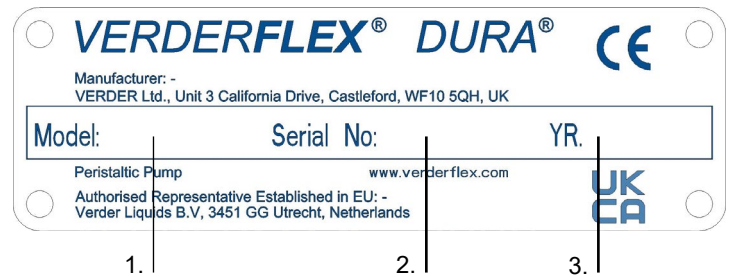



Figure 2. - Name plate

1. Pump Type
2. Serial Number
3. Year of Manufacture

 When requesting spares, the model and serial number should always be quoted.

5.3 Layout

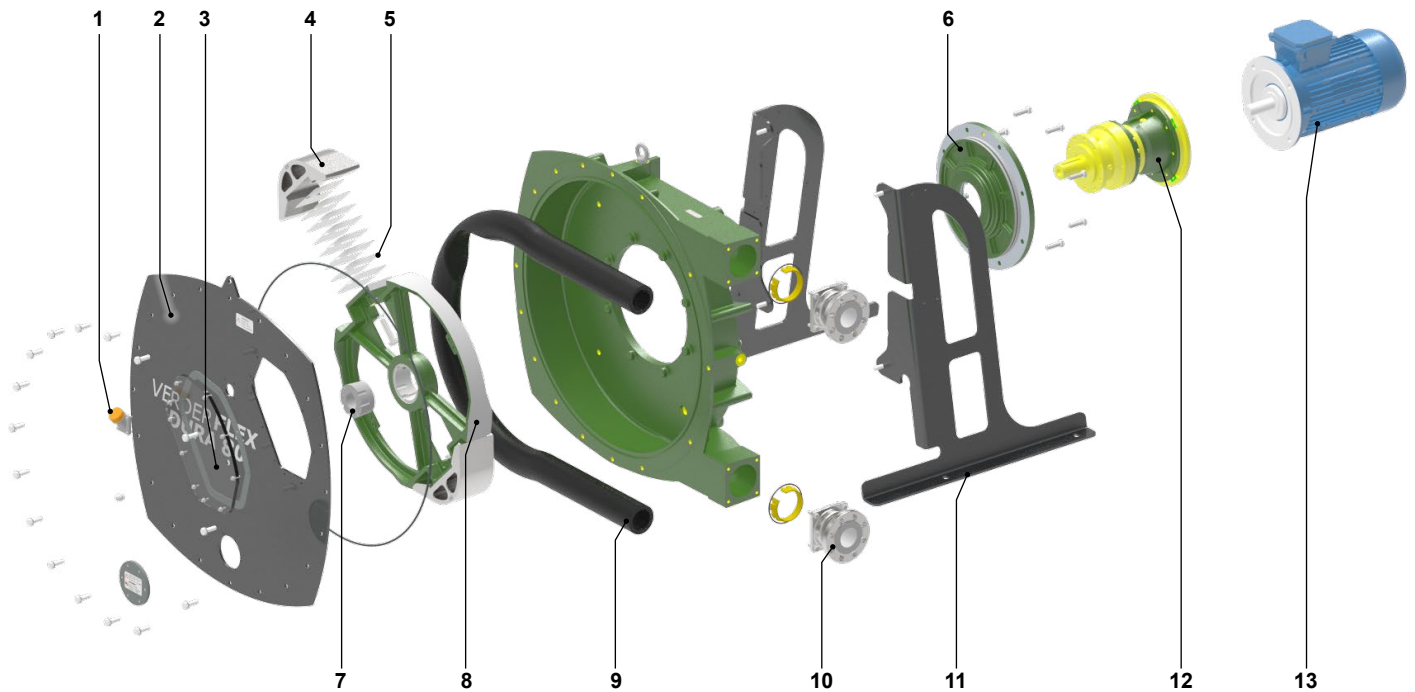


Figure 3. - Layout Dura 80 (Generic View)

- | | | | | | |
|---|-------------------------------|----|----------------------|----|---------|
| 1 | Filler port | 6 | Gearbox adaptor | 11 | Frames |
| 2 | Front cover assembly | 7 | Taperlock bush | 12 | Gearbox |
| 3 | Front cover inspection window | 8 | Rotor assembly | 13 | Motor |
| 4 | Rotor shoe assembly | 9 | Hose | | |
| 5 | Shims pack | 10 | Port flange assembly | | |

6. Installation and Connection



CAUTION

Material damage due to unauthorized modification on pump!

- ▶ Unauthorized modification will invalidate the warranty.

6.1 Preparing for installation

6.1.1 Checking the ambient conditions

1. Make sure that the operating conditions are complied with (→ 11. Technical specifications)
2. Make sure the required ambient conditions are fulfilled (→ 11. Technical specifications)

6.1.2 Preparing the installation site

- ▶ Ensure the installation site meets the following conditions:
 - Pump is freely accessible from all sides.
 - Sufficient space is available for the installation/ removal of the pipes and for maintenance and repair work, especially for the removal and installation of the hose.
- ▶ The pump and drive unit must not be installed in direct sunlight or exposed to rain without suitable shade cover.

6.1.3 Preparing the foundation and surface

- ▶ Make sure the foundation and surface meet the following conditions:
 - Level
 - Clean (no oil, dust or other impurities)
 - Capable of bearing the weight of the pump and all operating forces
 - Ensure the pump is stable and cannot tip over
 - Concrete foundation: Standard concrete strong enough to support the pump under load.

6.2 Installation at site


1. Lift the pump. (→ 4.1.2 Lifting)
2. Put the pump down at the installation site.
3. Bolt the pump down; use all 4 holes.

6.3 Planning the pipes

6.3.1 Specifying supports and flange connections

- When planning pipe runs, take every possible operating condition into account:
 - Cold / warm medium
 - Empty / full
 - Unpressurized / pressurized
 - Positional change of the flanges
- Ensure that the pipe supports are designed to accommodate any movement from environmental or pressure imposed forces.

6.3.2 Specifying nominal diameters

-  Keep the flow resistance in the pipes as low as possible. Pipework immediately connected to both inlet and outlet ports of the pump should be straight runs for at least 1 metre.

Ensure that nominal pipe diameter is at least 1.5 times nominal pump-hose diameter to reduce pulsation.

6.3.3 Specifying pipe lengths


- Keep pipework as short and direct as possible.
- To allow easy access when changing hoses, include a short, removable section adjacent to the port flanges.

6.3.4 Optimizing cross-section of pipework

- Avoid bending radii of less than 10r (r - the radii of nominal piping).
- Avoid abrupt changes of cross-section along the piping.

6.3.5 Providing safety and control devices (recommended)

Making provisions for isolating and shutting off pipes

-  For maintenance and repair work.


- ▶ Provide shut-off valves in the suction and discharge lines.

Allowing safe removal of product

- ▶ Include drainage taps in suction and discharge lines at the lowest point.

6.3.6 Solids size

Large solids can potentially damage the pump; for a specific solids size, refer to →11. Technical specifications.

-  For solids larger than mentioned in the table, we advise filtering before entering the pump.

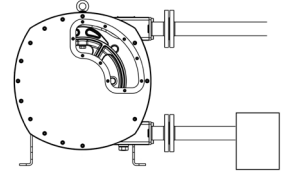

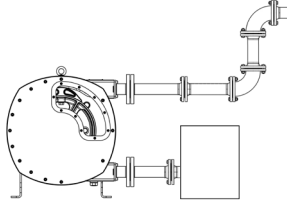
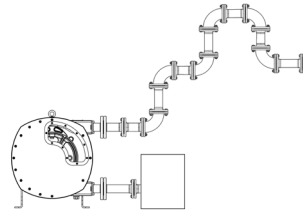
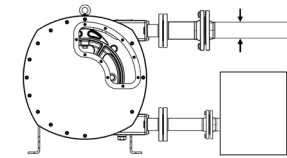
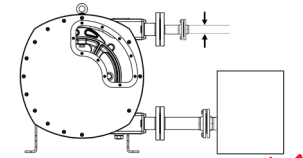
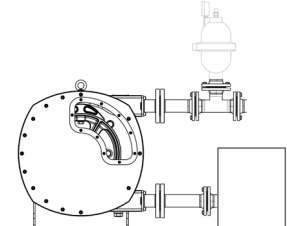
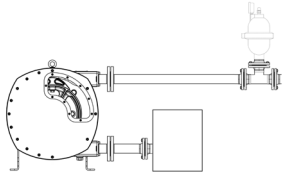
Dos	Don'ts
<p>1. Short pipe run to suction side</p>  <p style="text-align: right; color: green; font-size: 2em;">✓</p>	<p>Long pipe run to suction side</p>  <p style="text-align: right; color: red; font-size: 2em;">✗</p>
<p>2. Reduced joints/bends</p>  <p style="text-align: right; color: green; font-size: 2em;">✓</p>	<p>Multiple joints/bends</p>  <p style="text-align: right; color: red; font-size: 2em;">✗</p>
<p>3. Connecting pipe with diameter 1.5 times pump hose diameter</p> <p>Pipe ID 1.5 times hose ID</p>  <p style="text-align: right; color: green; font-size: 2em;">✓</p>	<p>Connecting pipe with smaller than pump hose diameter</p> <p>Pipe ID < pump hose ID</p>  <p style="text-align: right; color: red; font-size: 2em;">✗</p>
<p>4. Pulsation dampener connected close to the pump</p> <p>Pulsation dampener</p>  <p style="text-align: center;">Bellows</p> <p style="text-align: right; color: green; font-size: 2em;">✓</p>	<p>Pulsation dampener connected away from pump</p> <p>10% loss in dampener efficiency for every meter</p>  <p style="text-align: right; color: red; font-size: 2em;">✗</p>

Table 4. - Dos and don'ts

6.4 Installing the motor and gearbox (where not supplied)



DANGER

Death or crushing of limbs caused by falling loads!

- ▶ Use lifting gear appropriate for the total weight to be transported.
- ▶ Make sure the pump and accessories are lifted and moved by qualified lifting personnel equipped with suitable lifting gear.
- ▶ Do not stand under suspended loads.

Note

Please consult the motor and gearbox manual for the orientation of gearbox and use of a breather.

1. Attach the key to gearbox shaft.
2. Apply anti-seize grease to the gearbox shaft.
3. Attach the gearbox to the pump housing.
4. Fit the screw hex head with washers to fasten the gearbox to the gearbox adaptor.

Note

Please note that the size and number of the screws depends on the type of the gearbox:

- ▶ For the 305 gearbox: M12 screws x 10
 - ▶ For the 306 gearbox: M14 screws x 12
 - ▶ For the 307 gearbox: M16 screws x 8
5. Use a torque wrench to apply tightening torque (→11. Technical specifications).

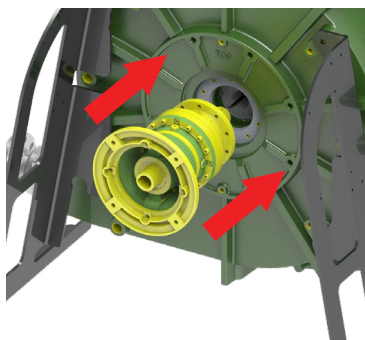


Figure 4. - Installing the gearbox

6. Apply anti-seize grease to the motor shaft.
7. Attach the motor to the gearbox.

Note

Please note that the size and number of screws depends on the type of motor:

- ▶ For the 112/132 motors, M12 screws x 4
- ▶ For the 160/180 motors, M16 screws x 4

8. Use a torque wrench to apply tightening torque (→11. Technical specifications).

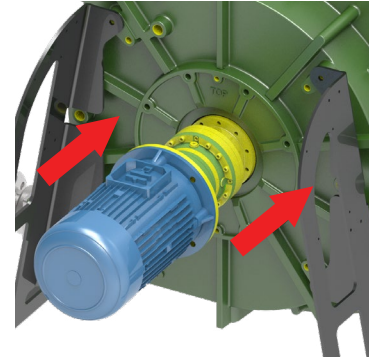


Figure 5. - Installing the motor

6.4.1 Connecting to a power supply



DANGER


Risk to health due to electric shock!

All electrical work must be carried out by qualified electricians.

1. Connect motor to the rated power supply. Ensure the correct gland is used and that the earth connection is made and secured.
2. Wiring instructions are available within the motor junction box.
3. Run the pump slowly to ensure correct rotation.

For more information on wiring the motor please refer to the relevant motor manual.

6.5 Shimming

 The pump must be shimmed for the required discharge pressure with the following procedure (→11. Technical specifications).

1. Please note that the Dura 80 can be shimmed without draining the lubricant. For changing the lubricant from the pump housing, please refer to 8.4 Drain/change the lubricant.
2. Rotate the pump so that a rotor shoe is visible through the inspection window.
3. Remove the inspection window and gasket. Leave the bolts on the inspection window for reassembly.
4. Loosen the shoe bolt.
5. Remove any existing shims.
6. Replace with correct number of shims for the required pressure (→11. Technical specifications).
7. Tighten the shoe bolt (→11. Technical specifications).
8. Repeat with the other rotor shoe.
9. Ensure the lubricant level is correct. (→11. Technical specifications).
10. Replace the window and gasket ensuring it is fitted the correct way with the bolts (→6.6 Fitting the inspection window).

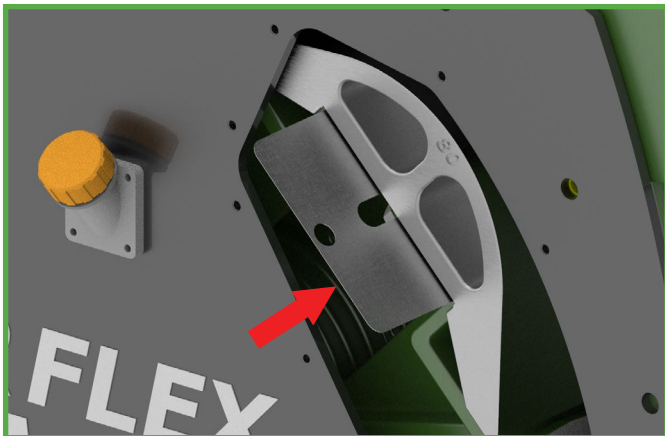


Figure 6. - Shimming

6.6 Fitting the inspection window

1. Fit M8 cap head bolts with washers into the window. The window is threaded to make bolts captive and counter-bored on the back face.
2. Mount the gasket on to the bolts.
3. Mount the window unit, with the bolts and gasket, over the front cover, aligned as shown in Figure 7.
4. Nip the bolts down in sequence ensuring that the bolts are not over-tightened (→11. Technical specifications). You can see the gasket pressing against the window as the bolts clamping force takes effect.

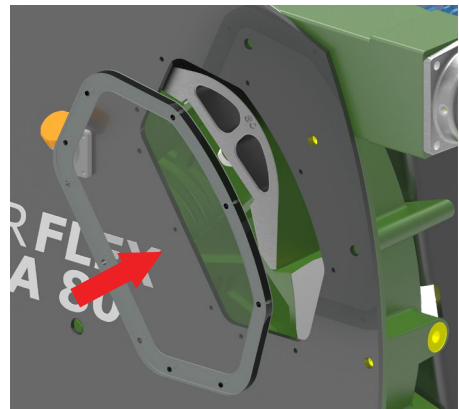


Figure 7. - Fitting the inspection window

6.7 Installing the hose

Connect the motor to the power supply and run the pump slowly to ensure correct connection.

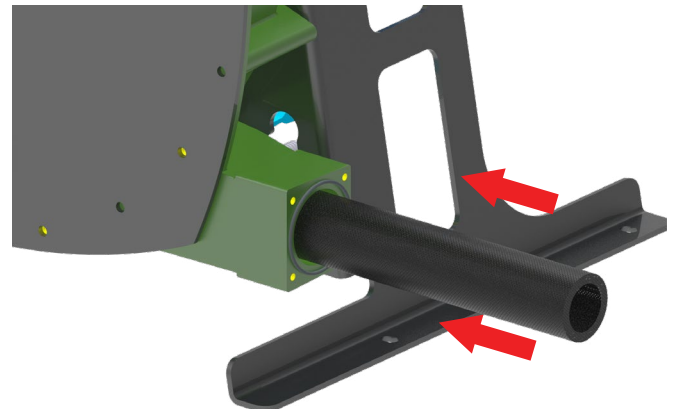


Figure 8. - Installing the hose

1. Lubricate the hose generously with Verderlube/Verdersil.
2. Insert the hose into the suction port (lower port as per Figure 8. - Installing the hose)
3. Run the pump forward and stop when the hose protrudes approx. 40mm.



CAUTION

Ensure the hose is installed as indicated in 6.8 Flange assembly.

6.8 Flange assembly

6.8.1 Port flange assembly without insert



CAUTION

1. Ensure the hose is installed as per 6.7 Installing the hose.
2. Insert the clamp ring over the hose with the large diameter towards the pump and ensure that the hose is protruding 5 to 10 mm past the clamp ring:

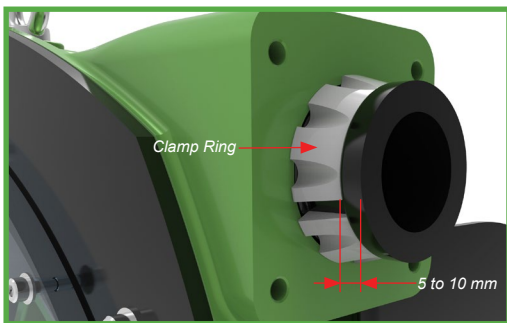


Figure 9. - Clamp ring inserted

3. Apply some lubricant compatible with the pumped media to the port flange.
4. Fit the O-ring to the port flange, making sure the O-ring is in place in the face groove.
5. Push the port flange into the hose.
6. Install the 4 bolts.
7. Tighten the bolts in a 1–3–4–2 sequence until the flange is evenly fitted; all 4 bolts should be fitted to each flange to avoid compromising the performance of the pump.
8. Ensure that only the hose can be seen through the drain port on the port flange (Figure 12).
9. Run the pump forward and stop when the hose is protruding 40 mm from the discharge/ upper port (Figure 10).
10. Repeat steps 2 - 8 for the other port to complete assembly.

6.8.2 Port flange assembly with insert

1. Slide the insert into the port flange and fix it with a counter flange (Figure 11).
2. Follow 6.8.1 to complete assembly.
3. Remove the counter flange(s) - see Figure 15.

6.8.3 Hose and flange assembly

6.8.3.1 Port flange assembly without insert

Hose is in position and protrudes 40 mm from the pump housing flange face (the side through which the hose has been inserted):

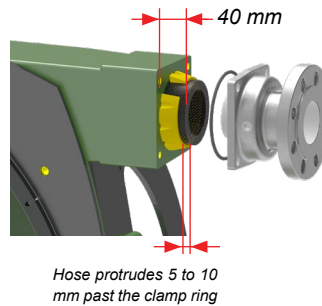


Figure 10. - Port flange without insert

6.8.3.2 Port flange assembly with insert

It is recommended to use a counter flange to fix the insert and push the flange insert unit in:

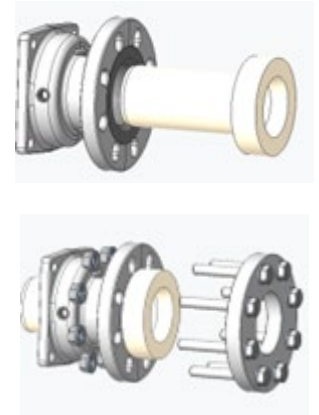


Figure 11. - Port flange with insert

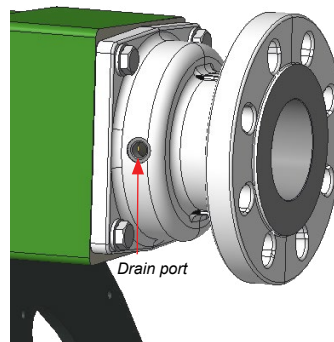


Figure 12. - Drain port without flange

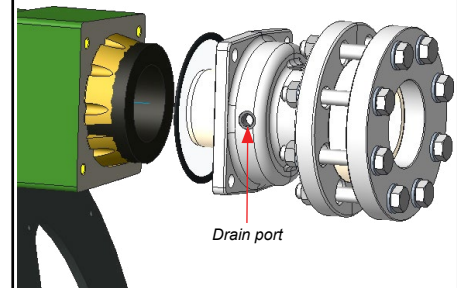


Figure 13. - Drain port with insert

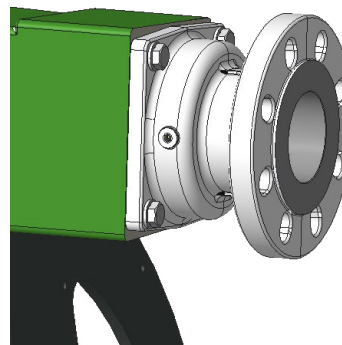


Figure 14. - Assembled without insert

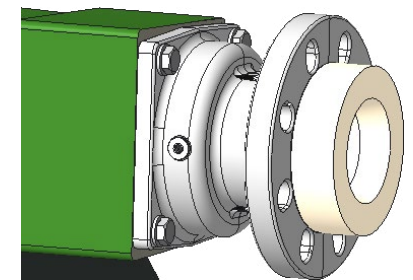



Figure 15. - Assembled with insert

Table 5. - Hose and flange assembly

6.9 Filling the pump with lubricant

 Safety data sheets for both Verderlube and Verdersil are available from the manufacturer for compatibility check.

1. Provide a suitable container to collect spilt lubricant.
2. Ensure compatibility of lubricant with the pumped liquid.
3. The pump housing can be filled with lubricant through the filler port.
4. Remove the breather cap from the filler port to fill the pump with lubricant.
5. Fill the pump housing with lubricant to the indicator:

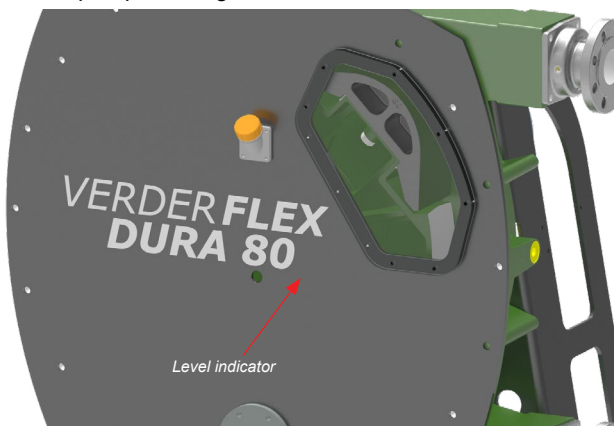


Figure 16. - Lubricant level

Note

High/low level sensor optional!

If fitted, the lubricant level is indicated on the sensor assembly aluminium channel:

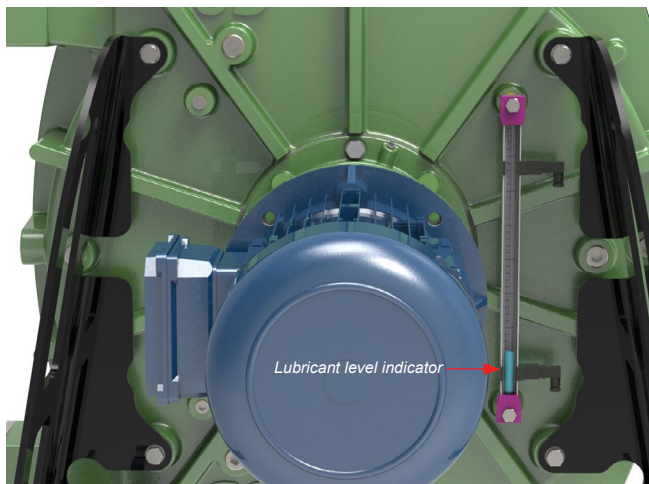


Figure 17. - High/low level sensor

6. Refer to →11. Technical specifications for the required quantity of lubricant.



Figure 18. - Filling the pump with lubricant

7. Position the breather cap and tighten it firmly.

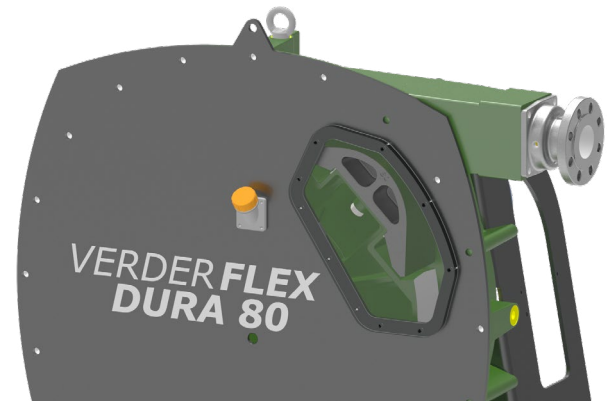


Figure 19. - Positioning the breather cap

6.10 Connecting the pipes

Note

Contamination of pumped media due to impurities in the pump!

- ▶ Care should be taken to avoid ingress of contaminants into the pumped media.
- Clean all piping parts and fittings prior to assembly.
- Ensure that the flange seal does not protrude inwards occluding the flow path.
- Remove flange covers on both the suction and discharge side prior to installation.

6.10.1 Installing the piping

1. Check all fasteners are tightened (→11. Technical specifications).
2. Ensure that the 1/4 turn flange is correctly indexed.
3. Remove the transport and sealing covers from the pump.
4. Before connecting any piping to the pump, ensure that the hose is properly secured by running the pump dry for 10–20 revolutions in both directions.
5. Run the pipes in a continuous upward or downward slope to avoid air pockets.
6. Connect the piping.
7. Make sure that the nozzle loadings on flanges are not exceeded.

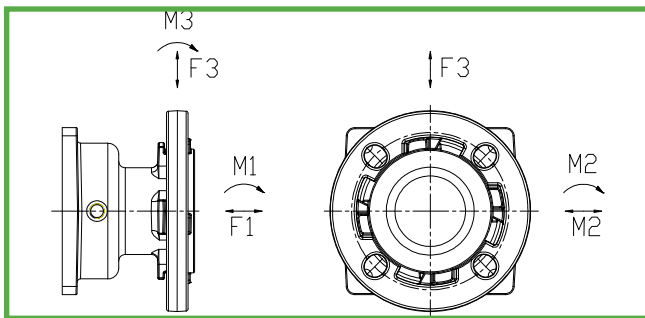


Figure 20. - Nozzle loadings on flanges

8. Consider the maximum nozzle loadings on flanges in the following table:

Pump Type	Maximum Nozzle Loadings (N)		
	F1	F2, F3	M1, M2, M3
Dura 80	1500 N	1000 N	145 Nm

Table 6. - Maximum nozzle loadings on flanges

7. Operation

7.1 Pre-commissioning the pump

7.1.1 Checking the direction of rotation with dry pump

- Ensure the pump has lubricant in it.
- Switch the motor on and check the direction of rotation then switch off immediately.
- If the direction of rotation is different: swap two of the phases (check with electrician).

7.1.2 Starting the Pump



DANGER

Risk of injury and poisoning due to pumped liquid spraying out!

- ▶ Use personal protective equipment when carrying out any work on the pump.

Equipment damage due to excess pressure!

- ▶ Do not operate the pump with the discharge-side fitting closed.
- ▶ Operate the pump only within the tolerances specified by the manufacturer (→11. Technical specifications).



WARNING

Risk of injury and poisoning due to hazardous pumped liquids!

- ▶ Safely collect any leaking pumped liquid and dispose of it in accordance with your environmental policies and requirements.

Checklist:

- Pump set up and connected properly.
- Motor set up and connected properly.
- All connections stress-free and sealed.
- Pump housing lubricant level correct (→6.9 Filling the pump with lubricant).
- All safety equipment installed and tested for functionality.

1. Close all drainage taps.
2. Open the suction-side and the discharge-side fittings.
3. Switch ON the motor and make sure it is running smoothly.
4. Run the pump, flushing with water first (cold commissioning) to check for leaks.
5. Verify that neither the pump nor the pipe connections are leaking.
6. Perform a second flush by running the pump, 10–20 revolutions with pumped liquid, to remove residue and water inside the pump.

7.1.3 Switching OFF the pump



WARNING

Risk of injury due to hot pump parts!

- ▶ Use personal protective equipment when carrying out any work on the pump.

Note

Risk of dead heading and hose burst due to closed suction or discharge!

- ▶ Keep the suction and discharge side fittings open till the rotor has come to a complete stop.

Equipment damage due to sediments!

- ▶ If the pumped liquid crystallizes, polymerizes or solidifies:
 - Flush pump
 - Make sure that the flushing liquid is compatible with the pumped liquid.

1. If necessary: Flush and empty the pump.
2. Switch off power to the motor.
3. Close the discharge side fitting.
4. Check all bolts and tighten them if necessary (only after putting the pump into service for the first time).

7.2 Commissioning the pump

7.2.1 Switching ON the Pump



Risk of injury due to running pump!

- ▶ Do not touch the moving parts of a running pump.
- ▶ Do not carry out any repair/ maintenance work on the running pump.
- ▶ Allow the pump to cool down completely before starting any work on the unit.

Risk of injury and poisoning due to pumped liquid spraying out!

- ▶ Use personal protective equipment when carrying out any work on the pump.

Note

Risk of pulsation when throttling down the suction flow rate!

- ▶ Fully open the suction-side fitting and **DO NOT** use it to adjust the flow as this could damage the hose.

Checklist:

- Pump pre-commissioned (→7.1 Pre-commissioning the pump).
- Pump prepared and filled.

1. Open the suction-side and the discharge-side fittings.
2. Switch on the motor and make sure it is running smoothly.

7.2.2 Switching OFF the pump (refer to 7.1.3)



Risk of injury due to hot pump parts!

- ▶ Use personal protective equipment when carrying out any work on the pump.

Note

Damage to hose due to sediments!

- ▶ If the pumped liquid crystallizes, polymerizes or solidifies:
 - Flush the hose
 - Make sure that the flushing liquid is compatible with the pumped liquid.

7.3 Shutting down the pump

- ▶ Take the following measures whenever the pump is shut down:

Pump is...	Measure
shut down	▶ Take measures according to the pumped liquid (→ Table 8).
dismounted	▶ Isolate the motor from its power supply and secure it against unauthorized switch-on.
put into storage	▶ Follow the storage instructions (→4.2 Storage conditions)

Table 7. - Measures to be taken if pump is shut down

Behaviour of the Pumped Liquid	Duration of Shutdown (Depending on Process)	
	Short	Long
Crystallized or polymerized, solids sedimenting	▶ Flush the pump	▶ Flush the pump, remove the hose
Solidifying non-corrosive	▶ Heat up or empty the pump	▶ Empty the pump
Solidifying corrosive	▶ Heat up or empty the pump	▶ Empty the pump ▶ Treat the pump with preservative
Liquid, non-corrosive	-	-
Liquid, corrosive	▶ Empty the pump	▶ Empty the pump ▶ Treat the pump with preservative

Table 8. - Measures depending on the behaviour of the pumped liquid

7.4 Start-up following a shutdown period

1. After a prolonged shutdown period, re-commission the pump as follows:
 - Check the seals and replace them if necessary
 - Grease the gearbox adaptor/bearing carrier through the grease nipple (→8.5 Grease the gearbox adaptor/ bearing carrier)
 - Install or change hose (→6.7 Installing the hose)
2. Carry out all steps as per →7.1 Pre-commissioning the pump.



7.5 Operating the standby pump

Checklist:

- Standby pump is filled with lubricant (→6.9 Filling the pump with lubricant).
- Operate the standby pump at least once a week to avoid formation of permanent dents from setting on the hose.

8. Inspection, Maintenance and Repair

i Only trained service technicians should be employed for fitting and repair work. Present a pumped medium certificate (DIN safety data sheet or safety certificate) when requesting service.

! DANGER

Risk of injury due to running pump or hot parts!

- ▶ Do not carry out any repair/maintenance work on a pump in operation.
- ▶ Allow the pump to cool down completely before starting any repair work.

Risk of injury due to pressure buildup!

- ▶ Do not carry out any repairs/maintenance work on a pump in operation.
- ▶ Do not block the breather tube which is designed for pressure relief.
- ▶ In the unlikely event of a hose burst which leads to blockage of the breather tube - safely relieve the pressure inside the casing before disassembling the pump.

! WARNING

Risk of injury and poisoning due to hazardous pumped liquids!

- ▶ Use protective equipment when carrying out any work on the pump.

8.1 Inspection

i The inspection intervals depend on the pump operating cycle.

1. Check at appropriate intervals:
 - Normal operating conditions unchanged
2. For trouble-free operation, always check the following:
 - Lubricant level
 - No leaks
 - No unusual running noises or vibrations
 - Hose in position

8.2 Maintenance

i These pumps are generally maintenance-free and any work should normally be limited to inspections and pump lubricant and hose changes, gearbox adaptor/bearing

carrier greased as required; these may be more frequent in dusty and/or hot conditions, refer to (→ 8.2.2 Cleaning protocol for hoses).

8.2.1 Cleaning the pump

! DANGER

Risk of electrocution!

- ▶ Have all electrical work carried out only by qualified electricians.

Note

High water pressure or spray water can damage motors!

- ▶ Do not clean motors with water or steam jet.

Remove the hose!

- ▶ Rinse the hose carefully to remove chemicals (follow the cleaning protocol → 8.2.2 Cleaning protocol for hoses)
1. Clean large-scale grime from the pump.
 2. Rinse the hose carefully to remove chemicals (follow the cleaning protocol as listed in (→8.2.2 Cleaning protocol for hoses).

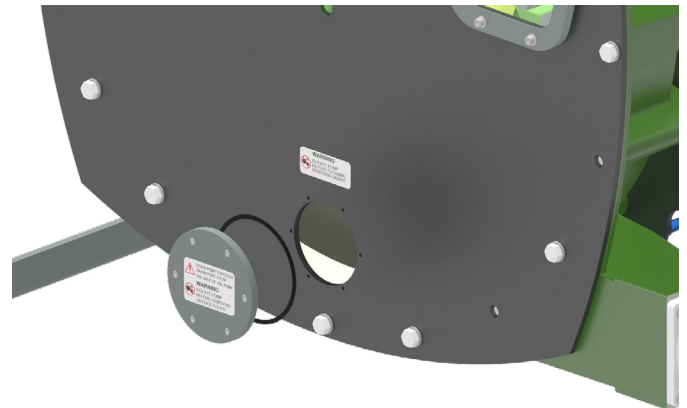


Figure 21. - Clean the pump housing

3. Check the O-ring of the service cover and replace if necessary.
4. Fit the screws with sealing washers to fix the service cover. For the tightening torque values, please refer to (→ 11. Technical specifications).

8.2.2 Cleaning protocol for hoses

- ▶ VERDERFLEX hoses should be cleaned using the following protocol –

NBR, NR and CSM Hoses:

1. First flush; 0.5% Nitric Acid (HNO₃) solution at up to 50°C, max 10-15 minutes.
2. Second flush; 5% Caustic soda (NaOH) solution at up to 50°C, max 10-15 minutes and eventually steamed open ends for 15 minutes at up to 110 °C.
3. Final flush; flush with clean water to remove all traces of cleaning solutions.

EPDM Hoses:

1. First flush; 0.5% Nitric Acid (HNO₃) solution at up to 50°C, max 10-15 minutes.
2. Second flush; 5% Caustic soda (NaOH) solution at up to 50°C, max 10-15 minutes and eventually steamed open ends for 15 minutes at up to 130 °C.
3. Final flush; flush with clean water to remove all traces of cleaning solutions.

NBRF Hoses:

1. First flush; 0.5% Nitric Acid (HNO₃) solution at up to 50°C, max 10-15 minutes.
2. Second flush; 5% Caustic soda (NaOH) solution at up to 50°C, max 10-15 minutes and eventually steamed open ends for 15 minutes at up to 110°C.
3. Final flush; flush with clean water to remove all traces of cleaning solutions .

Under no circumstances should VERDERFLEX NBRF food grade hoses be cleaned with Sodium Hypochlorite (NaOCl) based cleaning solutions, nor should the above concentrations, exposure, durations or temperatures be exceeded.

▶ Food Grade Approval

All VERDERFLEX NBRF food grade hoses' inner liners are certified as compliant to:

- FDA – CFR 21 Parts 170 to 199 – Item 177.2600
- EC regulation No.1935/2004
- EC regulation No.2023/2006

▶ Hose Description

All VERDERFLEX NBRF food grade hoses consist of a smooth black inner food grade liner bonded to a non-food grade outer. The inner liner is taste-free and odour less.

▶ Hose Installation

All VERDERFLEX NBRF food grade hoses must be installed in accordance with the procedures defined in this manual.

▶ Identification

VERDERFLEX NBRF food Grade hoses can be identified by:

Both an external yellow coding / identification tape and an additional white longitudinal stripe. The hose will also have the glass/fork symbol as per Regulation (EC) 1935/2004.



Figure 22. - Verderflex NBRF food grade hose identification

▶ Pump Installation

VERDERFLEX pumps using VERDERFLEX NBRF food grade hoses must be installed in accordance with recommendations made by the pump's supplier. In particular, special care must be given to the suction and discharge line conditions and that the hose is shimmed in accordance with VERDERFLEX's recommendations. Should there be any doubt about any installation details, these must be discussed with the pumps' supplier.

▶ Particle Release

All hoses will release small quantities of rubber into the product stream, especially immediately after the hose installation and just prior to hose failure. Whilst the rubber released will be food grade particles, these may cause end-user concerns about contamination and so we recommend suitable particle capturing devices, such as filters, being fitted into the pump's discharge line.

8.2.3 Maintenance schedule

Task	Frequency	Action
Check pump and gearbox for leaks and damage	<ul style="list-style-type: none"> - Before pump start up - Daily visual inspection - Scheduled intervals during operation 	<ul style="list-style-type: none"> ▶ Repair leaks and damage before operating the pump. ▶ Replace components as necessary. ▶ Clean up any spillage.
Check pump housing lubrication level	<ul style="list-style-type: none"> - Before pump start up - Daily visual inspection - Scheduled intervals during operation 	<ul style="list-style-type: none"> ▶ Make sure that lubricant level is visible in the inspection window between the lower sill and the first pair of bolts. ▶ Do not operate the pump if the level is too low or too high. Refill lubricant as required (→6.9 Filling the pump with lubricant).
Check geared motor unit lubrication level	<ul style="list-style-type: none"> - Before pump start up - Daily visual inspection - Scheduled intervals during operation 	<ul style="list-style-type: none"> ▶ → Motor instruction manual.
Check pump for unusual temperatures or noise in operation	<ul style="list-style-type: none"> - Daily visual inspection - Scheduled intervals during operation 	<ul style="list-style-type: none"> ▶ Check pump, gearbox and bearing housing for damage. ▶ Replace worn components.
Replace pump housing lubricant	<ul style="list-style-type: none"> - At every 2nd hose change or after 5000 running hours, whichever comes first. - After inspection when required 	<ul style="list-style-type: none"> ▶ Refill lubricant (→6.9 Filling the pump with lubricant)
Replace hose	<ul style="list-style-type: none"> - After inspection, when required. - When flow has dropped by 25% of nominal value - When the hose is burst/damaged 	<ul style="list-style-type: none"> ▶ Replace hose (→ 8.6 Hose change) ▶ Replace flange sealing kit
Check pump housing, rotor, rotor shoes and inserts internally	<ul style="list-style-type: none"> - Annually - On replacing the hose 	<p>Worn and damaged surfaces give rise to premature hose failure</p> <ul style="list-style-type: none"> ▶ Replace worn components. ▶ Check bearing play and function.
Replace bearing and seal	<ul style="list-style-type: none"> - After 30,000 running hours - When damage is suspected - When leak is detected 	<ul style="list-style-type: none"> ▶ Check bearing play and function. ▶ Replace worn components. ▶ Refer to gearbox manufacturers manual.

Table 9. - Maintenance schedule

8.3 Repair



DANGER

Risk of death due to electric shock!

- ▶ Have all electrical work carried out by qualified electrician only.



WARNING

Risk of injury due to heavy components!

- ▶ Pay attention to the component weight. Lift and transport heavy components using suitable lifting gear.
- ▶ Set down components safely and secure them against overturning or rolling away.

Risk of injury while dismantling the pump!

- ▶ Use protective equipment when carrying out any work on the pump.
- ▶ Observe manufacturer's instructions (e.g., for motor, coupling, gearbox).

8.3.1 Preparations for dismantling

Checklist:

- Safely release any pressure build-up in the pump housing (there may be significant built up of pressure in the discharge line or possible suction side vacuum).
- Pump completely emptied, flushed and decontaminated.
- Electrical connections disconnected and motor locked out against being switched on again.
- Pump cooled down.
- Auxiliary systems shut down, depressurized and emptied.
- Before dismantling the pump, mark the precise orientation and position of all components before dismantling them.

8.3.1 Returning the pump to the manufacturer

Checklist:

- Pump unpressurized.
- Completely emptied and decontaminated.
- Pump cooled down.
- Hose dismantled (→ 8.6 Hose change).

Obtain prior authorization before repair or return of the pump.

- ▶ Enclose a completed document of compliance when returning pumps or components to the manufacturer.
- ▶ Please contact Verder Ltd. internal sales department for a copy of the Return of Goods form.
- ▶ Returning without the Return of Goods form will not be accepted.

Repairs	Measure for Return
...at the customer's premises	<ul style="list-style-type: none"> – Return the defective component to the manufacturer. – Decontaminate if necessary.
...at the manufacturer's premises	<ul style="list-style-type: none"> – Flush the pump and decontaminate if it was used for hazardous pumped liquids.
...at the manufacturer's premises for warranty repairs	<ul style="list-style-type: none"> – Only in the event of hazardous pumped liquid, flush and decontaminate the pump

Table 10. - Measures for returning the pump to the manufacturer

8.3.2 Rebuild / Repair



Reinstall the components, in accordance with the marks applied.

Note

Material damage due to unsuitable components!

- ▶ Always replace lost or damaged bolts with bolts of the same strength and material.
1. Observe the following during the installation:
 - Replace worn parts with genuine spare parts.
 - Maintain the prescribed tightening torques (→11. Technical specifications)
 2. Clean all parts (→11. Technical specifications). Do not remove any markings which have been applied.
 3. Reassemble the pump.
 4. Install the pump in the system (→6. Installation and Connection).

8.4 Drain/change the lubricant



WARNING

Risk of injury!

- ▶ Always isolate the power supply before working on the pump.

Slip hazard due to spilt lubricant!

- ▶ Care must be taken when lubricant is drained into a container.
- ▶ Dispose of used lubricant in accordance with local laws and good environmental practices.

Checklist:

- Motor isolated
- System secured against being switched back on again.

1. Drain the lubricant from the pump housing through drain port from the back of the pump.
2. Place a suitable container under the drain port.
3. Open the valve and drain the lubricant as shown in the image.

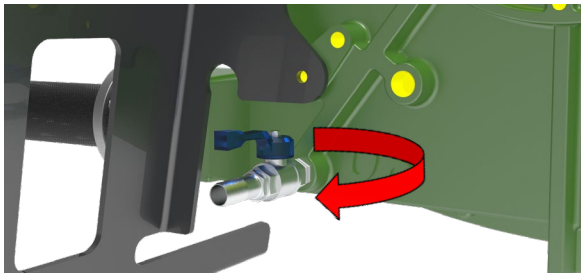


Figure 23. - Drain the lubricant

4. Close the valve in position by rotating the level to 90° to the right.

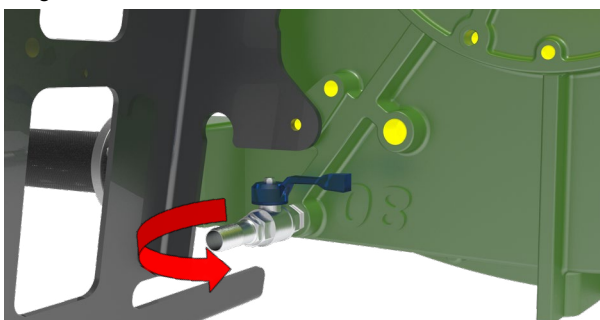


Figure 24. - Close the valve

For information on how to fill the pump housing with lubricant through the filler port, refer to 6.9 Filling the pump with lubricant.

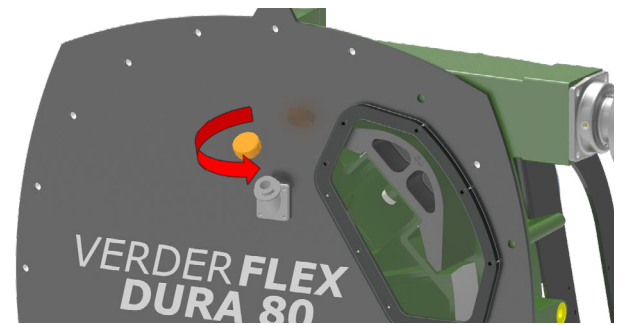


Figure 25. - Filling the pump with lubricant

8.5 Grease the gearbox adaptor/ bearing carrier



DANGER

Risk of injury due to running pump or hot pumps!

- ▶ Do not carry out any repair/maintenance work on a pump in operation.
- ▶ Allow the pump to cool down completely before starting any repair work.

8.6 Hose change



WARNING

Risk of injury!

- ▶ Always isolate the power supply before working on the pump.



CAUTION

Risk of injury if the hose is expelled too quickly!

- ▶ Slowly remove the hose by running the motor at a reduced speed.

Risk of injury while dismantling the pump!

- ▶ Use protective equipment when carrying out any work on the pump.
- ▶ For the tightening torque values, please refer to 11. Technical specifications.



The hose change involves removal and re-installing the port flanges.

Checklist:

- Motor isolated
- System secured against being switched back on again
- Close the suction and discharge side valves

1. Place a suitable container under the lower port flange.
2. Remove the drain port from the lower port flange and allow any excess lubricant to drain out.

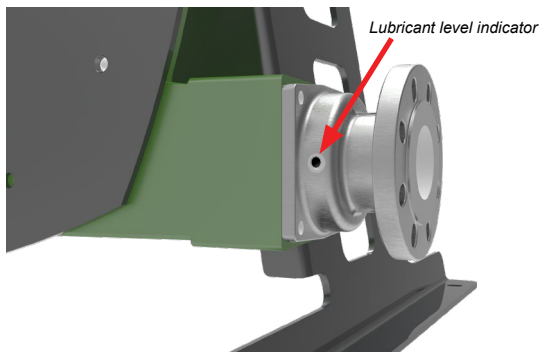


Figure 26. - Grease the gearbox adaptor/bearing carrier

3. Remove the bolts.
4. Slide the port flange off the hose.

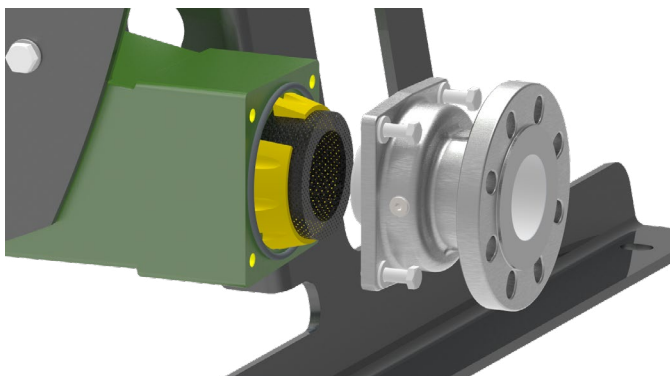


Figure 27. - Remove the lower port flange

5. Remove the O-ring and the clamp ring. Check that the O-ring and the clamp ring are not damaged and replace them if necessary.
6. Repeat steps 1-5 to remove the upper port flange.

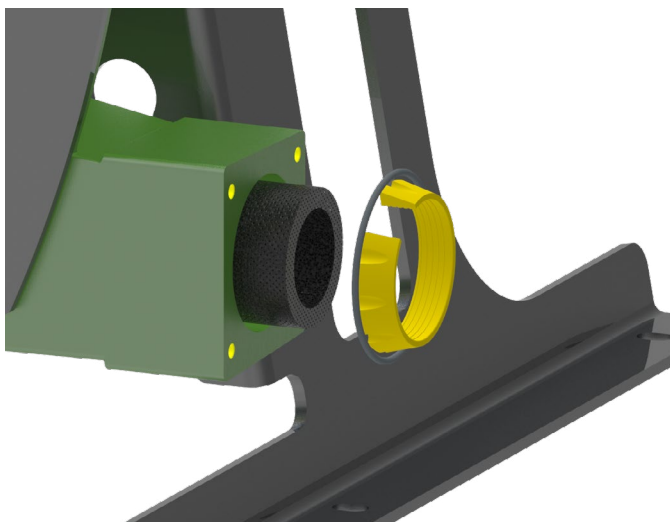


Figure 28. - Remove the O-ring and clamp ring

7. Use the motor to drive out the old hose. If no power is available, remove the fan cover and turn the shaft by hand or by using suitable leverage. Care must be taken not to damage the fan blades when using this method.
8. Cleaning the pump housing.

Note

We recommend to clean the pump housing through the service cover. For additional information, please refer to 8.2.1 Cleaning the pump.

9. Inspect the flanges for damage and signs of wear.
10. For installing the hose and port flanges, please refer to sections 6.7, 6.8.

8.7 Replace the rotor shoe



WARNING

Risk of injury!

- ▶ Always isolate the power supply before working on the pump.



CAUTION

Risk of injury while dismantling the pump!

- ▶ Use protective equipment when carrying out any work on the pump.

Checklist:

- Motor isolated
- System secured against being switched back on again.

1. Please note that the rotor shoes can be replaced without draining the lubricant. For changing the lubricant from the pump housing, please refer to 8.4 Drain/change the lubricant.
2. Rotate the pump so that a rotor shoe is visible through the inspection window.
3. Remove the inspection window and gasket. Leave the bolts on the inspection window for reassembly.

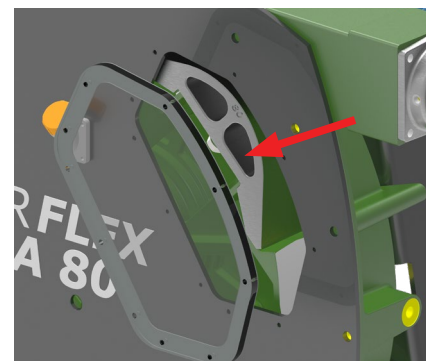


Figure 29. - Removing the inspection window

4. Loosen the shoe bolt (item 2).
5. Remove any existing shims (item 1).

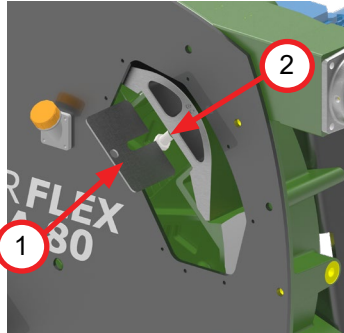
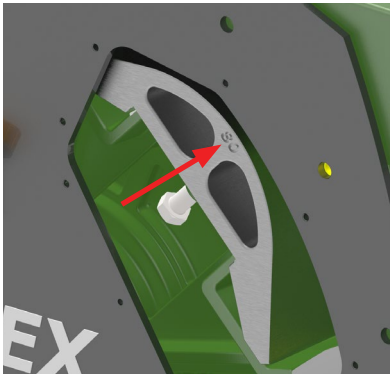


Figure 30. - Remove shims

6. Loosen the shoe bolt (item 2) completely and remove the rotor shoe.
7. Position in place the new rotor shoe. Please note that the correct position is when 80 is facing you:



8. Replace with correct number of shims for the required pressure (see 11. Technical specifications).
9. Tighten the shoe bolt with the correct torque (see 11. Technical specifications).
10. Repeat with the other rotor shoe.
11. Ensure that the lubricant level is correct (see 6.9 Filling the pump with lubricant).
12. Replace the window and gasket ensuring it is fitted the correct way with the bolts (see 6.6 Fitting the inspection window).

8.8 Replace the rotor



WARNING

Risk of injury!

- ▶ Always isolate the power supply before working on the pump.



CAUTION

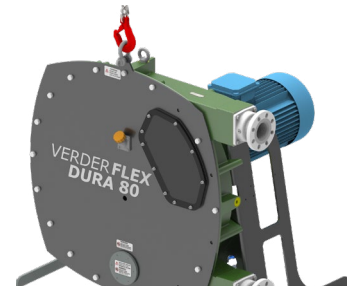
Risk of injury while dismantling the pump!

- ▶ Use protective equipment when carrying out any work on the pump.

Checklist:

- Motor isolated
- System secured against being switched back on

1. Remove the hose. Please refer to 8.6 Hose change.
2. Remove the front cover. Use lifting gear for the front cover to be moved.
3. Fasten the lifting gear to the front cover lifting eye as shown in the following illustration (front cover weight 95Kg).



4. Loosen the hex head set screws for the front cover to be removed.
5. Remove the set screws securing the taper lock bush to the rotor. Use the same screws to 'break' the joint between the bush and the rotor; the rotor should be lifted and moved by qualified lifting personnel equipped with suitable lifting gear to support the rotor as it slides off the gearbox shaft.

To re-assemble a new rotor:

1. Secure the taperlock bush to the rotor using the three set screws.
2. Mount the rotor onto the GMU drive shaft and assemble the rotor shoes into position. Again, the rotor should be lifted and moved by qualified lifting personnel equipped with suitable lifting gear.

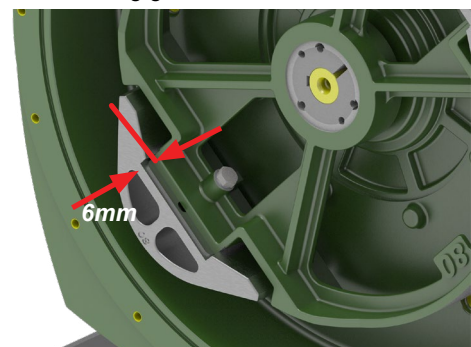


Figure 31. - Re-assemble a new rotor

3. Measure the correct distance from the front of the rotor shoes to the front of the pump housing.
4. Tighten the set screws then re-check the distance. Re-adjust if necessary (see 11. Technical specifications for torque settings).
5. Re-assemble pump (reverse of 1 - 4).



9. Troubleshooting

9.1 Pump malfunctions

If malfunctions occur which are not specified in the following table or cannot be traced back to the specified causes, please consult the manufacturer.

Possible malfunctions are identified and respective cause and remedy are listed in the table.

Abnormally high pump temperature	Low flow/pressure	Pump and pipework vibrating	Hose pulled in to pump housing	Possible cause	Solution
X	-	-	-	Incorrect lubricant	▶ Consult the manufacturer to obtain correct lubricant.
				Low lubricant level	▶ Add required amount
				Product ambient temperature too high	▶ Consult the manufacturer regarding maximum temperature
				Over shimming of the pump	▶ Check for and remove excess shims
X	X	-	-	Blocked suction / bad suction characteristics / no product	<ul style="list-style-type: none"> ▶ Check pipework and valves for blockages. ▶ Check that the suction pipework is as short and as large in diameter as feasible ▶ Correct the piping layout ▶ Consult the manufacturer
X	-	X	-	High pump speed	<ul style="list-style-type: none"> ▶ Reduce speed to a minimum ▶ Consult the manufacturer
-	X	-	-	Suction / discharge valve closed	▶ Open suction / discharge valve
				Hose failure	▶ Replace hose (→ 8.6 Hose change)
				Poor pump selection, incorrect shoe shimming	▶ Consult the manufacturer to check pump selection
				Suction line too long	▶ Consult the manufacturer
				Pump speed too high	▶ Consult the manufacturer
				Suction line bore too small	▶ Consult the manufacturer
				High product viscosity	▶ Consult the manufacturer
				Suction / discharge lines not secured properly	▶ Check and secure suction / discharge lines

Abnormally high pump temperature	Low flow/pressure	Pump and pipework vibrating	Hose pulled in to pump housing	Possible cause	Solution
-	-	X	-	Long suction / discharge lines / dampener malfunction	<ul style="list-style-type: none"> ▶ Shorten long suction / discharge lines wherever possible ▶ Consult the manufacturer
-	-	X	-	High product specific gravity / viscosity	<ul style="list-style-type: none"> ▶ Consult the manufacturer
-	-	X	-	Under-sized suction / discharge diameter	<ul style="list-style-type: none"> ▶ Increase suction / discharge pipework diameter ▶ Fit dampener
-	-	X	-	Insufficient lubricant in the casing	<ul style="list-style-type: none"> ▶ Check lubrication chart and add the required amount of lubrication
-	-	-	X	Inlet pressure too high	<ul style="list-style-type: none"> ▶ Reduce the inlet pressure
-	-	-	X	Blocked hose / incorrectly fitted	<ul style="list-style-type: none"> ▶ Check the hose and remove any blockages
-	-	-	X	Large particles in the product	<ul style="list-style-type: none"> ▶ Mount sieve or filter in suction line to avoid very large particles from entering the hose. Do not allow filters to limit suction below accepted levels.

Table 11. - Pump troubleshooting list

10. List of Tables and Figures

List of tables

Table 1. - Target groups	7
Table 2. - Warnings used in the manual	7
Table 3. - Symbols used in the manual	7
Table 4. - Dos and don'ts	14
Table 5. - Hose and flange assembly	17
Table 6. - Maximum nozzle loadings on flanges	19
Table 7. - Measures to be taken if pump is shut down	20
Table 8. - Measures depending on the behaviour of the pumped liquid	20
Table 9. - Maintenance schedule	24
Table 10. - Measures for returning the pump to the manufacturer	25
Table 11. - Pump troubleshooting list	31
Table 12. - Pump specifications	33
Table 13. - Tightening torques	33
Table 14. - Cleaning agents	33
Table 15. - Lubricant	33
Table 16. - Solids size handling	33

List of figures

Figure 1. - Fastening apparatus gear to pump	10
Figure 2. - Name plate	11
Figure 3. - Layout Dura 80 (Generic View)	12
Figure 4. - Installing the gearbox	15
Figure 5. - Installing the motor	15
Figure 6. - Shimming	16
Figure 7. - Fitting the inspection window	16
Figure 8. - Installing the hose	16
Figure 9. - Clamp ring inserted	17
Figure 10. - Port flange without insert	17
Figure 11. - Port flange with insert	17
Figure 12. - Drain port without flange	17
Figure 13. - Drain port with insert	17
Figure 14. - Assembled without insert	17
Figure 15. - Assembled with insert	17
Figure 16. - Lubricant level	18
Figure 17. - High/low level sensor	18
Figure 18. - Filling the pump with lubricant	18
Figure 19. - Positioning the breather cap	18
Figure 20. - Nozzle loadings on flanges	19
Figure 21. - Clean the pump housing	22
Figure 22. - Verderflex NBRF food grade hose identification	23
Figure 23. - Drain the lubricant	26
Figure 24. - Close the valve	26
Figure 25. - Filling the pump with lubricant	26
Figure 26. - Grease the gearbox adaptor/bearing carrier	27
Figure 27. - Remove the lower port flange	27
Figure 28. - Remove the O-ring and clamp ring	27
Figure 29. - Removing the inspection window	27
Figure 30. - Remove shims	28
Figure 31. - Re-assemble a new rotor	28


11. Technical specifications

11.1 Pump specifications

Size	Value
Max. delivery pressure	16 bar
Temperature of pumped liquid	< 100 °C < 40 °C (ATEX)
Max. continuous operation pump speeds	40 rpm at 0 bar 40 rpm at 6 bar 26 rpm at 10 bar 18 rpm at 16 bar
Dimensions	*(refer to pump datasheet)

Table 12. - Pump specifications

11.2 Ambient conditions

 Operation under any other ambient condition would require approval from the manufacturer


Operating conditions

- Ambient temperature -5 °C to +45 °C
- Relative humidity (non-condensing), long-term ≤ 85 %
- All units/calculations are based on operating conditions below 1000 m. For use above this height please check with manufacturer or local representative for confirmation of performance.

Storage conditions

- Ambient temperature +10 °C to +50 °C
- Relative humidity (non-condensing), long-term ≤ 85 %


11.3 Tightening torques

 Tightening torques should be applied at the following torque values:

Position	Torque Values (Nm)
Inspection Window	3.4 Nm
Port Flange	90 Nm
Rotor Shoe	150 Nm
Gearbox to GMU adaptor	145 Nm (305 gearbox size) 230 Nm (306 gearbox size)
Motor to Gearbox	87 Nm (112/132 size motor) 150 Nm (160/180 size motor)
Frames to Casing	100 Nm
Front Cover	100 Nm
Seal plate, filler port & service cover	3.4 Nm
Taperlock bush	116 Nm
GMU adaptor to housing	160 Nm

Table 13. - Tightening torques

11.4 Preservatives


 Use RUST-BAN 335 or similar preservatives on bare metal.

11.5 Cleaning agents (after hose is removed)

Cleaning Agents
Wax solvents, diesel paraffin, alkaline cleaners, warm water

Table 14. - Cleaning agents

11.6 Lubricants

 Recommended lubricants for longer hose life are VERDERLUBE or VERDERSIL.

Pump Type	Amount of Lubricant
Dura 80	35 Litres (9.2 US Gallons)

Table 15. - Lubricant


Note

The pump lubricant is filled to the lowest screw of the hole of the inspection window.

11.7 Solids size handling

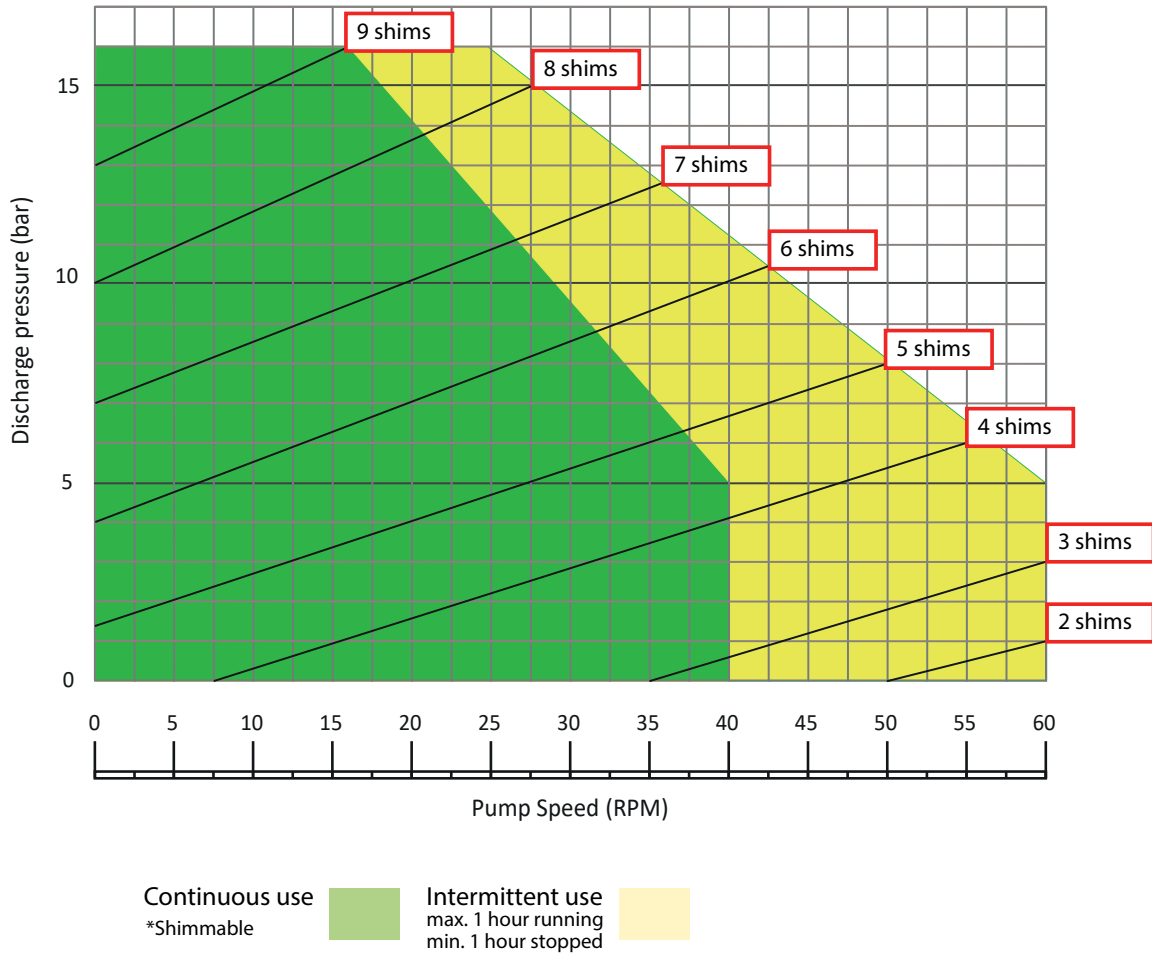
Solid type	Size of solid
Hard solid	< 8mm
Compressible solid	< 20mm

Table 16. - Solids size handling

 For more information about specific solids handling, please consult your Verder representative.

11.8 Shimming chart

Shimming table set with water at 20°C. Shimming may be affected by fluid conditions and might need to be altered to match application. Each shim is 0.5mm thick.





12. Trademarks

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13. Document History

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01	Initial release.	9/11/22	ISH