



VACGEN

Assembly Guide DPRF Assembly Information AS0002

VGS03-02T02



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DISCLAIMER

This Assembly Guide should be used in conjunction with the owner's manual where available, and is intended as a guide only as there may be variations between versions and therefore must be used at the Owner's Risk. For more detailed assistance, please contact our Support desk +44 (0) 1323 379 335 or support@vacgen.com.

HEALTH AND SAFETY

All repairs and services should be carried out by a qualified engineer, using the correct tools and procedures to carry out the repair. VACGEN are not liable for any errors within the assembly guides which may cause inconsistencies during repair.

The Goods, especially chemicals, may be dangerous if not properly used or stored and the appropriate precautions taken. The Customer accordingly agrees that it shall take all such steps as are reasonably practicable or usual to eliminate or reduce any risk to health and/or safety to which use of the Goods may give rise and acknowledges that where the Goods are manufactured to a design supplied by the Customer, the Company will not undertake any research as to the risks to health and/or safety which may arise from use or storage of the Goods. Where the Goods are manufactured to a design supplied by the Customer, the Customer shall comply with all the duties which may be implied at law on a designer and/or manufacturer of the Goods.



DPRF Assembly Information

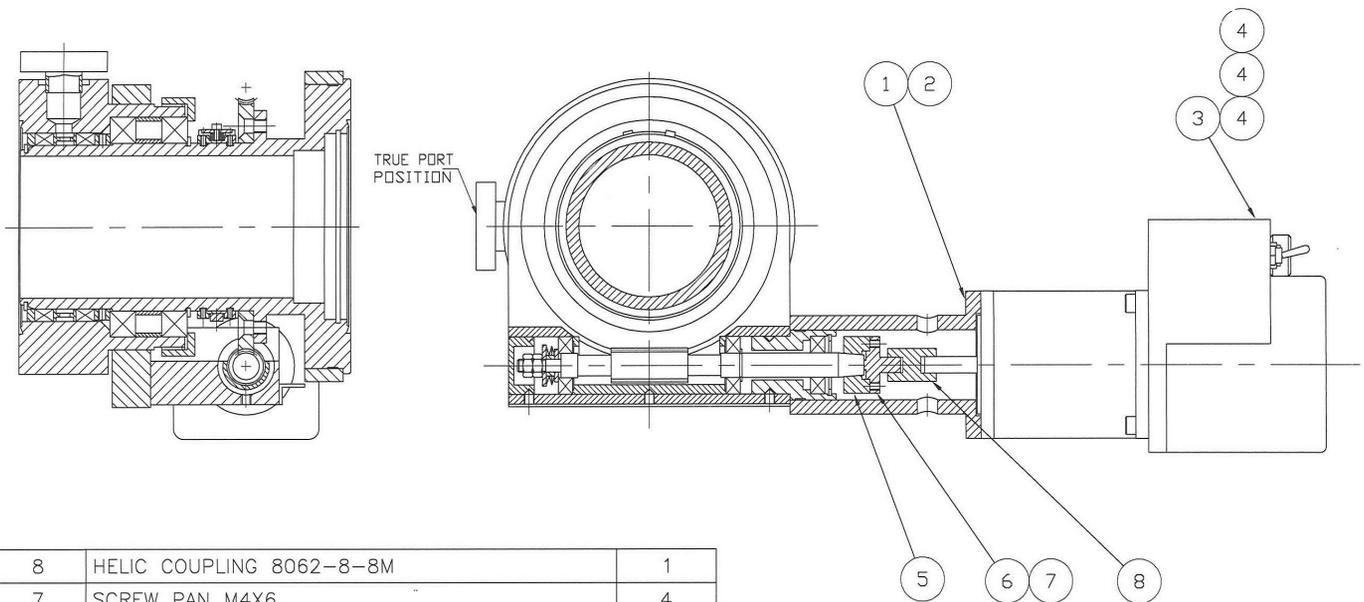
1. Remove the DPRF from the manipulator.
2. If fitted, remove the handwheel or motor assembly, this is held on to the body via six cap head screws.
3. With the lower flange hand held, unscrews the clamp ring.
4. NOTE: the clamp ring may not fully undo, but hits the gear (If fitted). The DPRF has to be pulled apart slightly too fully undo the clamping ring fully.
5. With the lower flange hand held, turn and pull the top flange up, to draw out the seal assembly. Keep the pull as vertical as possible. This can be tight!
6. You will now have the inner assembly free of the outer assembly.
7. NOTE: Note the orientation of the "U" shaped seals, so you fit the new ones in the same orientation.
8. WITH GREAT CARE remove the spiral clip (11) that holds the seal assembly on to the inner tube.
9. WITH GREAT CARE remove the seals and spacers.
10. Check the sealing surface for damage, which would be very rare.
11. However, if any damage is seen, polish in a lath using 1200 Grit Wet & Dry Paper. Isopropanol is a better wetting agent than water.
12. Check the inner seal surface, this is more difficult to polish if required, and should be done by a skilled machinist, in the same way.
13. FULLY clean with Isopropanol. VERY IMPORTANT: FULLY WIPE OVER THE SEALS WITH ISOPROPANOL, to remove loose surface.
14. If your process allows this, use isopropanol as a lubricant when fitting seals. VERY IMPORTANT: Make sure there is no dirt on the seal or seal face that will damage the sealing faces when the seals are refitted.
15. Assemble seal assembly as removed.
16. If your process allows this, use isopropanol as a lubricant when fitting the inner assembly into outer body. VERY IMPORTANT: Make sure there is no dirt on the seal or seal face that will damage the sealing faces when the seals are refitted.
17. When doing the locking ring up as the assembly closes down, pulling the inner assembly into the body, so take care not to trap your fingers as it closes down.
18. Rotate the DPRF in both directions and then test on a Leak Checker if possible, WITH the interspaced pumped.
19. Fit handwheel / motor assembly if fitted.



SEAL KITS (2 seals in each kit):

- | | | |
|----|--|-----------|
| A) | ZDPRF25 old style pumping port in body centre | Obsolete |
| B) | ZDPRF25 new style pumping port in lower flange | ZXSMS07 |
| C) | ZDPRF25 Main Bearings new version | ZDPRF25B |
| D) | ZDPRF55 Seals all ages two seal version | ZXSMS03 |
| E) | ZDPRF55 Seals all ages three seal version | ZXSMS03-3 |
| F) | ZDPRF55 Main Bearings all ages & seal version | ZDPRF55B |

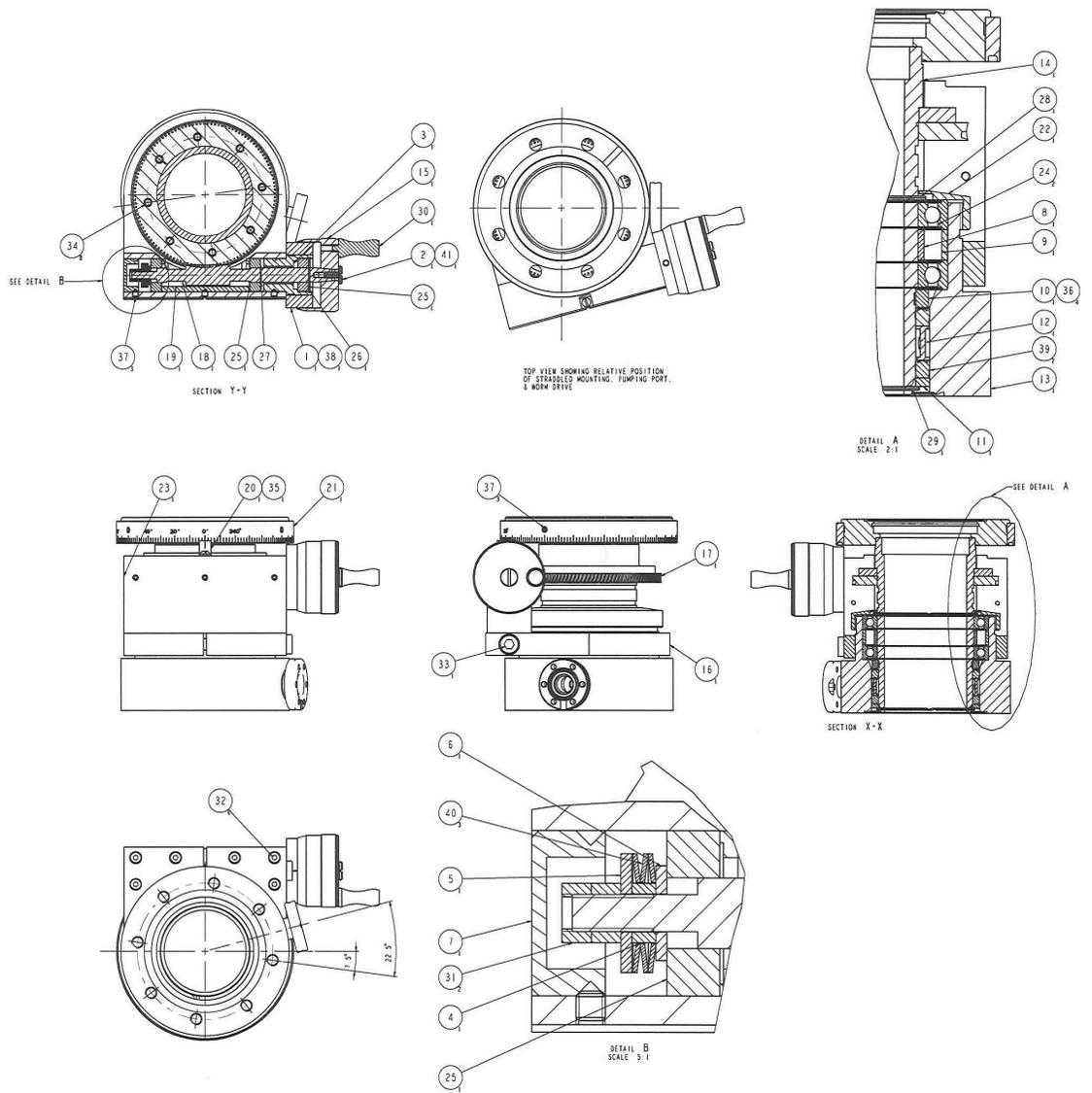
DRAWINGS



8	HELIC COUPLING 8062-8-8M	1
7	SCREW PAN M4X6	4
6	LOCKING BOSS	1
5	DRIVING BOSS	1
4	DC MOTOR MAINS LEAD EU	1
4	DC MOTOR MAINS LEAD UK	1
4	DC MOTOR MAINS LEAD US	1
3	DC MOT 23F WITH 5:1 G/BOX	1
2	SCREW SET M4x10 FLAT PNT	4
1	MOTOR SUPPORT	1
ITEM	DESCRIPTION	QTY



ITEM	DESCRIPTION	QTY
1	2 MICROMETER BARREL	1
2	SPINDLE SCREW	1
3	MICROMETER BEARING HOUSING	1
4	SPACER	1
5	WASHER	1
6	WASHER	1
7	CAP	1
8	SMALL SPACER	1
9	LARGE SPACER	1
10	LOCKING RING	1
11	KEEP RING	1
12	SPACER	1
13	HOUSING WELDED ASSY	1
14	BODY ASSY	1
15	THIMBLE ENGRAVING	1
16	SUPPORT BRACKET	1
17	NORM WHEEL	1
18	NORM SHAFT	1
19	SPACER	1
20	INDICATOR	1
21	INDEX RING	1
22	LOCKING RING WITH CHAMFER	1
23	BEARING HOUSING WITH DRIP GROOVE	1
24	BEARING SKF61813	2
25	BEARING	3
26	CIRCLIP, INTERNAL SERIES 1300-22	1
27	EXT CIRCLIP, SHAFT, 3/16"	1
28	RETENTION RING SMALLLY MS-255	1
29	RETENTION RING SMALLLY ES-61	1
30	ALL ROTATING HANDLE	1
31	NUT, FULL, ST STEEL, M5	2
32	SCREW, CAP HEAD, M4 x 20 ST STEEL	6
33	SCREW, CAP HD M5 x 10 LG	1
34	M5 CSK SCREW, 10mm LONG	8
35	SCREW, PAN HD M3 x 5L	1
36	SCREW SET M3 X 4 LONG	4
37	M4 SET SCREW 4 LONG	6
38	M4 SET SCREW 6 LONG	1
39	SEAL FOR ZDPRF55 AR10103-333-MU	2
40	WASHER, SCHNORR M5 x 0.8	3
41	WASHER WAVY M6 ST/ST	1



Revision	Date	Comment	Initials
1			
2			
3			

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