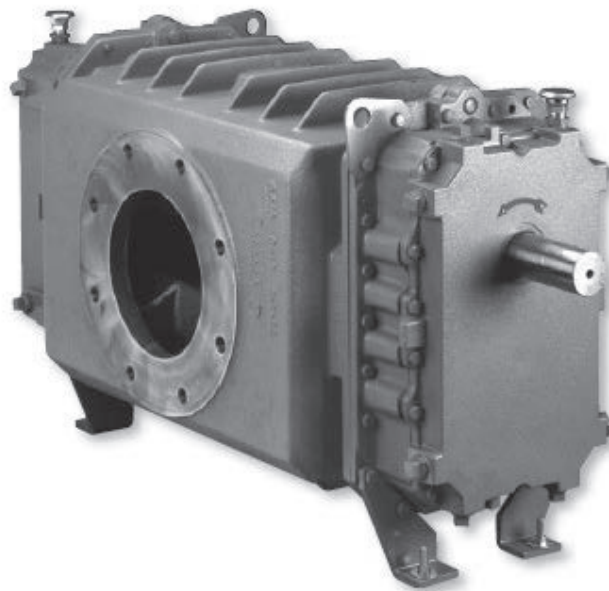


RAM* and RCS Series – GAS, DVJ, DPJ and VJ (400 & 600 RCS Vertical WHISPAIR* only)

Installation, Operation and Maintenance Manual



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Do these things to get the most from your Roots Blower

- ❑ Check shipment for damage. If found, file claim with carrier and notify Howden Roots.
- ❑ Unpack shipment carefully, and check contents against Packing List. Notify Howden Roots if a shortage appears.
- ❑ Store in a clean, dry location until ready for installation. Lift by methods discussed under INSTALLATION to avoid straining or distorting the equipment. Keep covers on all openings. Protect against weather and corrosion if outdoor storage is necessary.
- ❑ Read **OPERATING LIMITATIONS** and **INSTALLATION** sections in this manual and plan the complete installation.
- ❑ Provide for adequate safeguards against accidents to persons working on or near the equipment during both installation and operation. See **SAFETY PRECAUTIONS**.
- ❑ Install all equipment correctly. Foundation design must be adequate and piping carefully done. Use recommended accessories for operating protection

❑ **Make sure both driving and driven equipment is correctly lubricated before start-up. See LUBRICATION.**

❑ In event of trouble during installation or operation, do not attempt repairs of Howden Roots furnished equipment. Notify Howden Roots, giving all nameplate information plus an outline of operating conditions and a description of the trouble. Unauthorized attempts at equipment repair may void Howden Roots warranty.

❑ Units out of warranty may be repaired or adjusted by the owner. Good inspection and maintenance practices should reduce the need for repairs.

NOTE: Information in this manual is correct as of the date of publication. Howden Roots reserves the right to make design or material changes without notice, and without obligation to make similar changes on equipment of prior manufacture.

Safety Precautions

It is important that all personnel observe safety precautions to minimize the chances of injury. Among many considerations, the following should be particularly noted:

- Blower casing and associated piping or accessories may become hot enough to cause major skin burns on contact.
- Internal and external rotating parts of the blower and driving equipment can produce serious physical injuries. Do not reach into any opening in the blower while it is operating, or while subject to accidental starting. Protect external moving parts with adequate guards.
- Disconnect power before doing any work, and avoid bypassing or rendering inoperative any safety or protective devices.
- If blower is operated with piping disconnected, place a strong coarse screen over the inlet and avoid standing in the discharge air stream.

Operating Limitations

A Roots blower or exhauster must be operated within certain approved limiting conditions to enable continued satisfactory performance. Warranty is contingent on such operation.

Maximum limits for pressure, temperature and speed are specified in TABLE 1a, page 14 in the GAS Section, TABLE 1b, page 15 in the DVJ Section, TABLE 1c, page 19 in the DPJ Section and TABLE 1d, page 20 in the VJ Section for allowable speeds for various models & sizes of blowers and exhausters. These limits apply to all units of normal construction, when operated under standard atmospheric conditions. Be sure to arrange connections or taps for instruments such as thermometers and pressure or vacuum gauges at or near the inlet and discharge connections of the unit. These, along with a tachometer, will enable periodic checks of operating conditions.

Pressure – The pressure rise, between inlet and discharge, must not exceed the figure listed for the specific unit frame size concerned. Also, in any system where the unit inlet is at a positive pressure above atmosphere a maximum case rating of 25 psi gauge (1725 mbar) should not be exceeded without

CAUTION: Never cover the blower inlet with your hand or other part of body.

- Stay clear of inlet and discharge openings.
- Stay clear of the blast from pressure relief valves and the suction area of vacuum relief valves.
- Use proper care and good procedures in handling, lifting, installing, operating and maintaining the equipment.
- Casing pressure must not exceed 25 PSI (1725 mbar) gauge. Do not pressurize vented cavities from an external source, nor restrict the vents without first consulting Howden Roots.
- Do not use air blowers on explosive or hazardous gases.
- Other potential hazards to safety may also be associated with operation of this equipment. All personnel working in or passing through the area should be trained to exercise adequate general safety precautions.

first consulting Howden Roots. Never should the maximum allowable differential pressure be exceeded.

On vacuum service, with the discharge to atmospheric pressure, the inlet suction or vacuum must not be greater than values listed for the specific frame size.

Temperature – Blower & exhauster frame sizes are approved only for installations where the following temperature limitations can be maintained in service:

- Measured temperature rise must not exceed listed values when the inlet is at ambient temperature. Ambient is considered as the general temperature of the space around the unit. This is not outdoor temperature unless the unit is installed outdoors.
- If inlet temperature is higher than ambient, the listed allowable temperature rise values must be reduced by 2/3 of the difference between the actual measured inlet temperature and the ambient temperature.
- The average of the inlet and discharge temperature must not exceed 250°F. (121°C).

■ The ambient temperature of the space the blower/motor is installed in should not be higher than 120°F (48.8°C).

Speed— These blowers & exhausters may be operated at speeds up to the maximum listed for the various frame sizes. They may be direct coupled to suitable constant speed drivers if pressure/temperature conditions are also within limits. At low speeds, excessive temperature rise may be a limiting factor.

Special Note: The listed maximum allowable temperature rise for any particular blower & exhauster may occur well before its maximum pressure or vacuum rating is reached. This may occur at high altitude, low vacuum or at very low speed. The units' operating limit is always determined by the maximum rating reached first. It can be any one of the three: Pressure, Temperature or Speed.

Operation

Before operating a blower under power for the first time, recheck the unit and the installation thoroughly to reduce the likelihood of avoidable troubles. Use the following procedure check list as a guide, but consider any other special conditions in the installation.

1. Be certain that no bolts, tools, rags, or debris have been left in the blower air chamber or piping.
2. If an outdoor intake without filter is used, be sure the opening is located so it cannot pick up dirt and is protected by a strong screen or grille. Use of the temporary protective screen as described under INSTALLATION is strongly recommended.
3. Recheck blower levelling, drive alignment and tightness of all mounting bolts if installation is not recent. If belt drive is used, adjust belt tension correctly.
4. Turn drive shaft by hand to make sure impellers still rotate without bumping or rubbing at any point.
5. Ensure oil levels in the main oil sumps are correct.
6. Check lubrication of driver. If it is an electric motor, be sure that power is available and that electrical overload devices are installed and workable.
7. Open the manual unloading valve in the discharge air line. If a valve is in the inlet piping, be sure it is open.

8. Bump blower a few revolutions with driver to check that direction of rotation agrees with arrow near blower shaft, and that both coast freely to a stop.

After the preceding points are cleared, blower is ready for trial operation under "no-load" conditions. The following procedure is suggested to cover this initial operation test period.

- a. Start blower, let it accelerate to full speed, then shut off. Listen for knocking sounds, both with power on and as speed slows down.
- b. After blower comes to a complete stop, repeat above, but let blower run 2 or 3 minutes. Check for noises, such as knocking sounds.
- c. After blower comes to a complete stop, operate blower for about 10 minutes unloaded. Check oil levels. Observe cylinder and headplate surfaces for development of hot spots such as burned paint, indicating impeller rubs. Be aware of any noticeable increase in vibration.

Assuming that all trials have been satisfactory, or that necessary corrections have been made, the blower should now have a final check run of at least one hour under normal operating conditions. After blower is restarted, gradually close the discharge unloading valve to apply working pressure. At this point it is recommended that a pressure gauge or manometer be connected into the discharge line if not already provided, and that thermometers be in both inlet and discharge lines. Readings from these instruments will show whether pressure or temperature ratings of the blower are being exceeded.

During the final run, check operating conditions frequently and observe the oil levels at reasonable intervals. If excessive noise or local heating develops, shut down immediately and determine the cause. If either pressure rise or temperature rise across the blower exceeds the limit specified in this manual, shut down and investigate conditions in the piping system. Refer to the **TROUBLESHOOTING CHECKLIST** for suggestions on various problems that may appear.

The blower should now be ready for continuous duty operation at full load. During the first few days make periodic checks to determine whether all conditions remain steady, or at least acceptable. This may be particularly important if the blower is supplying air to a process system where conditions can vary. At the first opportunity, stop the blower and clean the

temporary inlet protective screen. If no appreciable amount of debris has collected, the screen may be removed. See comments under **INSTALLATION**. At this same time, verify levelling, coupling alignment or belt tension, and mounting bolt tightness.

Should operating experience prove that blower capacity is a little too high for the actual air requirements, a small excess may be blown off continuously through the manual unloading or vent valve. Never rely on the pressure relief valve as an automatic vent. Such use may cause the discharge pressure to become excessive, and can also result in unsafe operation of the valve itself. If blower capacity appears to be too low, refer to the **TROUBLESHOOTING CHECKLIST**. See page 15 and 19 for additional troubleshooting information regarding DVJ and DPJ units.

Vibration Assessment Criteria

With measurements taken at the bearing locations on the housings, see chart below for an appropriate assessment guide for rotary lobe blowers rigidly mounted on stiff foundations.

In general, blower vibration levels should be monitored on a regular basis and the vibration trend observed for progressive or sudden change in level. If such a change occurs, the cause should be determined through spectral analysis.

As shown on the chart below, the level of all pass vibration will determine the need to measure discrete frequency vibration levels and the action required.

All Pass Vibrations (in/sec)	Discrete Frequency Vibration (in/sec)	Action
0.45 or less	N/R	Acceptable
Greater than 0.45 but 1.0 or less	0.45 or less @ any frequency	Acceptable
	Greater than 0.45 @ any frequency	Investigate
Greater than 1.0	Less than 1.0	Investigate
	Greater than 1.0	Investigate

Installation

Howden Roots blowers & exhausters are treated after factory assembly to protect against normal atmospheric corrosion. The maximum period of internal protection is considered to be one year under

average conditions, if shipping plugs & seals are not removed. Protection against chemical or salt water atmosphere is not provided. Avoid opening the unit until ready to start installation, as corrosion protection will be quickly lost due to evaporation.

If there is to be an extended period between installation and start up, the following steps should be taken to ensure corrosion protection. See "Cleaning & Preservation" on page 17 and 18 for DVJ and DPJ units.

❑ Coat internals of cylinder, gearbox and drive end bearing reservoir with Nox-Rust VCI-10 or equivalent. Repeat once a year or as conditions may require. Nox-Rust VCI- 10 is petroleum soluble and does not have to be removed before lubricating. It may be obtained from Daubert Chemical Co., 2000 Spring Rd., Oak Brook, Ill. 60521.

❑ Paint shaft extension, inlet and discharge flanges, and all other exposed surfaces with Nox-Rust X-110 or equivalent.

❑ Seal inlet, discharge, and vent openings. It is not recommended that the unit be set in place, piped to the system, and allowed to remain idle for extended periods. If any part is left open to the atmosphere, the Nox-Rust VCI-10 vapor will escape and lose its effectiveness.

❑ Protect units from excessive vibration during storage.

❑ Rotate shaft three or four revolutions every two weeks.

❑ Prior to start up, remove flange covers on both inlet and discharge and inspect internals to ensure absence of rust. Check all internal clearances.

Because of the completely enclosed unit design, location of the installation is generally not a critical matter. A clean, dry and protected indoor location is preferred. However, an outdoor location will normally give satisfactory service. Important requirements are that the correct grade of lubricating oil be provided for expected operating temperatures, and that the unit be located so that routine checking and servicing can be performed conveniently. Proper care in locating driver and accessory equipment must also be considered.

Supervision of the installation by a Howden Roots Service Engineer is not usually required for these units. Workmen with experience in installing light to

medium weight machinery should be able to produce satisfactory results. Handling of the equipment needs to be accomplished with care, and in compliance with safe practices. Unit mounting must be solid, without strain or twist, and air piping must be clean, accurately aligned and properly connected.

Bare-shaft Units: Two methods are used to handle a unit without base. One is to use lifting lugs bolted into the top of the unit headplates. Test them first for tightness and fractures by tapping with a hammer. In lifting, keep the direction of cable pull on these bolts as nearly vertical as possible. If lifting lugs are not available, lifting slings may be passed under the cylinder adjacent to the headplates. Either method prevents strain on the extended drive shaft.

Packaged Units: When the unit is furnished mounted on a baseplate, with or without a driver, use of lifting slings passing under the base flanges is required. Arrange these slings so that no strains are placed on the unit casing or mounting feet, or on any mounted accessory equipment. DO NOT use the lifting lugs in the top of the unit headplates.

Before starting the installation, remove plugs, covers or seals from unit inlet and discharge connections and inspect the interior completely for foreign material. If cleaning is required, finish by washing the cylinder, headplates and impeller thoroughly with a petroleum solvent. Turn the drive shaft by hand to make sure that the impellers turn freely at all points. Anti-rust compound on the connection flanges and drive shaft extension may also be removed at this time with the same solvent. Cover the flanges until ready to connect piping.

Mounting

Care will pay dividends when arranging the unit mounting. This is especially true when the unit is a "bare-shaft" unit furnished without a baseplate. The convenient procedure may be to mount such a unit directly on a floor or small concrete pad, but this generally produces the least satisfactory results. It definitely causes the most problems in levelling and alignment and may result in a "Soft Foot" condition. Correct soft foot before operation to avoid unnecessary loading on the casing and bearings. Direct use of building structural framing members is not recommended.

For blowers without a base, it is recommended that a well anchored and carefully levelled steel or cast iron

mounting plate be provided. The plate should be at least 1 inch (25 mm) thick, with its top surface machined flat, and large enough to provide levelling areas at one side and one end after the unit is mounted. It should have properly sized studs or tapped holes located to match the unit foot drilling. Proper use of a high quality machinist's level is necessary for adequate installation.

With the mounting plate in place and levelled, set the unit on it without bolting and check for rocking. If it is not solid, determine the total thickness of shims required under one foot to stop rocking. Place half of this under each of the diagonally-opposite short feet, and tighten the mounting studs or screws. Rotate the drive shaft to make sure the impellers turn freely. If the unit is to be direct coupled to a driving motor, consider the height of the motor shaft and the necessity for it to be aligned very accurately with the unit shaft. Best unit arrangement is directly bolted to the mounting plate while the driver is on shims of at least 1/8 inch (3mm) thickness.

This allows adjustment of motor position in final shaft alignment by varying the shim thickness.

Aligning

When unit and driver are factory mounted on a common baseplate, the assembly will have been properly aligned and is to be treated as a unit for levelling purposes. Satisfactory installation can be obtained by setting the baseplate on a concrete slab that is rigid and free of vibration, and levelling the top of the base carefully in two directions so that it is free of twist. The slab must be provided with suitable anchor bolts. The use of grouting under and partly inside the levelled and shimmed base is recommended.

It is possible for a base-mounted assembly to become twisted during shipment, thus disturbing the original alignment. For this reason, make the following checks after the base has been levelled and bolted down. Disconnect the drive and rotate the unit shaft by hand. It should turn freely at all points. Loosen the unit foot hold-down screws and determine whether all feet are evenly in contact with the base. If not, insert shims as required and again check for free impeller rotation. Finally, if unit is direct coupled to the driver, check shaft and coupling alignment carefully and make any necessary corrections.

In planning the installation, and before setting the unit, consider how piping arrangements are dictated by the unit design and assembly. Drive shaft rotation must be established accordingly and is indicated by an arrow near the shaft.

Typical arrangement on vertical units has the drive shaft at the top with counterclockwise rotation and discharge to the left. Horizontal units are typically arranged with the drive shaft at the left with counterclockwise rotation and discharge down. See drawings on page 9, for other various unit arrangements and possible conversions.

When a unit is DIRECT COUPLED to its driver, the driver RPM must be selected or governed so as not to exceed the maximum speed rating of the unit. Refer to TABLE 1a, page 14 in the GAS Section, TABLE 1b, page 15 in the DVJ Section, TABLE 1c, page 19 in the DPJ Section and TABLE 1d, page 20 in the VJ Section for allowable speeds of various unit sizes.

A flexible type coupling should always be used to connect the driver and unit shafts.

When direct coupling a motor or engine to a blower you must ensure there is sufficient gap between the coupling halves and the element to prevent thrust loading the blower bearings. When a motor, engine or blower is operated the shafts may expand axially. If the coupling is installed in such a manner that there is not enough room for expansion the blower shaft can be forced back into the blower and cause the impeller to contact the gear end headplate resulting in damage to the blower. The two shafts must be in as near perfect alignment in all directions as possible, and the gap must be established with the motor armature on its electrical center if end-play exists. Coupling manufacturer's recommendations for maximum misalignment, although acceptable for the coupling are normally too large to achieve smooth operation and maximum life of the blower.

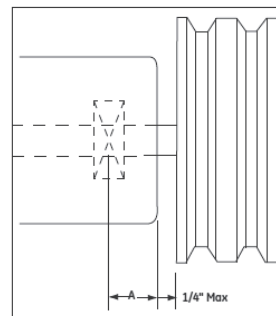
The following requirements of a good installation are recommended. When selecting a coupling to be fitted to the blower shaft Howden Roots recommends a taper lock style coupling to ensure proper contact with the blower shaft. Coupling halves must be fitted to the two shafts with a line to line thru .001" interference fit. Coupling halves must be warmed up per coupling manufacturer's recommendations. Maximum deviation in offset alignment of the shafts should not exceed .005" (.13 mm) total indicator

reading, taken on the two coupling hubs. Maximum deviation from parallel of the inside coupling faces should not exceed .001" (.03 mm) when checked at six points around the coupling.

When a unit is BELT DRIVEN, the proper selection of sheave diameters will result in the required unit speed. When selecting a sheave to be fitted to the blower shaft Howden Roots recommends a taper lock style sheave to ensure proper contact with the blower shaft. This flexibility can lead to operating temperature problems caused by unit speed being too low. Make sure the drive speed selected is within the allowable range for the specific unit size, as specified under TABLE 1a, page 14 in the GAS Section, Table 1b, page 15 in the DVJ Section, Table 1c, page 19 in the DPJ Section, and TABLE 1d, page 20 in the VJ Section.

Belt drive arrangements should employ two or more 3V, 5V, or 8V-belts running in grooved sheaves. Installation of the driver is less critical than for direct coupling, but its shaft must be level and parallel with the unit shaft. **The driver should be mounted on the inlet side of a vertical unit (horizontal piping) and on the side nearest to the shaft on a horizontal unit. (See page 7 for acceptable V belt drive configurations.)** The driver must also be mounted on an adjustable base to permit installing, adjusting and removing the V-belts. To position the driver correctly, both sheaves need to be mounted on their shafts and the nominal shaft center distance known for the belt lengths to be used.

Allowable Overhung Loads for V-belt Drives 400 - 600 RAM and 400 - 600 RCS-V units for DVJ, DPJ and VJ Blowers



$$\text{**Belt Pull lbs} = \frac{252100 \cdot \text{Motor HP}}{\text{Blower RPM} \cdot \text{Sheave Diameter}}$$

$$\text{Shaft Load (lb-in)} = \text{Belt Pull} \cdot \left(A + \frac{1}{4} \right) + \frac{\text{Sheave Width}}{2}$$

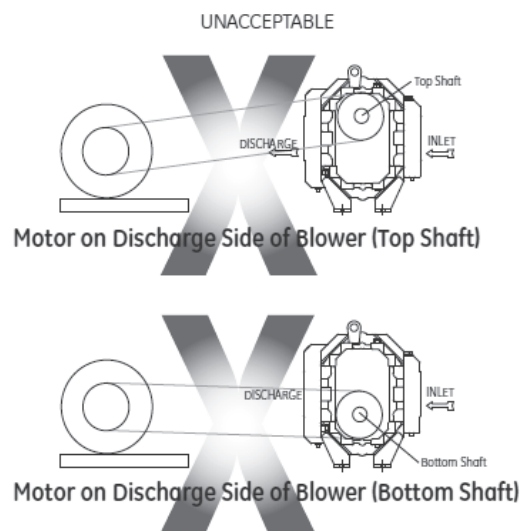
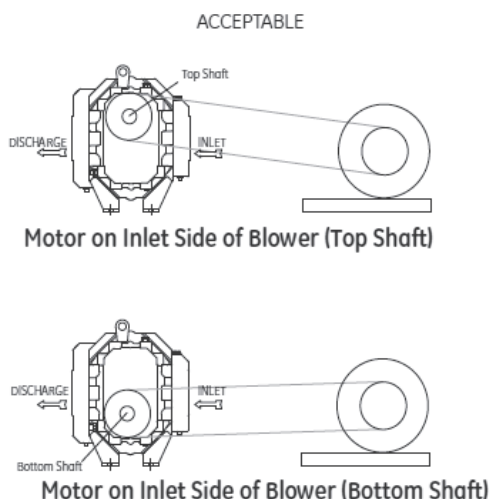
**Based on SF = 1.4 for v-belt drives. If higher SF belt is used, belt load should be increased proportionally and may exceed limits of the blower.

Frame Size	Dimension "A"		
	Standard Unit	Max. Allowable Shaft Load (lb-in)	Minimum Diameter (in)
404, 406	1.90	3,200	7.10
409, 412, 418	1.90	3,200	7.10
616, 624	2.11	7,975	8.50

NOTE: Arc of sheave belt contact on the smaller sheave not to be less than 170°. Driver to be installed on the inlet side for vertical units and on the drive shaft side for horizontal units.

Howden Roots recommends the use of two or more 3VX, 5VX or 8VX belts.

Acceptable Blower Drive Arrangement Options



CAUTION:

Drive couplings and sheaves (pulleys) should have an interference fit to the shaft of the blower (set screw types of attachment generally do not provide reliable service.) It is recommended that the drive coupling or sheave used have a taper lock style bushing which is properly sized to provide the correct interference fit required. Drive couplings, that require heating to fit on the blower shaft, should be installed per coupling manufacturer recommendations. A drive coupling or sheave should not be forced on to the shaft of the blower as this could affect internal clearances resulting in damage to the blower.

Engine drive applications often require special consideration to drive coupling selection to avoid harmful torsional vibrations. These vibrations may lead to blower damage if not dampened adequately. It is often necessary to install a flywheel and/or a torsionally soft elastic element coupling based on the Engine manufacturer recommendations.

The driver sheave should also be mounted as close to its bearing as possible, and again should fit the shaft correctly. Position the driver on its adjustable base so that 2/3 of the total movement is available in

the direction away from the unit, and mount the assembly so that the face of the sheave is accurately in line with the unit sheave. This position minimizes belt wear, and allows sufficient adjustment for both installing and tightening the belts. After belts are installed, adjust their tension in accordance with the manufacturer's instructions. However, only enough tension should be applied to prevent slippage when the unit is operating under load. Excessive tightening can lead to early bearing concerns or shaft breakage.

Before operating the drive under power to check initial belt tension, first remove covers from the unit connections. Make sure the interior is still clean, then rotate the shaft by hand. Place a coarse screen over the inlet connection to prevent anything being drawn into the unit while it is operating, and avoid standing in line with the discharge opening. Put oil in the sumps per instructions under **LUBRICATION**.

Piping

Before connecting piping, remove any remaining anti-rust compound from Unit connections. Clean pipe should be no smaller than unit connections. In addition, make sure it is free of scale, cuttings, weld beads, or foreign material of any kind. To further

guard against damage to the unit, especially when an inlet filter is not used, install a substantial screen of 16 mesh backed with hardware cloth at or near the inlet connections. Make provisions to clean this screen of collected debris after a few hours of operation. It should be removed when its usefulness has ended, as the wire will eventually deteriorate and small pieces going into the unit may cause serious damage.

Pipe flanges or male threads must meet the unit connections accurately and squarely. **DO NOT** attempt to correct misalignment by springing or cramping the pipe. In most cases this will distort the unit casing and cause impeller rubbing. In severe cases it can prevent operation or result in a broken drive shaft. For similar reasons, piping should be supported near the unit to eliminate dead weight strains. Also, if pipe expansion is likely to occur from temperature change, installation of flexible connectors or expansion joints is advisable.

Figure 3a, page 14, figure 3b, page 16, figure 3c, page 19 and figures 3d, 3e, 3f and 3g, pages 23 and 24, represents an installation with all accessory items that might be required under various operating conditions. Inlet piping should be completely free of valves or other restrictions. When a shut-off valve cannot be avoided, make sure a full size vacuum relief is installed nearest the unit inlet. This will help protect against unit overload caused by accidental closing of the shut-off valve.

Need for an inlet silencer will depend on unit speed and pressure, as well as sound-level requirements in the general surroundings. An inlet filter is recommended, especially in dusty or sandy locations. A discharge silencer is also normally suggested, even though Whispair units operate at generally lower noise levels than conventional rotary blowers.

Specific recommendations on silencing can be obtained from your local Roots distributor.

Discharge piping requires a pressure relief valve, and should include a manual unloading valve to permit starting the unit under no-load conditions. Reliable pressure/vacuum gauges and good thermometers at both inlet and discharge are recommended to allow making the important checks on unit operating conditions. The back-pressure regulator shown in Figure 3a, page 14 in the Gas Section, is useful mainly when volume demands vary while the unit operates at constant output. If demand is constant,

but somewhat lower than the unit output, excess may be blown off through the manual unloading valve.

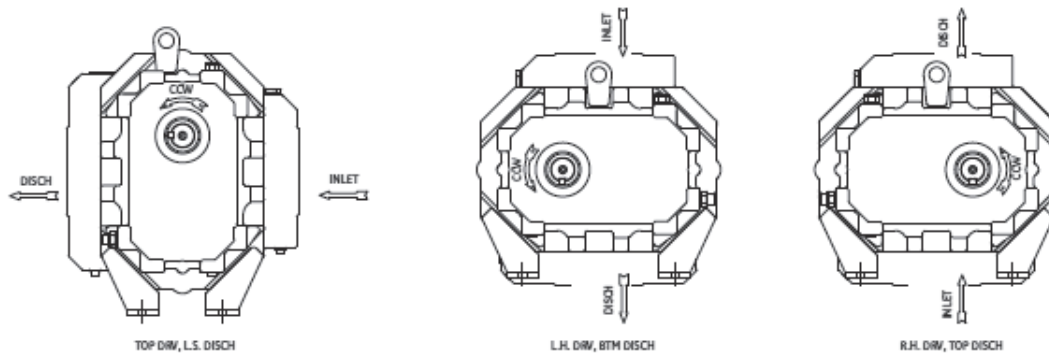
In multiple unit installations where two or more units operate with a common header, use of check valves is mandatory. These should be of a direct acting or free swinging type, with one valve located in each line between the unit and header. Properly installed, they will protect against damage from reverse rotation caused by air and material back-flow through an idle unit.

After piping is completed, and before applying power, rotate the drive shaft by hand again. If it does not move with uniform freedom, look for uneven mounting, piping strain, excessive belt tension or coupling misalignment.

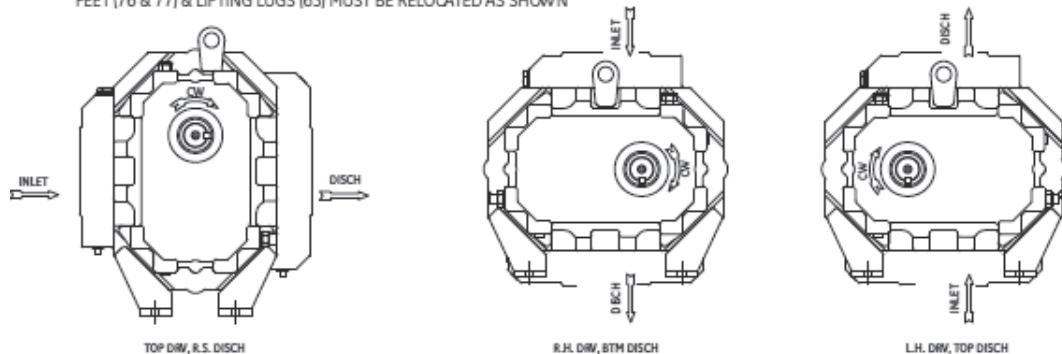
DO NOT operate the unit at this time unless it has been lubricated per instructions.

Blower Orientation Conversion - RAM WHISPAIR Units

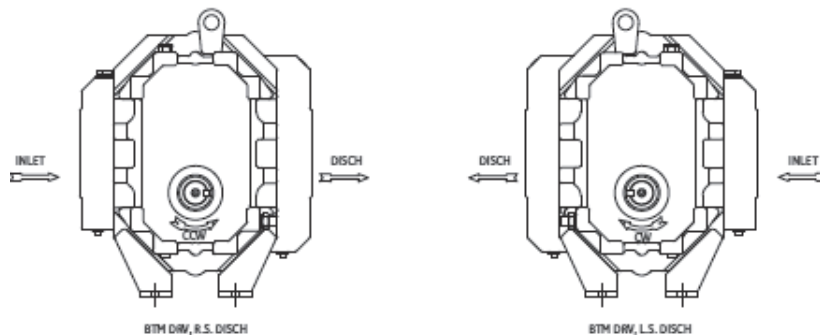
1. STANDARD ARRANGEMENT [3-WAY UNIVERSAL]
EXTERNAL SIGHT GLASSES (37) & BREATHERS (21) MUST BE RELOCATED AS SHOWN
FEET (76 & 77) & LIFTING LUGS (63) MUST BE RELOCATED AS SHOWN.



2. NON-STANDARD ARRANGEMENT [3-WAY UNIVERSAL]
CYLINDER (11) MUST BE UNBOLTED FROM HEADPLATES (1) AND DISCHARGE
RELOCATION AS SHOWN. **MUST HAVE AUTHORIZATION FOR CONVERSION
SO NOT TO VOID WARRANTY.**
EXTERNAL SIGHT GLASSES (37) & BREATHERS (21) MUST BE RELOCATED ALSO,
FEET (76 & 77) & LIFTING LUGS (63) MUST BE RELOCATED AS SHOWN



3. BOTTOM DRIVE SHAFT ARRANGEMENT "SPECIAL ORDER" (3-WAY UNIVERSAL)
SPECIAL OGE OIL SLINGER REQUIRED FOR ASSEMBLY.
MAY BE CONVERTED TO HORIZONTAL CONFIGURATION AS PREVIOUSLY SHOWN



Lubrication

Bearings and oil seals are lubricated by the action of the timing gears or oil slingers which dip into the main oil sumps causing oil to splash directly on gears and into bearings and seals. A drain port is provided below each bearing to prevent an excessive amount of oil in the bearings. Seals located inboard of the bearings in each headplate effectively retain oil within the sumps. Any small leakage that may occur should the seals wear passes into a cavity in each vented headplate and is drained downward.

Oil sumps on each end of the blower are filled by removing top vent plugs, Item (21), and filling until oil reaches the middle of the oil level sight gauge, Item (37).

Initial filling of the sumps should be accomplished with the blower not operating, in order to obtain the correct oil level. Approximate oil quantities required for blowers of the various models and configurations are listed in the Oil Sump Capacities table below. Use a good grade of **industrial type** non-detergent, rust inhibiting, anti-foaming oil and of correct viscosity per Recommended Oil Grades table on this page. Roots1 Synthetic Oil (Roots P/N 813-106-) is specified. Howden Roots does **NOT** recommend automotive type lubricants, as they are not formulated with the properties mentioned above.

The oil level should not fall below the middle of the site gauge when the blower is idle. It may rise or fall on the gauge during operation, to an extent depending somewhat on oil temperature and blower speed.

Proper lubrication is usually the most important single consideration in obtaining maximum service life and satisfactory operation from the unit. Unless operating conditions are quite severe, a weekly check of oil level and necessary addition of lubricant should be sufficient. During the first week of operation, check the oil levels in the oil sumps about once a day, and watch for leaks. Replenish as necessary. Thereafter, an occasional check should be sufficient. It is recommended that the oil be changed after initial 100 hours of operation. Frequent oil changing is not necessary unless the blower is operated in a very dusty location.

Normal life expectancy of petroleum based oils is about 2000 hours with an oil temperature of about 180°F (82°C). As the oil temperature increases by

increments of 15-18°F (8°C - 10°C), the life is reduced by half. Example: Oil temperatures of 210-216°F (99°C - 102°C) will produce life expectancy of 1/4 or 500 hours. Therefore, it is considered normal to have oil change periods of 500 hours with petroleum based oils.

Normal life expectancy of Roots Synthetic Oil is about 4000 to 8000 hours with an oil temperature of about 180°F (82°C). As the oil temperature increases by increments of 15-18°F (8°C - 10°C), the life is reduced by half. Example: Oil temperatures of 210-216°F (99°C - 102°C) will produce life expectancy of 1/4 or 1000 to 2000 hours.

NOTE: To estimate oil temperature, multiply the discharge temperature of the blower by 0.80. Example: if the discharge air temperature of the blower is 200° F, it is estimated that the oil temperature is 160° F.

1 Roots Synthetic Oil is superior in performance to petroleum based products. It has high oxidation stability, excellent corrosion protection, extremely high film strength and low coefficient of friction. Typical oil change intervals are increased 2-3 times over petroleum based lubricants. Also, Roots Synthetic Oil is 100% compatible with petroleum based oils. Simply drain the oil in the blower and refill the reservoirs with Roots Synthetic Oil to maintain optimum performance of your Roots blower.

Recommended Oil Grades

400 - 600 RAM & RCS-V (air only), GAS, DVJ & VJ Blowers

Recommended Oil Grades

400 - 600 RAM & RCS-V (air only), GAS, DVJ & VJ Blowers

Ambient ² Temperature °F	ISO Viscosity No.
Above 90° (32°)	320
32° to 90° (0° to 32°)	220
0° to 32° (-18° to 0°)	150
Below 0° (-18°)	100

2 Ambient temperature is defined as the temperature of the space in which the blower and drive are located.

Use a good grade of industrial type non-detergent, rust inhibiting, anti-foaming oil and of correct viscosity per the above table. Roots Synthetic Oil (Roots P/N 813-106-) is highly recommended. Roots does not recommend automotive type lubricants, as they are not formulated with the properties mentioned above.

Specific oil specifications apply for use in RAM/GAS blowers. The specified oil should be Roots Synthetic P/N 813-106- of the proper viscosity.

RAM, RAM-J Approximate Oil Sump Capacities

Model No./Drive Shaft Location	Gearbox		Drive End	
	Fl. Oz.	Liters	Fl. Oz.	Liters
400 (left or right)	36	1.06	19	0.56
400 (top or bottom)	18	0.52	9	0.27
600 (left or right)	95	2.81	50	1.48
600 (top or bottom)	55	1.63	28	0.83

RCS-V, RCS-JV Approximate Oil Sump Capacities

Model No./Drive Shaft Location	Gearbox		Drive End	
	Fl. Oz.	Liters	Fl. Oz.	Liters
400 (top or bottom)	30	0.089	18	0.53
600 (top or bottom)	64	1.89	32	0.95

These capacities are provided to assist stocking the correct amount of oil. Exact sump capacity may differ slightly. See "Lubrication" section for proper filling instructions.

Inspection & Maintenance : RAM & RCS (400 & 600 RCS vertical only) Series - GAS, DVJ, DPJ & VJ

A good program of consistent inspection and maintenance is the most reliable method of minimizing repairs to a blower. A simple record of services and dates will help keep this work on a regular schedule. Basic service needs are:

- Lubrication
- Checking for hot spots
- Checking for increases or changes in vibration and noise
- Recording of operating pressures and temperatures

Above all, a blower must be operated within its specified rating limits, to obtain satisfactory service life.

A newly installed blower should be checked often during the first month of full-time operation. Attention thereafter may be less frequent assuming satisfactory performance. Lubrication is normally the most important consideration and weekly checks of lubricant levels in the gearbox and bearing reservoirs should be customary. Complete oil change schedules are discussed under **LUBRICATION**.

Driver lubrication practices should be in accordance with the manufacturer's instructions. If direct connected to the blower through a lubricated type coupling, the coupling should be checked and

greased each time blower oil is changed. This will help reduce wear and prevent unnecessary vibration. In a belted drive system, check belt tension periodically and inspect for frayed or cracked belts.

In a new, and properly installed, unit there is no contact between the two impellers, or between the impellers and cylinder or headplates. Wear is confined to the bearings (which support and locate the shafts) the oil seals, and the timing gears. All are lubricated and wear should be minimal if clean oil of the correct grade is always used. Seals are subject to deterioration and wear, and may require replacement at varying periods.

Piston ring seals (28) are designed to operate without rubbing contact, once temperature and thermal growth have stabilized. The stationary rings will rub the rotating sleeve (38) briefly as a result of temperature cycles that occur during the start-up and shutdown of the unit. The sleeves are hardened and the rings are coated with dry lubricant that provides for temporary break in wear. Replace piston ring seals if they become excessively worn.

Shaft bearings are designed for optimum life under average conditions with proper lubrication and are critical to the service life of the blower. Gradual bearing wear may allow a shaft position to change slightly, until rubbing develops between impeller and casing. This will cause spot heating, which can be

detected by observing these surfaces. Sudden bearing failure is usually more serious. Since the shaft and impeller are no longer supported and properly located, extensive general damage to the blower casing and gears is likely to occur.

Oil seals should be considered expendable items, to be replaced whenever drainage from the headplate vent cavity becomes excessive or when the blower is disassembled for any reason. Some oil seal leakage may occur since an oil film under the lip is required for proper operation. Periodically leaked oil should be wiped off from surfaces. Minor seal leakage should not be considered as indicating seal replacement.

Timing gear wear, when correct lubrication is maintained, should be negligible. Gear teeth are cut to provide the correct amount of backlash, and gears correctly mounted on the shafts will accommodate a normal amount of tooth wear without permitting contact between lobes of the two impellers. However, too high an oil level will cause churning and excessive heating. This is indicated by unusually high temperature at the bottom of the gear housing. Consequent heating of the gears will result in loss of tooth-clearance, backlash and rapid wear of the gear teeth usually will develop. Continuation of this tooth wear will eventually produce impeller contacts (knocking), and from this point serious damage will be unavoidable if blower operation is continued. A similar situation can be produced suddenly by gear tooth fracture, which is usually brought on by sustained overloading or momentary shock loads.

Problems may also develop from causes other than internal parts failure. Operating clearances within a blower are only a few thousandths of an inch. This makes it possible for impeller interferences or casing rubs to result from shifts in the blower mounting, or from changes in piping support. If this type of trouble is experienced, and the blower is found to be clean, try removing mounting strains. Loosen blower mounting bolts and reset the leveling and drive alignment. Then tighten mounting again, and make sure that all piping meets blower connections accurately and squarely. Foreign materials sucked into the blower will also cause trouble, which can only be cured by disconnecting the piping and thoroughly cleaning the blower interior.

A wide range of causes & solutions for operating troubles are covered in the **TROUBLESHOOTING CHECKLIST**. (See specific sections for each series

of blowers). The remedies suggested should be performed by qualified mechanics with a good background. Major repairs generally are to be considered beyond the scope of maintenance, and should be referred to an authorized Roots distributor.

Warranty failures should not be repaired at all, unless specific approval has been obtained through a Sales Office or the factory before starting work.

Unauthorized disassembly within the warranty period may void the warranty.

Troubleshooting Checklist

Trouble	Item	Possible Cause	Remedy
No flow	1	Speed too low	Check by tachometer and compare with published performance.
	2	Wrong rotation	Compare actual rotation with Figure 1, change driver if wrong.
	3	Obstruction in piping	Check piping, valves, silencer to assure open flow path.
Low capacity	4	Speed too low	See item 1, if belt drive, check for slippage and readjust tension.
	5	Excessive pressure rise	Check inlet vacuum and discharge pressure and compare with published performance.
	6	Obstruction in piping	See item 3.
	7	Excessive slip	Check inside of casing for worn or eroded surfaces causing excessive clearances
Excessive power	8	Speed too high	Check speed and compare with published performance.
	9	Excessive pressure rise	See item 5
	10	Impeller rubbing	Inspect outside of cylinder for high temperature areas, then check for impeller contact at these points. Correct blower mounting, drive alignment.
	11	Scale, sludge, rust or product build up	Clean blower appropriately
Damage to bearings or gears	12	Inadequate lubrication	Check oil sump levels in gear and drive end headplates
	13	Excessive lubrication	Check oil levels. If correct, drain and refill with clean oil of recommended grade.
	14	Excessive pressure rise	See item 5.
	15	Coupling misalignment	Check carefully. Realign if questionable.
	16	Excessive belt tension	Readjust for correct tension.
Vibration	17	Misalignment	See item 15
	18	Impellers rubbing	See item 10
	19	Worn bearings/gears	Check gear backlash and conditions of bearings and replace as indicated.
	20	Unbalanced or rubbing impeller	Scale or process material may build up on casing and impellers, or inside impellers. Remove build-up to restore original clearances and impeller balance.
	21	Driver or blower loose	Tighten mounting bolts securely.
	22	Piping resonances	Determine whether standing wave pressure pulsations are present in the piping.
	23	Scale/sludge build-ups	Clean out interior of impeller lobes to restore dynamic balance.
	24	Casing strain	Re-work piping alignment to remove excess strain.
Driver stops, or will not start	25	Impeller stuck	Check for excessive hot spot on headplate or cylinder. See item 10. Look for defective shaft bearing and/or gear teeth.
	26	Scale, sludge, rust or product build-up	Clean blower appropriately
Excessive breather	27	Broken seal	Replace seals
Blow-by or excessive oil leakage to vent area	28	Defective O-ring	Replace seals and O-ring
Excessive oil leakage in vent area	29	Defective/plugged breather	Replace breather and monitor oil leakage
			Check sump levels in gear and drive headplates
	30	Oil level too high	Check oil to ensure it meets recommendations. Drain then fill with clean oil of recommended grade.
	31	Oil type or viscosity incorrect	Recommended oil temperature can be found on page 6 of this manual. The blower must be operated within the conditions of this manual.
	32	Blower running hot	

Gas Blowers

WHISPAIR Gas Blower

Whispair Gas Blower units are the same general design as the standard Whispair model except that (4) mechanical seals are used in place of the (4) inboard lip seals. The seal chambers are piped to plugged connections. These should be opened periodically to confirm that there is no build-up of oil due to leakage by the mechanical seal. Special traps may be required for vacuum operation. These units are intended for use with all gases which are compatible with cast iron, ductile iron, viton o-rings, 300 & 400 series stainless steel and carbon components of the mechanical seals. If there are any questions as to suitability of materials, consult the Roots sales office.

Precaution: Whispair Gas Blower

The mechanical seals may leak some amount of the process gas to the atmosphere through the gear/box end cover breather caps. If this leakage is undesirable, for toxic/ hazardous gases, provide inert purge gas in the vent chamber between the mechanical seals and the piston ring seals, refer to Figure 1a. The purge gas pressure in the vent chamber should be maintained at about 1 psi over the discharge pressure.

The plugged drain connections are provided to allow periodic draining of any fluid which might accumulate in the seal chamber. This can be a combination of lubricating oils, liquids entrained in the process gas, or condensables from the process gas. **Care must be used when opening the vent drain plugs as some gas will also escape if it is a pressure system. For system under vacuum the air will leak in. Never vent explosive or toxic gases in an unsafe manner. Care must be used when opening oil fill and oil drain plugs. The gas leakage past mechanical seal could accumulate in the gear box and drive end cover oil sump areas and leak out to the atmosphere.**

If there is any question regarding application or operation of this gas pump consult the Roots sales office.

Conversely, if the system is under vacuum, there will be leakage of atmospheric air into the system through the breather and the lube chamber, and by the mechanical seals or from vent drain when plug is open. This gas will contain oil vapor. If the process gas is non-toxic/nonhazardous and the leaked gas needs to be piped away, refer to Figure 3a for piping arrangement. The piping arrangement should not cause back pressure in excess of 10" water column.

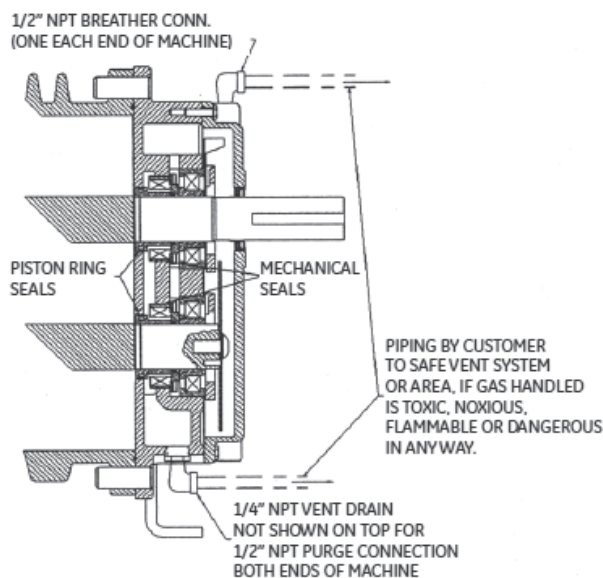
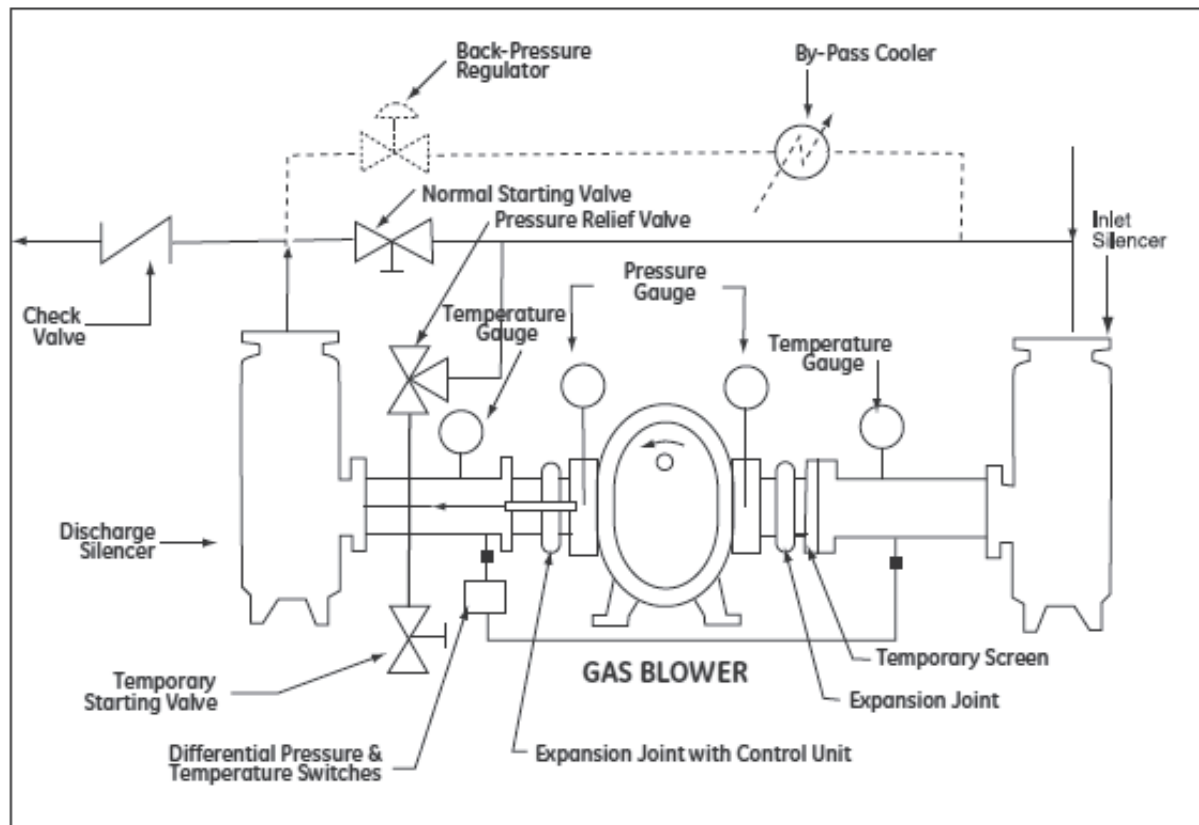


Table 1a - RAM-G & RAM-GJ Blower Maximum Allowable Operating Conditions

Frame Size	Gear Diameter (Inch)	Speed RPM	Temperature Rise		Delta Pressure		Inlet Vacuum	
			F°	C°	PSI	mbar	INHG	mbar
404	4.5	4000	240	133	18	1241	16	539
406	4.5	4000	240	133	18	1241	16	539
409	4.5	4000	240	133	18	1241	16	539
412	4.5	4000	240	133	15	1034	16	539
418	4.5	4000	240	133	10	690	16	539
616	6	3000	230	128	15	1034	16	539
624	6	3000	230	128	10	690	16	539

Figure 3a Gas Blower Installation with Accessories



400-600 Series DVJ Blowers

Information in this section not to conflict with other sections of this manual.

Operating Limitations

Normal DVJ applications have a vacuum on the inlet and atmospheric pressure on the discharge jet port connections.

Any unnecessary restrictions of discharge flow or atmospheric air inlet to the jet port reduces the cooling air flow and limits blower operation, as the maximum temperature rise will occur below the normal limits of vacuum level.

NOTE: One jet port must have a full size inlet silencer with no valve or other restrictions. The other port must have the metal cover plate installed.

Installation

A temporary cover is installed on one jet port and a permanent cover on the other at the factory. A silencer must be installed in place of the temporary cover before operating the blower, however, the permanent cover and silencer locations may be exchanged if the installation requires.

The permanent cover must be removed, both jet plenums inspected and cleared of foreign material, then the permanent cover and silencer installed in the desired locations before operating. Full size jet and discharge silencers are desirable, however, the jet silencer may be reduced one nominal size providing either the vacuum level is less than 18.5" Hg or the gear speed is below 3650 feet per minute. Both the jet silencer and the discharge silencer may be reduced one nominal size in applications with vacuum levels less than 18.5" Hg and a gear speed below 3650 feet per minute.

Jet and discharge flow restrictions result in increased blower temperature rise and should be checked as a possible cause if the temperature rise limits blower operation to less than the maximum vacuum level.

Backpressure limits are shown in Table 1 of this section. No valves should be used in the discharge piping or jet silencer piping.

Some type of protection, such as a filter or screen (1/4" mesh) is necessary to stop foreign particle entry through the jet port. Outside installations may also require some weather protection to prevent the entry of rain or snow. An elbow or some other pipe

configuration is desirable to assist in keeping the screen clear of foreign particles and the direct entry of rain or snow.

Operation

All check points should be followed with the addition and/or superseded by the following:

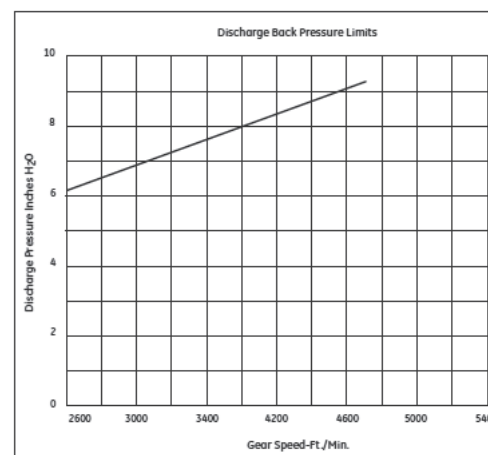
(1, add.) Be careful no rags, bolts, or dirt have been left in the cylinder slot inlet plenums

(2, add.) No valves should be installed in the discharge pipe or jet silencer pipe

The blower is suitable for vacuum operation only. A water manometer should be used on the discharge plenum to determine that the maximum discharge pressure has not been exceeded.

Table 1b - RAM-DVJ blower
Maximum Allowable Operating Conditions

Frame Size	Speed RPM	Temperature Rise		Inlet Vacuum	
		F°	C°	INHG	mbar
406	4000	275	153	27	684
412	4000	300	167	27	684
616	3000	300	167	27	684



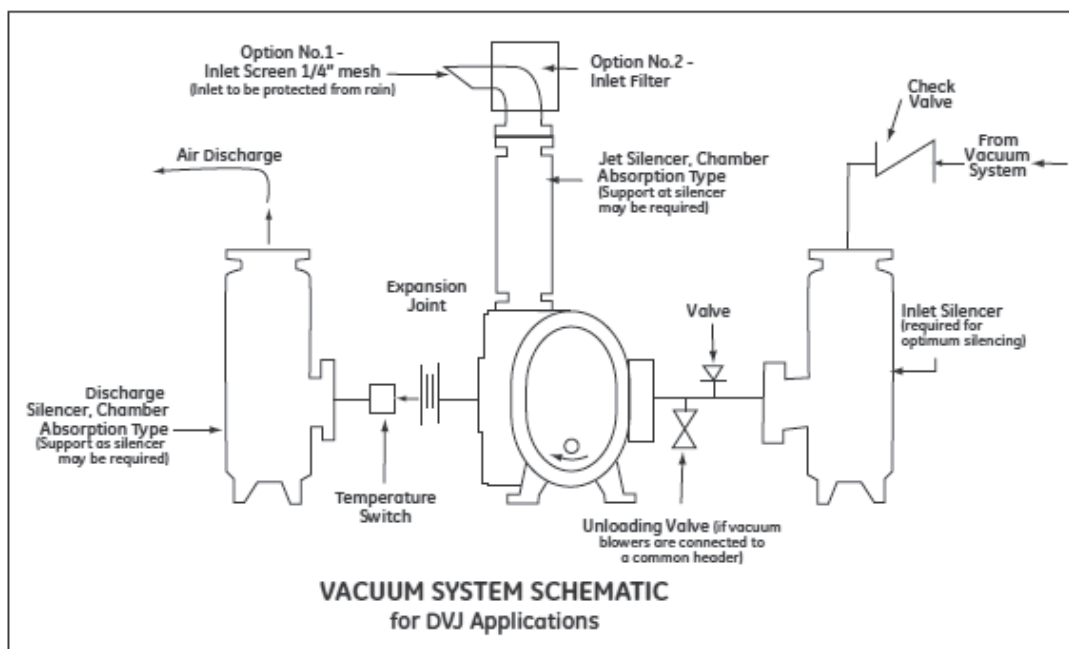
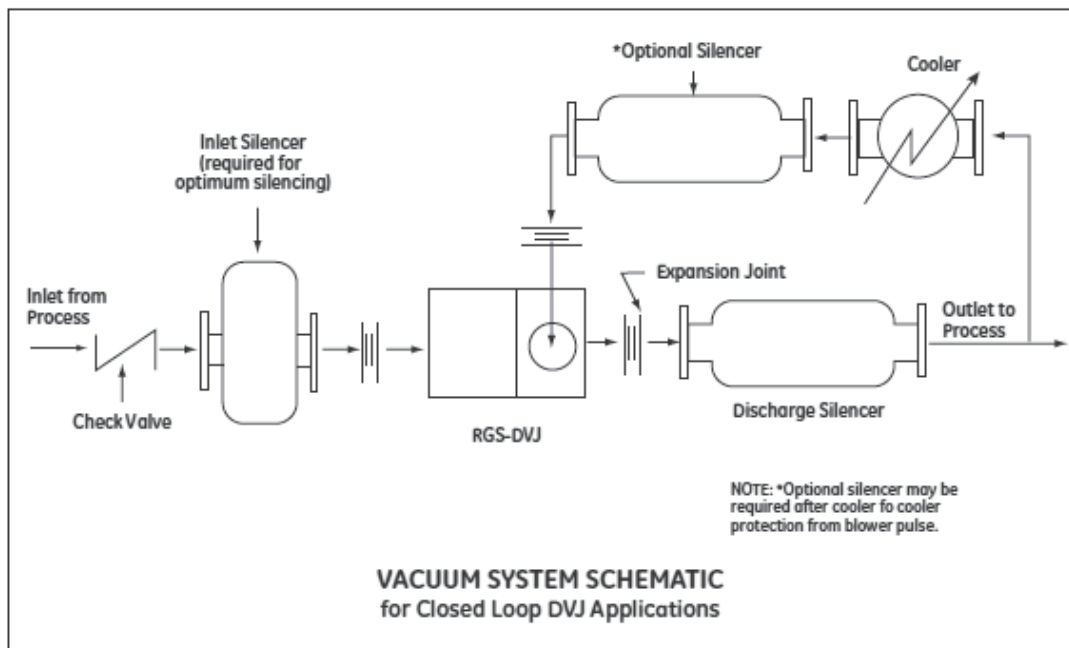
Gear Speed = $0.262 \times 4.5 \times \text{rpm}$ for 400 Series
Gear Speed = $0.262 \times 6.0 \times \text{rpm}$ for 600 Series

Troubleshooting

All troubleshooting points in this manual should be followed with the addition/or supersedure of the following: Excessive temperature rise - check for possible cylinder slot inlet flow restriction, excessive backpressure on the discharge, and troubleshooting checklist in the appropriate instruction and operation manual.

NOTES: No valves should be installed in the discharge or jet silencer pipe. Jet silencer should be a chamber type (non-packed).

Figures 3b - DVJ



DVJ & DPJ Blowers are supplied with internal abradable graphite-based coating

Coating

The coating is basically a fine-grained natural graphite¹. It is applied as several coats. Coating applied after the machine's internal clearances and impeller timing are established. The effect of coating is to close up internal clearances, decreasing slip and increasing flow and efficiency at any given speed. Exhaust air may carry some coating particles.

Characteristics of machines with coated internal service

Machines with internal abradable coating are for use with clean, dry air only.

After coating, it is not practical to try to measure clearances involving these surfaces before or after running the machine. After coating and before running, some coated surfaces may even be touching. After running, the coated surfaces may have abraded areas and scratches, due to run-in contact between the surfaces. Do not attempt to measure clearances involving coated surfaces as a basis for setting impellers in relation to the cylinder bore, headplates, or each other (fronts and backs). Clearance settings can be made accurately only with uncoated parts.

Cleaning and preservation

Where internal, inspection indicates a need for cleaning coated surfaces of dirt, dust, etc., wipe clean only with a clean, dry rag. Do not use a solvent or cleaner of any kind or allow a solvent or cleaner to reach these surfaces while cleaning uncoated surfaces.

If internal protection from rust or corrosion is required due, for example, to removal of the machine from service, or if the internal protections furnished as shipped by the factory has been removed, do not use a liquid preservative of any kind on these coated surfaces. Bags of vapor inhibitor powder, such as Shell Oil Company VPI No. 250 may be used internally, with all machine openings sealed with vapor barrier paper or tape.

Trouble shooting check list

This list in standard instructions applies, except note that in those lists and in various locations throughout the standard instruction manuals for uncoated

machines, rubbing, knocking, contact and wear between internal surfaces are mentioned as trouble indicators. This is with respect to metal-to-metal interference. Coated surfaces can have very close clearances and will wear in, or abrade, between surfaces, showing rub or scratch marks which are normal conditions. These can usually be differentiated from metal-to-metal contact.

Cleaning, coating & curing procedures for applying abradable coating

General. These procedures are for coating new uncoated repair parts, spot repair of coating, or renewal. If setting clearances and timing are involved, this should be done before the new parts are coated. Subsequent cleaning and coating may involve at least partial disassembly for proper cleaning without damaging the coating of other original parts still coated, and to apply coating properly.

Normally, for new uncoated surfaces, three coats are applied and each coat must be properly cured.

Cleaning before coating

For new uncoated surfaces, apply the cleaner with a clean, "soaked" rag. Apply the cleaner liberally, allow to set for one to two minutes, then wipe off. Repeat if necessary. Avoid cleaning surfaces which will not be coated.

Wiping off with a clean, dry rag is the only cleaning allowable for spot repair or renewal of existing coating except in the case of a small area of grease or similar substance where scraping clean before reaching bare metal may be attempted. If too dirty to clean by these methods, disassembly will be required to remove the coating entirely, solvent clean, and recoat.

Preparation of coating material

The graphite suspended in the material settles out in a fairly short time and the can must be shaken well, and also frequently, during spray application. Generally, the initial shaking should continue until the ball in the can rattles freely and should then continue for at least five minutes more.

Coating general

Procedures for application are for one coat, but when multiple coats are to be applied, EACH coat must be completely cured per CURE procedure described following, before applying the next coat.

Coating application

See notes on can concerning ventilation and inflammability.

Each layer of coating should be applied as evenly as possible. Note directions on the curing of each coating layer applied before applying subsequent coats.

The best distance of spray can nozzle to surface being coated is 8" to 12". Try to maintain this distance wherever space conditions allow it.

Coating cure

This procedure is for EACH coat. When multiple coats are to be applied, this curing procedure must be used on EACH coat before the next coat is applied. Keep coated parts clean during curing.

Note that coated parts may feel dry or "tack free" after a few minutes, but the coat will not have the CURE that is required.

Curing procedures

Alternate #1

Let set for 1-1/2 hours, minimum, at normal room temperature (not less than 70°F).

Abradable coating applied to impellers is slip plate #3 as manufactured by Superior Graphite Co. For a material safety data sheet, go to www.slipplate.com. Study material safety data sheet before working with Slip Plate #3.

Alternate #2

Where ambient, and coated metal temperatures, are not at least 70°F, allow each coat to cure at least overnight in shop ambient (not warehouse or outdoors).

Alternate #3

Cure in oven, or by other source of even heat (not flame), for 10 minutes, minimum, at a temperature of 310°F ±10.

Alternate #4

Cure in oven, or by other source of even heat (not flame), for one-half hour, minimum, at a temperature of 200°F ±10°.

Check for rotation

Finish blower build-up if not completely assembled when coated. In some instances, it is possible that clearances will be closed by coating to the extent that some surfaces touch. This is all right because the coating will wear (abrade) off as required. However, the blower may be hard to turn initially as a result. Turn over by hand until the running is free. Do not try to free up the blower by coupled or belted drive, and do not try to spin the rotors with shop air. Do not attempt to use any kind of solvent or cleaner to partially remove, coating – as this could ruin all of the coating. If necessary, coating can be scraped for such partial removal.

Complete removal of coating

This is for complete removal (to bare metal) of coating and may require some blower disassembly (depending on blower size and accessibility) for access to the coated parts and any overspray. Apply removal fluid liberally with a clean, "soaked" rag. Vigorously rubbing with this rag and scraping of the softened coating is required to clean surfaces down to bare metal, the amount of effort required will vary, depending upon the solvent used. Some are more effective than others. Protect surfaces, not coated, from rust.

406 RAM DPJ Section

Information in this section should not conflict with other sections of this manual.

Operating limitations

The RAM DPJ can be used in vacuum/pressure or combination applications as long as a portion of the discharge air is recirculated through a pipe, with diameter equal to the return air plenum port, and cooled before entering the return air plenum. The recycled and cooled discharge air should be above the dew point, which is approximately 110°F (43° C) for 30 psi, and have a minimum pressure drop before entering the return air plenum. The maximum pressure drop should not exceed the values given in Table 1c. The blower inlet temperatures, jet inlet temperature, inlet pressure, speed and pressure rise are all factors which affect the temperature rise. Therefore, a discharge air temperature switch, and thermometers at blower discharge and jet inlet, as shown on Figure 2, is recommended.

Howden Roots recommends delta/differential pressure and temperature protection.

Installation

Inspect the return air plenum to be sure it is clear of any foreign material before installing the return cooled air piping (full port size piping must be used). Inspect the cooler for foreign material before installation, as dirt, metal shavings, paper and other materials could restrict air flow to the blower jets or damage close clearance rotating parts within the blower.

Operation

NOTE: be sure the pressure drop between the blower discharge and the return air inlet does not exceed the maximum listed in Table 1c of this section.

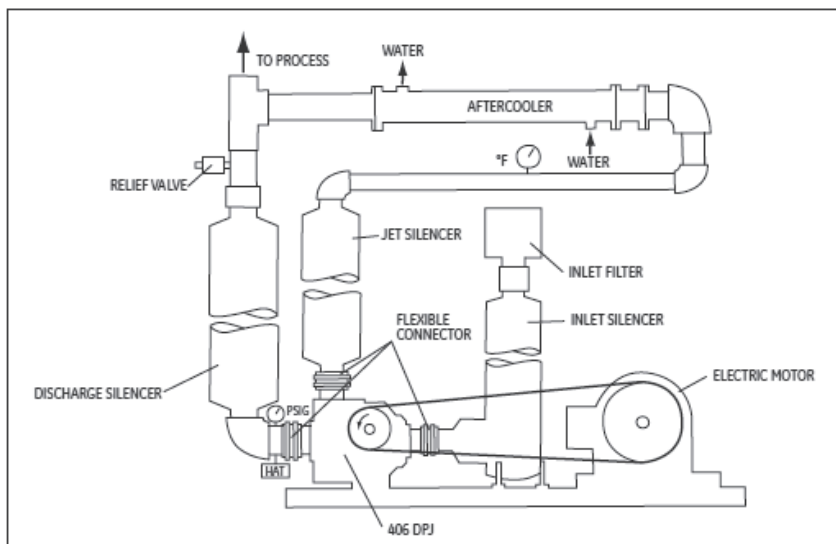


Figure 3c Flow Schematic for DPJ Applications

Table 1c - DPJ Blowers Maximum Allowable Operating Conditions

Frame Size	Speed (RPM)		ΔP Across Blower				Temperature Rise		Pressure Drop to Jet		
			Pressure		Vacuum						
	Min.	Min.	PSI	KPa	IN Hg	mm Hg	F°	C°	PSI	IN Hg	mm Hg
406	1750	3820	30	208	22	560	275	153	0.73	1.5	38

Troubleshooting for DPJ Blowers All troubleshooting points in this manual should be followed with the addition/or superseding of the following:

Trouble	Item	Possible Cause	Remedy
High Temperature	1	Excessive pressure rise across blower	Check inlet pressure and discharge pressure and compare with Table 1 (DPJ).
	2	Restriction in cooling air system	Check ΔP from discharge to jet inlet. Check piping, valves and cooler to assure an open flow path.
	3	Loss of coolant to the jet cooler	Check coolant flow and temperature at inlet and discharge of cooler.

406 RAM VJ Section

Roots VJ vacuum blowers are designed to handle a limited quantity of liquid without damage. This permits introduction of sealing water at the blower inlet to improve operating efficiency and reduce internal temperature rise. Part or all of the water required for sealing purposes may be present in the process being served by the blower. If this water input rate is known in terms of gallons per minute, and is less than the Recommended Continuous Rate shown in Table 1d in this section, spray injection of water may be reduced accordingly. As a safety precaution, it is recommended that at least a small quantity of water always be injected regardless of normal process water. This will reduce the likelihood of running dry at some vacuum level that will cause damage.

Where liquid flow rates from a process are in excess of the Recommended Continuous Rate in Table 1d in this section, some method of water removal should be employed. This can be a drain leg in the blower inlet piping, or a receiver and water pump arrangement. On wet vacuum filter service a vacuum receiver with filtrate removal system is recommended. This will normally serve the purpose of extracting excess water without the addition of a separate moisture trap.

Should water input rates exceed recommended values in Table 1d in this VJ Section, blower operation will become noisy and rough. If continued for an extended period of time, mechanical damage to the blower may result. Such high rates will put too much water in the blower, and this will increase horse power requirements to a point where the driver may become overloaded.

A VJ vacuum blower should not be expected to handle solid particles entrained in the sealing water on any continuous basis. If material build-up on the surfaces of the impellers and cylinder occurs, it must be removed to avoid internal contacts and resultant damage. Suggested methods for preventing scale build-up are outlined under OPERATION.

NOTE: If a VJ blower is to be converted from water sealed operation to use as a dry vacuum blower, all scale or dirt deposits must first be completely removed from all internal surfaces.

Operating Limitations

To establish and maintain continued satisfactory performance, a Roots VJ vacuum blower must be operated within certain approved limiting conditions. The Manufacturer's warranty is contingent on such operation.

Maximum limits for vacuum, temperature and speed, along with recommended and maximum water flow rates as specified in Table 1d in this section, for various standard sizes of single stage VJ blowers. These limits apply to all blowers of normal construction and having normal internal operating clearances when operating under standard atmospheric conditions (inlet air at 68° F, discharge pressure at 14.7 psia). Do not exceed any one of these limits.

Example: assuming water sealed operation the temperature rise probably will be considerably below the allowable maximum. If the blower operating speed is also below the maximum, the inlet vacuum then becomes the limiting factor to be watched. In other words, the operating limit is always to be determined by the maximum rating reached first. It can be vacuum pressure, speed, or temperature.

Temperature rise - normally this is not a problem in a wet vacuum blower since the water used for sealing purposed also removes the heat of compression. However, the VJ blowers may be operated with the maximum temperature rises listed in Table 1d in this section providing speed and inlet vacuum limits are not exceeded.

Vacuum - with the blower discharge connected directly to atmospheric pressure the suction or vacuum load on the pump inlet as measured in inches of mercury (hg.) must not be greater than the value listed for any specific frame size.

Speed Range - VJ vacuum blower may be operated at speeds up to the maximum listed for each gear diameter or frame series. They may be direct coupled to suitable constant speed drivers, or belt driven to obtain intermediate speeds.

Operating VJ Blowers 400 - 600 Series

Before operating a blower under power for the first time, recheck the unit and the installation thoroughly to reduce the likelihood of avoidable troubles. Use the following procedure list as a guide, but consider any other special conditions in the installation.

Table 1d - VJ maximum Allowable Operating Conditions

Frame Size	Inlet Vacuum ¹		Discharge Temperature		Speed (RPM)	Sealing Water Flow Rate MAX ²	
	IN Hg	mm Hg	F°	C°		Recommended	
406	24	610	200	94	3200	4-1/2	17
409	24	610	200	94	3200	4-1/2	17
412	24	610	200	94	3200	4-1/2	17
418	20	508	200	94	3200	4-1/2	17
616	24	610	200	94	2400	6	23
624	20	508	200	94	2400	6	23

¹ Applies to single stage VJ units as listed. The maximum inlet vacuum for two-stage VJ-2 combinations is 27 inches HG, based on 30" Gg. barometer. The minimum level at which reliable vacuum performance can be calculated is 3" Hg. above the absolute saturation pressure of the sealing water.

² Includes injected and process water. Total GPM is for either single stage or two-stage operation.

❑ Be certain that no bolts, tools, rags, or debris have been left in the blower air chamber and piping.

❑ If an outdoor intake without filter is used, be sure the opening is located so it cannot pick up dirt and is protected by a strong screen or grille. Use of the temporary protective screen as described under INSTALLATION is strongly recommended.

❑ Recheck blower levelling, drive alignment and tightness of all mounting bolts if installation is not recent. If belt drive is used, adjust belt tension correctly.

❑ Turn drive shaft by hand to make sure impellers still rotate without bumping or rubbing at any point.

❑ **Ensure oil levels in the main oil sumps are correct.**

❑ Check lubrication of driver. If it is an electric motor, be sure that power is available and that electrical overload devices are installed and workable.

❑ Close the three drain line valves in the bottom of cylinder (VERTICAL BLOWER ONLY).

❑ Open the manual unloading valve in the discharge air line. If a valve is in the inlet piping, be sure it is open.

❑ Bump blower a few revolutions with driver to check that direction of rotation agrees with arrow near blower shaft, and that both coast freely to a stop. Do not restart the blower until it has come to a complete stop.

❑ Turn on sealing water supply by opening the manual shut-off valve (C in Figure 3f). Water will not flow to the spray nozzle yet since solenoid operated valve (SV) is electrically held closed until de-energized by the motor starter.

❑ Set valving at the water flow meter (Figure 3) so meter is in the line, with the by-pass pipe loop closed. Set spray control valve (b) about 1/4 open as a preliminary adjustment. In a two-stage installation, also set corresponding valve (A) at the second blower in the same manner.

With the preceding checks and adjustment completed satisfactorily, the vacuum blower should be ready for an operating tests. The following procedure is recommended:

A. Start the blower, let it accelerate to full speed, then shut off. listen for knocking sounds, both with power on and as the unit slows down. Also observe the sealing water flow meter. A flow indication verifies that solenoid valve (SV) has opened properly.

B. If no problems have appeared, restart the blower and let it operate for 5 to 10 minutes under no-load conditions. Adjust spray control valve (B) so that the water flow meter show a rate in gallons per minute equal to the Recommended Rate in Table 1d in this section. For a two-stage installation, close valve (B) on first stage and adjust valve (A) on second stage so that flow meter indicates one-third of the allowable total flow rate. Then open valve (B) until flow meter reads the correct total water rate. This adjustment is semi-permanent, and the two control valves should be locked by removing their wheels or by other suitable methods. Valve (C) then serves as the master valve.

C. Also during this period, check the cylinder and headplates for hot spots indicating impeller rubs. Continue to be alert to unusual noises and changes in vibration. Check oil levels in the sight windows at both sumps, and verify several times that the flow rate at the sealing water meter remains reasonably constant. Shut unit down and note whether water

meter shows no flow, indicating the solenoid water valve (SV) has closed properly. Open valves in cylinder drain lines (vertical blower only) and make sure lines are not clogged. Close valves after draining. Recheck all surface for hot spots.

D. If all conditions are acceptable, restart the vacuum blower and observe operation for at least one hour. During this period the normal vacuum working load should be applied on the blower inlet gradually. As this is done, it is important to make sure the inlet vacuum level and the temperature rise do not exceed the allowable figures listed in Table 1d in this section. Mercury manometers should be installed at the inlet and discharge of the blower to check pressure conditions. On two-stage units they should be installed for both blowers.

Operating temperatures under average conditions will be low enough that sufficient check can be made by feeling the cylinder. However, if the cylinder temperature runs uncomfortably hot, it may be advisable to install inlet and discharge thermometers for more accurate information. As the run progresses, continue to check for noises and vibration changes, observe all levels in the sight glass at each sump, and watch the water flow rate. Also note the behaviour of the discharge silencer drain trap. If any troubles appear, refer to the **TROUBLESHOOTING CHECKLIST**, page 12, as well as the items at the bottom of this page for suggested remedies.

The vacuum blower should now be ready for continuous duty under full working load. During the first several days make periodic checks to be sure that all conditions remain reasonably steady and within specified limits. These checks can be especially important if the unit is part of a process system in which conditions may vary widely. If such variations can put an excessive vacuum on the blower, overloading can often be avoided by installation of a pilot operated vacuum relief valve

near the blower inlet. For further protection, a dependable pressure sensitive device can be installed to provide alarm and/or shutdown action.

At the first opportunity, stop the blower and clean the temporary protective pump inlet screen. Depending on the amount and type of debris found, judgement can be made as to how long the screen should remain in place. Unfavourable conditions may lead to repeated and frequent clogging or loading.

Installation of manometer in such cases will reveal the need for cleaning by indicating an increase in pressure drop through the screen. during this shut-down period verify levelling, anchor bolt tightness, alignment of shaft coupling, or tension of drive belts.

After VJ2 is in operation it may be found that only a small vacuum can be produced. this operating condition should be avoided, since the second stage blower will be running idle and doing no work, and the by-pass check valve may be fl uttering against its seat. one solution could be to remove the second blower from the system and thus eliminate excessive maintenance problems. The preferable choice should be to increase pumping capacity in order to bring the vacuum to the desired level and make normal use of both blower stages.

When a vacuum blower is taken out of service it may require internal protection against rusting or corrosion. The need for protection must be a matter of judgement based on existing conditions; protection probably will not be needed if shut-down is not longer than one day. Under conditions likely to produce rapid corrosion the blower should be protected immediately. Following is a suggested procedure.

Remove the vacuum load from the blower and vent the inlet to atmosphere, if possible. With the sealing water shut off at valve (C), run the blower until the interior surfaces are judged to be dry. Remove inlet and discharge piping at the blower connections and

Additional Troubleshooting for VJ Blowers

Trouble	Possible Cause	Remedy
Excessive power	Excessive water flow	Compare flow meter rate with table 1a, determine whether water process has increased.
Excessive power	Pressure unbalance (2 stage pump)	Check interstage valve and piping for leakage.
Vibration	Water build-up in cylinder at start	Clean out cylinder drain line and make sure outlet end is not submerged.

inspect the interior. If any moisture is present, run the blower again until drying is completed. Coarse screens should be placed over both connections to avoid damage or personal injury.

Now coat all finished surfaces of cylinder, headplates, and impellers with a protective compound. Amount suitable commercial products is Motorstor, marketed by Daubert Chemical Company. This material is best applied by spraying at, but may also be brushed on. Special care should be taken to ensure good coverage between the end of the impellers and the headplates. Before doing this work make sure the blower cannot be started accidentally. After completing the application, seal all blower opening with vapor barrier paper and tape.

This type of protection is normally effective for about one year if seals are not broken. When blower is to be returned to service, remove all seals and inspect the internal surfaces. If dirt of any kind is found clean with all surfaces with a good petroleum solvent. If cleaning is not required for dirt removal the blower may be reconnected and a check run made to verify normal operation. Before operating under power, turn the drive shaft several revolutions manually to verify that impellers turn freely at all points, with no scrapping or bumping. Also make sure that tape is removed from the drain/vent holes near the bottom of each headplate.

Scale build-up

A basic principle of the Roots VJ unit is that there is no internal contact of moving parts. To satisfy this concept and still maintain maximum pumping efficiency, there must be small but definite clearances between the impellers and between impellers and case. Any scale build-up due to mineral deposits from the water or process residue, which tend to close these clearances is intolerable. Loss of clearance will cause the impellers to rub the case and each other, which may cause the unit to stick while in operation or to freeze when shut down.

There are two methods of preventing scale build-up. One method is to use de-mineralized water for sealing and to filter any process residue ahead of the unit. The other method is to de-scale the unit at regular intervals, such as weekend shut-downs. The latter method is the simpler and more economical, unless shut-down periods are infrequent.

It is recommended that a sample of the build-up material be sent to the scale removal supplier for analysis so the proper agent can be selected for the removal. Scale deposits in different processes and localities may require variations in concentration or type of removal agent.

Following are two recommendations received from scale removal suppliers who examined samples of build-up deposits from a particular installation. They are listed in order of preference based on effectiveness, estimated cost of solution, cost of equipment, ease of applying, and possibility of damage to the blowers from the solution

1. Magnus 61-C alkaline stripping compound – Magnus Chemical Co., Inc., Garwood, N.J.

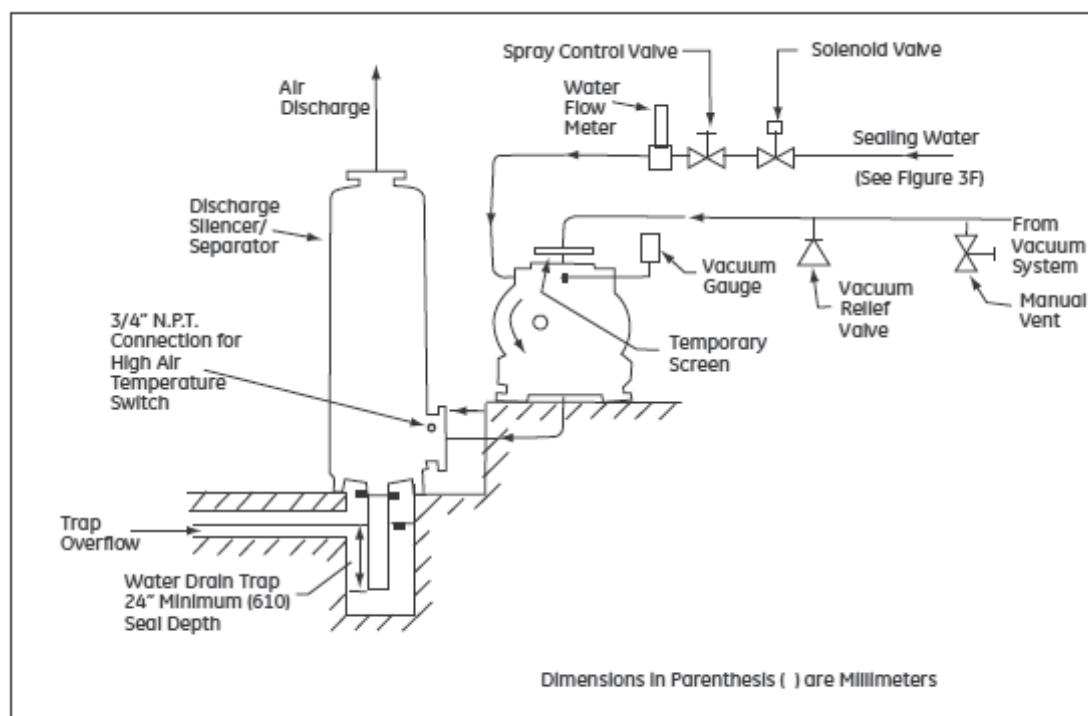
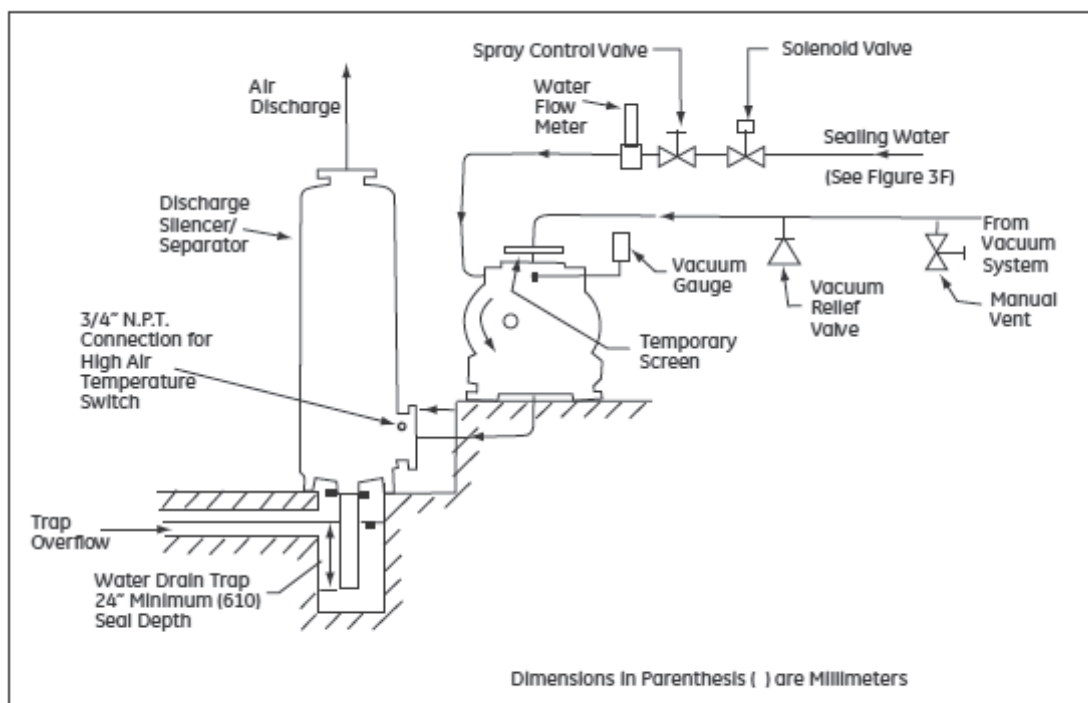
Fifteen pounds of Magnus 61-C dissolved in 40 gallons of water can be fed into the blower before shutdown and allowed to soak as long as possible before flushing. For weekend shut-downs, the start up of the blower after shut-down can be considered as the flush.

The solution may be made up in a 55-gallon steel drum and fed into the blower by attaching a hose from the drum to a threaded connection at the inlet to the blower. A valve should be placed in the line near the blower for shutoff during normal operation. On two-stage blowers, feed the solution into the inlet of the first stage. The sealing water flow should be shut off immediately after starting to feed the Magnus 61-C solution. Shut down the blower as soon as the solution has been fed into the blower.

2. Calgon Micromet® phosphate product – Calgon, Inc. 323 Fourth Ave., Pittsburgh 30, Pennsylvania. A Micromet feeder should be installed in the sealing water line ahead of the blower. The feeder should be sized for an initial charge of 4 to 8 pounds of Micromet per gpm of water flow. The Micromet dissolves at a slow rate, and the feeder should be recharged regularly.

Micromet discourages scale build-up, but is not effective as a de-scaler. The scale should be removed by other methods before the Micromet treatment is used.

The above recommendations apply generally where the scale is primarily organic. Where the scale composition is primarily mineral, or is unknown, samples of the material should be checked and specific recommendations requested from the scale removal suppliers. Strong acid compounds or other corrosion causing materials should be avoided because of the harm which will result to the internal surfaces and clearances of the blowers.



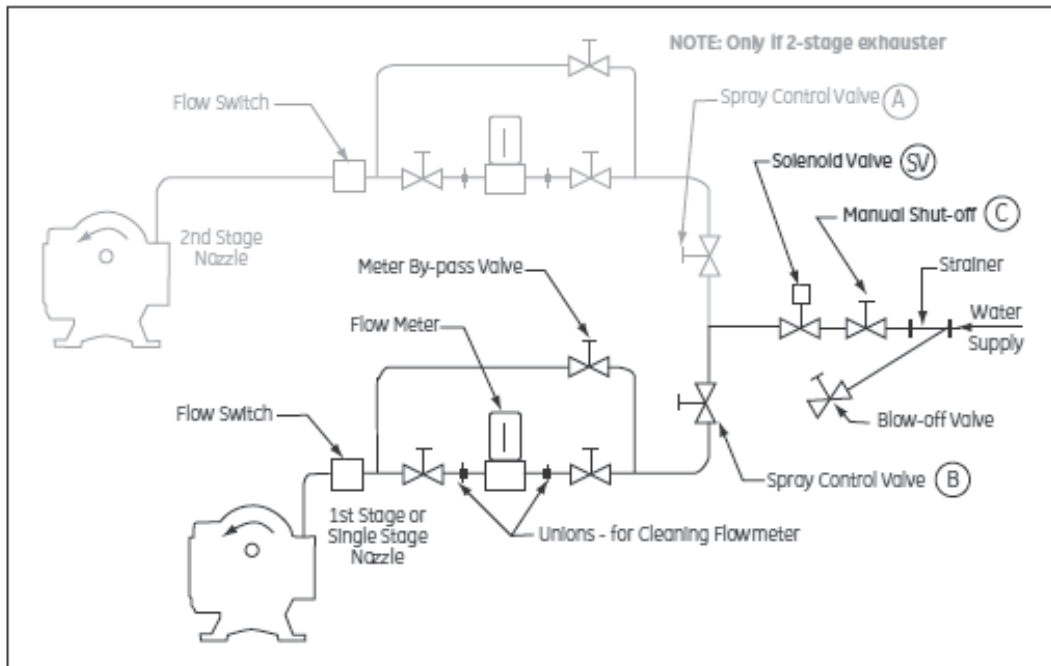


Figure 3f - Seal Water Control Piping Diagram

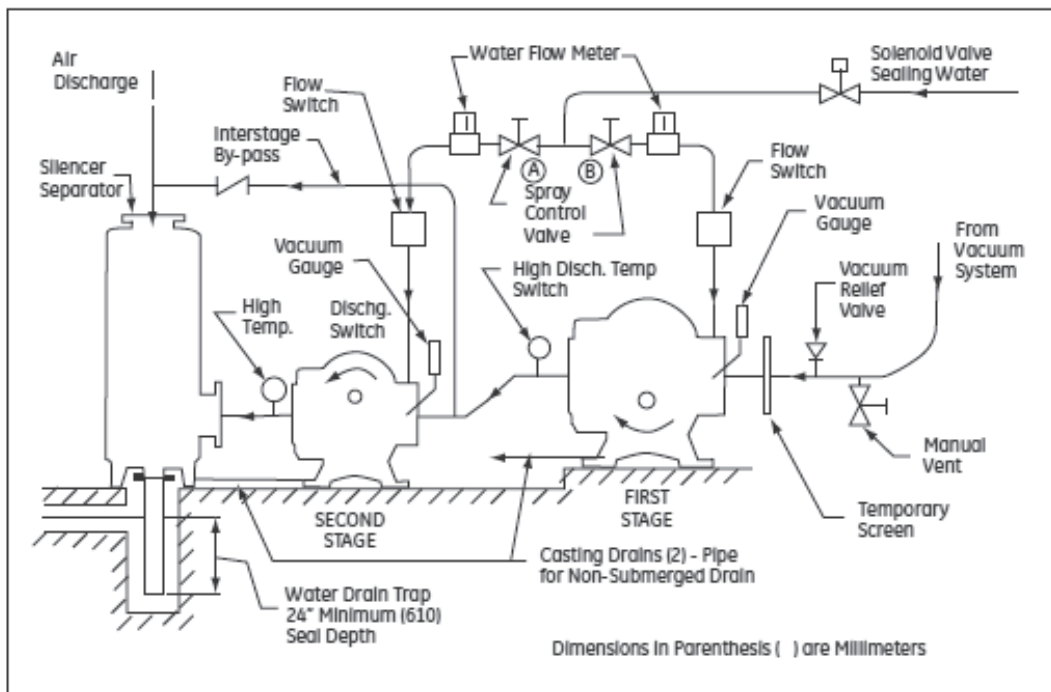


Figure 3g - Installation of Two Stage VJ-2 Vacuum Blower

**RAM series parts list 4" & 6" gear diameter for
Gas, DVJ, DPJ & JV**

(Refer to drawing #81881023)

Item Number	Part Name	Quantity
1	Headplate	2
2	Spray nozzle assembly	1
3	Gearbox	1
4	Timing Gears	2
5	End Cover	1
7	Gasket - Gearbox/Cover	2
10	Shims	Lot
11	Cylinder	1
12	Impeller & Shaft Drive	1
13	Impeller & Shaft Driven	1
14	Bearing Roller	4
16	Pin, Dowel (Pull Out)	4
17	Pin, Dowel	2
19	Key Square	1
21	Plug - Vent	2
22	Plug, Pipe	12
23	Screw, Cap Hex Hd.	**
27	Seal, Lip Headplate DVJ, DPJ, VJ	4
27	Seal-Mech-Viton Gas	4
28	Piston, Ring-Seal	4
29	Washer, Wavy Spring	2
31	Gear Nut	2
32	Scr, Cap Hex Hd.	16
33	Seal, Lip Drive	1
34	Brg. Clamp Plate - D. E.	2
35	Lock Washer - Spring	16
37	Oil Level Gauge	2
38	Sleeve, Shaft DVJ, DPJ, JV	4
38	Sleeve - Gas	4
40	Slinger - D.E. (Top Drive)	1
46	Slinger - G.E.	1
49	Oil Leader L/S	1
50	Oil, Leader-R/S	1
54	Brg Clamp Plate - G. E.	2
60	Screw, Cap Butt. HD.	1
64	Pin, Spring	1
66	Screw, Cap Hex HD.	**
66.1	Whispair, Spring Lock 3/8M	**
70	Shims D.E. Brg.	1
75	Screw, Cap - Hex HD.	**
76	Blower Foot - RH	2
77	Blower Foot - LH	2
85	Elb, Pipe-Block	2
85.1	Plug, Pipe	2
87	Scr, Cap BH	2
88	Anti Rotation Ball	4
90	BSHG-RDCG	2
91	Washer, Plain Flat	2
92	Washer, Plain Flat	2
93	Washer	2
94	Oil Leader	2
95	Cap Screw	4

**Quantities vary by blower.

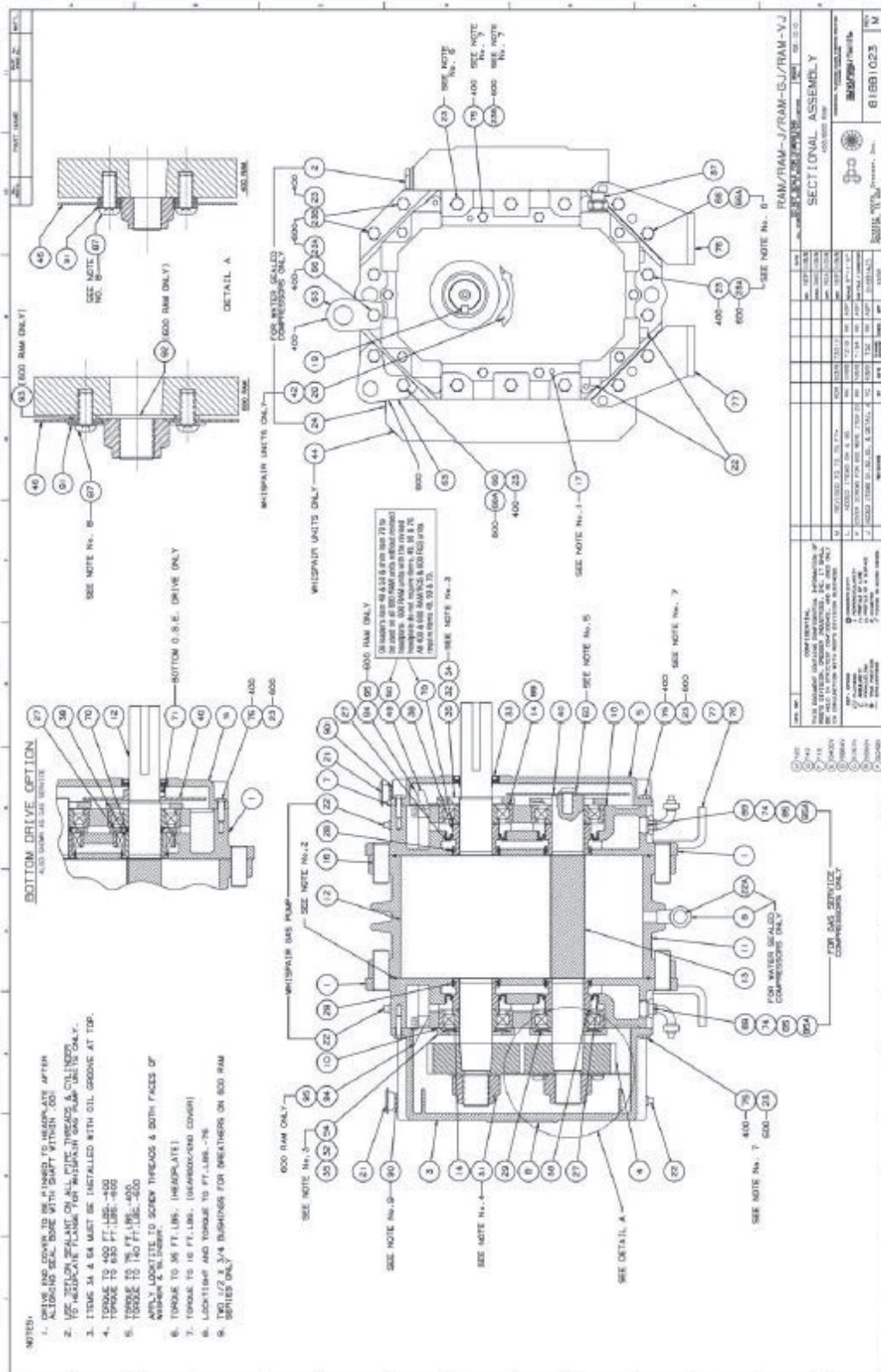
**RCS series parts list 4" & 6" gear diameter for
DVJ, DPJ & JV**

(Refer to drawing #65467023)

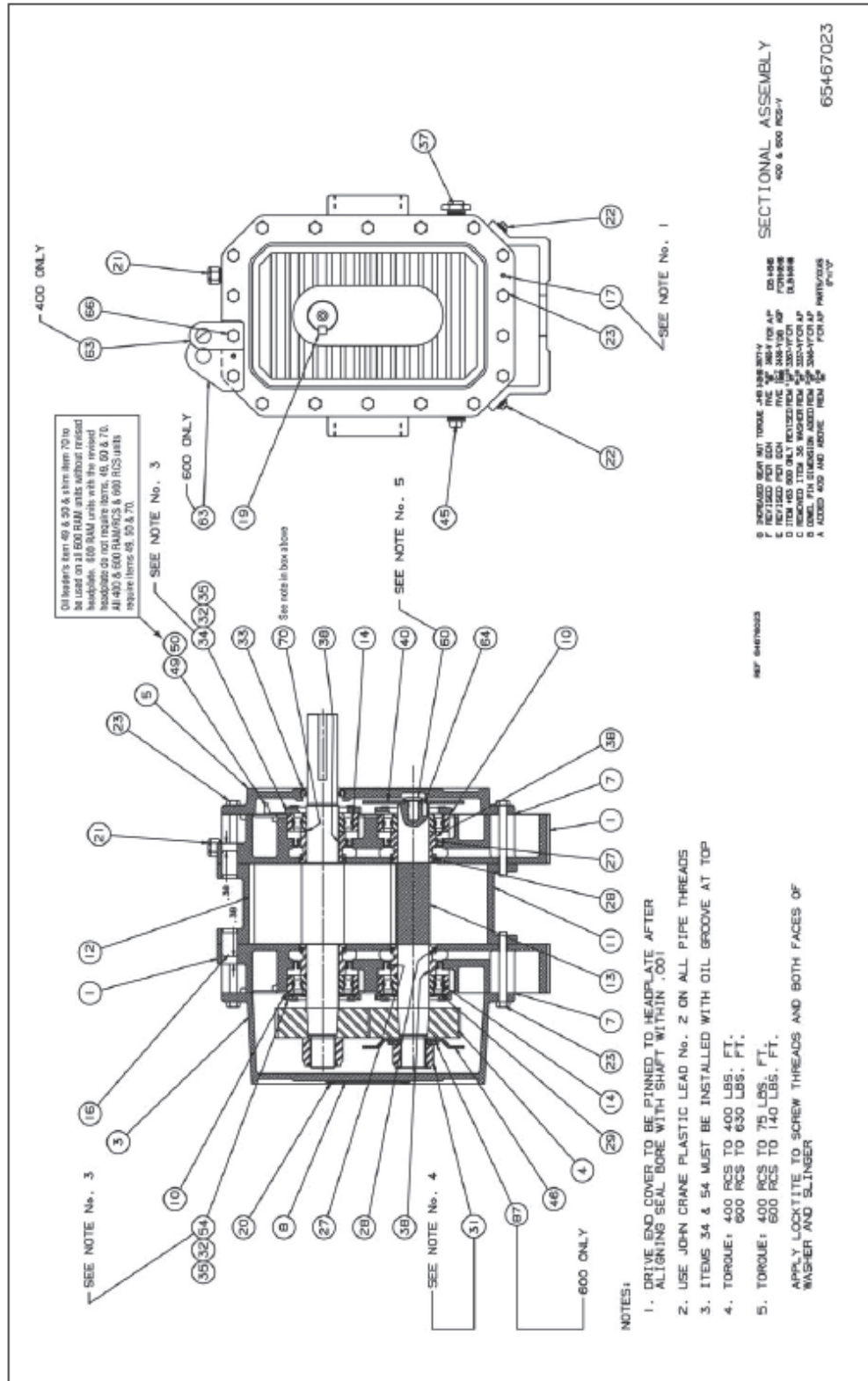
Item Number	Part Name	Quantity
1	Headplate	2
2	Spray nozzle assembly	1
3	Gearbox	1
4	Gear Assembly	1
5	Drive End Cover	1
7	Gasket	2
8	Nameplate	1
9	Lubrication Label	2
10	Shim Set	1
11	Cylinder	1
12	Impeller & Shaft Drive	1
13	Impeller & Shaft Driven	1
14	Bearing Roller	4
16	Pin, Dowel	4
17	Dri-Lok Pin	2
19	Key	1
20	Drive Screw	2
21	Plug - Vent	2
22	Drain - Filler Plug	4
23	Capscrew (400)	34
23	Capscrew (600)	40
27	Seal-Lip, Headplate DVJ, DPJ, VJ	4
27	Seal-Mech-Viton Gas	4
28	Seal Ring	4
29	Washer, Wavy Spring	2
31	Locknuts	2
32	Capscrew	16
33	Seal, Lip D. E. Cover	1
34	Clamp Plate, Drive End	2
35	Lock Washer	16
37	Oil Level Gauge	2
38	Sleeve, DVJ, DPJ, JV	4
38	Sleeve - Gas	4
40	Slinger - D.E.	1
45	Pipe Plug	2
46	Slinger - G.E.	1
49	Oil Leader L/S	1
50	Oil, Leader-R/S	1
54	Clamp Plate, Gear End	2
60	Slinger Capscrew	1
63	Lifting Lug	2
64	Pin, Spring	1
70	Shim	1
87	Washer (600 only)	1

Specified Lubricants

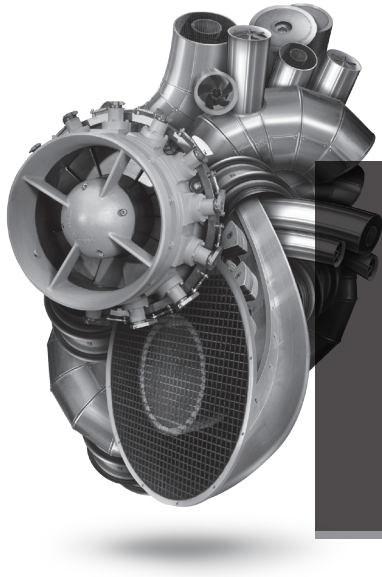
Roots® Synthetic Oil: ISO-VG-220 Grade	
	Part Number
Quart	813-106-001
Gallon	813-106-002
Case (12 qts)	813-106-008
Roots® Synthetic Oil: ISO-VG-320 Grade	
	Part Number
Quart	813-106-004
Gallon	813-106-005
Case (12 qts)	813-106-007



Assembly of RAM Series - Air & Gas Blowers



Assembly of Series - RCS-V



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