

Ing. Dušan Rodák SIGMATECH TRNAVA

Štúrova 6, 917 01 TRNAVA

Prevádzka a fakturačné oddelenie:

Jasná 16, 917 01 TRNAVA

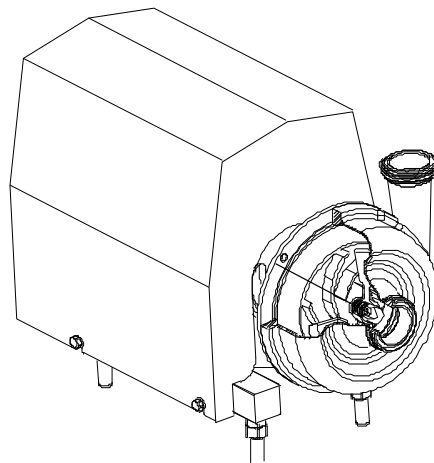
Tel: +421 33 / 55 01 606, **Fax:** +421 33 / 53 51 241

mail: rodak@sigmatechtrnava.sk (objednávky, ponuky)

web: www.sigmatechtrnava.sk (cenníky, katalógy)



sigma**TECH**



Centrifugal pump(BS Impeller)

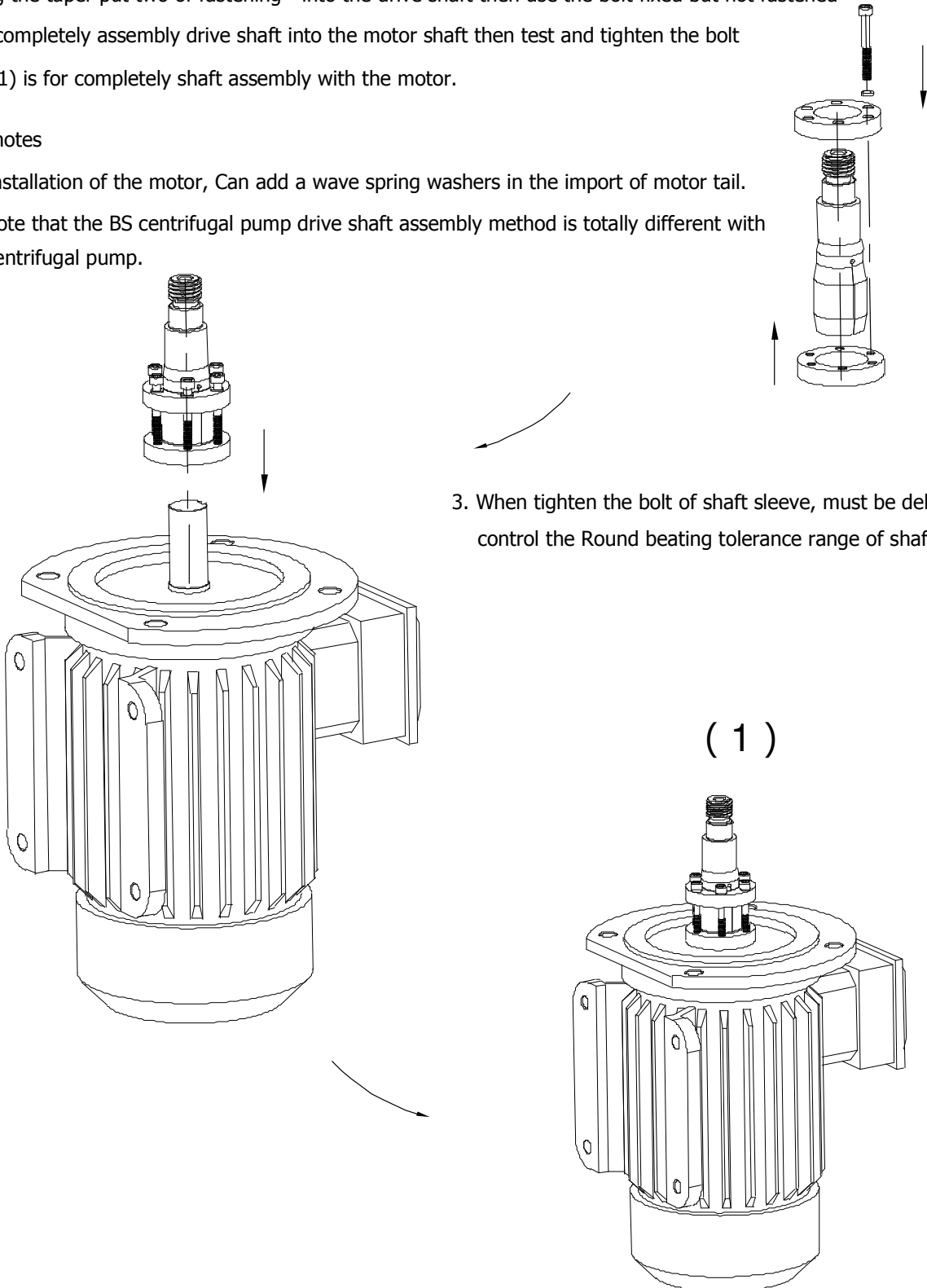
Instructions

Assembly process:

1. According to the taper put two of fastening into the drive shaft then use the bolt fixed but not fastened
2. Put the completely assembly drive shaft into the motor shaft then test and tighten the bolt
3. Picture (1) is for completely shaft assembly with the motor.

Assembly notes

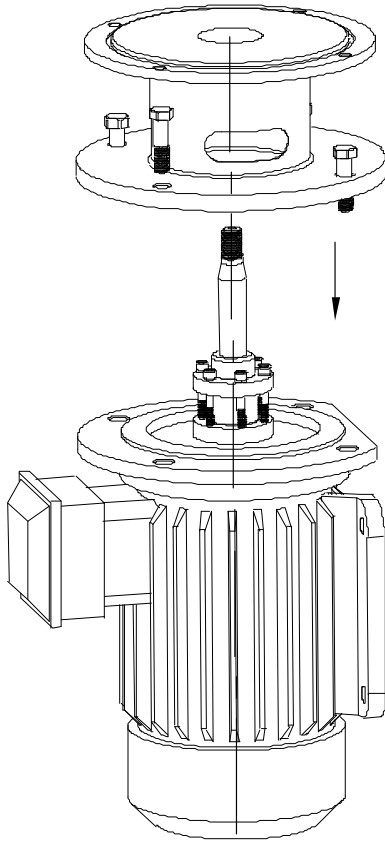
1. Before installation of the motor, Can add a wave spring washers in the import of motor tail.
2. Please note that the BS centrifugal pump drive shaft assembly method is totally different with the KS centrifugal pump.



3. When tighten the bolt of shaft sleeve, must be debugging and control the Round beating tolerance range of shaft assembly

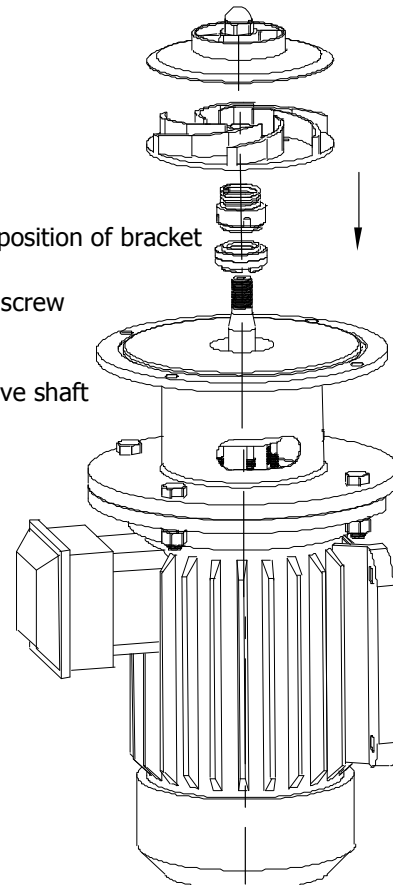
Assembly process:

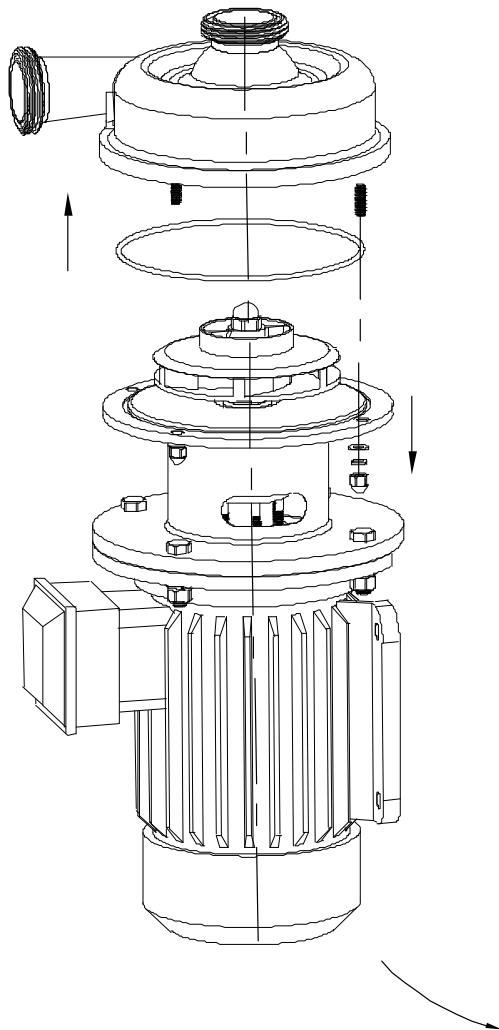
1. Along the direction of the axis link the bracket and motor flange surface then tightened with bolts.
2. Along the direction of the axis put the mechanical seal static ring into the bracket, then put int screwed ring then tighten impeller and impeller cover.
3. Put the O-ring and pump head then tighten the pump head with the bolt
4. Picture (2) is for the completely assembly type



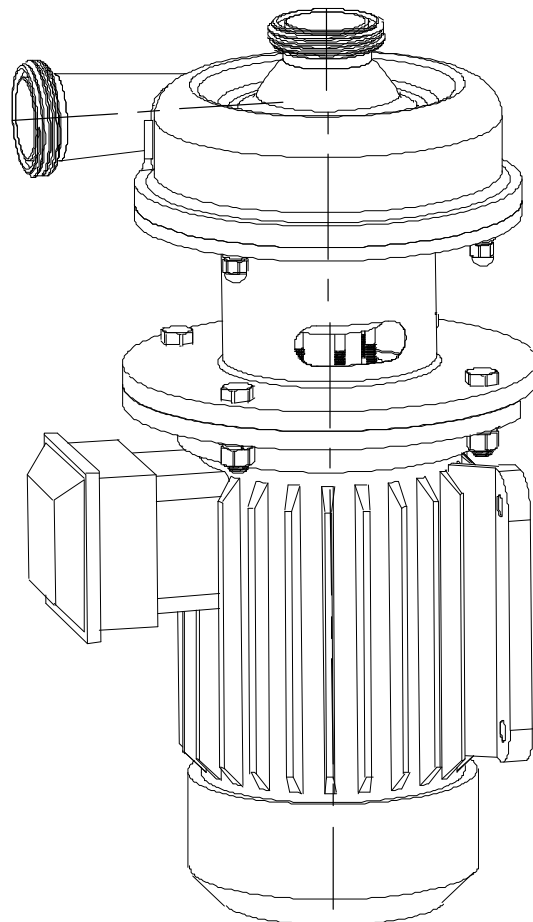
Assembly note:

1. When install the static ring, Please note put the incision of static ring into the position of bracket
2. When install the impeller, please note put the incision of impeller push on the screw spring position
3. When install the impeller cover should use the crescent wrench to fixed the drive shaft
4. Must be smear the silicon oil on the o-ring and sufficient lubrication





(2)

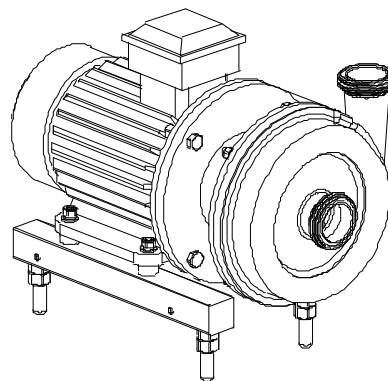
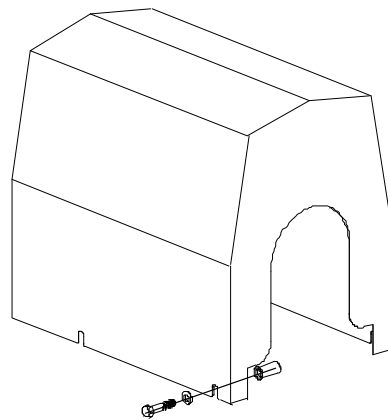
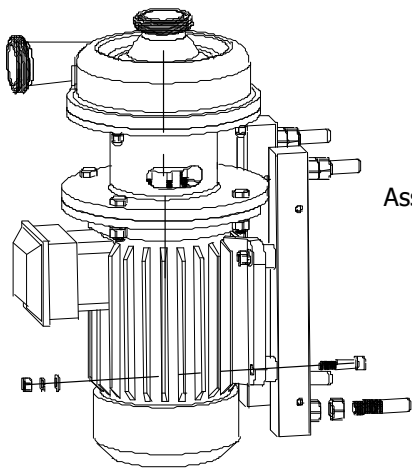


Assembly process:

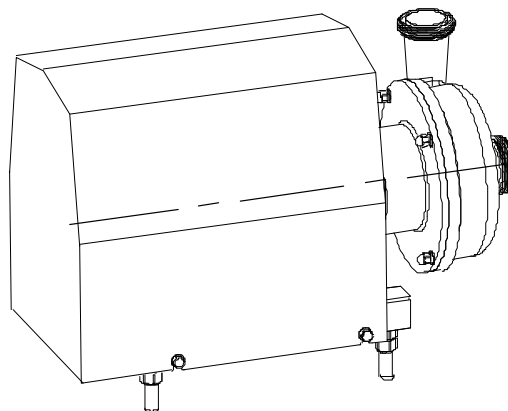
1. As required assembly machine feet.
2. As required assembly and fixed the motor cover
3. Picture (3) is for the completely finished of pump

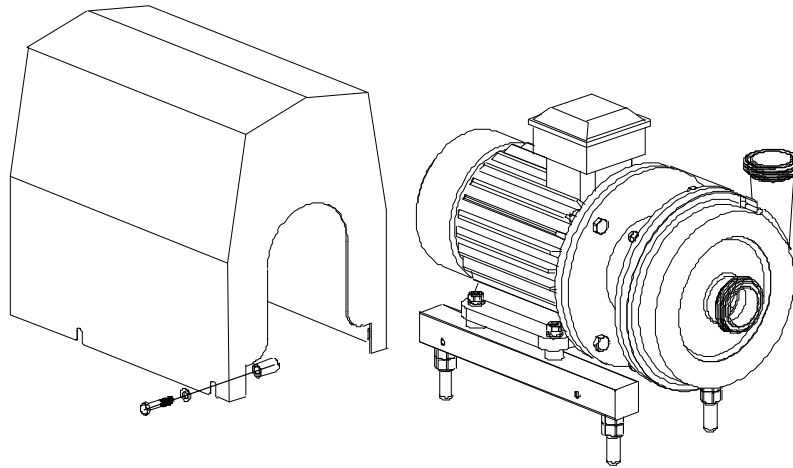
Assembly note:

1. If the flange faces of motor conflict with the machine feet,
Can adding higher gaskets to heightening the machines foot
center height of the motor
2. Adjust machines feet bolt to horizontal position of 4 machines feet
3. Fully assembled, must be tested and meet the relevant technical
requirements.



(3)





Assembly process:

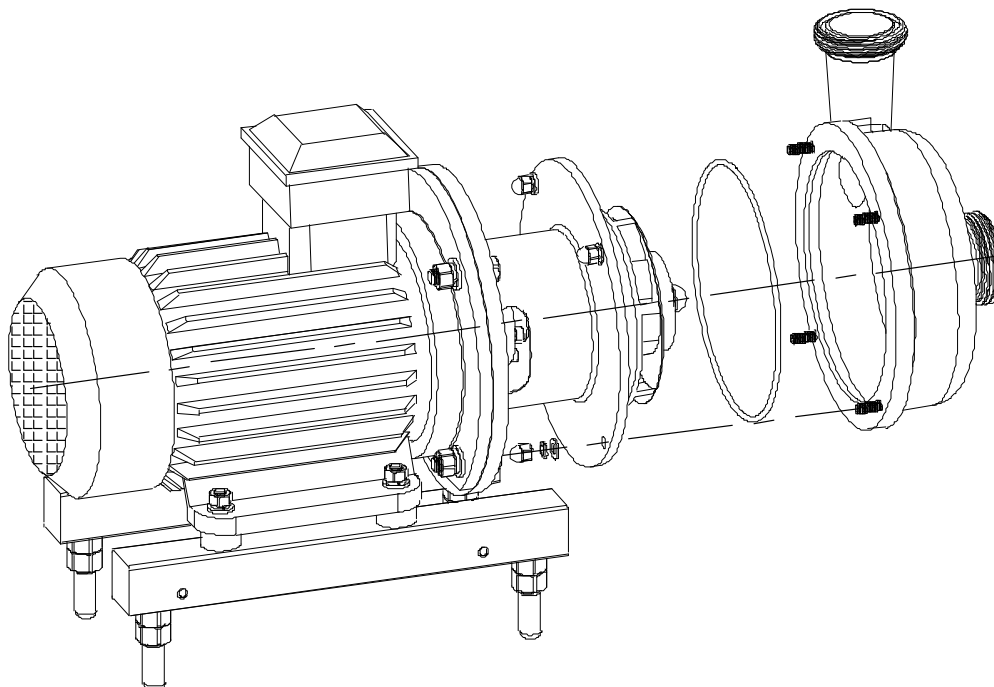
(1)

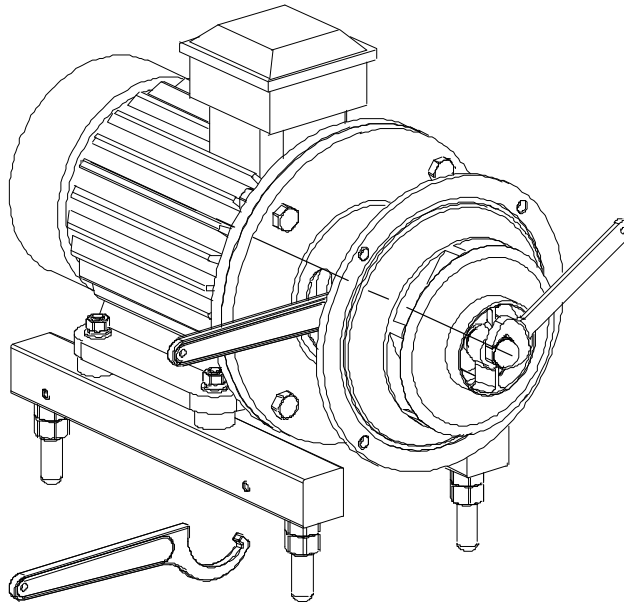
1. Picture (1) is for the disassembly the motor cover. Loosen the cover screws and remove the motor cover and washer
2. picture (2) is for the disassembly the pump head. Loosen the screw cap between pump head and back cover then remove the pump head and washer.

Assembly note:

1. When replace the O-rings need to smear the silicone oil on it.

(2)





Assembly process:

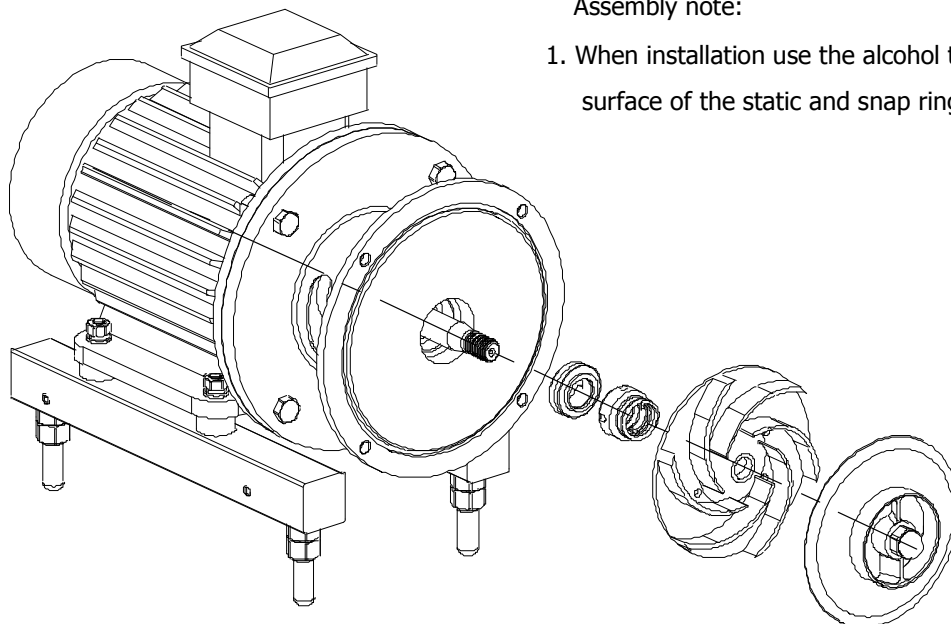
(3)

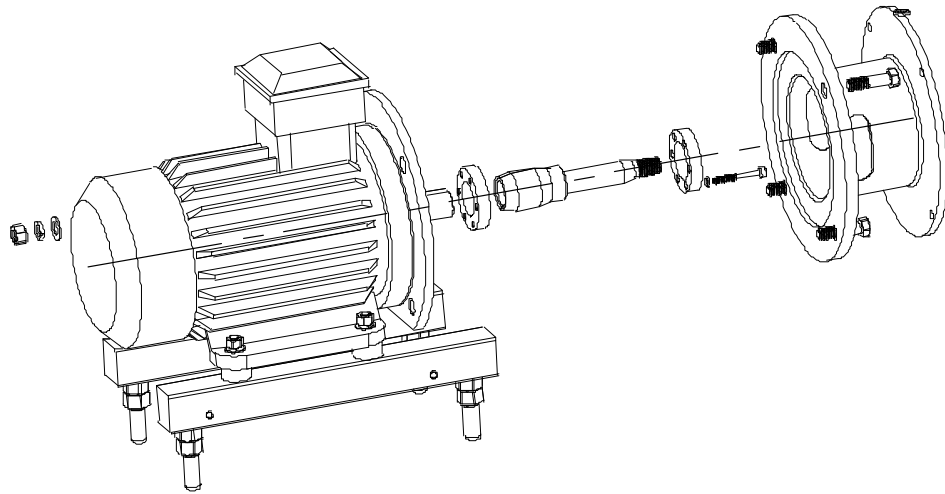
1. Picture(3)(4)is for the disassembly the impeller cover, impeller and mechanical seal: Put Crescent wrench into the inside of bracket and withstood the bolt of locking fastening ring to control the rotation of the motor shaft and other activities wrench to loosen the impeller cap nut. Then turn to remove the impeller and the static and snap ring of mechanical seal.
2. Picture (3) is for the type of Crescent wrench on the lower left corner.
3. Picture (4) is for the remove parts

(4)

Assembly note:

1. When installation use the alcohol to clean the contact surface of the static and snap ring.



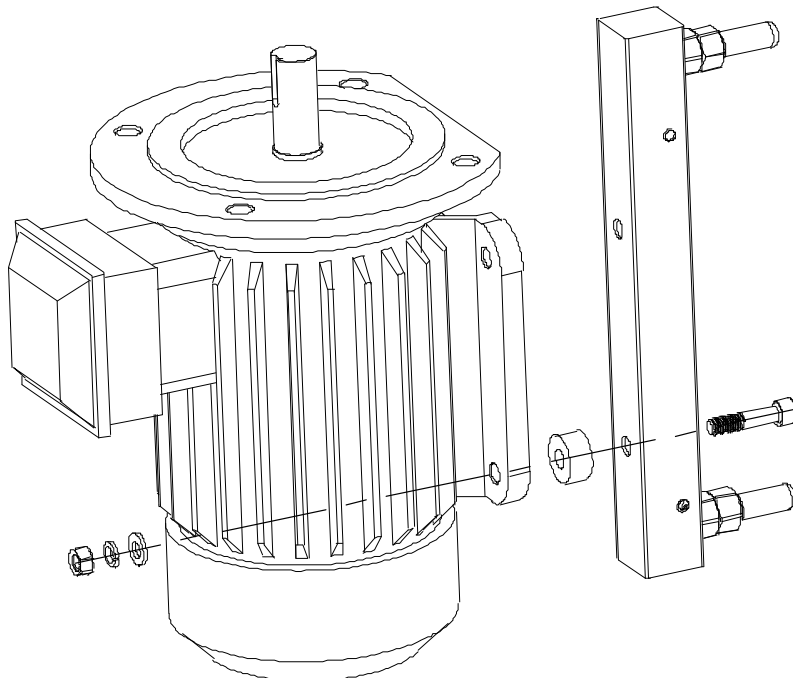


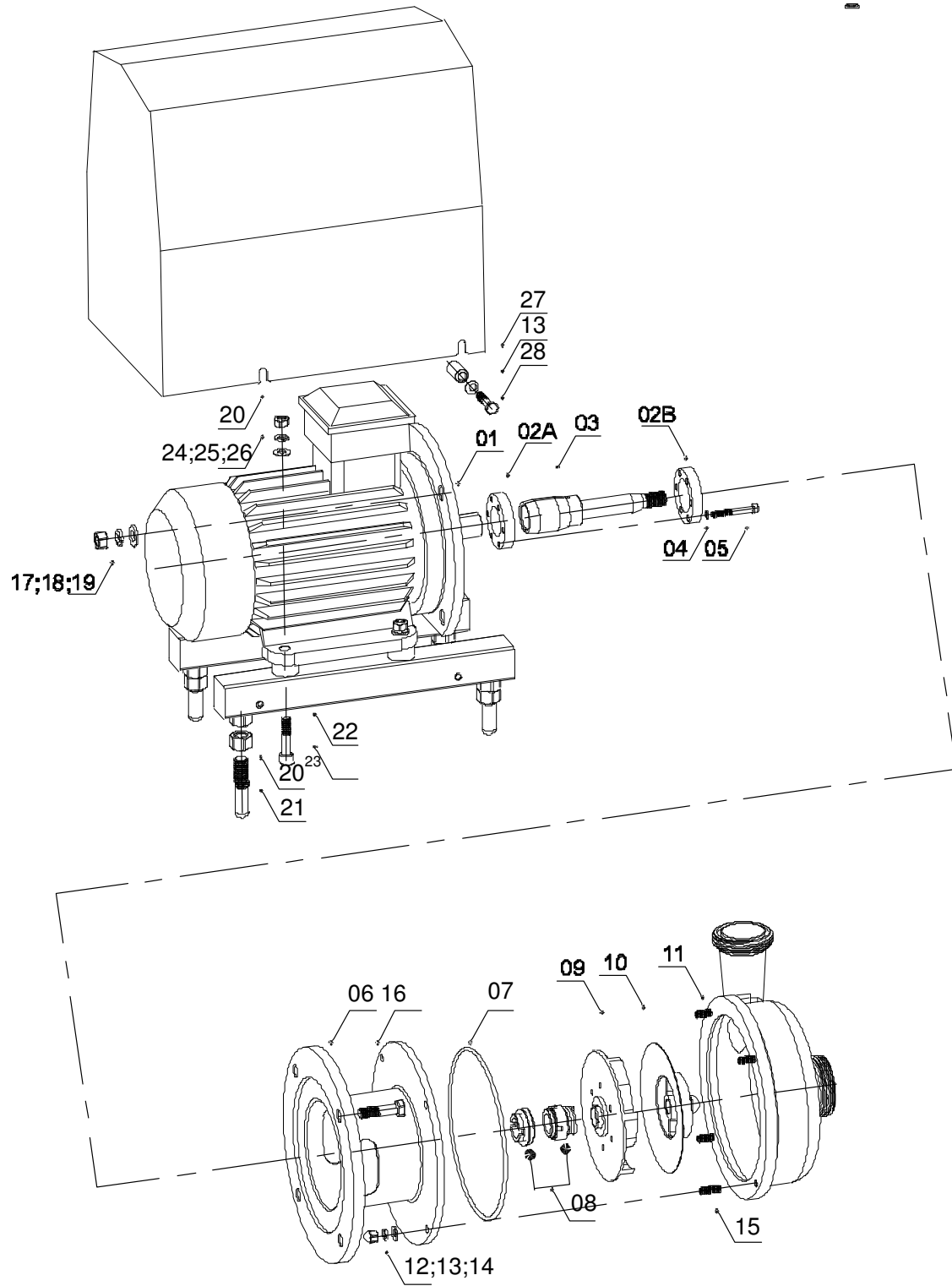
Assembly process:

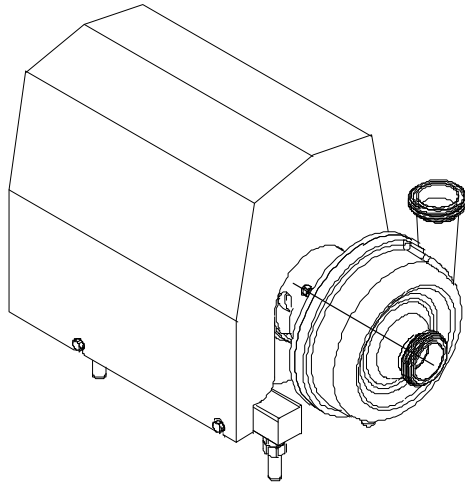
(5)

2. Picture (5) is for disassembly of bracket and shaft component:twist off the lock nut of between bracket and motor, remove the bracket and loosen the nut of shaft component and take it out.
3. Picture (6) is for the disassembly the pump feet. Twist off the looking nut of pump feet and remove the washer and pump feet component.

(6)







Technical requirements:

1. Single seal BS centrifugal pump selection table right schedule
2. The spring pins which is used to orientation in the snap ring of double mechanical seal should be proportionally bobbed processing before installation.

30			
29			
28	Coarse hexagon head screws	4	304
27	Gasket	4	P TFE/POM
26	Flat washer A level	4	304
25	Spring washer (Standard)	4	65Mn
24	Coarse hexagon nut	4	304
23	Bracket of Pump feet	2	304
22	Pump feet	4	304
21	Coarse hexagon nut	4	304
20	Motor cover	1	304
19	Coarse hexagon nut	4	304
18	Spring washer (Standard)	4	65Mn
17	Flat washer A level	4	304
16	Coarse hexagon head screws	2	304
15	Hexagon socket set screws	4	304
14	Flat washer A level	8	304
13	Spring washer (Standard)	4	65Mn
12	Combined cap nuts	4	304
11	Pump Head	1	316L
10	Impeller cover	1	316L
09	Impeller	1	316L
08	Single seal component	1	SS C/S iC/EP DM
07	O-ring	1	NBR
06	Connection bracket	1	304
05	Hexagon socket head screws	6	304
04	Spring washer	6	65Mn
03	Shaft	1	304
02	hole of the fastening ring	1	45 5
01	Motor	1	
	Name		Materials
	Number		Quantity