AIRTECH® VACUUM



# PCX60/105/155

## DRY ROTARY CLAW COMPRESSORS

## INSTALLATION AND OPERATING MANUAL

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# Version History

| Version | Revised On | Author(s) | Description |
|---|---|---|---|
| 1.0 | | Airtech PDM | PCX60/105/155 Draft |
| | | | |
| | | | |

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# 1 GENERAL INFORMATION



Important safety information regarding installation, operation, and maintenance is included in the manual. Read and follow all instructions before use and keep manual for future reference. Failure to comply with all AIRTECH's instructions, including improper installation or use of the product, alterations to the product, and/or failure to use the product in accordance with this manual can result in serious bodily injuries, property damage and/or damage to the compressor. Please read carefully before proceeding.

## 1.1 PREFACE

This manual serves as a comprehensive guide to the operation and maintenance of PCX60/105/155 Dry Rotary Claw Compressors. It provides detailed instructions and information for all stages of the products' lifecycle, from initial delivery to safe dismantling and disposal. The manual covers the following key areas:

- Safety
- Product Description
- Transport & Storage
- Installation
- Commissioning
- Overhaul
- Maintenance
- Spare Parts
- Decommissioning
- Troubleshooting
- Dismantling and Disposal

By following the instructions and guidelines provided in this manual, you can ensure the safe and efficient operation of PCX60/105/155 Dry Rotary Claw Compressors throughout its lifetime. We recommend keeping this manual readily available for future reference and consulting it regularly for optimal performance and longevity. Throughout this manual, the term "compressor" will be used to refer to the PCX60/105/155 Dry Rotary Claw Compressors.

The images shown throughout this manual are intended for illustrative purposes only and may not accurately reflect the final appearance of the actual product. The information contained within this manual supersedes any information conveyed by the images.

If anything remains to be clarified, please contact the manufacturer.

**AIRTECH TIP**

Depending on the design of the compressor, other supplied documents must be observed in addition to this manual, e.g. the operating manuals and datasheets of the motor.

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## 1.2 GENERAL TERMS OF BUSSINESS AND DISCLAIMERS

Manufacturer makes no warranties with respect to the product [other than those expressly set forth in the General Terms of Business and/or any applicable delivery contract]. Manufacturer disclaims any and all [other] express and implied warranties and representations of any kind, including but not limited to the implied warranties of merchantability or fitness for a particular purpose. To the maximum extent permitted by law, Manufacturer is not responsible for and will not be liable for any direct, indirect, special, incidental or consequential damages resulting from the use of this product, including but not limited to loss of use, loss of revenue, loss of actual or anticipated product, loss of business, loss of opportunity, loss of goodwill, loss of reputation or any other indirect or consequential loss or damages howsoever caused, whether asserted in tort, contract, warranty or under any other legal theory.

The product should only be used for the purposes and in the manner specified in the manual and that failure to follow all instructions for use and heed all safety warnings could result in improper product performance, potential personal injury or safety hazard or property damage.

The manufacturer expressly disclaims and will not be liable for any injury or damages resulting from:

- Failure to read and follow all instructions for use and safety warnings contained in this manual,
- Use of the product for any purpose other than its intended use, or in any manner inconsistent with the instructions for use, as set forth in this manual,
- Installation, maintenance of use of the product by untrained or unqualified persons or persons who have not read and fully understood the instructions for use and safety warnings in this manual
- Technical modifications, conversions, repair, disassembly, or other alteration of the product, unless performed by the manufacturer or its authorized service personnel,
- Use or installation of parts or materials other than those [recommended in this manual or elsewhere] that were supplied with the product by the manufacturer.


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# 2 SAFETY

The safety warnings, notes and symbols described in this manual are valid only for the original product as delivered by the manufacturer. Any modifications or alterations to the product by the customer may void the safety guidelines and render them inaccurate and may also create new or different safety risks not addressed in this manual.

Before handling the product:

- Thoroughly review and understand all safety information provided in this manual before use.
- Familiarize yourself with the meaning and significance of all safety symbols.
- Never attempt to operate the product without proper training and authorization.

## 2.1 SAFETY NOTES

There are potential safety risks inherent in the use of the compressor. These operating instructions warn about potential hazards to inform the user of the need strategies to minimize the risk of bodily harm or property damage. Safety notes are tagged with one of the keywords DANGER, WARNING, CAUTION, AIRTECH TIP, and ATTENTION as follows:

**DANGER!**

This indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

**WARNING!**

This indicates potentially hazardous situation which, if not avoided, could result in death or serious injury.

**CAUTION!**

This indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

**AIRTECH TIP**

This provides valuable information for maximizing performance and minimizing potential problems.

**NOTICE!**

This highlights important information and best practices to help avoid potential problems or damage to property.

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In addition to the safety notes described above, you may encounter the following symbols within this manual depending on the specific situations described:

| | | | |
|---|---|---|---|
|  | Wear safety gloves |  | Warning of suspended load |
|  | Wear safety shoes |  | Electrical voltage warning |
|  | Wear ear protection |  | Warning of hot surface |
|  | Wear respiratory protection |  | Warning of dangerous explosive material |
|  | Disconnect before maintenance |  | Warning of toxic substances |
|  | Read and understand operator's manual before using the product |  | Warning of biological hazard |
|  | Connect an earth terminal to the ground |  | Watch out crushing hand |
|  | Wear protective clothing |  | Crush and entanglement hazard |



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# 3 PRINCIPLE OF OPERATION

The PCX compressor is a dry, contactless machine, enclosed in an acoustic sound shield. It is designed to have cooling air passed through the sound shield by a fan, with warm air being exhausted through a vent. The PCX features a modular construction, consisting of two compartments: the pumping chamber and the gear chamber, separated by labyrinth seals.

In the pumping chamber, two rotary claws rotate in opposite directions, drawing in air to compress and discharge it under pressure. In the gear chamber, two gears synchronize the rotation of the claws and are lubricated with oil. To reduce noise, an inlet silencer is installed on the compressor's intake side. For overload protection, a pressure safety valve or regulating valve is installed on the exhaust.

The compressors are directly driven by a flanged motor via a coupling. The PCX series compressors have an identical internal construction to the VCX vacuum pumps but are equipped with different inlet and outlet accessories to function as a compressor.

**NOTICE!**

Ensure that the compressor always has an appropriate amount of gear oil and that the oil is changed according to the AIRTECH's recommendations or based on usage and environmental factors. See section *7.1 GEAR BOX OIL* for details on oil changing.

**Risk of premature failure!**

Do not overfill the gear box of the compressor with oil!

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## 3.1 COMPRESSOR LABEL

Airflow volume, oil capacity, and pressure level are given on the compressor label or on a separate datasheet. *Figure 3-2* is an example PCX compressor label that can be found on the side of the compressor. If you require more technical data, other available sizes or versions of the compressor, additional accessories, and spare parts, please contact AIRTECH.

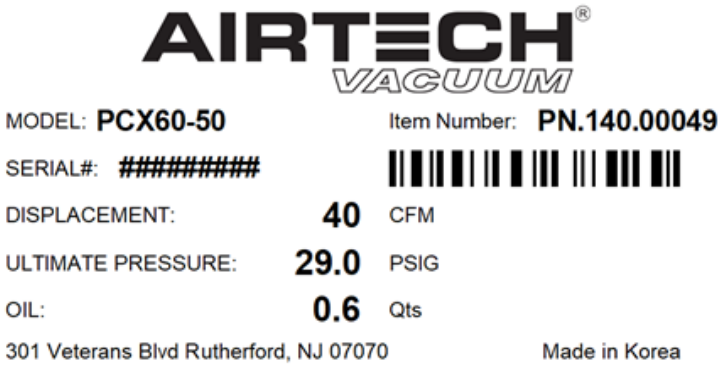



*Figure 3-1 Compressor Label*

On the compressor label are stated:

- Compressor Model Name
- Serial Number
- Item Number
- Displacement Volume (CFM)
- Ultimate Pressure (PSIG)
- Gear Box Oil Capacity

**DO NOT** remove or tamper with the compressor label. Please contact AIRTECH if you have any further questions about the compressor label or any other technical data.


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## 3.2 MOTOR NAMEPLATE

Nominal efficiency, rated horsepower and motor speed are given on the motor nameplate or on a separate motor datasheet. *Figure 3-3* is an example motor nameplate located on the motor.

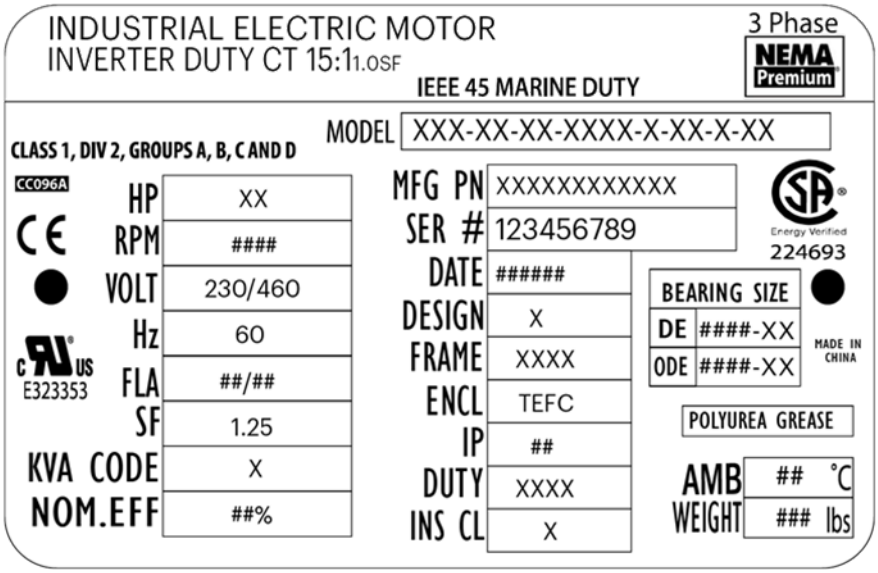



*Figure 3-2 Motor Nameplate*

On the motor nameplate are stated: Motor model number

- Phase
- Rated horse power (HP)
- Full load speed (RPM)
- Rated volts (VOLT)
- Rated frequency (Hz)
- Full load amps (FLA)
- Service Factor (SF)
- Locked rotor KVA code (KVA CODE)
- Nominal Efficiency (NOM.EFF)
- Manufacturer's part number (MFG PN)
- Serial number (SER #)
- Date
- Design
- Frame size
- Enclosure (ENCL)
- Index of protection (IP)
- Time rating (DUTY)
- Insulation class (INS CL)
- Drive end bearing size (DE)
- Opposite drive end bearing size (ODE)
- Maximum ambient temperature (AMB)
- Weight

Motors with a rating under 15 HP do not have the IEEE 45 Marine Duty standard indicated on their labels.

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## 3.3 COOLING

The compressor is cooled off by free convection of the components, airflow from the cooling fan of the compressor, and fan wheel of the drive motor.



**WARNING!**

During operation, the surface of the compressor can become hot, reaching temperatures exceeding 350 °F (177 °C).

**Risk of burns!**

Do not touch the surface of the compressor during and directly after operation. Wait until cool down (approx. room temperature), or wear heat protection gloves prior to handling the compressor. Touching the surface of the compressor before it has cooled down can lead to serious bodily injuries including death and/or damage to the compressor.



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# 4 TRANSPORT AND STORAGE

## 4.1 UPON RECEIPT

When the compressor is first received, check the packaging to confirm it is intact and free from any signs of damage due to transport or storage conditions.

If damage to the packaging is observed, immediately inform the shipping agent and the manufacturer. Do not use the compressor if the packaging is damaged.

## 4.2 TRANSPORT AND HANDLING



**WARNING!**

Crush injuries and cutting of body parts caused by tipping or falling loads.

**Risk of severe injury!**

Do not walk, stand, or work under suspended loads.

The compressor should be securely fastened to a pallet or base plate for transportation. It can be moved using a suitable lifting equipment. Before installation and start-up, remove the bolts that secure the compressor to the base or pallet.

**DO NOT** attempt to lift the compressor alone or without following guidelines when a crane is not available. Lifting it must be a team effort. Trained individuals must lift the compressor and proper lifting equipment and techniques must be utilized.



**NOTICE!**

The compressor's gear box is prefilled with oil by AIRTECH. Do not tip the compressor over while filled with oil during transport.

**Compressor oil leakage and spill!**



**WARNING!**

Failure to follow these instructions may result in serious injuries including death, property damaged and/or damage to the equipment.

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## 4.3 STORAGE

When the compressor is not being used and powered off, close off gas suction connection and the gas discharge connections.

If the compressor will not be used upon receipt, make sure that:

- The compressor is stored in its original packaging, if possible,
- The compressor is stored indoors where the ambient temperature is between 32°F and 104°F (0°C and 40°C),
- The compressor is stored in a dry (<60% humidity), well ventilated, non-hazardous, dust and vibration free environment.

If the appropriate storage conditions cannot be maintained or adverse ambient conditions occur (e.g. aggressive atmospheric changes, frequent peaks in temperature) conserve the compressor by:

1. Firmly closing off all ports,
2. Sealing any ports that are not closed off with PTFE tape,
3. Sealing any gaskets and O-rings with adhesive tape,
4. Airtight packing the whole compressor with plastic foil,
5. Adding dehumidifying agent (e.g. granules) into packaging, if necessary.

**AIRTECH TIP**

If the compressor was commissioned prior to being stored, it is recommended to replace the gear box oil before recommissioning due to potential oil contamination.


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# 5 INSTALLATION

**WARNING!**

Installation must only take place under the following conditions:

- The compressor is completely assembled and intact (not damaged or tampered).
- The storage conditions are met.

Failure to follow these instructions may result in serious personal injuries, including death and/or damage to the equipment.

## 5.1 INSTALLATION CONDITIONS

Before installing the compressor, make sure the that the operation environment is not hazardous and the ambient conditions are met as outlined on the motor nameplate and in this manual.

**NOTICE!**

If your application is in hazardous environments where flammable gases, dust or fibers present, AIRTECH may offer Division 1 Class 1 explosion proof motors with PCX Dry Rotary Claw Compressor series. Contact AIRTECH for explosion proof motor selection for your application.

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## 5.2 MOUNTING POSITION AND SPACE



**WARNING!**

Crush injuries and cutting of body parts caused by tipping or falling loads.

**Risk of severe injury!**

Do not walk, stand, or work under suspended loads. Designate a location or a place for the compressor prior to the receipt. Failure to follow these instructions may result in serious personal injuries, including death and/or damage to the equipment.

Mount the compressor on an even and level surface away from any strong vibrations, supported by its rubber feet. To ensure proper ventilation and clear visibility of the oil sight glass, leave at least 1 foot of open space around the compressor. The location must also allow the operator to easily change the oil and inlet filter when necessary.

Place the compressor in a dry (<60% relative humidity), well-ventilated, non-hazardous, and dust-free environment. Ensure that no heat-sensitive materials, items, or parts (e.g., plastics, wood, cardboard, paper, electronics) touch the surface of the compressor.

When placing the compressor, ensure the following:

- The ambient temperature is between 32°F and 104°F (0°C and 40°C).
- The gearbox oil used is the specific type recommended in this manual, suitable for the ambient and operating temperatures.
- The compressor is regularly cleaned of any dust or dirt.
- There is no direct sun exposure.
- The terminal box cover and cable entries are tightly sealed to remain dustproof and waterproof.



**NOTICE!**

Do not tip the compressor over if filled with oil.



**WARNING!**

Failure to follow these instructions may result in serious personal injuries, including death and/or damage to the equipment.



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## 5.3 ELECTRICAL CONNECTIONS



**DANGER!**

Lethal electric shock due to contact with live wires!

**Risk of electric shock!**

Electrical components must be executed only by a qualified and authorized personnel.

To prevent electrical shock and potential serious bodily injuries including death and/or damage to the compressor:

- Maintain a minimum clearance of 0.217 inches (5.5 mm) between bare and live parts, as well as between these parts and earth. This applies to rated voltages of UN ≤690 V.
- Ensure no wires stick out when connecting cables to the compressor.
- Seal both the terminal box lid, and cable duct openings to be dust-tight and watertight.
- Make sure that electrical and occupational safety directives, local or national regulations are complied with.
- Make sure that the power supply is compatible with the data on the motor nameplate.
- If a motor starter is being used, make sure that the amperage is compatible with the data on the motor starter datasheet.



**WARNING!**

Only a qualified and authorized personnel should carry out work and the unit should be stationary.

**Risk of electric shock!**

- Make sure the compressor is powered off and cannot initiate a sudden start-up (this also applies to auxiliary circuits).
- Confirm there is no voltage!
- Establish a safe protective earth connection before starting work.

Failure to follow these instructions may result in serious bodily injury death and/or damage to the unit.

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Carefully follow these instructions to ensure safe operation of the unit:

1- Confirm motor of the compressor will not be affected by electric or electromagnetic disturbance from the mains; if you have any questions, please contact the manufacturer.
2- Confirm there is a safe protective earth connection.
3- Confirm the power supply is capable of providing the motor with enough power as per the nameplate.
4- Confirm the wire size selected is rated to carry the full load amperage stated on the nameplate.

The schematic diagram for the electrical motor terminal connections is shown in the junction box of the motor or on the motor nameplate. *Figure 5-1* is an example of typical Three Phase Motor wiring diagram.

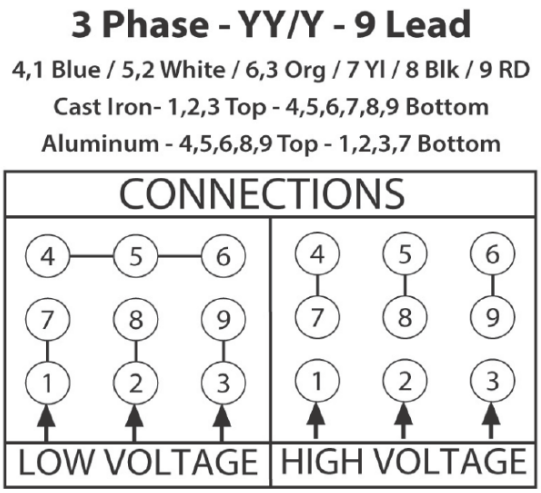



*Figure 5-1 Wiring Diagram*

The wiring, fusing , and grounding must comply with the National Electric Code (NEC) or IEC standards, as well as local regulations.

**NOTICE!**

After making the electrical connections and after filling the compressor gear box with oil, verify the motor's rotation direction. If the rotation is incorrect, reverse any two of the three power leads at the power connection. Correct direction of rotation is marked by an arrow on the motor fan housing as shown below.



**Do not check the rotation of the motor without gear box oil present in the compressor!**


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## 5.4 PIPE CONNECTIONS

Use a pipe size that is at least the size of the compressor outlet connection. Smaller lines result in reduced compressor capacity.



**WARNING!**

Operating the compressor with exposed parts may result body parts, hair, jewelry, loose clothing or other worn accessories being sucked in (at the gas inlet) and particles being hurled out (at the gas outlet/discharge). This may result in serious bodily injuries, including death.

**Risk of severe injury!**

Do not power on the compressor prior to finalizing pipe connections.



**AIRTECH TIP**

Even if the process gas is expected to be clean, a suitable inline (inlet) filter should be connected to the inlet port to protect against dust or other foreign particles. Please reach out to AIRTECH for filter recommendations for your application.

Refer to the table below for the thread sizes of the AIRTECH PCX60/105/155 Dry Rotary Claw Compressors.

| Compressor Model | Inlet Size | Exhaust/Outlet Size |
|---|---|---|
| PCX60 | NPT 1” | NPT 1” |
| PCX105/155 | NPT 1-1/2" | NPT 1-1/2" |

Ensure that the discharge is free from obstructions, as restrictions can cause back pressure in the compressor, potentially leading to compressor failure.

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## 5.5 OIL FILLING ON GEAR BOX

The compressor is pre-filled with AIRTECH ATO-3000 Semi-Synthetic Gear Oil prior to shipping. Upon installation, verify that the oil level reaches over ¾ mark on the oil sight glass as shown below.




If additional oil is required, fill the compressor with the recommended oil type through the oil fill port after ensuring that the installation is level and the rotation is correctly set.

| Compressor Model | Oil Capacity |
|---|---|
| PCX60 | 0.6 Qts |
| PCX105/155 | 0.5 Qts |

**NOTICE!**

Using inappropriate oil type will cause damage, and may invalidate your warranty.

**Risk of premature failure!**

We recommend using genuine AIRTECH oil, high-quality ATO-3000 Semi-Synthetic gear oil to extend the duration between oil changes, enhance lubrication at elevated operating temperatures, and prolong the life of the compressor.

**WARNING!**

Do not add oil through the oil fill, inlet or exhaust ports while the compressor is running and do not overfill the compressor's oil reservoir.

Please refer to the table below for a list of oils offered by AIRTECH for the compressor. Contact AIRTECH for further information on oil selection.

| Product Name | Oil Type | Qty | Viscosity |
|---|---|---|---|
| ATO-3000-01 | Gear Lube | 1Quart | 150 cSt @104°F (40°C)<br>19.4 cSt @212°F (100°C) |
| ATO-3000-02 | | 1 Gallon | |



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# 6 COMMISSIONING

## 6.1 PRESTART-UP CHECKS

**NOTICE!**

Ensure that the compressor always has an appropriate amount of gear oil and that the oil is changed according to the AIRTECH's recommendations or based on usage and environmental factors. See section *7.1 GEAR BOX OIL* for details on oil changing.

**Risk of premature failure!**

Do not overfill the compressor with oil!

Do not add oil while the compressor is running!

- Check rotation of the motor as described in section *5.3 ELECTRICAL CONNECTIONS*.
- Fill the compressor gearbox with oil as described in section *5.5 OIL FILLING ON GEAR BOX*.
- Confirm all the installation conditions are met.
- Confirm the pipes, hoses and electrical connections are correctly established according to the manual.
- Confirm all the provided covers, guards, hoods etc. are mounted securely.
- Confirm cooling air inlets and outlets are clear of any covers or obstructions.
- Confirm the direction of rotation matches the indicated direction on the compressor.

**CAUTION**

Only trained and/or qualified personnel should operate the compressor. Do not allow any untrained and/or unqualified personnel to store, install, start-up, operate and/or dismantle the compressor.

**CAUTION**

Noise from running compressor can damage your hearing.

**Risk of damage to hearing!**

All persons in the vicinity of the compressor for extended periods of time must always wear ear protection.

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## 6.2 START-UP

Run the compressor for a few minutes and then shut down. Check the oil level again and make sure the oil level is ½ position oil sight glass when the compressor is stopped.

Add oil through the oil fill port at the top of the compressor only if the oil level is below the ½ position. Gear oil should only be added when the compressor is powered off.

## 6.3 OPERATION



**WARNING!**

During operation, the surface of the compressor can become hot, reaching temperatures exceeding 350 °F (177 °C).

**Risk of burns!**

Do not touch the surface of the compressor during and directly after operation. Wait until cool down (approx. room temperature), or wear heat protection gloves prior to handling the compressor. Touching the surface of the compressor before it has cooled down can lead to serious bodily injuries including death and/or damage to the compressor.

While operating the compressor, adhere to the following safety and operational guidelines:

- Ensure the ambient and suction air temperature is between 40 °F (5 °C) and 104 °F (40 °C).
- Do not use the standard versions of the compressor in hazardous/explosive areas or applications. Contact AIRTECH for versions of the compressor with explosion proof motors.
- Wear ear protection while working near the compressor.
- Ensure the compressor is firmly fixed and secured in its location, away from strong vibrations.



**CAUTION**

Noise from running the compressor can damage your hearing.

**Risk of damage to hearing!**

All persons in the vicinity of the compressor for extended periods of time must always wear ear protection!



**NOTICE!**

Non-compliance with the operational guidelines invalidates the warranty and may lead to accidents resulting in death, serious bodily injuries or irreparable damage to the compressor.



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The pressure can be adjusted by turning the knob on the pressure regulating valve, as marked on the top of the valve. The regulating valve, or safety valve, is set to the permissible operating pressure. If the compressor exceeds this set pressure, the valve will open to discharge the excess pressure, ensuring safe operation.

**NOTICE!**

Set the regulating valve, or safety valve to the permissible pressure.

**Do not operate the compressor without a regulating valve or safety valve!**

Setting regulating valve, or safety valve, above the permissible pressure can cause severe damage to compressor.

## 6.4 STOPPING

To stop the compressor, turn off the power supply.

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# 7 MAINTENANCE



**WARNING!**

Work on the compressor should only be performed by qualified and authorized personnel, and the compressor must be stationary before any maintenance or repairs are carried out. Failure to follow these instructions may result in serious bodily injuries including death, property damage or damage to the compressor.

**Risk of electric shock!**

Before starting work:

- Make sure the compressor is powered off and cannot initiate a sudden start-up (this also applies to auxiliary circuits e.g., standstill heating).
- Confirm there is no voltage!
- Establish a safe protective earth connection before starting work.



**WARNING!**

During operation, the surface of the compressor can become hot, reaching temperatures exceeding 350 °F (177 °C).

**Risk of burns!**

Do not touch the surface of the compressor during and directly after operation. Wait until cool down (approx. room temperature), or wear heat protection gloves prior to handling the compressor. Touching the surface of the compressor before it has cooled down can lead to serious bodily injuries including death and/or damage to the unit.



**WARNING!**

Compressors contaminated with hazardous material pose risks of poisoning and infection!

**Risk of poisoning!**

**Risk of infection!**

If the compressor is contaminated with hazardous material, always wear appropriate personal protective equipment (PPE) before handling the unit.

Do not attempt to clean or service the unit yourself unless you are properly trained and equipped for hazardous materials!



**NOTICE!**

Non-compliance with the maintenance, servicing obligations, or operational guidelines invalidates the warranty and may lead to accidents resulting in death or serious bodily injuries.



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AIRTECH PCX Series Dry Rotary Claw Compressors require very little maintenance. To ensure optimum performance, the following maintenance steps should be followed:

- Regularly check connection tightness of the unit
- Avoid overloading the compressor
- Check the compressor for unusual noise and vibration
- Ensure the compressor's surface is free of dust or clutter
- Ensure the compressor has adequate amount of oil present in the gear box during operation

Prior to starting maintenance:

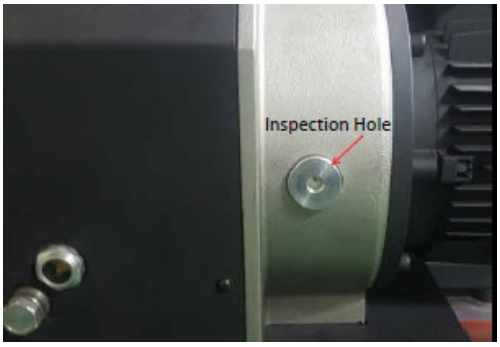
1. Power off the compressor and disconnect from all electrical connections.
2. Allow the compressor to cool down.
3. Ensure all pipes and lines are vented to atmospheric pressure and isolated, especially if manifolded with other pressure and vacuum producing equipment.

**AIRTECH TIP**

The maintenance schedule listed in this manual is based on average operating conditions. For heavy duty operations, consider shortening the time between routine maintenance.

## 7.1 INSPECTION HOLE

The inspection hole, fitted with a G1" plug, allows for regular checks of the coupling, its inserts, and the fan. This can be done using an endoscope wire cam, which can be connected to a smartphone for convenient viewing. Contact AIRTECH for more information on inspecting the compressor via the inspection hole.




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## 7.2 GEAR BOX OIL

See section *5.5 OIL FILLING* for details on oil type and quantity.

### 7.2.1 OIL LEVEL

Under normal circumstances it should not be necessary to add oil between oil changes. A significant drop in oil level means there is an oil leak, or the compressor is operating outside of rated operating parameter. In case of an oil leak, check the O-rings, drain plug or oil sight glass

Check the oil level only when the compressor is powered off. Replenish oil if it drops below the "MIN" mark on the side of oil sight glass. Consult AIRTECH for any further questions.

### 7.2.2 OIL CHANGE

Oil life is dependent on the operating conditions. Under normal ambient conditions, and with AIRTECH's ATO-3000 gear oil, it is recommended to change the oil every 10,000 operating hours. Additionally, it is necessary to perform the first oil change between 500 and 1,000 operating hours. Always drain the old oil completely from the gear box before refilling.

**WARNING!**

Do not change oil while the compressor is powered on or while operating.

**Risk of burns!**

Hot oil can spray out from the oil fill port. Always power off the compressor prior to oil change.

**AIRTECH TIP**

When disposing of used gearbox oil, ensure compliance with all applicable local and national environmental regulations regarding waste recycling procedures and protocols.

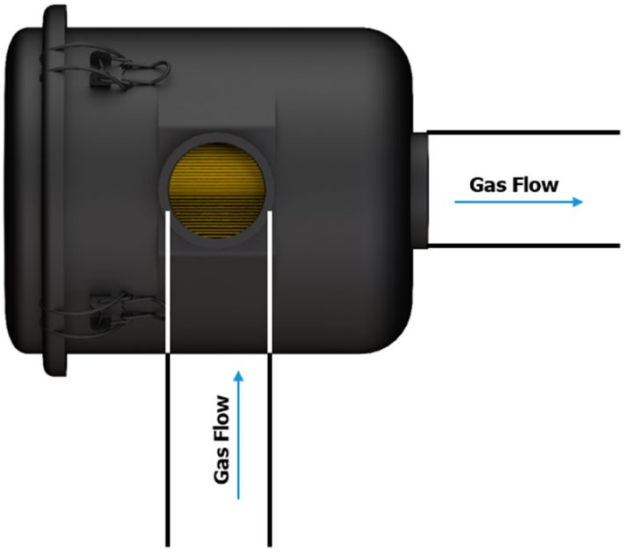

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## 7.3 INLINE (INLET) FILTER

Check inline (inlet) filter on a weekly basis. The filter cartridge should be cleaned or replaced when dirty. Please reach out to AIRTECH for replacement element information. Paper/Polyester filter cartridge(element) are available to the application.

**NOTICE!**

It is recommended that the inline air filters are mounted horizontally, as shown below, in order to prevent any filtered media from falling into the compressor when cleaning or replacing the element. Contact AIRTECH for inlet and inline filter recommendations for your application.




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## 7.4 MAINTENACE CHART

*Table 7-1* details the recommended periodic maintenance schedule for the PCX105/155 Compressors.

*Table 7-1 Regular Maintenance Guide*

| Maintenance Intervals | Maintenance Actions |
|---|---|
| Weekly | Inspect inline (inlet) filter and check for oil leaks.<br>Inspect the filter more frequently than weekly, if there's high amount of particulates in inlet stream. |
| Monthly | Check the oil level in the gear box.<br>Check the protective mesh. |
| Every 750 Operating Hours | Check cooling fans and coupling. |
| Every 2000 Operating Hours | Check bearings and shaft seals.<br>Check bearings and shaft seals more frequently than every 2000 operating ours if the ambient temperature is higher than 68 °F (20 °C). |
| Every 5000 Operating Hours | Check the gear oil conditions, and if necessary, change gear oil. |
| For motor's maintenance, please see the motor manufacture's manual for periodic motor maintenance. | |


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## 7.5 KITS AND SPARE PARTS

Kits and parts that are available for maintenance and replacement that we offer for PCX60/105/155 Dry Rotary Claw Compressors:

| Kit | Kit Contents | Part Number | Catalog Number | Compressor Model |
|---|---|---|---|---|
| Rebuild Kit | • Spacers<br>• Piston Rings<br>• Sleeves<br>• O-rings<br>• Shaft Seals<br>• Bearings<br>• Power Locks<br>• Compressor Cover O-ring<br>• Gear Box Cover O-ring<br>• Inlet Screen (Conical)<br>• Flange Gasket<br>• Silencer Gasket<br>• Oil Sight Glass Gaskets<br>• Drain Plug O-rings<br>• Coupling Insert | PN.601.00156 | C060.500.P0 | PCX60-50 |
| Coupling Set | • Compressor Side Coupling<br>• Coupling Insert<br>• Motor Side Coupling with Fan | PN.210.00111 | C060.104.P0 | |

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| Kit | Kit Contents | Part Number | Catalog Number | Compressor Model |
|---|---|---|---|---|
| Rebuild Kit | • Spacers<br>• Piston Rings<br>• Sleeve<br>• O-rings<br>• Shaft Seals<br>• Bearings<br>• Power Locks<br>• Compressor Cover O-ring<br>• Gear Box Cover O-ring<br>• Exhaust Silencer Gasket<br>• Inlet Screen (Conical)<br>• Inlet Flange O-ring, Low and Upper Part<br>• Support Isolator<br>• Oil sight Glass Gasket<br>• Drain Plug O-ring<br>• O-Ring For Oil Filler<br>• Coupling Insert | PN.601.00122 | C105.500.P0 | PCX105-50/75/100 |
| | | PN.601.00178 | C155.500.P0 | PCX155-100/150 |
| Coupling Set | • Compressor Side Coupling<br>• Coupling Insert<br>• Motor Side Coupling with Fan | PN.120.00115 | C100.104.P0 | PCX105-75/100 |
| | | PN.210.00116 | C155-100.104.P0 | PCX155-100 |
| | | PN.210.00117 | C155-150.104.P0 | PCX155-150 |

Please contact AIRTECH for all other available kits and spare parts you may require.



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# 8 TROUBLESHOOTING

## 8.1 REMEDIAL ACTIONS

While the troubleshooting guide offers valuable assistance in resolving system failures, it is critical for users to understand the entire compressor. Only trained and qualified personnel should operate the compressor.



**WARNING!**

All troubleshooting operations must be done by a qualified and/or trained personnel.

**Risk of electrical shock!**

**Risk of serious damage to the property!**

Avoid interfering with any of the electrical components of the compressor while the compressor is powered on or has an electrical connection to a power source.

If the troubleshooting guide does not resolve the issue with the compressor, or the symptoms have worsened please contact AIRTECH for further assistance.

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*Table 8-1 Troubleshooting Guide*

| Fault | Possible Cause | Remedy | Responsible Party |
|---|---|---|---|
| Compressor does not reach capacity. | Inlet screen (mesh) of the inlet filter clogged with debris. | Check inlet filter element and clean by compressed air or wash with water. | Operator |
| | Pipe work is too long or too small. | Use larger diameter pipe and shorten the line length if possible. | |
| | Obstruction in the inlet filter. | Check the filter to ensure it is clean and replace it if necessary. | |
| | Leaks in the air piping. | Check for leaks using soapy water at all pipe joints. Only very large leaks are audible – a number of smaller leaks could result in underperformance and must be check in a systematic manner. | |
| Compressor runs over set pressure. | Pressure regulator or safety valve is set incorrectly, or is out of order. | Set point again or replace regulator. | Operator |
| Compressor does not reach set pressure. | Leak in compressor or system. | Check compressor and system for leaks. | Operator |
| Compressor is making too much noise. | Contamination of the claws or chamber. | Clean the pumping chamber and the claws. | Operator |
| | Coupling insert is worn. | Replace coupling insert in motor/compressor coupling. | |
| | Bearing is worn down. | Replace bearings. | |
| | Failure of pressure regulator or safety valve | Replace pressure regulator or safety valve. | |
| Compressor will not operate or seized up. | Rotary claws, bearing , or gears stuck. | Contact AIRTECH for further assistance. | Authorized Service Personnel. |
| Compressor will not start. | Improper or overloaded supply voltage. | Check the voltage supply, overload settings in motor starter for size and settings according to motor nameplate.<br><br>If the ambient temperature is high, use the next larger size overloads, or adjust settings 5% above motor nameplate. | Electrician |
| | Motor Starter overload settings are too low or improper. | | |
| | Fuses are burnt. | | |
| | Wire size is too small or too long, causing voltage drop. | Install proper size wire. | |



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| Fault | Possible Cause | Remedy | Responsible Party |
|---|---|---|---|
| Motor Starter Trips | Incorrect voltage (lower than required) | • Check voltage at the motor and correct any sources of voltage drop in the system.<br>• Check wiring to ensure it is properly sized according to National Electrical Code requirements. | Electrician |
| | Incorrect wiring of the motor. | • Ensure the motor is wired according to the instructions contained in the motor junction box.<br>• Correct placement of the bridges if necessary to configure your motor for the proper voltage. | |
| | Motor starter is not set correctly or is too small for the application. | • Check to ensure the motor starter is set for the full load amps at the operating voltage as indicated on the motor nameplate.<br>• Be sure to multiply the full load amperage by any service factor that appears on the motor. If the current required is outside the range of adjustability of the starter, replace the starter with a properly sized starter. | |
| | Motor starter trips too fast. | Use a motor starter with a high current trip delay to avoid nuisance trips on startup. | |

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# 9 DISMANTALING AND DISPOSAL



**WARNING!**

All troubleshooting operations must be done by a qualified and/or trained personnel.

**Risk of electrical shock!**

**Risk of serious damage to the property!**

Avoid interfering with any of the electrical components of the compressor while the compressor is powered on or has an electrical connection to a power source.

1. Power off the compressor and disconnect from all electrical connections to protect against unintended start-up
2. Allow the compressor to cool down
3. Ensure all pipes and lines are vented to atmospheric pressure
4. Disconnect piping and hoses
5. Dismount compressor from installation space
6. Separate components by recyclability and separate special waste
7. Dispose of materials according to local regulations.

If you are unsure about how to dismantle and dispose your compressor, please contact AIRTECH for further assistance.



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# 10 TECHNICAL DATA

| MODEL: PCX60 | | | 50 |
|---|---|---|---|
| Displacement | CFM | 60Hz | 40 |
| | | 50Hz | 33 |
| Motor Rating (3Ph) | HP | 60Hz/50Hz | 5 |
| Ultimate Pressure | PSIG | 60Hz/50Hz | 29.0 |
| Motor Voltage | V | 60Hz | 230/460 |
| | | 50Hz | 190/380 |
| Speed | RPM | 60Hz | 3510 |
| | | 50Hz | 2900 |
| Noise | dB(A) | 60Hz | 79 |
| | | 50Hz | 78 |
| Ambient Operating Temp. | °F | 60Hz/50Hz | 40 ~ 104 |
| Oil Capacity | Qts | | 0.6 |
| Connections | NPT | Intake | 1” |
| | | Exhaust | 1” |
| Approx. Weight | Lbs (with motor) | | 165 |

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| MODEL: PCX105 | | | 50 | 75 | 100 |
|---|---|---|---|---|---|
| Displacement | CFM | 60Hz | 71 | | |
| | | 50Hz | 59 | | |
| Motor Rating (3Ph) | HP | 60Hz/50Hz | 5 | 7.5 | 10 |
| Ultimate Pressure | PSIG | 60Hz | 11.6 | 20.3 | 31.9 |
| | | 50Hz | 20.3 | 31.9 | 31.9 |
| Motor Voltage | V | 60Hz | 230/460 | | |
| | | 50Hz | 190/380 | | |
| Speed | RPM | 60Hz | 3510 | 3520 | |
| | | 50Hz | 2900 | 2910 | |
| Noise | dB(A) | 60Hz | 80 | | |
| | | 50Hz | 79 | | |
| Ambient Operating Temp. | °F | 60Hz/50Hz | 40 ~ 104 | | |
| Oil Capacity | Qts | | 0.5 | | |
| Connections | NPT | Intake | 1-1/2” | | |
| | | Exhaust | 1-1/2” | | |
| Approx. Weight | Lbs (with motor) | | 260 | 293 | 313 |

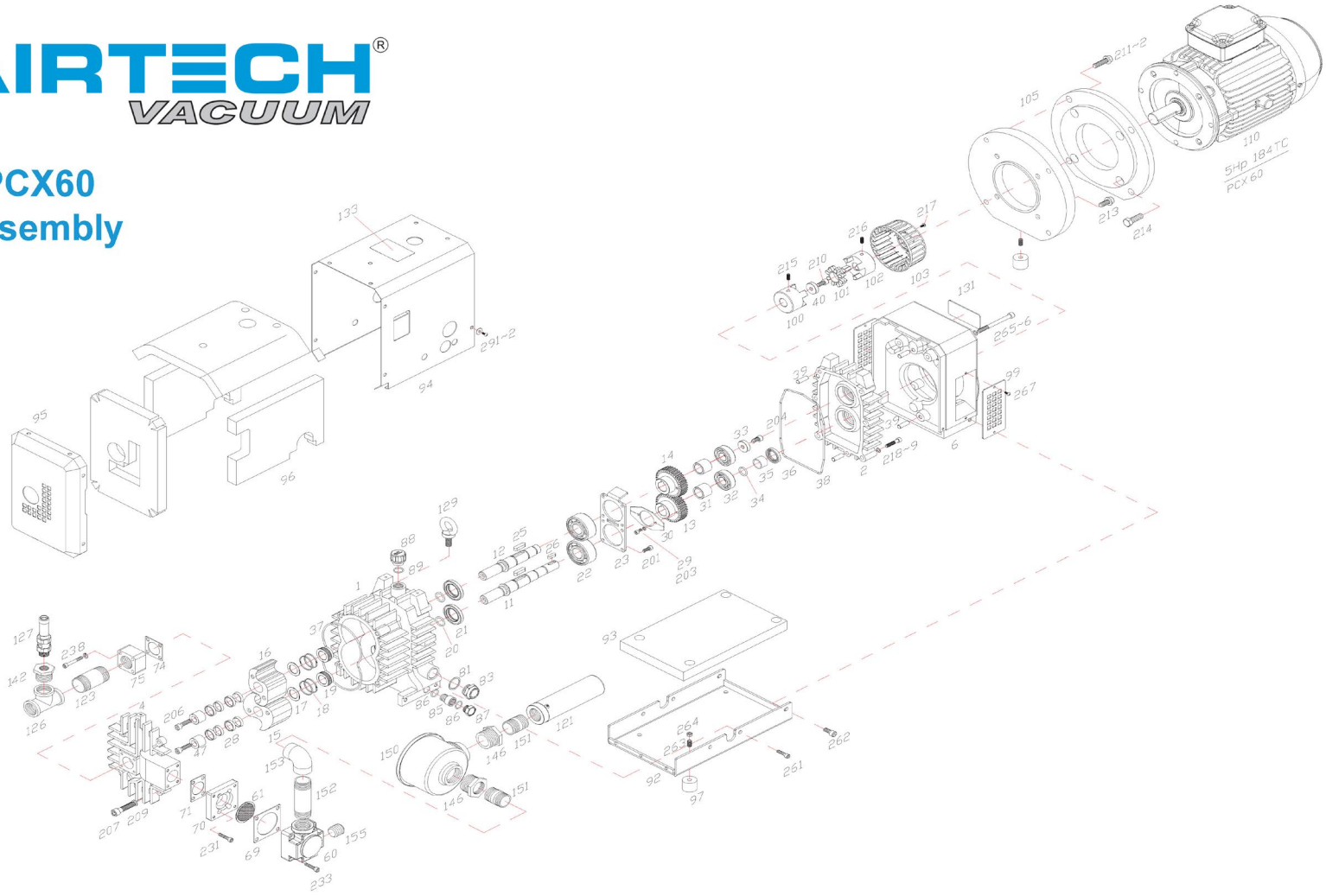

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| MODEL: PCX155 | | | 100 | 150 |
|---|---|---|---|---|
| Displacement | CFM | 60Hz | 106 | |
| | | 50Hz | 88 | |
| Motor Rating ( 3Ph) | HP | 60Hz/50Hz | 10 | 15 |
| Ultimate Pressure | PSIG | 60Hz | 17.4 | 29.0 |
| | | 50Hz | 29.0 | 29.0 |
| Motor Voltage | V | 60Hz | 230/460 | |
| | | 50Hz | 190/380 | |
| Speed | RPM | 60Hz | 3520 | 3540 |
| | | 50Hz | 2910 | 2920 |
| Noise | dB(A) | 60Hz | 82 | |
| | | 50Hz | 80 | |
| Ambient Operating Temp. | °F | 60Hz/50Hz | 40 ~ 104 | |
| Oil Capacity | Qts | | 0.5 | |
| Connections | NPT | Intake | 1-1/2” | |
| | | Exhaust | 1-1/2” | |
| Approx. Weight | Lbs (with motor) | | 190 | 330 |

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# PCX60
# Assembly




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# PCX60

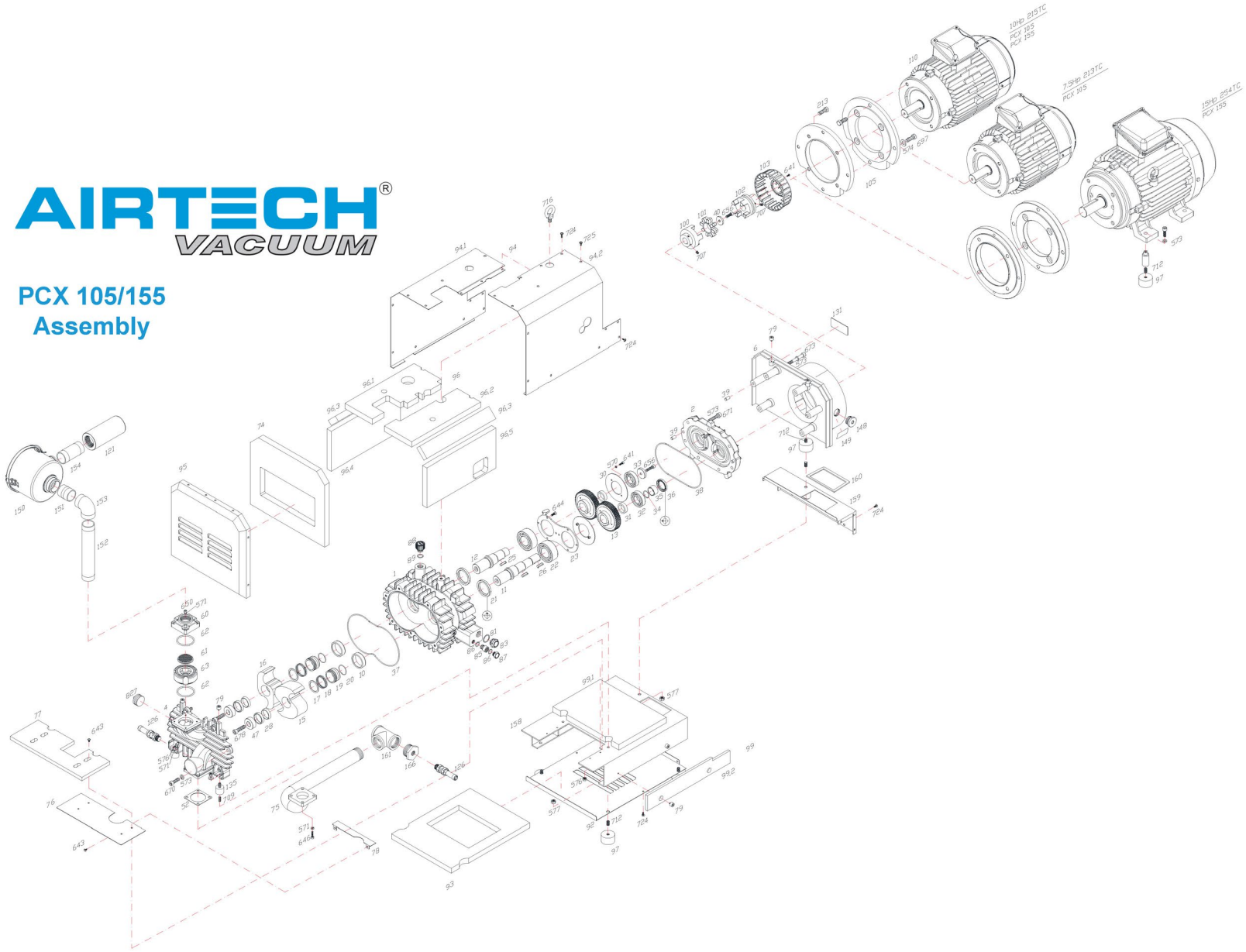
| Pos. No. | Description | Qty | Pos. No. | Description | Qty | Pos. No. | Description | Qty | Pos. No. | Description | Qty |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 | Gear Box Housing | 1 | 40 | Locking Disk | 1 | 126 | Tee | 1 | 238 | Hex. Socket Head Cap Screw | 4 |
| 2 | Gear Box Cover (rear) | 1 | 47 | Locking Disk, side Rotor | 2 | 127 | Safety valve - 2.0bar (Press. Regulator) | 1 | 261 | Hex. Socket Head Cap Screw | 4 |
| 4 | Pump Housing Cover 1 (End Plate) | 1 | 60 | Inlet flange, Upper Housing | 1 | 129 | Eye Bolt | 1 | 262 | Hex. Socket Head Cap Screw | 2 |
| 6 | Fan Housing | 1 | 61 | Inlet screen (Conical ) | 1 | 130 | Label, Direction Arrow | 1 | 263 | Set Screw | 3 |
| 11 | Shaft 1 | 1 | 69 | Gasket, Inlet Connection Housing | 1 | 131 | Name Plate | 1 | 264 | Hexagon Nut | 2 |
| 12 | Shaft 2 | 1 | 70 | Flange Adapter, Inlet | 1 | 133 | Label, read manual | 1 | 265 | Hex. Socket Head Cap Screw | 2 |
| 13 | Gear 1 | 1 | 71 | Gasket, Flange | 1 | 142 | Bushing | 1 | 266 | Washer, Spring Lock | 2 |
| 14 | Gear 2 | 1 | 74 | Gasket, Silencer | 1 | 146 | Bushing | 2 | 267 | Round Head Bolt | 4 |
| 15 | Rotor 1 | 1 | 75 | Spacer, block | 1 | 150 | Inlet Filter, IF-130 | 1 | 291 | Round Head Bolt | 11 |
| 16 | Rotor 2 | 1 | 81 | Gasket, Oil Sight Glass | 2 | 151 | Pipe, extension, Short, inlet | 2 | 292 | Washer, Flat | 11 |
| 17 | Spacer | 2 | 83 | Oil Sight Glass | 2 | 152 | Pipe, extension, inlet | 1 | | | |
| 18 | Piston Ring | 4 | 85 | Pipe, for Drain Plug | 1 | 153 | Elbow 1" | 1 | | | |
| 19 | Sleeve | 2 | 86 | O-ring, Drain Plug | 2 | 155 | Plug | 1 | | | |
| 20 | O-Ring | 2 | 87 | Drain Plug | 1 | 201 | Hex. Socket Head Cap Screw | 8 | | | |
| 21 | Shaft Seal, | 2 | 88 | Oil filler Breather, Plastic | 1 | 203 | Hex. Socket Head Cap Screw | 2 | | | |
| 22 | Bearing, | 2 | 89 | O-Ring for Oil filler | 1 | 204 | Hex. Socket Head Cap Screw | 1 | | | |
| 23 | Bearing cover | 1 | 92 | Shield Cover, Bottom | 1 | 206 | Hex. Socket Head Cap Screw | 2 | | | |
| 25 | Key, for Gear | 2 | 93 | Acoustic Mat for Shield Cover, Bottom | 1 | 207 | Hex. Socket Head Cap Screw | 4 | | | |
| 26 | Key, for Coupling | 1 | 94 | Shield Cover, Side (PCX) | 1 | 209 | Washer, Spring Lock | 4 | | | |
| 28 | Power Lock | 4 | 95 | Shield Cover, Front (PCX) | 1 | 210 | Hex. Socket Head Cap Screw | 1 | | | |
| 29 | Washer, Spring Lock | 2 | 96 | Acoustic Mat for Shield Cover, front and Side (VCX) | 1 | 211 | Hexagon Bolt | 4 | | | |
| 30 | Flinger | 1 | 97 | Foot, Rubber | 3 | 212 | Washer, Spring Lock | 4 | | | |
| 31 | Sleeve | 2 | 99 | Grill for Fan | 2 | 213 | Hexagon Bolt | 4 | | | |
| 32 | Bearing, | 2 | 100 | Coupling, Pump Side ø20 | 1 | 214 | Hexagon Bolt (NEMA only) | 4 | | | |
| 33 | Locking Disk | 1 | 101 | Insert, Coupling | 1 | 215 | Set Screw | 2 | | | |
| 34 | O-Ring | 1 | 102 | Coupling, Motor Side | 1 | 216 | Set Screw | 2 | | | |
| 35 | Sleeve | 1 | 103 | Fan, new, Plastic | 1 | 217 | Round Head Bolt | 5 | | | |
| 36 | Shaft Seal, | 1 | 105 | Flange Adapter for NEMA | 1 | 218 | Hex. Socket Head Cap Screw | 6 | | | |
| 37 | O-Ring, Compressor cover | 1 | 110 | Motor (NEMA) | 1 | 219 | Washer, Spring Lock | 6 | | | |
| 38 | O-Ring, Gear Box cover | 1 | 121 | Silencer, Inlet | 1 | 231 | Hex. Socket Head Cap Screw | 4 | | | |
| 39 | Dowel Pin | 4 | 123 | Pipe, extension, medium, exhaust 1" | 1 | 233 | Hex. Socket Head Cap Screw | 4 | | | |



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# PCX 105/155
## Assembly



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# PCX105/155

| Pos. No. | Description | Qty | Pos. No. | Description | Qty | Pos. No. | Description | Qty | Pos. No. | Description | Qty |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 | Gear Box Housing | 1 | 47 | Locking Disk, Rotor Side | 2 | 97 | Foot | 5 | 159 | Cover, Exhaust | 1 |
| 2 | Gear Box Cover (rear) | 1 | 52 | Gasket, Exhaust Silencer | 1 | 99 | Accoustic Mat for base (set) | 1 | 160 | Seal | 1 |
| 4 | Pump Housing Cover 1 (End Plate) | 1 | 60 | Inlet flange, Upper Housing | 1 | 99.1 | Accoustic Mat for base (on the base) | 1 | 161 | Tee, Exhaust | 1 |
| 6 | Fan Housing IEC 100 B5 | 1 | 61 | Inlet screen (Conical ) | 1 | 99.2 | Accoustic Mat for base (side) | 2 | 166 | Bushing | 1 |
| 10 | Sleeve | 2 | 62 | O-Ring, Inlet Flange, low and upper part | 2 | 100 | Coupling, Pump Side | 1 | 571 | Washer, Spring Lock | 4 |
| 11 | Shaft 1 | 1 | 63 | Inlet flange, Lower housing | 1 | 101 | Insert, Coupling | 1 | 572 | Washer, Spring Lock | 6 |
| 12 | Shaft 2 | 1 | 74 | Accoustic mat for PCX front cover | 1 | 102 | Coupling, Motor Side, NEMA | 1 | 573 | Washer, Spring Lock | 18 |
| 13 | Gear | 2 | 75 | Discharge Pipe | 1 | 102 + 103 | Coupling, Motor Side, NEMA | 1 | 574 | Washer, Spring Lock | 4 |
| 15 | Rotor 1 | 1 | 76 | Plate (front) | 1 | 103 | Fan | 1 | 576 | Hexagon nut | 2 |
| 16 | Rotor 2 | 1 | 77 | Accoustic mat | 1 | 105 | Flange Adapter for NEMA (Ass'y) | 1 | 577 | Hexagon Nut | 5 |
| 17 | Spacer | 2 | 78 | Plate (back) | 1 | 105 | Flange Adapter for NEMA | 1 | 641 | Hex. Socket Head Cap Screw | 9 |
| 18 | Piston Ring | 4 | 79 | Support isolator | 8 | 105 | Flange Adapter for NEMA | 1 | 643 | Hex. Socket Head Cap Screw | 4 , 6 |
| 19 | Sleeve | 2 | 81 | Gasket, Oil Sight Glass | 1 | 105 | Flange Adapter for NEMA | 1 | 644 | Hex. Socket Head Cap Screw | 8 |
| 20 | O-Ring | 2 | 83 | Oil Sight Glass | 1 | 105 | Flange Adapter for NEMA | 1 | 646 | Hex. Socket Head Cap Screw | 4 |
| 21 | Shaft Seal, | 2 | 85 | Pipe, for Drain Pulg | 1 | 105 | Flange Adapter for NEMA | 1 | 650 | Hex. Socket Head Cap Screw | 4 |
| 22 | Bearing, | 2 | 86 | O-ring, Drain Plug | 2 | 110 | Motor (NEMA) 5HP | 1 | 656 | Hex. Socket Head Cap Screw | 2 |
| 23 | Bearing cover | 1 | 87 | Drain Plug | 1 | 110 | Motor (NEMA) 7.5HP | 1 | 670 | Hex. Socket Head Cap Screw | 7 |
| 25 | Key, for Gear | 2 | 88 | Oil filler Breather, Plastic | 1 | 110 | Motor (NEMA) 10HP | 1 | 671 | Hex. Socket Head Cap Screw | 7 |
| 26 | Key, for Coupling | 1 | 89 | O-Ring for Oil filler | 1 | 121 | Silencer, Inlet | 1 | 673 | Hex. Socket Head Cap Screw | 4 |
| 28 | Power Lock | 2 | 92 | Shield Cover, Bottom | 1 | 126 | Safety valve - 2.2bar | 1 | 678 | Hex. Socket Head Cap Screw | 2 |
| 30 | Flinger | 2 | 93 | Accoustic Mat for Shield Cover, Bottom | 1 | 130 | Label, Direction Arrow | 1 | 695 | Hexagon Bolt | 4 |
| 31 | Sleeve | 2 | 94 | Shield Cover, Side (set) | 1 | 131 | Name Plate | 1 | 697 | Hexagon Bolt | 4 |
| 32 | Bearing, | 2 | 94.1 | Shield Cover, Side (left) | 1 | 135 | Foot | 2 | 707 | Set Screw | 4 |
| 33 | Locking Disk, Shaft 2 | 1 | 94.2 | Shield Cover, Side (right) | 1 | 148 | Plug | 1 | 709 | Set Screw | 4 |
| 34 | O-Ring | 1 | 95 | Shield Cover, Front | 1 | 149 | Sticker | 1 | 712 | Set Screw | 6 |
| 35 | Sleeve | 1 | 96 | Accoustic Mat for shield Cover, Side (set) | 1 | 150 | Inlet Filter IF-175 | 1 | 716 | Eye Bolt | 1 |
| 36 | Shaft Seal, | 1 | 96.1 | Accoustic Mat for shield Cover, Side (left) | 1 | 151 | Pipe, extension, Short, inlet | 1 | 724 | Botton Flange Bolt | 21 |
| 37 | O-Ring, Compressor cover | 1 | 96.2 | Accoustic Mat for shield Cover, Side (right) | 1 | 152 | Pipe, extension, inlet | 1 | 725 | Botton Head Bolt | 31 , 29 |
| 38 | O-Ring, Gear Box cover | 1 | 96.3 | Accoustic Mat for shield Cover, Side (middle) | 2 | 153 | Elbow | 1 | 827 | Plug | 1 |
| 39 | Dowel Pin | 4 | 96.4 | Accoustic Mat for shield Cover, Side (under left) | 1 | 154 | Pipe, extension, inlet | 1 | | | |
| 40 | Locking Disk, Coupling Side | 1 | 96.5 | Accoustic Mat for shield Cover, Side (under right) | 1 | 158 | Base | 1 | | | |



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