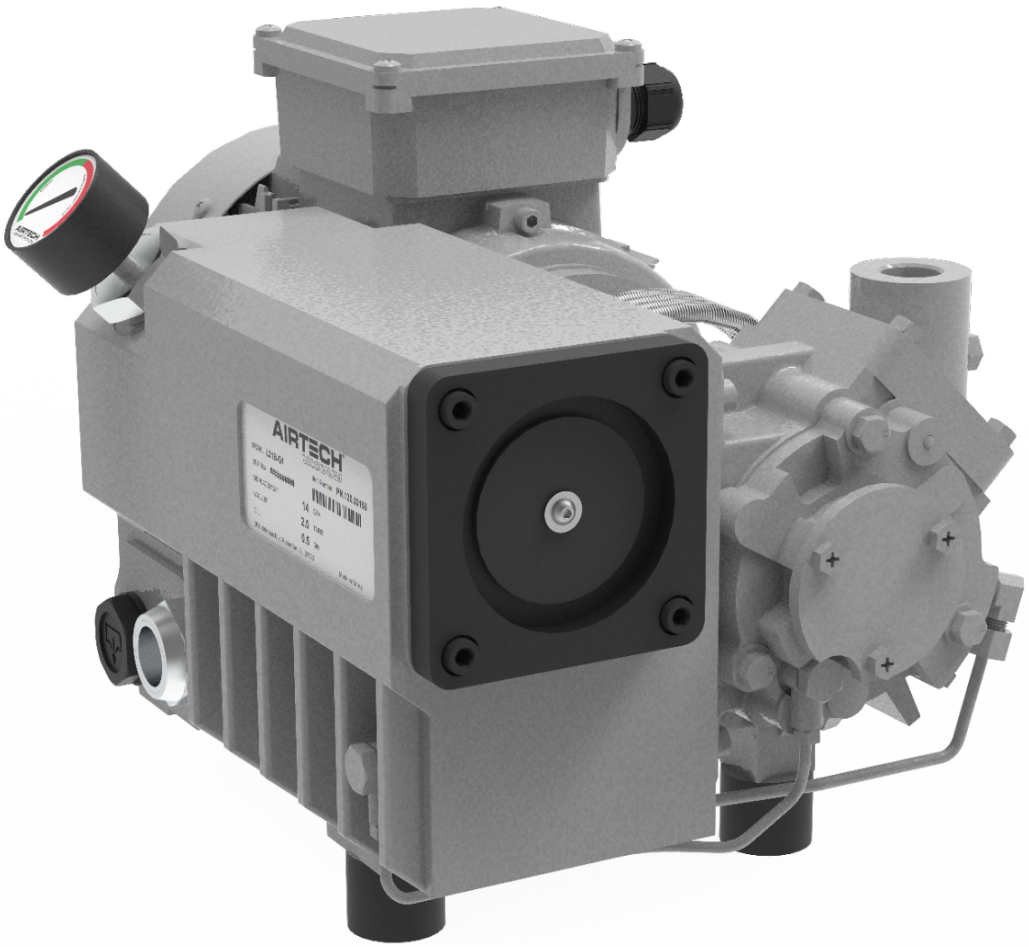
AIRTECH®
VACUUM



L12B/L21B

OIL-FLOODED ROTARY VANE VACUUM PUMPS

INSTALLATION AND OPERATING MANUAL

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Version History

Version	Revised On	Author(s)	Description
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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 pump. Please read carefully before proceeding.

1.1 PREFACE

This manual serves as a comprehensive guide to the operation and maintenance of L12B and L21B Oil-Flooded Rotary Vane Vacuum Pumps. 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
- Troubleshooting
- Dismantling and Disposal

By following the instructions and guidelines provided in this manual, you can ensure the safe and efficient operation of L12B and L21B Oil-Flooded Rotary Vane Vacuum Pumps throughout their 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 "pump" will be used to refer to the L12B and/or L21B Oil-Flooded Rotary Vane Vacuum Pumps.

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 pump, other supplied documents must be observed in addition to this manual, e.g. the operating manuals and datasheets of the motor, motor starter etc.

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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 pump. 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 PRODUCT DESCRIPTION

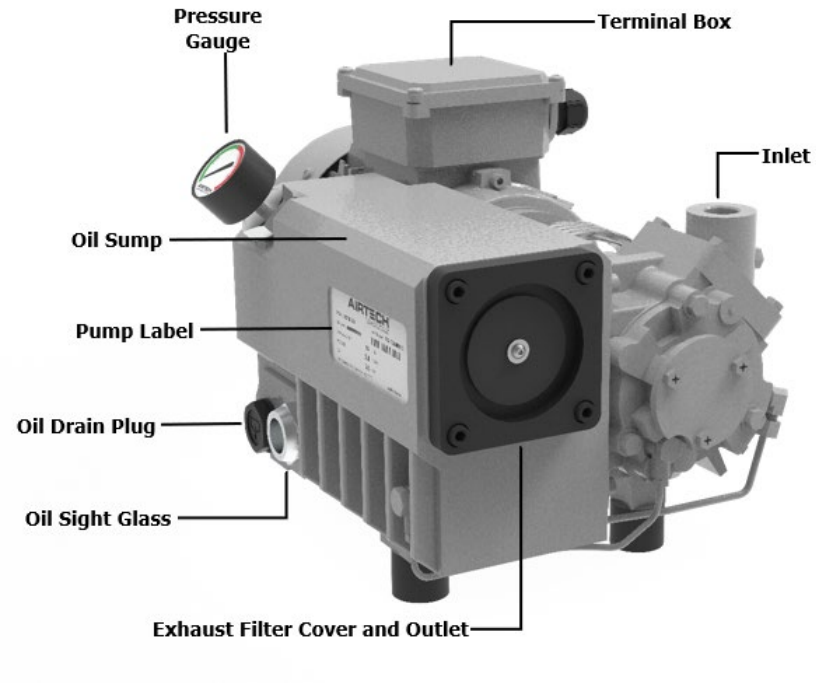


Figure 3-1 L21B -G1 Rotary Vane Pump

3.1 COOLING

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

WARNING!

During operation, the surface of the pump can become hot, reaching temperatures exceeding 203 °F (95 °C).

Risk of burns!

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

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3.2 PRINCIPLE OF OPERATION

The oil-flooded rotary vane vacuum pump operates using a series of vanes mounted to a rotor inside a cylindrical housing. As the rotor spins, centrifugal force extends these vanes from their slots, creating sealed pockets of air. The rotation of the rotor moves these air pockets from the inlet towards the outlet, compressing the air as the space between the vanes decreases. Oil is continuously injected into the pump chamber to provide sealing, cooling, and lubrication, which enhances the efficiency and longevity of the pump. The compressed air mixed with oil vapor is then directed through an exhaust filter at the outlet, which traps oil mist and allows cleaner air to be expelled. The oil collected by the filter is recirculated into the pump, ensuring efficient operation and minimal environmental impact. The principle of operation is demonstrated in *Figure 3-2*.

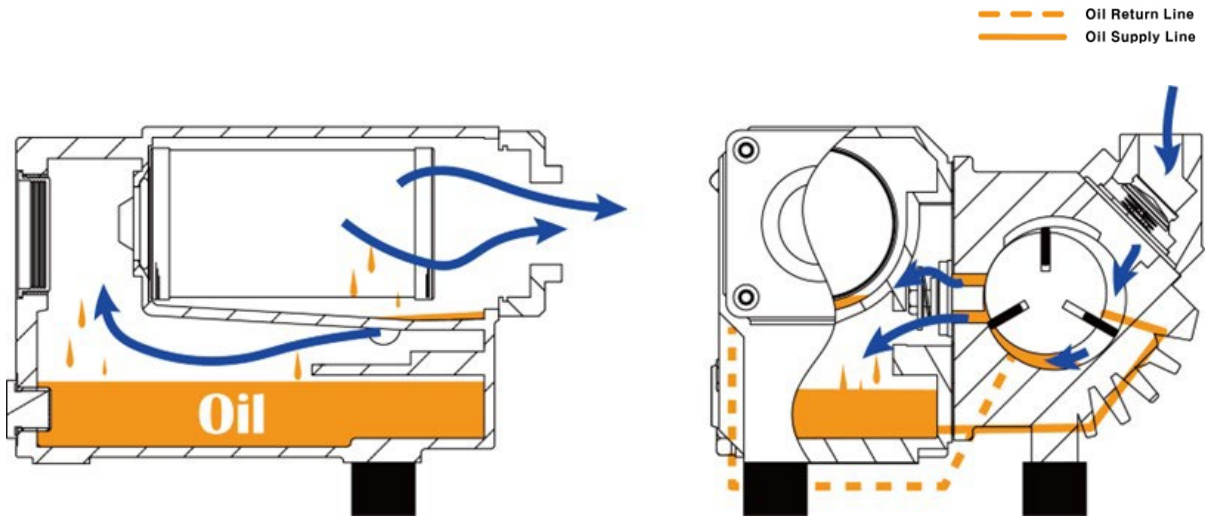


Figure 3-2 Principle of Operation

NOTICE!

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

Risk of premature failure!

Do not overfill the pump with oil!

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3.3 PUMP LABEL

Airflow volume, oil capacity, and vacuum level are given on the pump label or on a separate datasheet. *Figure 3-3* is an example L21B pump label that can be found on the L-Series rotary vane pumps. If you require more technical data, other available sizes or versions of the pump, additional accessories, and spare parts, please contact AIRTECH.

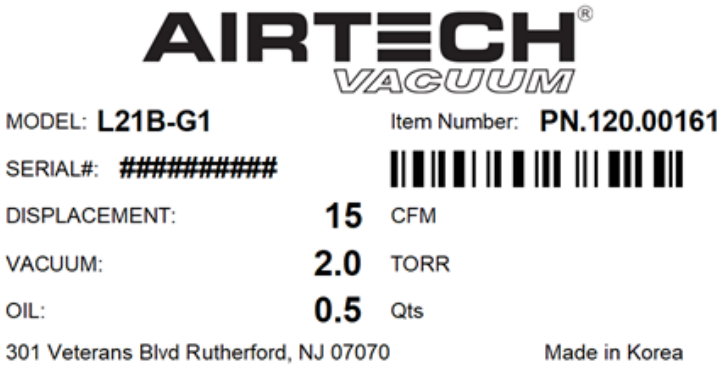


Figure 3-3 Pump Label

On the pump label are stated:

- Pump Model Name
- Serial Number
- Item Number
- Displacement Volume (CFM)
- End Vacuum Level (Torr)
- Oil Capacity

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

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3.4 MOTOR NAMEPLATE

Nominal efficiency, rated horsepower and motor speed are given on the motor nameplate or on a separate motor datasheet. *Figure 3-4* is an example motor nameplate located on the motor.

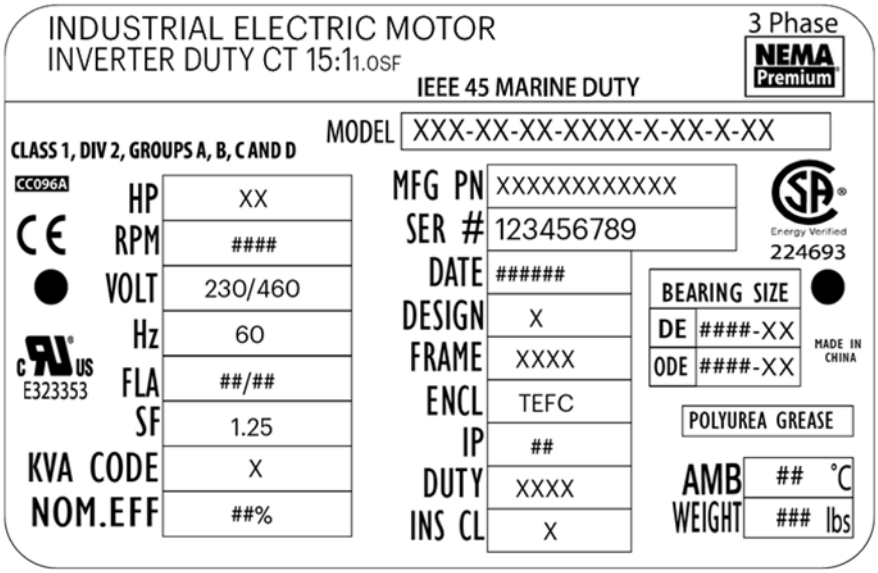


Figure 3-4 Motor Nameplate

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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4 TRANSPORT AND STORAGE

4.1 UPON RECEIPT

When the pump 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 pump 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 pump 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 pump to the base or pallet.

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



NOTICE!

The pump is prefilled with oil by AIRTECH. Do not tip the pump over while filled with oil during transport.

Pump 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 pump is not being used and powered off, close off gas suction connection and the gas discharge connection.

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

- The pump is stored in its original packaging, if possible,
- The pump is stored indoors where the ambient temperature is between 32°F and 104°F (0°C and 40°C),
- The pump 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 pump 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 pump with plastic foil,
5. Adding dehumidifying agent (e.g. granules) into packaging, if necessary.

AIRTECH TIP

If the pump was commissioned prior to being stored, it is recommended to replace the pump 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 pump must be 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 pump, 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 L-Series Oil-Flood Rotary Vane Vacuum Pumps. 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 pump 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 pump 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 pump. The location must also allow the operator to easily change

Place the pump 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 pump.

If the pump will be placed outdoors, make sure:

- The ambient temperature is between 32°F and 104°F (0°C and 40°C).
- The oil pump uses is the specific type recommended in this manual, suitable for the ambient and operating temperatures.
- The pumps 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 pump 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 pump:

- 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 pump.
- 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 pump 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 pump 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.

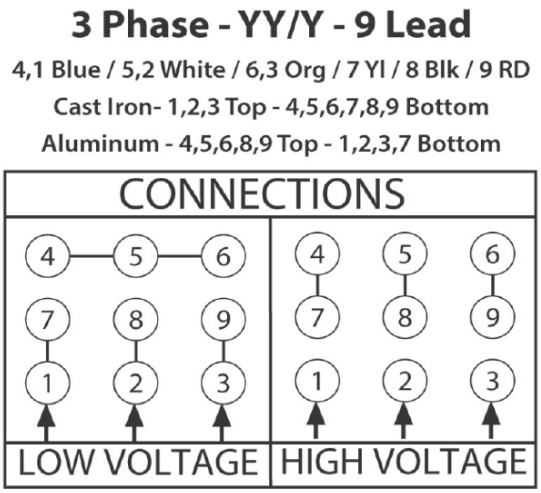


Figure 5-1 Wiring Diagram

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 pump 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 a red arrow on the on the pump as shown below.



Do not check the rotation of the motor without oil present in the pump!

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5.4 PIPE CONNECTIONS

Use a pipe size that is at least the size of the pump inlet connections. Smaller lines result in reduced pump capacity.

Pumps operating in parallel on a common main line should have a check valve installed in the suction line to prevent oil suck back. The built-in anti-suck back valve should not be used as a shut-off valve for the vacuum system.



WARNING!

Operating the pump 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 pump 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.



NOTICE!

If the discharge connection of the pump has been piped outside of the building, equip the pump with a suitable rain protection and a drip leg with drain valve. Failure to equip the pump with a suitable protection may result in damage to the pump.

The vacuum piping should be designed to ensure that no liquids such a condensate or liquid carried over from the process can reach the pump. If this possibility exists, a knock-out liquid separator should be installed. Please contact AIRTECH for recommendations.

Refer to the table below for the thread sizes of the AIRTECH L-Series L12B and L21B pumps.

Pump Model	Inlet Size	Exhaust/Outlet Size
L12B and L21B	NPT 1/2”	NPT 1-1/4”



AIRTECH TIP

If an exhaust manifold is connected, install a drip leg with drain valve near the pump exhaust to prevent exhaust condensation from entering the exhaust box.

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

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5.5 OIL FILLING

The pump is not pre-filled with oil prior to shipping. During installation, ensure the correct type of oil is used by referring to this manual for the appropriate oil specification, and fill the pump until the oil reaches ¾ mark on the oil sight glass.

Pump Model	Oil Capacity
L12B and L21B	0.5 Quarts

NOTICE!

Do not use detergent oil in AIRTECH L-Series Oil-Flooded Rotary Vane Pumps.

Shortened service life!

Oil detergent additives can cause exhaust filters to become clogged and shorten their service life.

WARNING!

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

We recommend using original AIRTECH oil, high-quality vacuum oil series designed to extend the duration between oil changes, enhance lubrication at elevated operating temperatures, and prolong the life of the exhaust filter elements. Please refer to the table below for a list of oils offered by AIRTECH for the pump. Contact AIRTECH for further information on oil selection.

Product Name	Oil Type	Viscosity
ATO-4000-02	Fully Synthetic	98.32 mm2/s @104°F (40°C) 14 mm2/s @212°F (100°C)
ATO-4000F-04	Food Grade	98.32 mm2/s @104°F (40°C) 14 mm2/s @212°F (100°C)

Do **NOT** use ATO-2000 oil for Airtech L12B/L21B Oil-Flooded Rotary Vane Pump.

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6 COMMISSIONING

6.1 PRESTART-UP CHECKS

NOTICE!

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

Risk of premature failure!

Do not overfill the pump with oil and do not add oil while the pump is running.

- Check rotation of the motor as described in section *5.3 ELECTRICAL CONNECTIONS*.
- Fill the pump with oils as described in section *5.5 OIL FILLING*.
- 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 pump.

CAUTION

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

CAUTION

Noise from running pump can damage your hearing.

Risk of damage to hearing!

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

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6.2 START-UP

Start the pump with the inlet closed. Run the pump for a few minutes and then shut down. Check the oil level again and make sure the oil level is between the 3/4 marks and full on the upper oil sight glass.

Add oil if necessary. Pump oil should only be added when the pump is off and circulating oil has had sufficient time to return to the oil sump

6.3 OPERATION



WARNING!

During operation, the surface of the pump can become hot, reaching temperatures exceeding 203 °F (95 °C).

Risk of burns!

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

While operating the pump, 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 pump 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 pump can damage your hearing.

Risk of damage to hearing!

All persons in the vicinity of a non-noise insulated pump 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 pump.

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6.4 STOPPING

To stop the pump, turn off the power supply. A built in anti-suck back valve will prevent oil from the oil reservoir being sucked back into the cylinder after the pump is shutdown.

WARNING!

Do not utilize the anti-suck back valve as a check valve in the system. Consult AIRTECH for proper check valves.

6.5 CHECK VALVE

AIRTECH L-Series pumps are equipped with Built-in Check Valve which is located inside the inlet flange housing at the upper part of pump module and is there to prevent oil back to inlet side when the pump is turned off.

AIRTECH TIP

We recommend installing a separate external check valve if necessary. Contact AIRTECH for the right size check valves and options for your application.

6.6 EXHAUST PRESSURE GAUGE

A pressure gauge is pre-installed on the pump to monitor the condition of the exhaust filters.

NOTICE!

If the reading is 0.6 Bar or greater the exhaust filters will need replacing.

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7 MAINTENANCE



WARNING!

Work on the pump 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 pump 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 pump can become hot, reaching temperatures exceeding 203 °F (95 °C).

Risk of burns!

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



WARNING!

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

Risk of poisoning!

Risk of infection!

If the pump 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 and servicing obligations invalidates the conformity and may lead to accidents resulting in death or serious bodily injuries

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AIRTECH L-series Oil-Flooded Rotary Vane pumps 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 pump
- Check the pump for unusual noise and vibration
- Ensure the pump's surface is free of dust or clutter
- Ensure the pump has adequate amount of oil present during operation

Prior to starting maintenance:

1. Power off the pump and disconnect from all electrical connections.
2. Allow the pump 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 PUMP OIL

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

7.1.1 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, exhaust filters are defective or the pumps is operating outside of rated operating parameter.

It is normal for the oil to be foamy or lightly colored in an operating pump. This may be normal aeration of the oil. If the oil appears milky or dark in color, it is most likely contaminated or burned and must be changed.

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

CAUTION

Do not add oil while the pump is running!

Risk of burns!

Hot oil can spray out from the oil fill port.

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7.1.2 OIL CHANGE

Oil life is dependent on the operating conditions. A clean and dry air stream and operating temperatures below 212°F (100 C) are ideal. We recommended that the oil is replaced every 500-1000 hours depending on application and conditions. In certain unfavorable conditions the oil may need replacement earlier than 500 hours. It is preferred that the oil is drained from the pump when warm.

WARNING!

Always change the oil when the pump is powered off. Do not change oil while the pump is powered on or while operating.

NOTICE!

When disposing of used oil, must observe the relevant environmental regulations and dispose of responsibly. Please contact an authorize AIRTECH representative if you have any questions or concerns regarding disposing of pump oil.

7.1.3 OIL SPIN-ON FILTER

Airtech L12B/L21B Oil-Flooded Rotary Vane Pumps do not have an Oil Spin-On Filter.

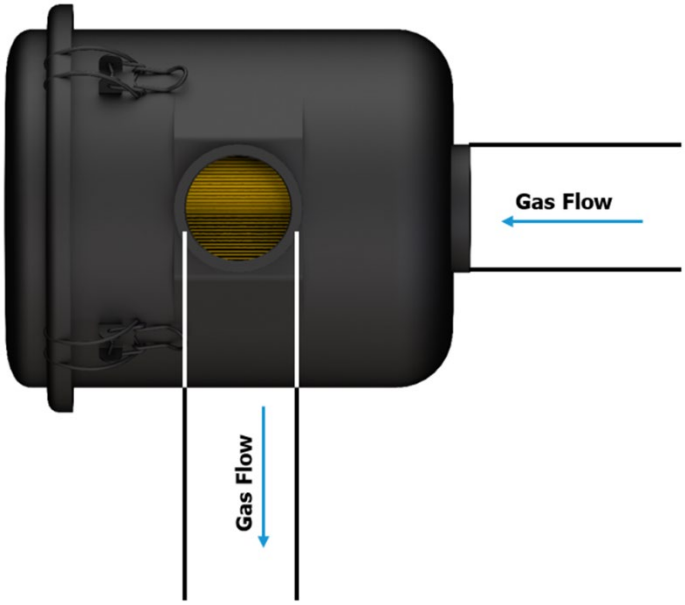
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7.2 INLINE (INLET) FILTER

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 pump when cleaning or replacing the element. Contact AIRTECH for inlet and inline filter recommendations for your application.



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7.3 EXHAUST FILTER

Exhaust filters must be replaced every 9-18monts or if any of the following symptoms have been observed:

- High back pressure (0.6 bar or above)
- Exhaust filters start producing smoke
- Rated motor current is exceeded

Item Name	Part Number	Catalog Number
L12B | L21B | L12 | L21 Exhaust Filter Kit	PN.600.00030	0040.490.00

NOTICE!

Do not clean or re-use exhaust filters. Filters must be disposed of in a proper way according to local and national environmental regulations as they might contain toxic substance carried over the process. Replace O-rings on filter when changing.

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7.4 MAINTENACE CHART

Table 7-1 details the recommended periodic maintenance schedule for the pump.

Table 7-1 Regular Maintenance Guide

Maintenance Intervals	Maintenance Actions
Daily	Visually check oil level and color.
Weekly	Inspect inline (inlet) filter and check for oil leaks.
Monthly	Check the exhaust filter's function.(if there is oil mist at exhaust, replace the exhaust filter and O-ring)
Every 750 Operating Hours	Drain and discard oil from the pump while warm. Refill with fresh oil.
Every 2000 Operating Hours	Replace exhaust filters and O-rings.
Every 500 ~ 2000 Operating Hours	Change the oil and oil filter. Check the float valve on the oil return line version.
For Motor	See the motor manufacture's manual for periodic motor maintenance.

AIRTECH TIP

The longevity of the pump is greatly improved if the oil condition is good, regularly refreshed, and the filters are maintained as described in this manual.

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7.5 KITS AND SPARE PARTS

Kits and parts that are available for maintenance and replacement that we offer:

Kit	Kit Contents	Part Number	Catalog Number	Pump Model
Gasket Kit	• Gaskets • O-rings • Shaft Seals	PN.305.00150	0040.490.00	L12 L21 L12B L21B
Exhaust Filter Kit	• Exhaust Filters • Oil Drain Plug • Exhaust Cover Gasket • Oil Spin-On Filter	PN.600.00025	0040.505.00	L12 L21 L12B L21B
Overhaul Kit	• Gasket Kit • Vanes • Bearings • Bearing Sleeves • Taper Pins • Oil Sight Glass • Pressure Gauge • Exhaust Valve Assembly • Rubber Feet • Oil Drain Plug	PN.601.00042	0040.500.00	L12 L21
		PN.601.00125	0040.500.01	L12B L21B
Combo Overhaul Kit	• Overhaul Kit • Exhaust Filter Kit	PN.601.00043	0040.509.00	L12 L21
		PN.601.00170	0040.509.01	L12B L21B
Inlet Check Valve Kit	• Inlet Flange, Lower Housing • Check Valve Plate • Check Valve Plate O-ring • Check Valve Spring • Inlet Part O-ring • Inlet Flange, Upper Housing • Inlet Screen • Allen Bolt • Spring Lock Washer	PN.600.00009	0020.550.00	L12B L21B

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Kit	Kit Contents	Part Number	Catalog Number	Pump Model
Exhaust Valve Assembly	• Exhaust Valve Fixed Bolt • Exhaust Valve Washer • Exhaust Valve Spring • Exhaust Valve Plate • Exhaust Valve Lock Nut • Exhaust Valve Seat Plate	PN.409.00054	0020.159.A0	L12B L21B
Coupling Set	• Pump Side Coupling • Motor Side Coupling • Coupling Sleeve	PN.210.00090	0040.310.B0	L12B L21B

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

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 pump. Only trained and qualified personnel should operate the pump.



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 pump while the pump is powered on or has an electrical connection to a power source.

If the troubleshooting guide does not resolve the issue with the pump, 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
Pump does not reach end pressure.	Oil condition.	Drain oil from pump and refill with fresh oil. Run the pump for 15 minutes and compare.	Operator
	Clogged inlet screen.	Clean screen and check inlet filter element.	
	Shaft seal leak.	Replace shaft seal from Overhaul Kit, or contact AIRTECH for further assistance.	Operator / Authorized Service Personnel
	Vane stuck in rotor slot	Fill the pump with flushing oil. Run the pump for 15 minutes and drain. Replace fluid with fresh oil, and apply Exhaust Filter kit.	Operator
		Replace vanes from Overhaul Kit or contact AIRTECH for further assistance.	Operator / Authorized Service Personnel
	Anti-suck back valve stuck in closed position due to contamination.	Disassemble valve and screen, clean as required. Drain old oil and replace with fresh oil.	
	No oil or low oil level in reservoir.	Shut down pump, drain balance of oil and refill with fresh oil.	Operator
	Vacuum fitting or hose is not leak tight.	Check hose and pipe connections for leaks.	
	Radial clearance between rotor and cylinder are no longer adequate.	Overhaul the pump or contact AIRTECH for further assistance.	Operator / Authorized Service Personnel
	Float Valve does not shut off correctly.	Check the condition of float valve, and adjust the nozzle position or repair it.	Operator
Pump runs very noisy.	Coupling insert is worn.	Replace coupling insert in motor/pump coupling	
	Bearing noise	Replace bearings or contact AIRTECH for further assistance.	Operator / Authorized Service Personnel
	Vanes stuck.	Fill the pump with flushing oil. Run the pump for 15 minutes and drain. Replace fluid with fresh oil, and apply Exhaust Filter kit.	Operator
		Replace vanes from Overhaul Kit or contact AIRTECH for further assistance.	Operator / Authorized Service Personnel

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Fault	Possible Cause	Remedy	Responsible Party
Pump starts, but labors and draws high amperage.	Oil is too viscous.	Drain and change with fresh oil using with recommended viscosity.	Operator
	Exhaust filter is clogged.	Replace exhaust filters and maintain proper oil condition.	
		Make sure inlet filter is operational and that it is preventing particulate carryover	
	Loose connection in motor terminal box or wired for wrong voltage.	Check wiring diagram for proper connections; tighten or replace loose connections.	Electrician
	Foreign particles in pump. Broken vanes or seized bearings.	Overhaul the pump or contact AIRTECH for further assistance.	Operator / Authorized Service Personnel
	Pump is overfilled with oil or wrong kind of oil.	Drain oil; use correct type of Vacuum pump oil.	Operator
	Pump runs in wrong direction.	Check for correct rotation. If incorrect, switch any two leads.	Electrician
Pump will not start.	Supply voltage is not proper or is overloaded. Motor starter overload settings are too low or improper; fuses are burned; wire size is too small or too long causing a voltage drop.	check voltage supply; overload settings in motor starter for size and settings according to motor nameplate. Install proper size wire. If ambient temperature is high, use the next larger size overloads or adjust settings 5% above motor nameplate valve.	
		turn pump fan by hand. If it will not turn, remove motor from pump and check motor and pump separately. Repair or replace if needed or contact AIRTECH for further assistance.	
	Oil temperature is below 12°C or oil is too viscous due to contamination.	Heat the pump and oil, or change the oil.	Operator

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Fault	Possible Cause	Remedy	Responsible Party
Pump smokes at the exhaust side or expels oil droplets from the exhaust	Exhaust filters are not properly installed with O-ring	Check exhaust filter condition and replace if needed.	Operator
	Filter media is damaged.		
	Exhaust filters are clogged with foreign particles.	Replace filter and O-ring.	
	Oil is not re-circulating properly.	Check oil quality and make certain oil lines are clean.	
	Pump is operating at a too shallow vacuum level.	Check for leaks. Contact AIRTECH for further assistance	Operator / Authorized Service Personnel
Pump is running too hot.	Not enough oil in the oil reservoir or oil is badly burned or carbonized.	Check upper part of oil sump (open the exhaust filter cover) if the oil has not been scavenged back into the pump, check that the float valve is not stuck or that the oil line is not blocked.	Operator
		Drain oil and refill with proper oil ; change oil more frequently.	
	Not enough air ventilation to pump.	Clean radiator and motor fins. Make sure that there is good ventilation.	
Pump will not operate (seized up).	Pump operated without oil and vanes broke.	Contact AIRTECH for further assistance.	Authorized Service Personnel
	Liquid carry over into pump cylinder broke vanes while pump was running.	Install knock-out pot at inlet of pump.	Operator

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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 pump while the pump is powered on or has an electrical connection to a power source.

1. Power off the pump and disconnect from all electrical connections against unintended start-up
2. Allow the pump to cool down
3. Ensure all pipes and lines are vented to atmospheric pressure
4. Disconnect piping and hoses
5. Dismount pump 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 pump, please contact AIRTECH for further assistance.

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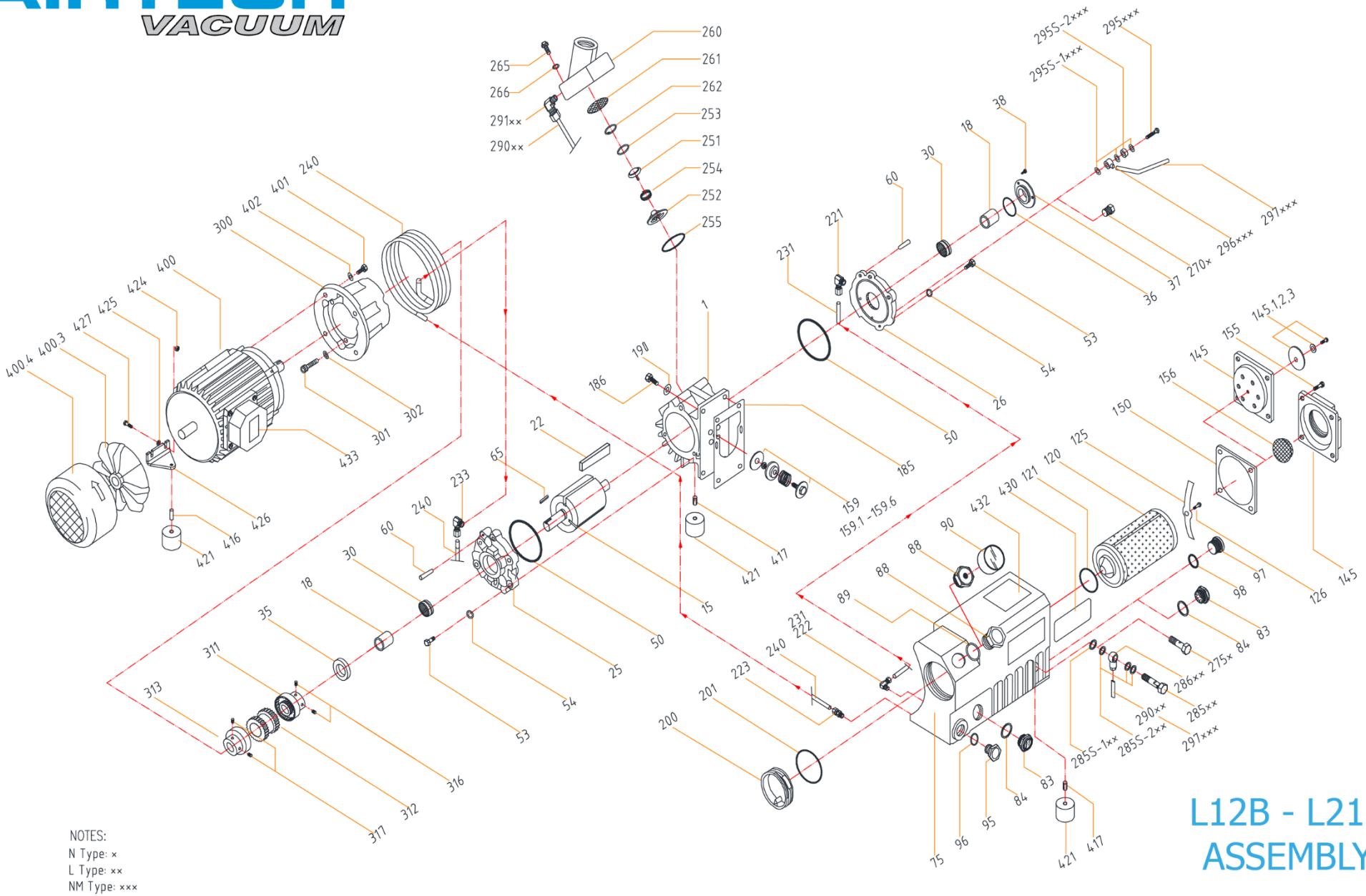
10 TECHNICAL DATA

MODEL			L12B*	L21B*
Displacement	CFM	60Hz	7	14
		50Hz	5	12
End- Vacuum	H Type	Torr	2.0	
NEMA Premium Motor (3Ph)	HP	60Hz/50Hz	0.75	1
Motor Voltage	V	60Hz	230/460	
		50Hz	190/380	
Revolution	RPM	60Hz	1750	3490
		50Hz	1430	2850
Noise	dB(A)	60Hz	59	62
		50Hz	57	60
Water Vapor	Tolerance	mbar	~	
	Capacity(L/Hr)	50/60Hz	~	
Operating Temp.	°F	50/60Hz	170.6	185
Oil Capacity	Qts	1.5		
Connections	G(BSP) or NPT	Intake	1-1/4‴	
		Exhaust	1-1/4‴	
Approx. Weight	Lbs (with motor)	44		

*Contact AIRTECH for motor starter versions and datasheet.

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AIRTECH® VACUUM



NOTES:
N Type: ×
L Type: ××
NM Type: ×××

L12B - L21B ASSEMBLY

AIRTECH® VACUUM

L12B/L21B

Pos. No.	Description	Qty	Pos. No.	Description	Qty	Pos. No.	Description	Qty
1	Cylinder	1	155	Allen Bolt	4	285**/***	Oil Recirculation Screw (For L/NM)	1
15	Rotor	1	156	Outlet Screen	1	285S-1**/***	Sealing Ring (For L /NM) For 285**	1
18	Sleeve, Bearing	2	159	Exhaust Valve Ass`Y (159-1 ~ 159-6)	1	285S-2**/***	Sealing Ring (For L /Nm) For 285**	3
22	Vane	3	159-1	Exhaust Valve Fixed Bolt	1	286**/***	Banjo Fitting (For L /Nm) In Oil Sump	1
25	A-End Plate	1	159-2	Exhaust Valve Washer	1	290**	Oil Return Tube (For L Only)	1
26	B-End Plate	1	159-3	Exhaust Valve Spring	1	291**	Elbow Hydraulic Fitting (For L Only)	1
30	Bearing	2	159-4	Exhaust Valve Plate	1	295S-2***	Sealing Ring(For NM) For 295**	1
35	Shaft Seal	1	159-5	Exhaust Valve Lock Nut	1	295S-1***	Sealing Ring(For NM) For 295**	3
36	O-Ring, Bracket	1	159-6	Exhaust Valve Seat Plate	1	295***	Sealing Ring (For N Only) For 275*	1
37	Bracket	1	185	Gasket, Cylinder	1	296***	Banjo Fitting (For Nm Only) In End Plate	1
38	Hexagon Head Screw	3	186	Allen Bolt	4	297***	Oil Return Tube (For NM Only)	1
50	O-Ring, End Plate	2	190	Spring Lock Washer	4	300	Motor Mounting Bracket	1
53	Hexagon Head Screw	6	200	Plug, Drum	1	301	Allen Bolt	3
54	Spring Lock Washer	6	201	O-Ring, Drum Plug	1	302	Spring Lock Washer	3
60	Taper Pin	4	221	Elbow Hydraulic Fitting	1	311	Coupling, Pump Side	1
65	Shaft Key	1	222	Elbow Hydraulic Fitting	1	312	Coupling Insert (Spider)	1
75	Oil Sump	1	223	Straight Hydraulic Fitting	1	313	Coupling Motor Side	1
83	Oil Sight Glass	1	231	Oil Tube (B)	1	316	Set Screw (Pump Side)	2
84	Gasket, Oil Sight Glass	1	233	Elbow Hydraulic Fitting	1	317	Set Screw (Motor Side)	2
88	Plug, Oil Fill	1	240	Cooling Spiral	1	400	Motor (NEMA)	1
89	O-Ring, Oil Fill Plug (Al Type W/ Gage)	1	251	Check Valve Plate	1	400.3	Motor Fan Blade	1
90	Pressure Gage	1	252	Check Valve Guide	1	400.4	Motor Fan Cover	1
95	Plug, Oil Drain (Plastic Type)	1	253	O-Ring, Check Valve Plate	1	401	Hexagon Head Screw	4
96	O-Ring, Oil Drain Plug	1	254	Check Valve Spring	1	402	Spring Lock Washer	4
120	Exhaust Filter	1	255	O-Ring, Inlet Part	1	416	Slotted Set Screw	1
121	O-Ring, Exhaust Filter	1	260	Inlet Flange, L Type	1	417	Slotted Set Screw	2
125	Exh. Filter Spring Assembly	1	260	Inlet Flange , Nm Type	1	419	Sleeve, Bearing	1
126	Slotted Cheese Head Screw	1	261	Inlet Screen	1	421	Rubber Foot	5
145	Exhaust Cover (W/ Rubber Flap)	1	262	Retaining Ring For Bores	1	424	Rubber Foot Support	1
145	Exhaust Cover (W/ Threaded Flange)	1	265	Hexagon Head Screw	4	425	Rubber Foot Support	1
145-1	Rubber Flap For 02145	2	266	Spring Lock Washer	4	426	Bracket For Rubber Foot	1
145-2	Washer For 02145	1	270*	Plug (For N Only)	1	427	Allen Bolt	2
145-3	Slotted Cheese Head Screw For 02145	1	275*	Oil Return Valve (For N Only)	1	433	Terminal Board (NEMA)	1
150	Gasket, Exhaust Over	1	275S*	Sealing Ring (For N Only) For 275*	1			

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AIRTECH® VACUUM

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