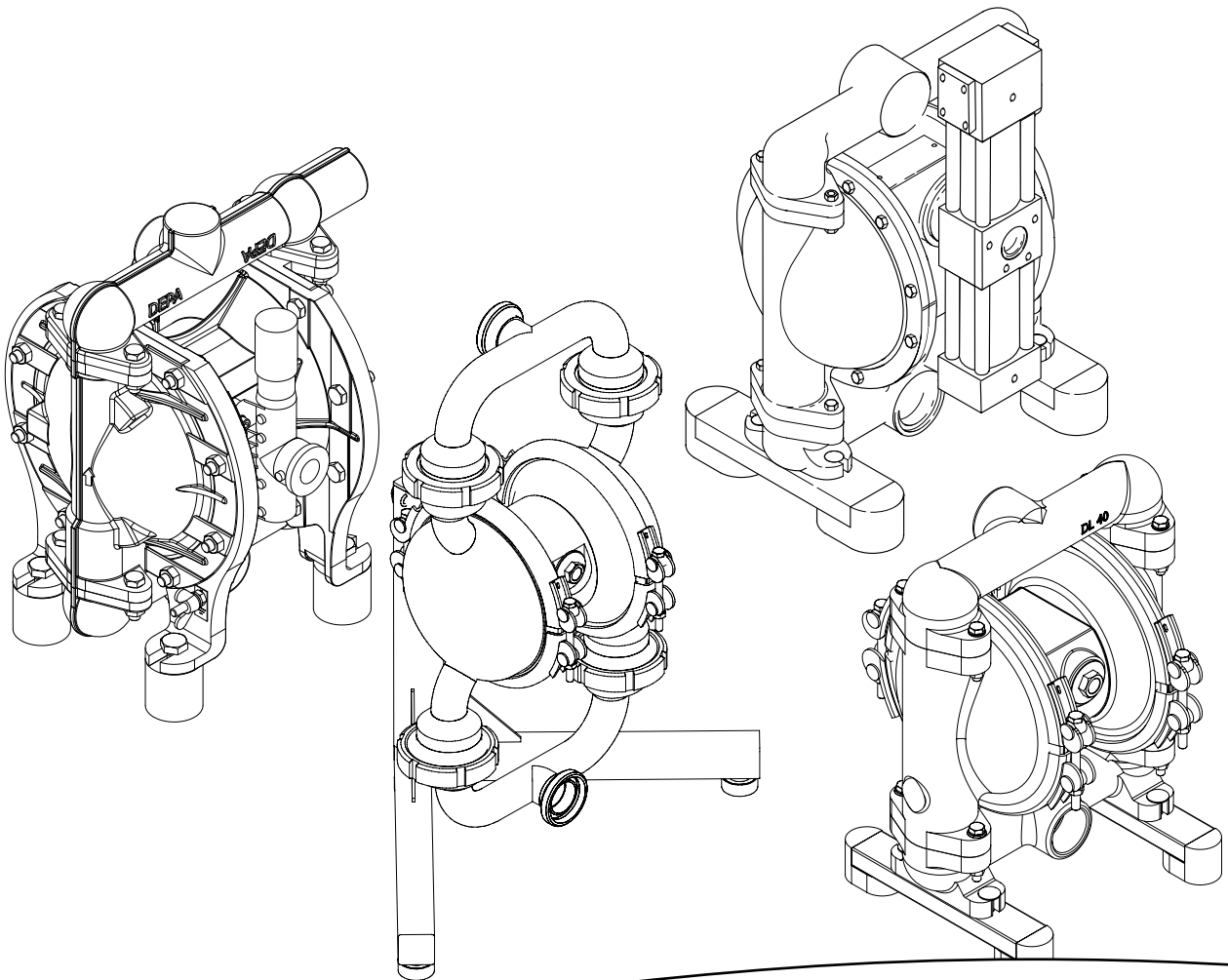


DEPA[®]

BA-DL-GB/10.20

Air Operated Diaphragm Pumps

Operating and
Installation Instructions
Installation, Operation
and Maintenance



CRANE[®]

www.depapumps.com
www.cranecpe.com



EC Declaration of Conformity

in compliance with the Machinery Directive 2006/42/EC

We hereby declare, that the pump units manufactured in series production

Designation: DEPA Air Operated Diaphragm Pumps
DEPA Active Pulsation Dampers

Series: DL, DH, DF, DZ, DB

Manufacturer: Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf, www.depapumps.com

Serial number: see identification plate

in the version delivered by us, is in compliance with the following applicable regulations:

EC Directive: Machinery Directive 2006/42/EC

Harmonized standards: DIN EN 809:2012-10
DIN EN ISO 12100:2011-03

Mr. Ralf Rennwanz is authorized to compile the technical documents.

Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf

Place, date Düsseldorf, 08/07/2015

Signature of manufacturer:

Information on signatory: Hans-Dieter Ptak, Managing Director

**This are the translations of the original declarations of conformity
for DEPA Air Operated Diaphragm Pumps.**



EC Declaration of Conformity

in compliance with the machine directive
2006/42/EC

We hereby declare, that the pump units manufactured in series production for the pneumatic conveyance of bulk material

Description: DEPA Air Operated Diaphragm Pumps
Series: DP
Manufacturer: Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf, www.depapumps.com
Serial number: see identification plate

in the version delivered by us, is in compliance with the following applicable regulations:

EC Directive: Machinery Directive 2006/42/EC
Harmonised standards: DIN EN 741:2011-6
DIN EN ISO 12100:2011-03

Mr. Ralf Rennwanz is authorised to compile the technical documents.

Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf

Place, date: Düsseldorf, Germany, 24/07/2019

Signature of manufacturer:

Information on signatory: Hans-Dieter Ptak, Managing Director



EC Declaration of Conformity

in compliance with the machine directive
2006/42/EC

We hereby declare, that the pump units manufactured in series production

Description: DEPA air operated diaphragm pumps
DEPA active pulsation dampeners

Series: DL, DH, DF, DZ, DB

Manufacturer: Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf, www.depapumps.com

Serial number: see identification plate

in the version delivered by us, comply with the following applicable regulations:

EC Directive: Machinery Directive 2006/42/EC

Harmonised standards: DIN EN 809:2012-10
DIN EN ISO 12100:2011-03

Mr. Ralf Rennwanz is authorised to compile the technical documents.

Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf

Place, date: Düsseldorf, Germany, 02/11/2020

Signature of manufacturer:

Information on signatory:

Hans-Dieter Ptak, Managing Director

Declaration of Incorporation

for partly completed machinery
according to the machinery directive 2006/42/EC

The manufacturer Crane Process Flow Technologies GmbH,
Heerdter Lohweg 63-71, 40549 Düsseldorf, www.depapumps.com

declares that with the series production pulsation dampers

Designation: DEPA compressed air diaphragm pumps without air control

Series: DJ/DH*, PD, PH
* DHxx-FA in custom design with control block
for external air control.

Serial number: see identification plate

the following basic requirements as specified in annex I of the above directive have been applied and complied with:

General principles No. 1

Nr. 1.1, 1.3, 1.5, 1.6; 1.7, 2.1, 3.4, 3.6, 4.1 und 4.2

Commissioning is prohibited until it has been determined that the machine into which the above specified machine shall be incorporated meets the machinery directive 2006/42/EC.

Pay attention to the installation instructions in Chapter 3 and 7.2 of these operating instructions.

The special technical documents were prepared in compliance with annex VII part B of the directive. The previously mentioned special technical documents will be made available to the competent authority by mail, if this should be necessary.

EC directive: Machinery directive 2006/42/EC

Harmonized standards: DIN EN ISO 12100:2011-03,
DIN EN 809:2012-10

Mr. Ralf Rennwanz is authorized to compile the technical documents.

Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf

Place / date: Düsseldorf, 08/07/2015

Signature of manufacturer:



Information on signatory: Hans-Dieter Ptak, Managing Director



EU Declaration of conformity

Complies with the terms of Directive 2014/34/EU for equipment authorised for use in potentially explosive environments

The manufacturer: Crane Process Flow Technologies GmbH,
Heerdter Lohweg 63-71
D-40549 Düsseldorf, www.depapumps.com

declares that the pump units manufactured in series production

Description: DEPA Air Operated Diaphragm Pumps and DEPA Active Pulsation Dampeners

Series: DL, DH, DF, DZ, DJ, DP, DBX and PD, PH

Pump size: 15, 25, 40, 50, 80

Casing material: FA, FS, CA, CX, PL, TL, TPL,
SA, SS, SF, SFS, HS, SLV, SUV, UEV

Diaphragm materials: DEPA Nopped E4®, EPDM, NBR, NRS, EPDM grey, FKM**,
PTFE compound diaphragm as well as PTFE and S4 versions***
** not for sizes 50 and 80, ***not for size 80

Valve seat materials: EPDM, NBR, PTFE, NRS, 316L, FKM, EPDM grey

Valve ball materials: with and without steel core, EPDM, NBR, PTFE, NRS, FKM, EPDM-
grey as well as 316L and ceramic

Accessories: Needle valve, fluidisation system, high-performance silencer, ball
lifter, suction lance, suction and pressure hose, external valve M
series

Installed electrical components: Specific manufacturer's declarations of conformity are supplied with
all of the electrical units

in the design delivered by us, are in compliance with the following applicable regulations:

EU Directive: Directive 2014/34/EU for equipment authorised for use in potentially
explosive environments.

Assessment method: Equipment group II, category 2GD, explosion group IIB, equipment
protection level (EPL) GbDb

Harmonised standards: DIN EN 1127-1:2011-10
DIN EN ISO 80079-36:2016-12
DIN EN ISO 80079-37:2016-12

Place / date: Düsseldorf, Germany, 18.12.2019

Signature of manufacturer:

Information on signatory: Hans-Dieter Ptak, Managing Director



EU Declaration of conformity

Complies with the terms of Directive 2014/34/EU for equipment authorised for use in potentially explosive environments

The manufacturer: Crane Process Flow Technologies GmbH,
Heerdter Lohweg 63-71
D-40549 Düsseldorf, www.depapumps.com

declares that the pump units manufactured in series production

Description: DEPA air operated diaphragm pumps* and DEPA active pulsation dampeners * with internal air valve or external M-control valve

Series: DL, DH, DF, DZ, DJ, DP

Pump size: 15, 25, 40, 50, 80

Casing material: CX, SX, PL, TL, TPL, SS, SFS, HS

Diaphragm materials: DEPA Nopped E4®, EPDM, NBR, NRS, EPDM grey, FKM**, PTFE compound diaphragm as well as PTFE and S4 versions***
** not for sizes 50 and 80, ***not for size 80

Valve ball materials: EPDM, NBR, PTFE, NRS, 316L, FKM, EPDM grey

Accessories: Needle valve, fluidisation system, high-performance silencer, ball lifter, suction lance, suction and pressure hose.

Installed electrical components: Specific manufacturer's declarations of conformity are supplied with all of the electrical units

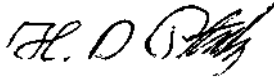
in the design delivered by us, are in compliance with the following applicable regulations:

EU Directive: Directive 2014/34/EU for equipment authorised for use in potentially explosive environments.

Assessment method: Equipment group I, category M2, explosion group IIB, equipment protection level (EPL) Mb

Harmonised standards: DIN EN 1127-1:2011-10
DIN EN ISO 80079-36:2016-12
DIN EN ISO 80079-37:2016-12

Place / date: Düsseldorf, 06.12.2019

Signature of manufacturer: 

Information on signatory: Hans-Dieter Ptak, Managing Director



ATEX  II 1G Ex h IIB T6...T4 Ga

EU Declaration of Conformity

in accordance with directive 2014/34/EU for equipment intended for use
in potentially explosive atmospheres

The manufacturer Crane Process Flow Technologies GmbH,
Heerdter Lohweg 63-71,
40549 Düsseldorf, www.depapumps.com

declares that the pump units manufactured in series production

Description: DEPA Air Operated Diaphragm Pumps
Series: DH
Sizes: 15, 25, 40, 50, 80
Casing material: SS
Diaphragm materials: DEPA nopped E4® EPDM, NBR, PTFE compound diaphragm,
electro-conductive / electrically dissipative
Supplementary operating manuals: DEPA air operated diaphragm pumps
BA-DL-GB/01.20a

in the design supplied by us, are in compliance with the following applicable regulations:

EU Directive: Directive 2014/34/EU for equipment intended for use in poten-
tially explosive environments

Conformity assessment: Pump and accessories:
Equipment group II, category 1G,
explosion group IIB T6...T4, Device protection level (EPL) Ga

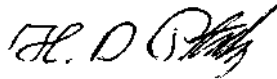
Installed electrical components: Specific manufacturer's declarations of conformity are supplied
with all of the electrical units

EC type examination: Physikalisch-Technische Bundesanstalt in Braunschweig

PTB 18 ATEX 5007 X Issue 3
DIN EN ISO 80079-36:2016-12

Nominated body TÜV Nord Cert GmbH
Quality assurance: Langemarkstr. 20, 45141 Essen,
ID No. 0044

Place / date: Düsseldorf, Germany, 01.04.2020

Signature of manufacturer: 

Information about the signatory: Hans-Dieter Ptak, Managing Director



EU Declaration of conformity

complies with the terms of Directive 2014/34/EU for equipment authorised for use in potentially explosive environments

The manufacturer: Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf, www.depapumps.com

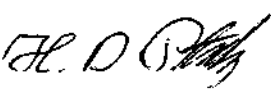
declares that the pump units manufactured in series production

- Description:** DEPA Air Operated Diaphragm Pumps
- Series:** DL, DH
- Pump size:** 15, 25, 40, 50, 80
- Casing material:** FA, FA, CA, CX, PL, TL, TPL, SA, SS, SF, SFS, SLV, SUV, UEV
- Diaphragm materials:** DEPA Nopped E4®, EPDM, NBR, NRS**, PTFE compound diaphragm, electro-conductive
** not for sizes 50 and 80
- Valve seat materials:** EPDM, NBR, PTFE, 304, 316L
- Valve ball materials:** with and without steel core, EPDM, NBR, PTFE*
* not for sizes 50 and 80
- Accessories:** Ball lifter
- Installed electrical components:** Specific manufacturer's declarations of conformity are supplied with all of the electrical units

in the version delivered by us, is in compliance with the following applicable regulations:

- EU Directive:** Directive 2014/34/EU for equipment authorised for use in potentially explosive environments.
- Assessment method:** Equipment group II, category 2GD, explosion group IIC, equipment protection level (EPL) GbDb
- Harmonised standards:** DIN EN 1127-1:2011-10
DIN EN ISO 80079-36:2016-12
DIN EN ISO 80079-37:2016-12

Place / date: Düsseldorf, Germany, 06.12.2019

Signature of manufacturer: 

Information on signatory: Hans-Dieter Ptak, Managing Director



EU-Declaration of Conformity

In accordance with directive 2014/34/EU for equipment intended for use in potentially explosive atmospheres

The manufacturer: Crane Process Flow Technologies GmbH
Heerdter Lohweg 63-71
40549 Düsseldorf, www.depapumps.com

declares that the pump units manufactured in series production

Description: DEPA air operated diaphragm pumps with external pressure booster

Series: DB

Pump size: 25, 40, 50

Casing material: ESA, FSA

Diaphragm materials: DEPA Nopped E4®, Closed Surface Diaphragms EPDM, NBR, NRS, FKM* and PTFE compound diaphragm
** not for sizes 50 and 80

Valve seat materials: EPDM, NBR, NRS, FKM, PTFE, 316L

Valve ball materials: with and without steel core in EPDM, NBR, NRS, FKM, PTFE and 316L

Accessories: Needle valve, high-performance silencer

Installed electrical components: Specific manufacturer's declarations of conformity are supplied with all of the electrical units

in the version delivered by us, comply with the following applicable regulations:

EU Directive: Directive 2014/34/EU for equipment authorised for use in potentially explosive environments.

Assessment method: Equipment group II, category 2G, explosion group IIB, equipment protection level (EPL) Gb

Harmonised standards: DIN EN 1127-1:2011-10
DIN EN ISO 80079-36:2016-12
DIN EN ISO 80079-37:2016-12

Place / date: Düsseldorf, Germany, 01/11/2020

Signature of manufacturer: 

Information on signatory: Hans-Dieter Ptak, Managing Director



EC Declaration of conformity

In accordance with EC regulation No. 1935/2004 on materials and articles intended to come into contact with food, as well as EU regulation No. 10/2011 on plastic materials and articles intended to come into contact with food.

The manufacturer Crane Process Flow Technologies GmbH,
Heerdter Lohweg 63-71,
40549 Düsseldorf, www.depapumps.com

declares that the pump units manufactured in series production

Designation: DEPA – Air Operated Diaphragm Pumps and DEPA Pulsation Dampeners
Types: DL..SLV, DL..SUV, DL..UEV, DL..SF/SFS, DH..UEV
PD..SL, PD..SU, PD..UE, PH..UE
Sizes: 15, 25, 40, 50, 80
Casing material: Stainless steel: 316L/1.4404, 304/1.4301
Diaphragm materials: PTFE, EPDM grey and DEPA® Closed Surface diaphragms series nopped E4® PTFE-compound and EPDM-grey
Valve ball materials: PTFE, stainless steel: 316L/1.4404, EPDM grey
Valve seats: PTFE, stainless steel: 316L/1.4404, 304/1.4301, EPDM grey
O-rings: FKM/FEP coated

in the design delivered by us, are in compliance with the following applicable regulations:

EU Regulations: VO 2023/2006 und VO 10/2011 and Reg. 1935/2004

and, in addition, are free from **bisphenol-A** and **phthalates**, FCM substance Nos. 151 and 283.

Harmonised standards: DIN EN 1672-2:2009

Other applied standards and international directives: BfR Recommendation XXI (Category 3)
FDA21 CFR 177.2600 (rubber articles)
FDA21 CFR 177.1550 (perflourcarbon resins)

The plastic and elastomer articles or objects listed here are suitable for multiple contact with all food categories.

The maximum permitted operating temperatures of the respective materials according to the operating instructions must not be exceeded.

Mr. Ralf Rennwanz is authorised to compile the technical documents.

Place, date: Düsseldorf, 14/04/2019

Signature of manufacturer:

A handwritten signature in black ink, appearing to read 'H. D. Ptak'.

Information about signatory: Hans-Dieter Ptak, Managing Director



EC Declaration of conformity

In accordance with EC regulation No. 1935/2004 on materials and articles intended to come into contact with food, as well as EU regulation No. 10/2011 on plastic materials and articles intended to come into contact with food.

The manufacturer Crane Process Flow Technologies GmbH,
Heerdter Lohweg 63-71,
40549 Düsseldorf, www.depapumps.com

declares that the pump units manufactured in series production

Description: DEPA air operated diaphragm pumps
Types: DH..TP- and DH..TPL
Sizes: 15, 25, 40, 50
Casing material: PTFE, PTFE conductive
Diaphragm materials: DEPA Nopped E4® Closed Surface PTFE compound diaphragm
Valve ball materials: PTFE
O-rings: FKM/FEP coated

in the design delivered by us, are in compliance with the following applicable regulations:

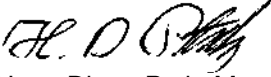
EU Regulations: Regulation 1935/2004 and Regulation 2023/2006 and Regulation 10/2011

and, in addition, are free from **bisphenol-A** and **phthalates**, FCM substance nos. 151 and 283

Harmonised standards: DIN EN 1672-2:2009
and international guidelines: FDA21 CFR 177.1550 (Perfluorocarbon Resins)

The plastic and elastomer articles or objects listed here are suitable for multiple contact with all food categories.

The maximum permitted operating temperatures of the respective materials according to the operating instructions must not be exceeded.

Place, date: Düsseldorf, 18/12/2019
Signature of manufacturer: 
Information on signatory: Hans-Dieter Ptak, Managing Director

DEPA® Air Operated Diaphragm Pumps

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1.0 Introduction

The following instructions solely refer to DEPA Air Operated Diaphragm Pumps. Since the pumps are used in combination with other assemblies, such as solenoid valves, sensors or pulsation dampers, the valid operating instructions for these components and the associated notes on safety must also be taken into account.

These instructions contain information on safety, installation, operation, maintenance, repair and environmental waste disposal of the DEPA Air Operated Diaphragm Pump. Thoroughly read these instructions before use and always follow the information contained therein.

Persons entrusted with the installation, operation, maintenance or repair of the pump must have read and understood these instructions, especially the chapter on “Health and Safety”. This applies in particular for those who are only occasionally involved in work on the pump, like cleaning or service personnel.

Each pump is subjected to stringent inspections and function tests before leaving the factory.

You should always bear in mind that a correct function, a long lifetime and optimal operational reliability of the pump mainly depend on

- correct installation
- correct commissioning
- and correctly performed maintenance and repair work.

Enquiries concerning service, spare parts or repairs should be addressed to the manufacturer or an authorized dealer.

Always provide the following information:

- Series
- Pump size
- Serial number of pump

This information is stamped on the identification plate on top of the pump.



Danger!

When returning pumps or pump parts to your supplier for repair or general overhaul, the delivery must be accompanied by certificates stating that pumps or pump parts are free of product and other aggressive or hazardous substances.

1.1 Warranty

The correct function of each DEPA Air Operated Diaphragm Pump is tested in the factory. The manufacturer or authorized dealer assumes warranty for the product as specified in the effective terms of sales and delivery. Faults resulting from the non-compliance with the aforementioned regulations and notes can only be rectified at the cost of the customer.

1.2 Transport, unpacking, storage

In order to avoid any problems you should

- check the delivered goods against the delivery note for completeness and correctness,.



Danger!

Consider the weight specified in paragraph 9.1 before attempting to lift the pump. Use only lifting gear of appropriate capacity. Do not step or stand under suspended loads.

- Fasten the lifting tackle so that the pump can be safely lifted.
- For pumps DH40-TP/TPL please use the corresponding lifting eye. For pumps DH50-TP/TPL please use the available notches.



Danger!
In order to avoid slipping of the sling the rope must be crossed over at the hook (Fig. 1).

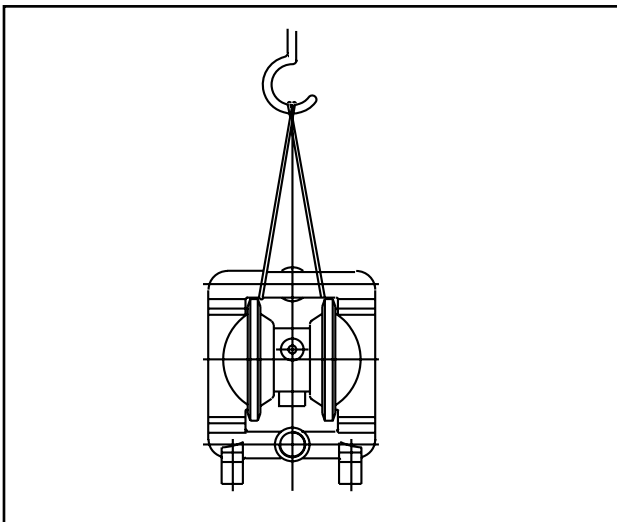


Fig. 1: Transport of pump

Be careful when unpacking the pump and proceed as follows:

- Check the packaging material for transport damage.
- Take the pump carefully out of the packaging material.
- Check the pump for visual damage.
- Remove the plugs from all pump ports.
- Check seals and fluid lines for damage.

The following points must be strictly observed when preparing the pump for storage:

- Store the pump in a dry place.
- Thoroughly clean used pumps before storage.
- Do not subject stored pumps to extreme temperature fluctuations.

1.3 Principle of function

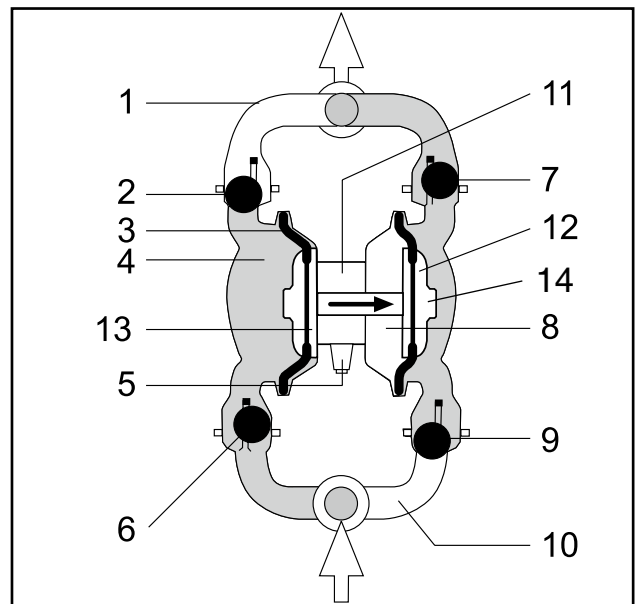


Fig. 2: Design of pump

- 1 Discharge manifold
- 2 Top valve ball (closed during suction)
- 3 Diaphragm
- 4 Pump chamber
- 5 Silencer
- 6 Bottom valve ball (opened. Medium flows into chamber)
- 7 Top valve ball (open. Product is pressed out)
- 8 Air chamber (the drive air displaces the medium via the diaphragm and at the same time pulls back the second diaphragm)
- 9 Bottom valve ball (closed during delivery)
- 10 Suction socket
- 11 Air control unit
- 12 Outer piston
- 13 Inner piston
- 14 Diaphragm, in the case of nopped E4® without outer diaphragm plate

DEPA® Air Operated Diaphragm Pumps

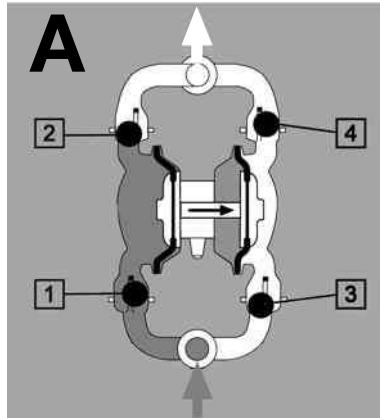
1.3.1 Functionality

DEPA Air Operated Diaphragm Pumps are oscillating positive displacement pumps with two pump chambers arranged opposite each other. Both of these are separated by a diaphragm each into an air and a fluid section.

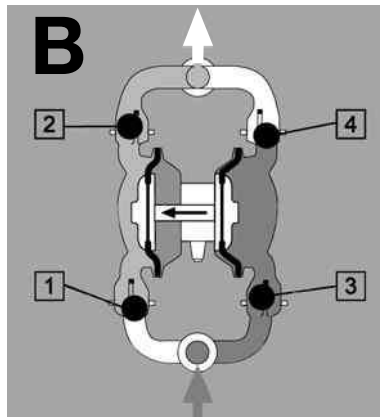
Both diaphragms are linked by a piston rod, so that with every stroke product is displaced to the outside from the one pump chamber and product is drawn into the opposite pump chamber.

The four drawings opposite describe the sequence of a complete cycle consisting of a suction and pressure stroke, an empty and a filled pump chamber.

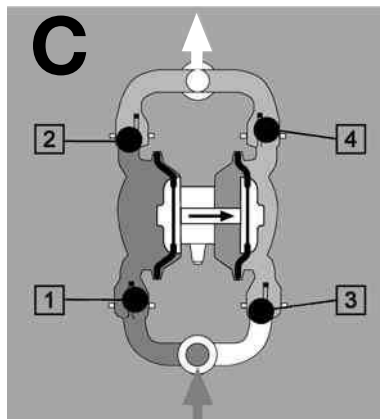
In order to explain the function the product to be pumped was highlighted in colour.



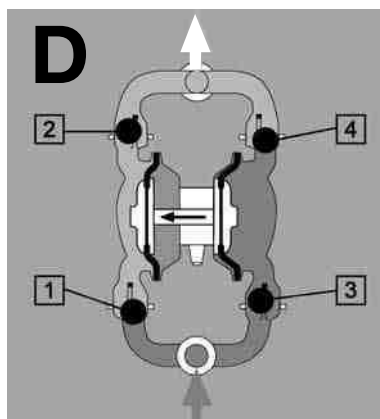
By filling the right hand air chamber (dark grey) the right hand diaphragm is pressed towards the outside. The piston rod thereby pulls the left hand diaphragm to initial position. Valve ball (1) is pulled out of its position, product (grey) flows into the left hand pump chamber. At the same time valve ball (2) is fixed in end position by the vacuum. The left hand pump chamber is thus completely filled with product (grey).



After switching of the control valve air flows into the left hand air chamber (dark grey), the right hand air chamber is vented. The suction process (see A) now takes place in the right hand pump chamber. Product (dark grey) is drawn in, product (light grey) in the left hand pump chamber is displaced to the outside. Valve ball (1) presses down, closes and valve ball (2) opens the flow path for product to the pressure outlet port.



The suction process "A" is repeated with the only difference, that the right hand pump chamber is already filled with product (light grey). By switching of the control valve the right hand air chamber (dark grey) is filled, product (red) is drawn into the left hand pump chamber and the product from the right hand pump chamber (light grey) is displaced.



This sequence is repeated in reverse order as shown under C. The left hand air chamber (dark grey) fills up, vacuum draws product (dark grey) into the right hand pump chamber, while product (green) from the left hand pump chamber is displaced through the pressure port.

1.4 Technical data

1.4.1 Dimensions, weights and temperatures

See corresponding data sheet.



Danger!
For correct selection of the lifting gear you should multiply the specified weight with factor 1.5.

See table in 9.1..

In case of short-term exceeding the max. permanent operating temperature you should consult the manufacturer. When using PP control blocks the max. ambient temperature is 60° C.

When the pump is operated at higher temperatures, diaphragm service life is likely to be reduced.



Warning! For operation with auxiliary heating you should observe the temperature limit.

1.4.2 Control air

Max operating pressure see table 2.

DEPA pumps are dimensioned as machines in accordance with chapter 1, article 1, section 2, paragraph (j), point (ii) of the Pressure Equipment Directive and are therefore not pressure equipment as defined by the EC Pressure Equipment Directive 2014/68/EU.

1.4.3 Air quality

Only air or inert gases of class 5 acc. to DIN ISO 8573-1 may be used as control air. (Class 5 corresponds with a max. particle size of 40µm; max. particle density 10mg/m³; max. pressure dew point +7°C; max. oil concentration 25 mg/m³).

Operating the pump with dry, non-lubricated and solids free compressed air prolongs the lifetime of the air control unit.

Note: When using gases other than compressed air, there is a risk of suffocation.



Warning!
Highly oil containing control air causes soiling of the control valve and swelling of the O-rings.

1.4.4 Particle sizes, suction heads

In order to ensure correct functioning of the pump the maximum product particle sizes listed in the following table must not be exceeded.

Table 1: Particle sizes and suction lifts

	Pump sizes				
	15	25	40	50	80
Particle size (mm)					
Standard	3,5	4	6	8	10
DL-PM	2,5	4	6	-	-
SL/SU/UE - DH-FA/SA/SS	3,5	10	16	18	25
DH-PT/-TL	3,5	6,5	8	-	-
DH-TP/TPL	3,5	10	12	12	-
max. suction head [mWs]					
Standard dry *)	3,5	5,5	5,8	5,8	6
Standard filled with product	8,5	9	9	9	9
DL-PM	2,5	5,5	5,5	-	-
DH-PT/-TL dry *)	2	2	2	-	-
DH-PT/-TL filled with product	9	9	9	-	-
DH-TP/-TPL dry	1	3	3	5	-

**Values are reduced when using PTFE diaphragms, seats and balls.*

DEPA® Air Operated Diaphragm Pumps

Table 2: Temperature range of housing material and max operating pressure

	Description	Pump Type Code	Min	Max	Max Operating Pressure
Metal	Aluminium	FA	Temperature range is determined by the diaphragm, valve seat and ball combinations		7 (4****)
	Stainless Steel	SA			8,6 *
		SS			8,6 *
		SX			7
	Nodular Cast Iron	CA			7
		CX			7
		CS			7
	Hastelloy	HS			7
Non-Metal	Polypropylene	PP	0	60	7
		PM	0	60	7
		PL	0	60	7 **
	PTFE	TP	-20	100	7
		TPL	-20	100	7
	PTFE	PT	-20	100	7
		TL	-20	100	7 **
	PVDF	PV	-12	80	7
Polished Stainless Steel	Stainless Steel	SLV	Temperature range is determined by the diaphragm, valve seat and ball combinations		7 ***
		SUV			7 ***
		UEV			7 ***
		SF			7
		SFS			7

* Maximum operating pressure for DHxx-SA and DHxx-SS version is 8.6 bar, DBxx-SA version is upto 21 bar, all other variants 7 bar

** Maximum operating pressure for DL50-PL and DL50-TL version is 5 bar

*** Maximum operating pressure for SLV, SUV and UEV pumps in combination with EPDM grey valve balls is 5 bar

**** Maximum operating pressure for DP125-FA

Table 3: Temperatur-Range for Interiors

Material	Code	Min (°C)	Max (°C)	Diaphragm	V.seat	V.balls
NRS	B	-15	70	●	●	●
NRR	L	-30	85	●	-	-
NBR	N	-15	90	●	●	●
EPDM	E	-25	105	●	●	●
EPDM Grey	G	-25	90	●	●	●
FKM (Viton®)	F	-5	120	●	●	●
PTFE	T	-20	100	●	●	●
nopped E4® PTFE compound	Z	-10	130	●	-	-
DEPA® Nopped S4 ****	S	-20	110	●	-	-
NRS with core	V	-15	70	-	-	●
EPDM with core	W	-25	105	-	-	●
EPDM Grey with core	X	-25	90	-	-	●
NBR with core	Y	-15	90	-	-	●
PTFE with core	Z	-20	100	-	-	●
Stainless Steel	R	****	****	-	●	●
Stainless Steel (DB)	H	****	****	-	●	-
EPDM Grey (DH Polished Stainless Steel Pumps)	U	-25	90	●	-	-
PTFE (DH Polished Stainless Steel Pumps)	P	-20	100	●	-	-

**** Lifetime of the diaphragm reduces with increased temperature (i.e. at 50 oC the lifetime can be reduced by upto 50% depending on fluid, application and discharge pressure)

***** Temperature range is determined by the diaphragm or valve seat or valva ball combination

2.0 Safety

2.1 General information

These instructions were written for the operator and the maintenance and repair personnel. A well founded technical education and technical understanding is a major prerequisite. Persons lacking qualification have no permission to install, operate, service or repair the pump.

Installation, operation, maintenance and repair of the pump must in any case comply with the applicable national safety regulations and accident prevention instructions.

The following precautions must be applied before performing maintenance work.

If the product to be pumped is a hazardous or noxious substance, the system must be neutralized and vented. For this purpose the pump must strictly depressurized.

When cleaning the pump or its components you must make sure that all necessary precautions are in place.

Incorrectly installed, inattentively operated or insufficiently serviced pumps always are sources of potential dangers. The negligence of safety measures can cause severe personal injury or damage to the pump and connected units.

On pumps with protective covering and guards these must be properly assembled again before restarting.

In case of deficiencies adversely affecting the safety the pump must be shut down immediately and reliably secured against being switched on again. Only restart operation of the pump after all deficiencies have been rectified.

2.2 Danger sources

The pump works with pneumatic and hydraulic energies, which may be under high pressure.

Depending on its equipment, the pump may also work with electric energy.

Always relieve any pressure from the pump before starting work in the pneumatic or hydraulic system.

Always de-energize the pump before starting work in the electrical system.

Do not change any pressure settings to values higher than the ones specified in these instructions.

Safety facilities should not be removed or made ineffective.

2.3 Permitted operators

The pump must only be operated, serviced and repaired by authorised and trained persons. Persons under the influence of alcohol, medicine or drugs are not permitted to install, operate, service or repair this pump.

2.4 Intended use

The air operated diaphragm pump is a working machine specially designed for the transport of aggressive, abrasive and viscous fluids. Any other use is unintended and causes the immediate loss of warranty.

2.5 Unintended use

The operating safety and reliability of the pump can only be assured if it is used for the purpose it is intended for. The limits mentioned in the corresponding technical data sheets must not be exceeded under any circumstances.

2.6 Conversions and alterations to the pump

Conversions and alterations to the pump are strictly prohibited. Safety installations must not be made ineffective or changed or used in a way contradicting their purpose.

2.7 Symbols

The following symbols are used to highlight dangers and particular operating situations.



Danger!
warns of possible bodily injury or danger to life, if the corresponding instructions are not observed.



Warning!
warns of possible damage to the equipment.



Attention!
warns of dangerous electrical voltage.



Note:
provides useful hints for optimal and economical use of the product.



Environment:
Gives tips on how to handle the product in an environmentally friendly way.



Danger of explosion:
provides special information on how to handle explosive product or operation in explosive environments.



Danger!
Warning against caustic substances.

2.8 Maintenance and repair work

Maintenance and repair work must solely be carried out by qualified and specially instructed persons. This applies particularly for work on electric, hydraulic and pneumatic facilities as well as for the handling of hazardous fluids and substances.

Pumps used for the transport of harmful product must be decontaminated.

Keep unauthorized persons away from the pump.

Repairs in mechanical and electrical systems must only be carried out by the respective expert personnel. The professional execution of this work must be examined and approved by a highly skilled and responsible "Inspector".

The system must be shut down before starting any repair or maintenance work.

Before starting maintenance or repair work you should always check whether the pump has been depressurized and de-energized.

Secure the pump reliably against being switched on again, for this reason:

- Lock switch or shut.off element and remove the key,
- Attach a warning label to the pump.

The operator is solely responsible for compliance with the accident prevention instructions valid at the place of use.

As a measure to avoid injury all maintenance, adjustment and repair work should only be carried out using permissible and appropriate tools and working aids.

Moveable parts must be locked in place before starting work. It must be assured that these parts will not start to move while work is in progress.

2.9 Personal protective outfit

You should always wear protective clothing suitable for the job, in particular for cleaning, maintenance and repair. Depending on the type of work you should wear the following protective outfit:

- protective overall
- goggles or face mask
- ear defenders
- hard hat
- safety boots
- gloves

If there is a risk that your face may come into contact with chemicals, splinters or dust, you should wear a full face protection.



Danger!

During operation the pump may develop extreme heat. You should therefore switch off the pump and let it cool down before touching it. On DB high pressure pumps the booster can reach a temperature of >70° C.

2.10 Safety information for work on lines under pressure



Danger!
Take care when handling dangerous (caustic, harmful) fluids.

Always relieve the pressure before starting work on pressure lines, for this purpose

- Close shut-off valves
- Vent lines



Danger!

Be careful when checking for leaks on pressurized lines. Fluids or air escaping under pressure can penetrate clothes and skin and cause severe injury.

Be careful when loosening or changing pressure lines; lines mixed up by mistake may reverse the function.

Moveable parts must be moved to a safe home or parking position.

Always wear your personal protective outfit.

If a dangerous substance comes into contact with skin or eyes or if vapours of such a substance have been inhaled, you should immediately consult a medical service.

Do not touch pump or pipelines during operation. Danger or burning!



Environment:

Catch and dispose of chemicals and dangerous substances environmentally.

Do not expose the pump to extreme and sudden temperature fluctuations. This may cause the pump to start leaking. Retighten clamp bands or mounting flanges!

2.11 Safety during storage

Always observe the applicable regulations when storing or handing out chemicals.

2.12 Noise emissions

In a room with several pumps you may experience an extreme development of noise. Depending on the sound pressure level the following measures must therefore be applied:

below 70 dB (A): No special measures required.

above 70 dB (A): Persons who are permanently in the room

above 85 dB (A): must wear ear defenders.
Room with dangerous noise level! Each door must have a clearly noticeable warning sign to warn persons from entering the room without ear defenders.

Measured mean sound pressure level L_p [dB(A)] acc. to DIN EN ISO 20361 in 1m distance with a pump head of 60 m, pump DL50-FA-NNN, control air 7 bar, medium water, 20 °C = 66.8 dB(A). With a different pump rating and pump size or other application related conditions the mean sound pressure level may deviate.

3.0 Installation

3.1 To be observed before installation

- 1 The installation must only be carried out by persons who have the necessary skills for this work (see chapter 2 "Safety").
- 2 Before installation align the pump correctly and fasten it without any tension. Pipelines must be assembled in a way that the basic weight of the lines is not resting on the pump.
- 3 In order to avoid damage to the pump new installations should generally be checked for any debris (welding beads, pieces of wire, etc.) in tank and pipeline system.
- 4 Consider the arrangement of the pump with respect to suction and discharge heads.
- 5 The pump system must be designed according to the requirements of the application. Valves or spools must be installed as close as possible to pressure port.
This also applies for T-fittings with valve for bypass control or pressure relief

- 6 valves, pressure gauges, flow control valves and shut-off valves.
- 6 Thoroughly examine the alignment of the pump with the pipelines, in order to avoid strain and premature wear.
- 7 Check all pipelines for leaks. This applies in particular for the suction line, in order to avoid the intake of air.
- 8 If the fluid to be pumped contains solid particles bigger than specified in Table 1 in Section 1.4.4, a filter must be installed. The filter must be of such a size, that the change in resistance at the pump inlet port is only minor. This filter must be permanently monitored and cleaned if necessary. Insert a suction basket.
- 9 Fluids which change their viscosity must be permanently agitated, or the tank must be fitted with a temperature sensor. With increasing viscosity start the agitator and/or the heating. This is of special importance for intermittent operation!
- 10 Retighten the clamps bands on pump and pulsation dampener before initial start-up. The torques specified on Section 11 must be observed.

3.2 Design and arrangement of connecting lines

By experience, the cross section of the pipelines must be designed to allow a flow velocity of 1 to 3 m/s in the pressure line and 0.5 to 1.5 m/s in the suction line (see Section 9.0 for pump connection sizes).



Pumping combustible liquids. Experience has shown that dangerous charges are not likely at flow velocities > 7m/s (TRGS 727).

The cross-section of the compressed air supply must not be smaller than the connection on the pump.

For simple removal of the pump a shut-off element each must be installed in the suction and pressure sides.

- The weight of the pipeline must be taken up before the pump.
- Elongation compensators must be installed to compensate any elongation of the pipes caused by temperature increase.



Note: It is recommended to install flexible, shape and pressure resistant hoses or

compensators at the suction and pressure ports of the pump (Fig. 3). This will prevent the transfer of pulsation shocks into the pump.

3.3 Placement and possible installations of the pump

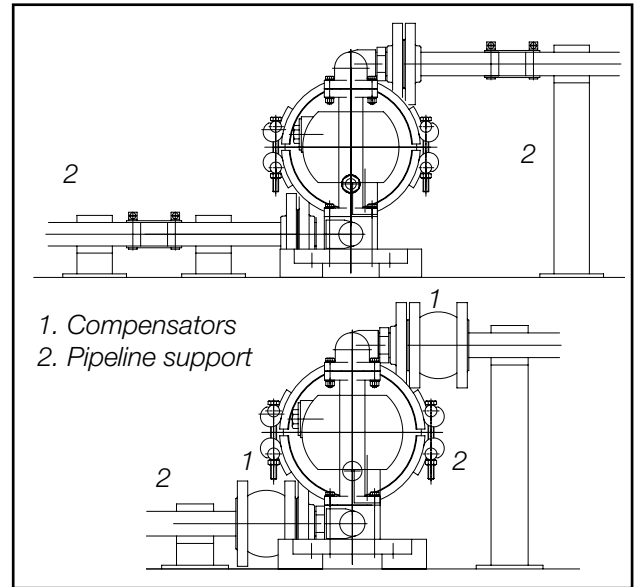


Fig. 3: Installation proposal for diaphragm pump

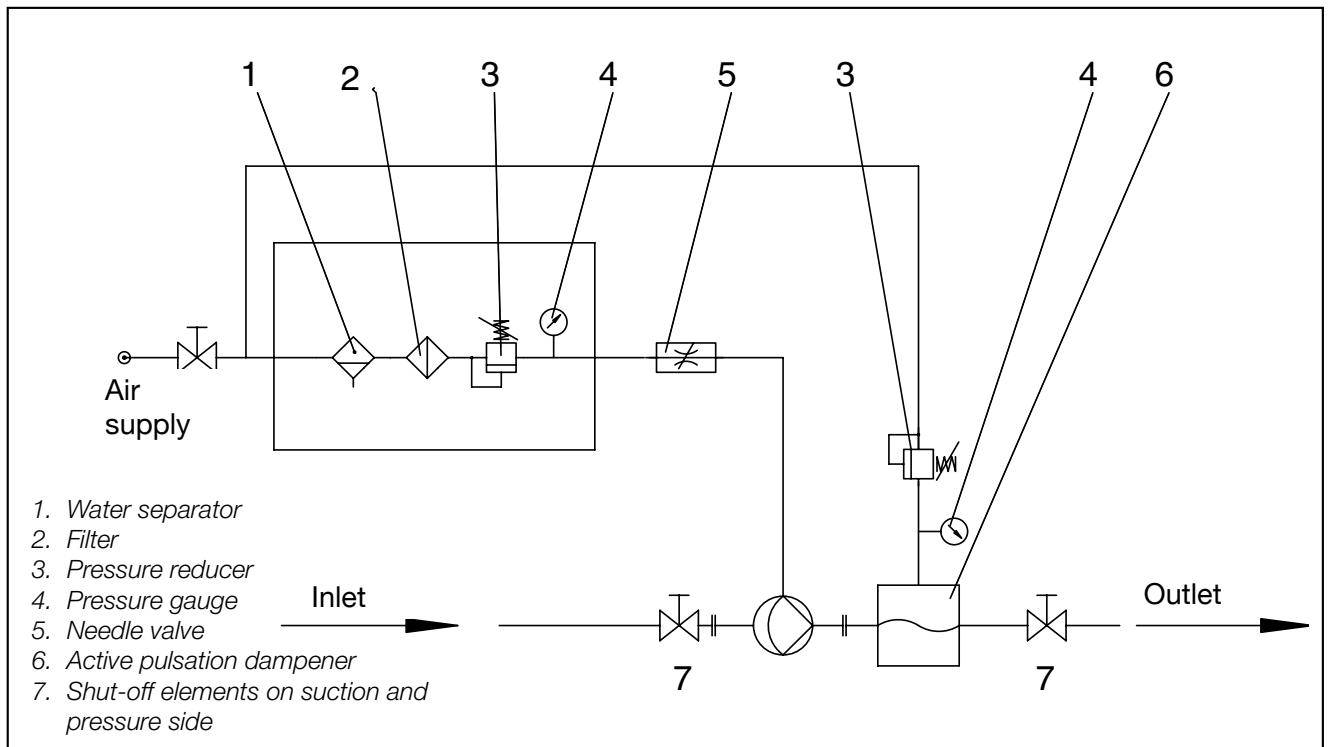


Fig. 4: Example of a pump installation

3.4 Foundations

Special foundations are not required. Each pump can be secured to the ground with dowels if appropriate.

3.5 Connection of air supply line

We recommend to supply the air through a hose to the pump. Using moisturized compressed air requires the installation of a service unit with water separator. This control equipment can additionally be used to regulate the flow capacity of the pump. The diaphragm must not be subjected to shock loads. For this reason, we recommend the upstream installation of a spool, diaphragm, needle or slow start valve.



Warning! Do not use a ball valve as shut-off element.



Note: Especially for plastic pumps or pumps with PTFE diaphragms we highly recommend to install a slow start valve in the supply line to the pump. This valve protects both the diaphragm and housing parts against suddenly occurring pressure shocks

3.6 Connection of suction and pressure pipes

Suction and pressure lines must be installed in a way that no additional loads are applied to the pump ports. Pay attention to tightening torques of mounting screws and pressure strength of sockets and flanges during installation of suction and pressure lines. After assembly check the system for leaks.

For connection of suction- and discharge pipes to DEPA pumps equipped with cylindrical female thread (shortly signed "G", standard version ISO 228-G) fittings with either

- cylindrical male thread (none-sealing within the thread) or

- fittings with conical male thread (shortly signed "R", sealing by means of a sealant within the thread)

can be used.

For fittings equipped with cylindrical male thread a suitable seal for sealing between sealing surfaces (outside of thread) is needed (hints acc. DIN 3852)

For fittings equipped with conical male thread (acc. DIN EN 10226, R-conically) the sealing can be done by a suitable sealant (e.g. PTFE tape). For connection dimensions see Section 9.0.

3.7 Pump in suction operation

DEPA Air Operated Diaphragm Pumps are dry self-priming. Depending on the pump design a suction head of max. 9 m Wc can be reached, when the suction line is filled (Table 1 in Section 1.4.4).

3.8 Pump in submerged operation

The DEPA Air Operated Diaphragm Pumps are suitable for submerged operation. However, it must be assured that the surrounding fluid will not attack the pump.

When installing the pump make sure that the air discharge muffler has been removed and the exhaust air is discharged from the fluid through a hose.



Does not apply to DB high pressure pumps.

3.9 Pump with pre-pressure

Avoid excessive feed on the suction side. This causes irregular running of the pump with extreme noise. The results are limited power and reduced lifetime of the pump. The maximum pre-pressure on the suction side must not exceed 0.7 bar.

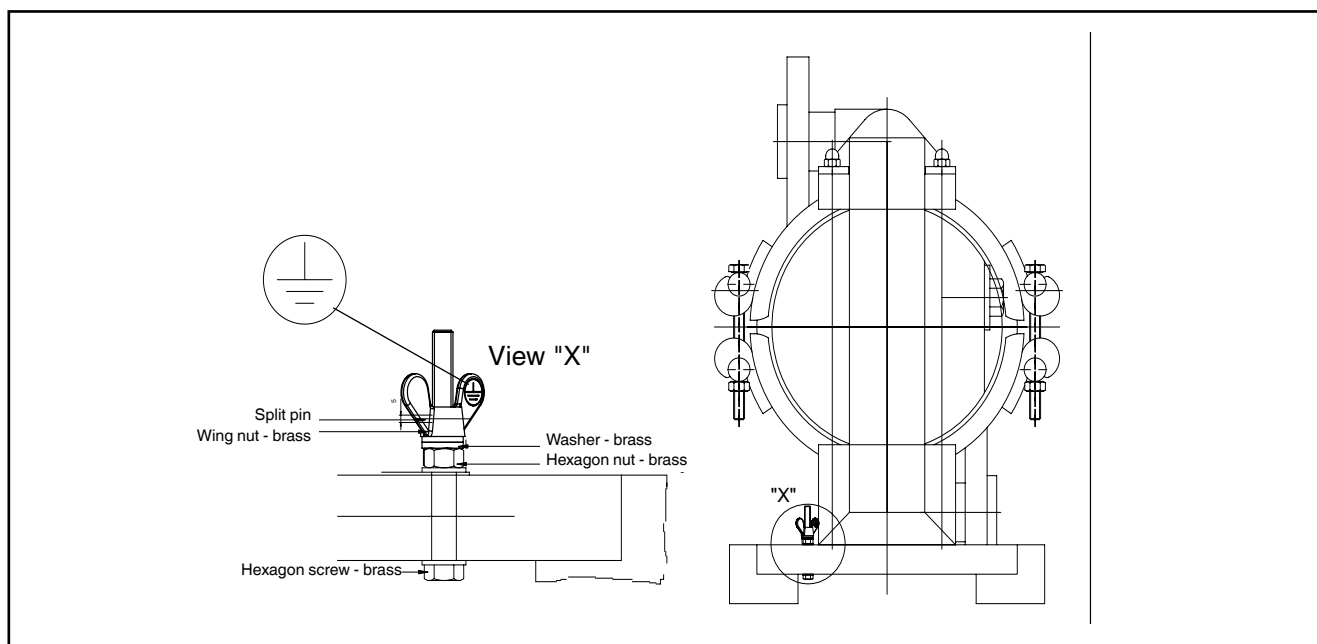


Fig. 5: Earthing screw

3.10 Pump on drum

DEPA pumps of type DF can be directly mounted on drums or containers. For simple emptying mount the pump with an adapter on the container. Complete emptying of the container requires the use of a suction pipe with adapted length.

3.11 Equipotential bonding / earthing

In principle, pumps and accessories must be earthed or provided with equipotential bonding if there is the possibility of product specific electro-static charging and when used in potentially explosive areas. Pumps and pulsation dampers with ATEX-approval are therefore fitted with an earthing screw (Fig. 5). See also page 46 for category 1 pumps and accessories.

3.12 Vibration distance

When installing the pump ensure a sufficient distance (DL15 to DL40 of at least 5 cm; DL50 and DL80 of at least 10 cm) between pump and other components, except the connections.

3.13 Routing of exhaust air

The muffler permanently discharges relieved compressed air. This air can whirl up dust and thus generate an explosive atmosphere.

For pumps used in potentially explosive areas of category 1 discharging the waste air out of zone 0 is mandatory (See Section 10).

3.14 Installation instructions for incomplete machines (2006/42/EC, Append. I)

For the installation of DEPA Air Operated Diaphragm Pumps without air control, Type DJ/DH*, the following conditions must be fulfilled so that the pump can be correctly assembled to other components to a complete machine, without affecting the health and safety of persons:

Valves provided by the customer has to be according to the following specification::

1. Air flow rate:: DJ/DH* 15-40: 80Nm³/h (approx. 1350 NI/min)
2. Operating pressure: 1...8,6 bar

3. Function: 5/2-way valve, monostable, air-spring center position must be connected.

After the pump stops, the piston rod has no defined position.

4. Control: Suitable control signal for switching in due time (prevention of impermissible high loading of the diaphragm).

Stroke frequency max:

DJ/DH*15: 2,5 Hz

DJ/DH*25/40: 2,0 Hz

5. Compressed Air Conditioning::

In accordance with the specifications from the valve manufacturer.

The applicable minimum requirements on the air quality, has to be in accordance with 1.4.3 of these operating instructions.

The following threaded connection are available on the pump:

DJ/DH*15: pipe thread EN 10226 R 1/4

DJ/DH*25/40: pipe thread EN 10226 R 3/8

The valve must be connected to the pump using a hose and pipelines PN10 (rated pressure 10 bar).

Using pumps in potentially explosive areas:

The instructions in 3.11, 3.13 and 10.0 - 10.4 in it's present form of the operating manual have to be applied.

* *DHxx-FA in custom design with control block for external air control.*

4.0 Operation

4.1 General

After correct connection of suction and pressure line as well as the compressed air supply the pump is ready for operation.



Warning!

Make sure that the diaphragm is not subjected to a pressure difference of more than 2 bar.

Do not expose the pump to sudden temperature fluctuations. This may cause the pump to start leaking.



Danger!

Do not touch pump or pipeline. Danger or burning! Always wear your personal protective outfit when handling chemicals.



Environment:

Observe the applicable regulations for storage and hand-out of chemicals.

Dispose of chemicals according to legal regulations.

4.2 Switching on the pump



Warning!

The empty pump must never be immediately subjected to high pressure.

For automatic switching of the pump by means of a solenoid valve we recommend the upstream installation of a slow start valve.

The pump will start to deliver immediately after opening the air flow.

4.3 Flow control

The pump flow can be regulated via the fed air pressure and the air quantity. We recommend an air flow dependent regulation, in order to rule out fluctuations in pumping pressure. The air pressure must in this case be considerably higher than the pumping pressure. It is recommended to run the pump with a stroke frequency as low as possible, in order to save wear items, e.g. diaphragms, ball valves and air control valve and to protect the environment.

4.4 Switching off the pump

To shut-off the pump reduce the air flow to the pump by means of the valve. The pump will stop immediately.



Warning!

If the pumped product is of aggressive nature the pump must be thoroughly flushed or cleaned after use.

Observe the notes on cleaning.

4.5 What to do in events of emergency

In the event of an emergency, the pump must be switched off immediately and, if necessary, secured against being switched on again.

4.6 Remote operation indicator

Operation of the pump can be electronically monitored by means of a remote operation indicator.

4.7 Diaphragm monitoring - conductive

With a defective diaphragm product will enter into the air chamber, where it is detected by the integrated sensor. When pumping conductive product the conductivity measurement will measure a current flow between both electrodes.

The evaluation unit supplies the sensor with voltage and from a certain amperage (<1mA) it switches a relay, which in turn switches the pump off or triggers an alarm signal.



Note:

The product must have a minimum conductivity value of >5µS.

4.8 Diaphragm monitoring - capacitive

When pumping non-conductive product diaphragm monitoring requires the use of a capacitive sensor system.

4.9 Cleaning pumps for food applications (CIP = Clean In Place)

The pumps can be cleaned manually after dismantling or in place (CIP). Consult the pump supplier for special application related cleaning procedures.

Here an example for CIP-cleaning:

- To clean the inside, the pump must be flushed with cold water during operation.
- Flush with approx. 2.5% caustic soda solution at 70 - 80°C for approx. 20 - 30 minutes.
- Finally flush again with cold, clear water.



Warning!

During all CIP cleaning processes the DEPA® Air Operated Diaphragm Pump must be running. Otherwise the diaphragm may be excessively stretched and prematurely damaged.



Warning!

Reassemble clamp bands or mounting flanges after cleaning, retighten if necessary!

DEPA® Air Operated Diaphragm Pumps

4.10 Diaphragm break sensors and shut-down in the event of leaks

When using diaphragm break sensors, the air supply may be interrupted if there is a leak. For electrical connections please refer to the wiring diagram (Fig. 6).

4.11 Pulsation damping

Air operated diaphragm pumps are double-acting, oscillating displacement pumps and thus generate a pulsating flow. For minimizing this pulsation we recommend the use of pulsation dampeners. There are various designs available, active and passive, made of metal or plastic, with and without diaphragms and in several different sizes. Depending on the prevailing pressure conditions they must be manually or automatically adjusted in-situ. See Fig. 4 and Section 7.

4.12 Downtimes

After pumping product with solids, chemicals or oils the pump chambers must be thoroughly flushed before shutting down. This prevents the settlement of solids or chemical attacks and

thus the destruction of the diaphragms when re-starting.

4.13 Taking out of service

The pump stops when cutting off the air supply. Since the valve balls in suction and pressure sides act as non-return valves, the rising part of the pressure line will always remain filled with product. When disassembling the pump care must be taken, as the pump may still be filled with product. The pump itself can be partly emptied through the plugs on the sides of the pump (optional).

4.14 Waste disposal after expiry of the expected service life



The metal components used, such as aluminium, grey cast iron, high-grade steel and steel can be returned for recycling. Plastic parts made of polypropylene are recyclable and should be collected and disposed of separately. All other plastic parts cannot be recycled and must be disposed of as residual waste.

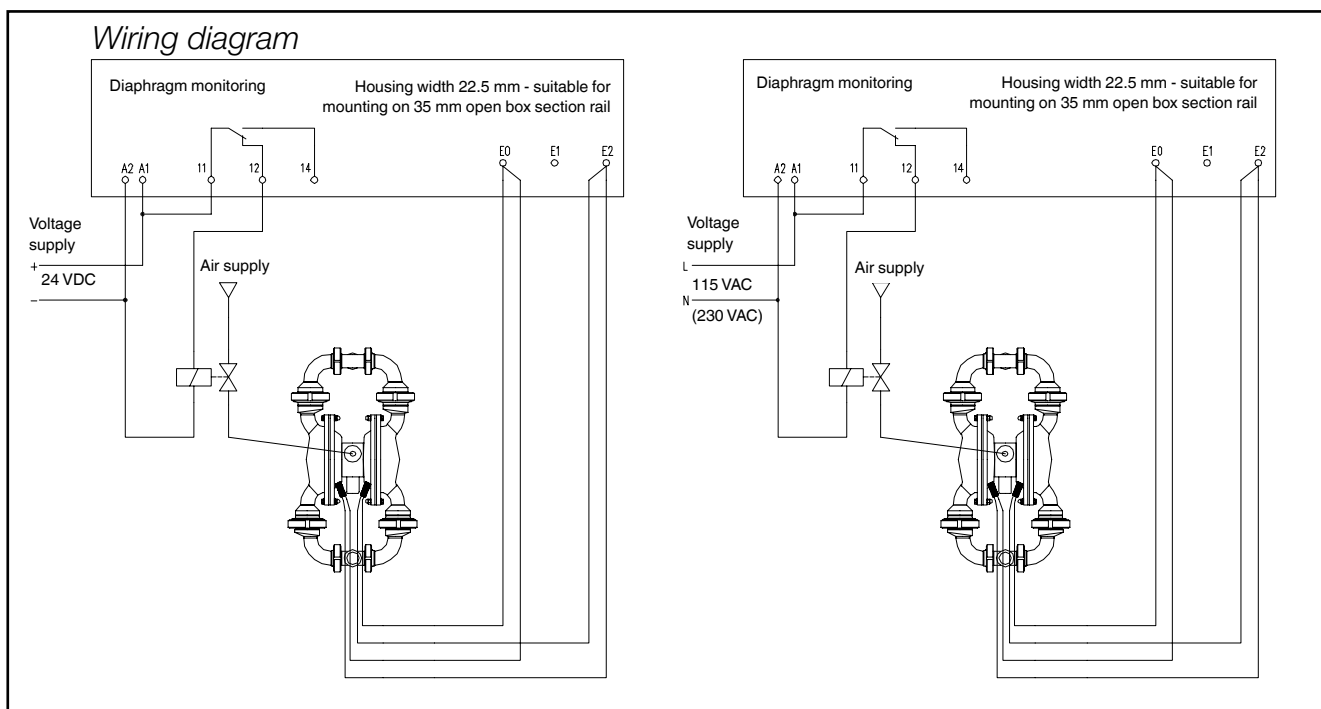


Fig. 6: Wiring diagram leakage sensors

5.0 Maintenance

5.1 Inspection periods

- Visual inspection, at least every week depending on the application..
- Depending on type and/or duration of use disassembly and renewal of wear items every 4 weeks to 6 months.
- Since PTFE deforms under pressure, the following pumps must be checked for leakage at regular intervals and the screw connections must be retightened as necessary (For tightening torques, see Section 11):

Type	Inspections interval	Srew joint
PM with PTFE Valve seats	weekly	Annchor rod, Clamp band
DH-TP/TPL	monthly	Socket / Pump chamber

5.2 Cleaning



Danger!
Always observe the notes on safety in chapter 2 “Safety”.

Check all lines and fittings regularly for leaks and externally visible damage! Repair any damage immediately!



Danger!
Before working with the pump, the pump must be moved from a possible ATEX area to a work area.

No work on the pumps in the ATEX area!



If the pump is used for aggressive, caustic or toxic product, the pump must generally be flushed with a neutral agent before opening the pump housing.



Always wear protective clothing when working with solvents and/or cleansing agents.



Pumps for use in explosion hazard areas must always be kept clean of dust deposits.

The following is generally valid:

The pump should preferably be cleaned mechanically instead of using chemical means. When using chemical cleansers, the compatibility with the pumped product must be assured..

5.3 Dismantling and assembling



Danger! Before disassembly the pump must be disconnected from the compressed air supply and removed from the system.

General

In case of damage on the pump you may perform the following work to replace the damaged assemblies and parts. Please bear in mind that the manufacturer or the authorized dealer will only accept possible warranty claims if the pump is returned without being opened.



Note: For repairs use only genuine DEPA spare parts, as otherwise the warranty will become null and void.

5.3.1 Series DL, DP, DZ, DF, DB

For pump type DP125-FA see section 5.3.3.

5.3.1.1 Replacement of diaphragms, valve seats and valve balls

Depending on the application, air operated diaphragm pumps can be delivered with various elastomer materials. The following materials are available:

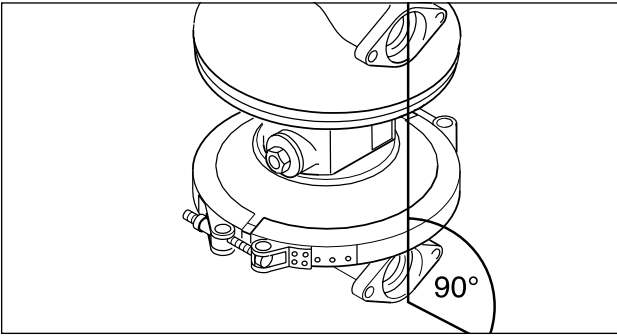


Fig. 7: Alignment of pump chambers

NRS	marked yellow
NBR	marked red
EPDM	marked blue
FKM (Viton®)	marked white
PTFE (polytetrafluorethylene)	not marked

The specified colour marks only apply for valve balls and valve seats. The diaphragms are marked by corresponding characters.

Before installing a new set of diaphragms, valve seats and valve balls make sure that the available material is suitable for the intended use (see compatibility list).

If the defective parts in the pump have not been damaged by normal mechanical wear, but show signs of chemical attack, you should use a different material.

5.3.1.2 Replacement of elastomer components

- Loosen the screws and disassemble pressure and suction sockets (Fig. 8).
- Loosen the ball lifter (optional accessory)
- Loosen the clamp bands (to avoid sizing of high-grade steel nuts and bolts, if necessary apply some oil) (Fig. 9).

On the polished high-grade steel versions (DL, DH) unscrew the milk pipe fitting.

- Remove the pump chambers.
- Loosen the outer diaphragm plate and take it off with the diaphragm (Fig. 10).

On plastic pumps turn on the plastic cap first (from DL25).

- With compound diaphragms, the diaphragm is unscrewed by hand directly out of the plunger.
- Pull the piston rod with the second diaphragm out of the central block and disassemble the second diaphragm as described before (Fig. 11).

5.3.1.3 Replacement of the PTFE diaphragm

Proceed as follows to replace PTFE diaphragms:

- Pumps DL 40, 50 and 80 with PTFE diaphragms have thicker internal diaphragm plates to reduce and displace the stroke. For subsequent conversion to PTFE diaphragm, the corresponding plates must be used (Fig. 13).
- PTFE diaphragms are generally delivered with a EPDM back diaphragm. This must be mounted on the air side.
- Assembly of the pump chamber: Assembly of diaphragm, fixation by fastening the outer diaphragm plate acc. to Section 11 "Tightening torques". The pump chambers must generally be assembled with the diaphragm in suction position (Press diaphragm plate into air chamber) (Fig. 15). Fasten clamp band or mounting flange. Assemble the second diaphragm in the same way. The flange face of the pump housing must be in line (Fig. 7).
- Assembly of PTFE valve seats:
PTFE valve seats (except series PM and DL15-FA/SA) are generally delivered with 2 O-rings. In order to guarantee leak tightness of the pump these O-rings must be replaced after each disassembly of the inlet and outlet ports.

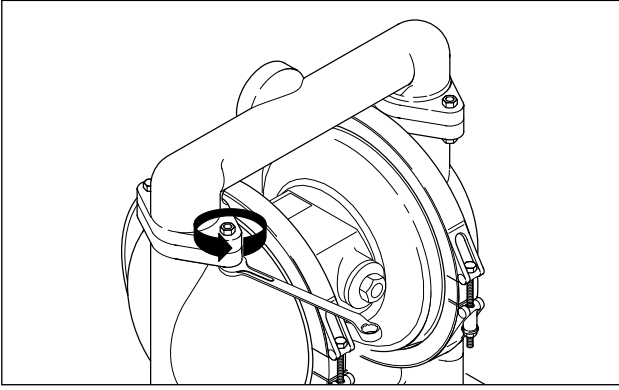


Fig. 8: Removing suction and pressure ports.

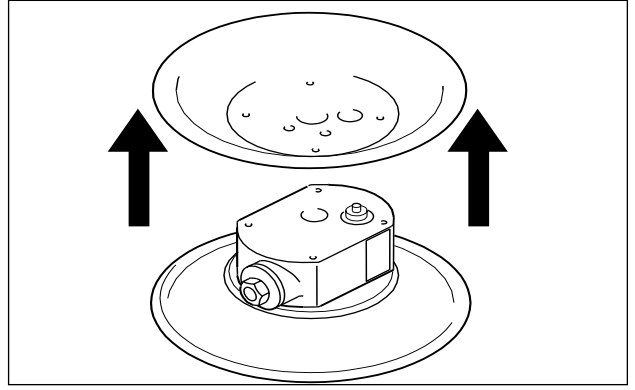


Fig. 12: Disassembling the air chambers

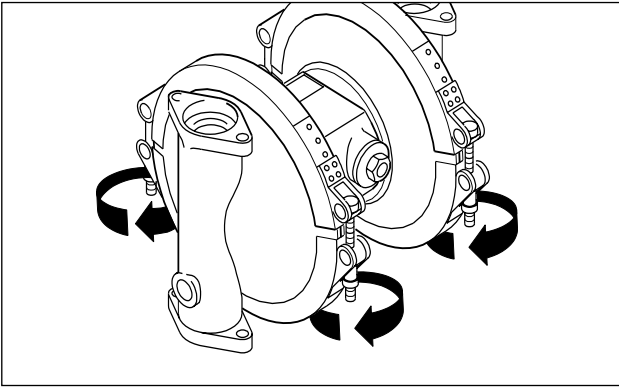


Fig. 9: Opening the clamp bands.

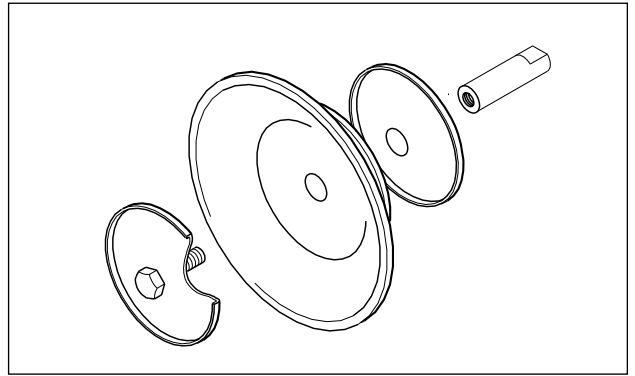


Fig. 13: Assembly of standard diaphragm with inner and outer plate

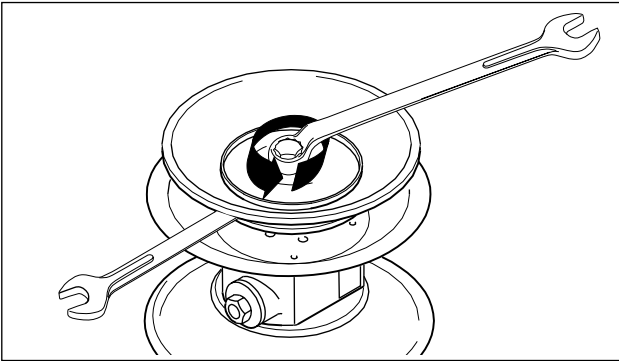


Fig. 10: Loosen the diaphragm plate. (Not used for nopped E4® diaphragms.)

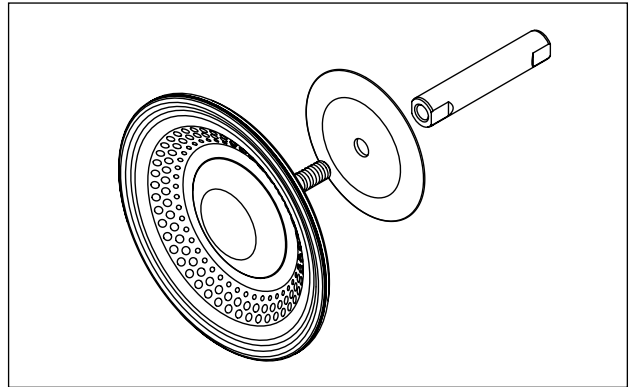


Fig. 14: Installation of nopped E4® diaphragm.

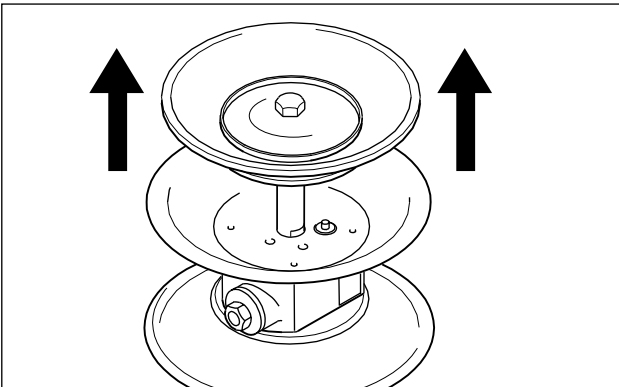


Fig. 11: Pulling out the piston rod.

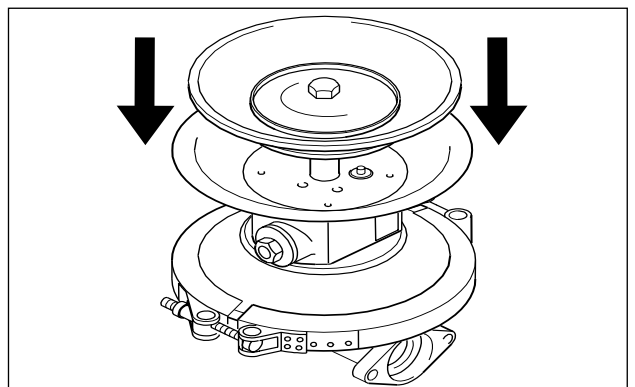


Fig. 15: Assembly of second pump chamber

DEPA® Air Operated Diaphragm Pumps

Valve seats for series PM (only one O-ring or no O-ring) must be completely replaced after each disassembly of the ports.

On plastic pumps from DL25 the O-rings in the outer diaphragm plate must be replaced after each disassembly.

- Assemble the ball lifter (optional accessory), install a pressure-side valve seat in the ball lifter
- Assemble new valve balls.
- Tighten the fastening screws for suction and pressure ports with the correct torque.
- Pumps of series DH-TP/TPL are generally equipped with DEPA nopped E4® compound diaphragms. Installation of the diaphragm takes place by means of indexing disc and set screw, without the diaphragm plate: After the set screw is threaded, the diaphragm is to be screwed onto the plunger and tightened by hand.

5.3.1.4 Replacement of the internal control valve

- Procedure as described under 5.3.1.
- Unscrew the air chambers from the central block (only on metal pumps, exception: DB diaphragm pumps, DH) (Fig. 12).
- Press the air control valve out of the central block.
- The air control valve is replaced as a complete unit (Fig. 16).
- To install the plain bearing bushings and seal ring, we recommend using the piston rod for guidance (see Fig. 17).

- In contrast to the assembly instructions for bearing bushings of pump series DL25 - DL80, which are fitted with two bearing bushings, the procedure for pump size DL15 with kits single bearing bushing is slightly different.

The bearing bushing has two grooves to take up the outer O-rings. In order to

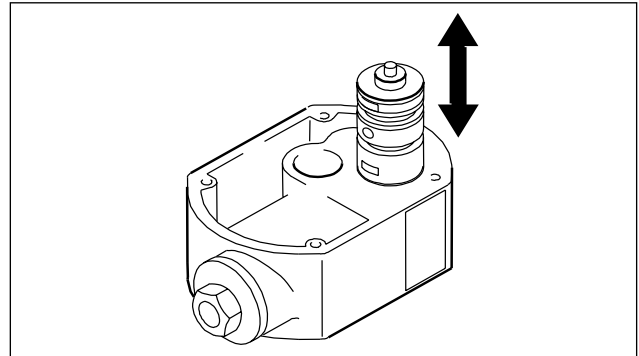


Fig. 16: Assembly of internal control valve

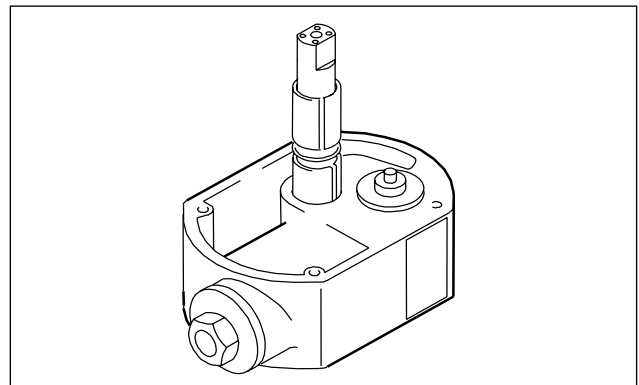


Fig. 17: Assembly of piston rod

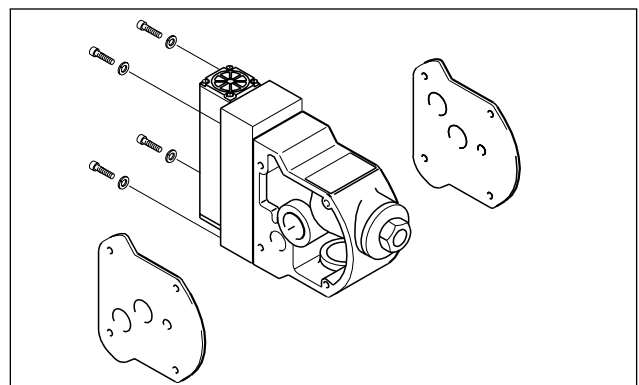


Fig. 18: Assembly of external control valve

prevent the O-rings being damaged by the recess in the bore the O-rings must not be pushed past the recess. For this purpose an O-ring is pushed over the bushing, the bushing is then inserted into the bore with the side without O-ring and pressed in until the groove becomes visible on the opposite side. Now the second O-ring is placed into the groove and the complete bushing is pressed flush into the bore.

The piston rod is only delivered completely assembled with shell and O-rings.

Replacement of the shell rings is not possible for technical reasons.

5.3.1.5 Replacement of the external Q-control valve

- Loosen four fastening screws on the control block. Now you can pull out the complete control valve with pilot control. This is also possible without disassembling the pump (Fig. 18).

5.3.1.6 Replacement of the outside DEPA AirSave System (DL15/25/40)

- Loosen four mounting screws on the

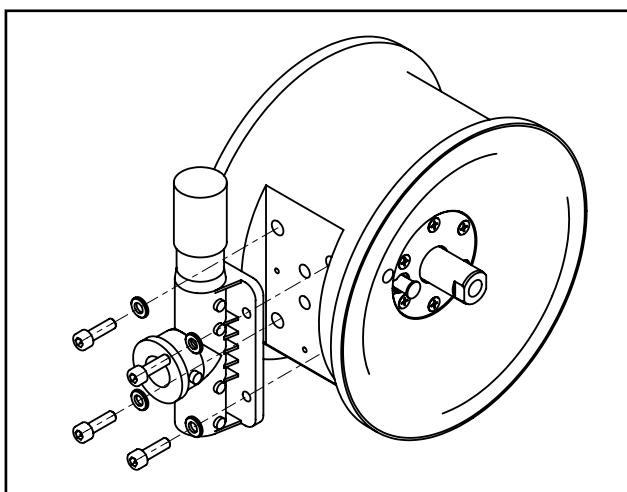


Fig. 19: DEPA AirSave System (DL15/25/40)

control block. Now you can detach the complete control valve from the control block. This is also possible without disassembling the pump first! (Fig. 19).

5.3.1.7 Assembling and disassembling the pressure booster (DB series)

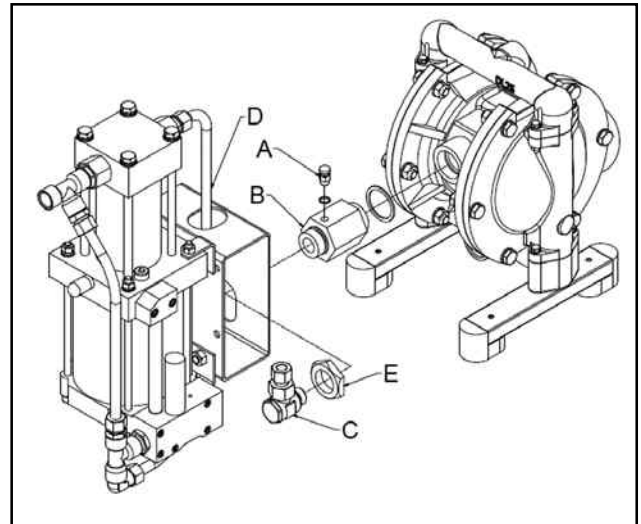


Fig. 20:

Disassembly:

- Release the pressure with the ventilation valve (A).
- Loosen the screw fitting between the adapter piece (C) and adapter (B).
- Loosen the spigot nut (E) so that the booster (D) can be removed.
- (Unscrew the adapter (B) from the pump.)

Assembly:

- Screw the adapter (B) into the pump and then screw the ventilation valve (A) into the adapter (B).
- Screw the adapter piece (C) to the air supply line of the booster (D).
- Screw the booster to the adapter (B) using the spigot nut (E) and the adapter piece (C).

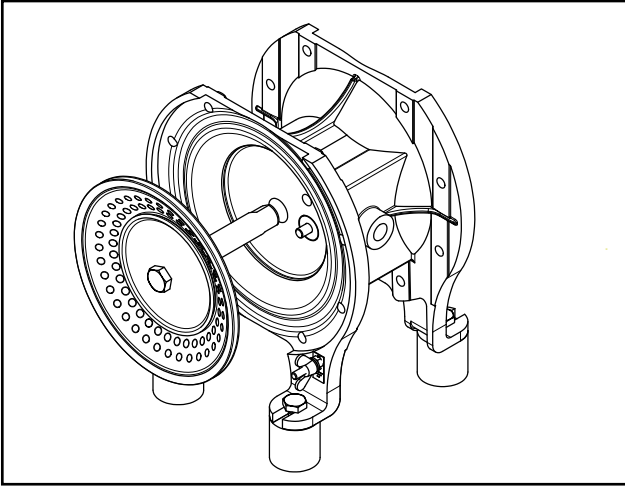


Fig. 21: Pulling out the diaphragm with piston rod

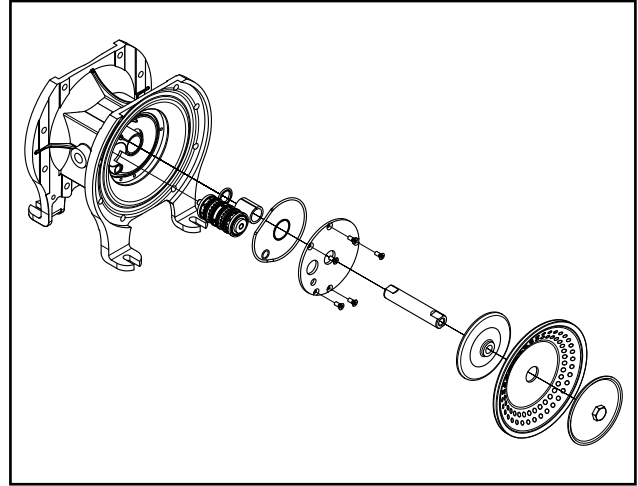


Fig. 22: DH pump with interior control valve

5.3.1.8 Information on operating the high-pressure pump (DBxxE/F)

Disassembly:

- The high-pressure pump is equipped with an internal special high-pressure control pressure valve. The standard internal valve is not permitted
- The booster may only be mounted vertically
- Please follow the instructions in the operating manual supplied separately for the high-pressure booster (compressor station)
- The operating temperature range of the high-pressure pump is -10 to +40 °C
- The compressed air quality must be maintained in accordance with ISO 8573-1
- The high pressure pump with booster may be operated with a maximum of 7 bar.
- Sustained dry running of the pump or no-load operation of the booster must be prevented
- Temperature development at the booster must be checked and monitored depending on the drive gas used and its quality

An additional adapter is required for retrofitting or conversion to the new booster tech-

nology. For torque values, please refer to the section Tightening torques DB-FSA/ESA series

5.3.2 Series DH-FA/SA/SS

5.3.2.1 Replacement of elastomer components

See information provided under 5.3.1.1.

5.3.2.2 Replacement of diaphragms, valve seats and valve balls

- Loosen screws on the suction / pressure socket
- Loosen the ball lifter (optional accessory)
- Remove the pressure-sided valve balls and valve seats
- Remove the suction-sided valve seats and valve balls
- Disassemble the pump chambers
- Loosen the outer diaphragm plate and remove with the diaphragm (Fig. 10 + Fig. 21).

With nopped E4® diaphragms, manually unscrew the diaphragm directly out of the piston rod.

- Pull the piston rod with the second diaphragm out of the central block and disassemble the second diaphragm (Fig. 11).

- The installation of the new diaphragm, valve seats and valve balls is done in reverse order of the above

Information for the material can be found in Section 5.3.1.1

We recommend removing and inspecting the air control, if the product reach the air area (see 5.3.2.3).

5.3.2.3 Disassembly of the control block

- Loosen the suction-/discharge manifolds and pump chambers
- Loosen diaphragm, see Fig. 10 and 21
- Disassemble the control valve and seal
- Disassemble the muffler
- Loosen the control block cover and remove the seal
- Push control valve out (interior valve)
- Push out the switch cartridge (Pilot control) (on pumps with AirSave valve)
- Push out the bearing bush and the jacket ring
- The assembly is done in reverse order from the above

5.3.2.4 Replacement of internal valve

- as described under 5.3.2.3.
- Insert control valve as complete unit

5.3.2.5 Replacement of the AirSave control valve (M-valve)

- Remove AirSave valve and seal
- Loosen the control block cover and remove the seal
- Push out the switch cartridge (Pilot control) out

The switch cartridge and the AirSave control valve require replacement as a complete unit.

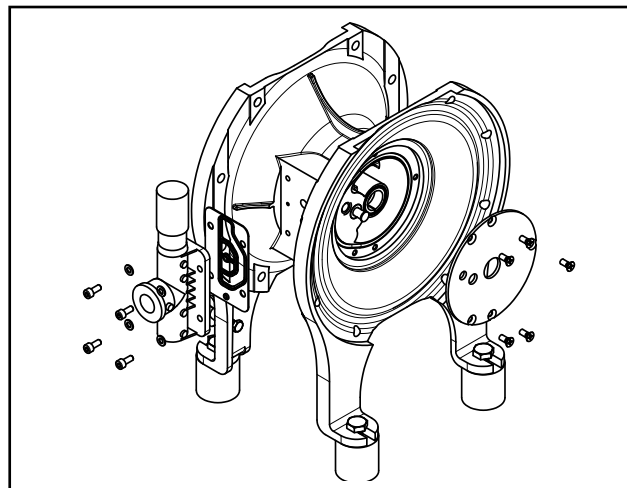


Fig. 23: DH pump with AirSave control valve

5.3.3 Pump type DP125

5.3.3.1 Replacement of elastomer components.

Also refer to information under 5.3.1.1. and 5.3.1.2

- Instead of the clamping straps, loosen the pump chamber / control block mounting screws.
- The pump chambers, sockets and diaphragms can conveniently be disassembled with the pump standing upright inside the frame (deviating from fig. 10)
- To disassemble the diaphragms, loosen the diaphragm seating bolt and pull off the diaphragm plate including the diaphragm.
- Instead of the clamping straps, the pump chamber / control block mounting screws must be loosened.
- The DP125 includes valve discs instead of ball valves. The elastomer valves are to be mounted on suction side so that the guidance lip points upwards.

5.3.3.2 Disassembly of the control block

also see 5.3.2.3. Deviating from fig. 21, loosen the diaphragm plates first of all. Remove the piston rod separately from the control block.

5.3.3.3 Replacement of internal valve

see 5.3.2.4

5.3.3.4 Assembling the pump

also see 5.4 (the DP125-FA does not include an air filter)

Refer to tightening torques in section 11.0

- For installing the diaphragms, mount the inner and outer plates on the diaphragm
- Mount the shaft bearings, shell and O-ring (use piston rod as guide if applicable)
- Insert the piston rod
- Insert pre-assembled diaphragms with diaphragm plates and mount with diaphragm seating bolt
- Mount pump chambers
- Insert flaps (also see 5.3.3.1)
- Mount suction and pressure socket

5.3.3.5 Information on operating the DP125

The DP125-FA is solely intended for the pneumatic conveyance of bulk material or powders.



Max. air pressure 4 bar for DP125.

5.4 Assembling the pump

The arrangement of parts can be seen in the exploded view.

- Assemble the gasket so that the air supply bore remains open (applies also for assembly of the air chambers).
- Check air filter and muffler for clogging, replace if necessary.
- During installation, the corresponding tightening torques must be observed on Section 11.

5.4.1 Assembling new clamp bands (DL, DP, DZ, DF)

- Assemble the new clamp bands and pre-tension these with the clamping bolts.
- Knock the clamp bands lightly with a plastic hammer onto the pump chamber for easier settling.
- Once the clamp bands have settled tighten the clamping bolts.



Danger!
Retighten the clamp bands after 5 operating hours.

6.0 Troubleshooting

Fault	Possible cause	Remedy
Pump running, no delivery	Pump draws in air Suction valve closed Suction capacity exceeded Valve ball and seat on suction side worn	Seal the suction line Open valves Change the arrangement Replace seats and balls
Insufficient pumping capacity	Muffler clogged Air inlet filter clogged Insufficient air supply Pipelines blocked Viscosity too high	Clean or renew Clean or renew Check supply line Clean Change conditions
Pump slows down, stops, restarts	Icing of the control valve	Use dry air Supply the air with anti-freeze Use a heavy-duty muffler
Reduced flow, stronger pulsation	Valve ball on suction side blocked	Ensure movability of valve ball
Product from muffler	Diaphragm cracked	Replace diaphragm
Air in product	Diaphragm cracked	Replace diaphragm
After filling the line pump standstill	Air pressure too low To high viscosity Viscosity too hig	Increase air pressure

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Fault	Possible cause	Remedy
Pump does not work despite air supply	Muffler clogged	Clean or renew
	Air inlet filter clogged	Clean or renew
	Valve balls sticking to valve seat	Loosen, use PTFE balls instead
Valve balls deformed	Chemical attack Mechanical attack	Change material Change material
Pump leaking at the clamp band	Clamp band cracked	Replace
	Diaphragm not centred during assembly	Assemble again
PTFE diaphragm cracked a after short time	Large solids in product	Install a filter
	Compressed air opened with a shock	Install a slow start valve
Insufficient suction head	Valve ball and seat leaking	Replace
	Pump completely dry	Fill suction line
Pump very loud, crackling noise	Control valve worn	Replace
	Excessive feed on the suction side	Install heavier valve balls Throttling of suction line
Piston rod hard moving	Compressed air too dry (Instrument air)	Lubricate the air
	Temperature too high	Cool down
	Compressed air dirty	Install a filter
	Piston rod run in	Replace

7.0 Active pulsation damper

7.1 Function

The active pulsation dampers are designed for in-line installation. The pressure peaks of the flowing product raise the diaphragm and compromise the air cushion in the air chamber.

When the displacement pressure in the pipeline drops, the diaphragm is pressed down by the compressed air cushion which keeps the pressure in the pipeline virtually constant.

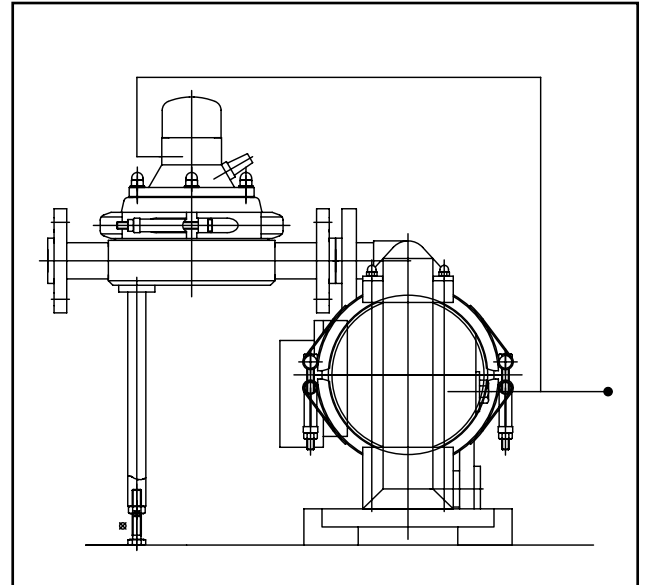
The pressure in the air chamber automatically adjusts as a result of the internal air control if the pressure in the pipeline is increased due to system conditions.

Any extra pressure needed is supplied by the air port; excess pressure escapes through the muffler.

We recommend installing the pulsation damper directly on the discharge manifold of the pump.

7.2 Recommended installation schematic

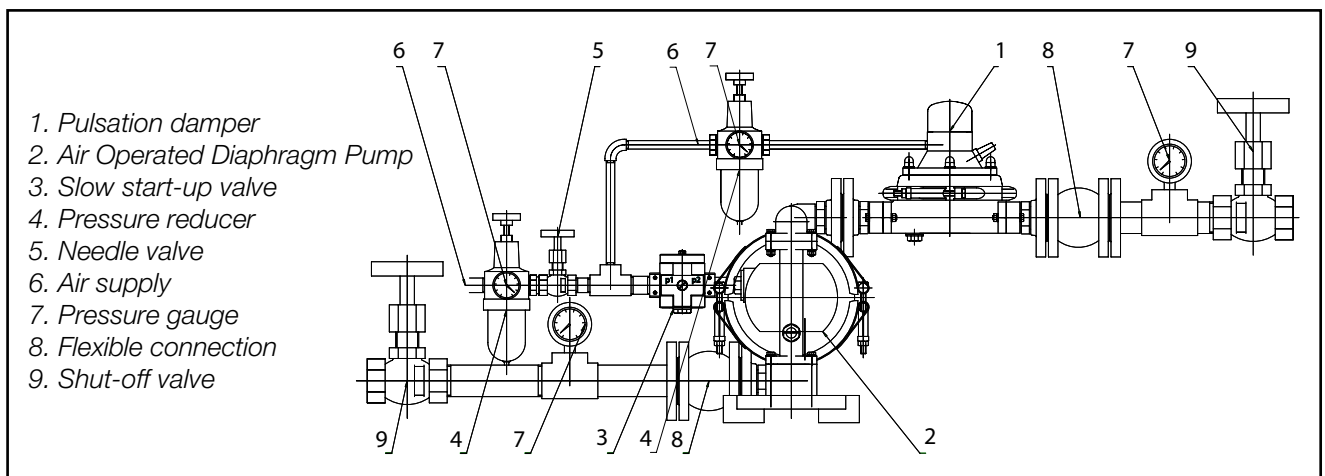
Pulsation dampers can be mounted in any position, as long as there are not intentions to install diaphragm breakage monitoring.



Sketch 1

The air supply connection must always be independent from the pump, so that the air pressure for the pulsation damper can be adjusted separately.

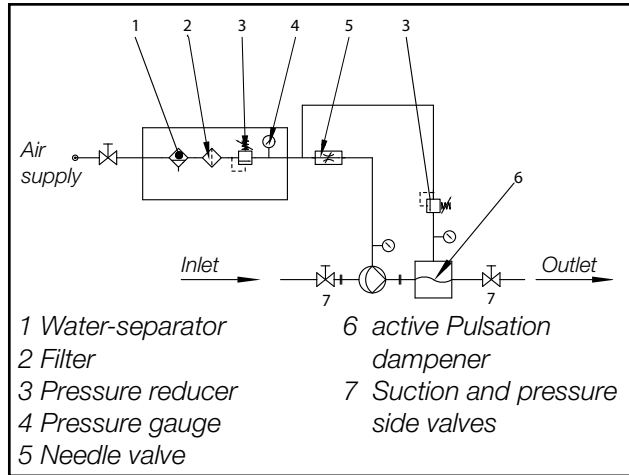
To achieve an optimal degree of damping of the active pulsation damper the operating air pressure must be determined through trials. As starting value the pressure is set 0.5 bar lower than the delivery pressure of the pump. The optimal degree of damping can subsequently be determined by regulating up or down in 0.1 bar increments.



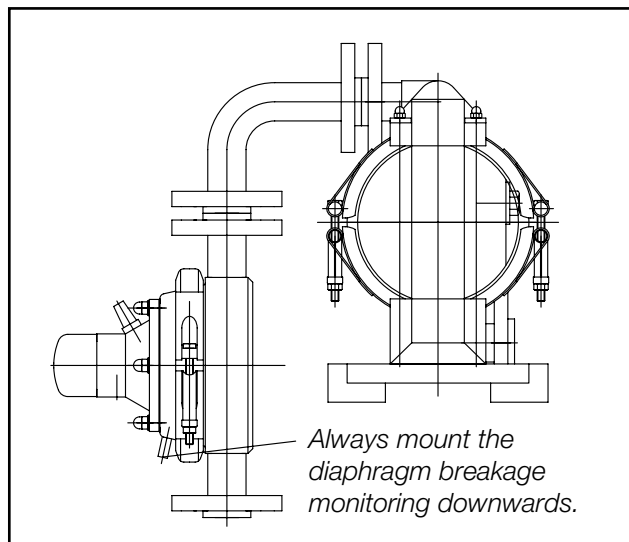
Sketch 2

DEPA® Air Operated Diaphragm Pumps

Attention: If the operating conditions such as delivery pressure or product viscosity change, the driving pressure of the pulsation damper may need to be adjusted.



Sketch 3



Sketch 4

One must always make sure that the weight of the pulsation damper is supported as shown in sketch 1 and any load is taken off the pump connection.

If the pulsation damper is directly mounted to the pressure socket of the pump, a flexible connection (e.g. compensator) should be considered to connect to the onwards pipeline.

7.3 Pulsation damper with diaphragm breakage monitoring

Pulsation dampers equipped with a diaphragm monitoring system in the air chamber must not be installed horizontally, they must be vertically installed as otherwise the function of the diaphragm monitoring system is not assured (see sketch 4).

7.4 Active pulsation damper with DEPA nopped E4 compound diaphragm

The DEPA nopped E4® compound diaphragm can also be installed in all active DEPA pulsation dampers.

The same requirements as outlined in section 5.3.1.3 (and Fig. 14, page 33) apply. However, it should be noted that different setscrews must be used for the pulsation damper (see table 4). In the case of PD50/80, in contrast to the pump the switching disc is installed 180° rotated (counter-bore points towards the diaphragms).

Table 4

Pump size	Item No. Setscrew	Dimensions
PD15	910003611	M5 x 20
PD25	910003311	M12 x 25
PD40		
PD50	910003711	M12 x 50
PD80	910002711	M20 x 70

8.0 Spare Parts

8.1 Spare parts storage

Since the extent of the recommended spare parts storage depends on the period of use and the different operating conditions for the pumps, you should consult the manufacturer or an authorized dealer.

8.2 Ordering spare parts

Please state the following when ordering spare parts:

- Pump type
- Construction year and serial number
- Spare parts article number

Should subsequent material changes for different parts of the pump have taken place, this information is mandatory. The required spare parts and their article numbers can be found in the spare parts lists. These can be found under www.cranecpe.com.

Liability when using non-genuine spare parts:

The installation and/or use of non-genuine spare parts or accessories can have a negative effect on design features of the air operated diaphragm pump and thus adversely affect its operation. For damage caused by the use of non-genuine spare parts and accessories on pump, system or product all liability and warranty is excluded.

8.3 Spare parts kits

MINI spare part kit			
Pump type			all
Pump size			all
	Item	Quantity	
Diaphragm	30	2	●
Flat gasket air chamber/control block and control block cover (interior valve)	51	2 (1 piece at DH15-FA)	●
Flat gasket air chamber/control block and control block cover (exterior valve)	51Q	2	● not size 15
Glide ring + O-ring	65	1 + 1 (size 15x2)	● not size 15
O-Ring ((valve-) housing)	16	4	--
O-ring (exterior diaphragm plate)	38	2	--
O-ring	31	8	--
O-ring air filter	68	1	--
O-ring air inlet	681	1	● not size 15
O-ring control block cover	51-1	1	● not size 15
O-ring control block cover	51-2	1	● not size 15
O-ring control block cover	51-3	1	● not size 15
O-ring control block cover	74	1	● size 80 only
O-ring T-piece	20	4	--

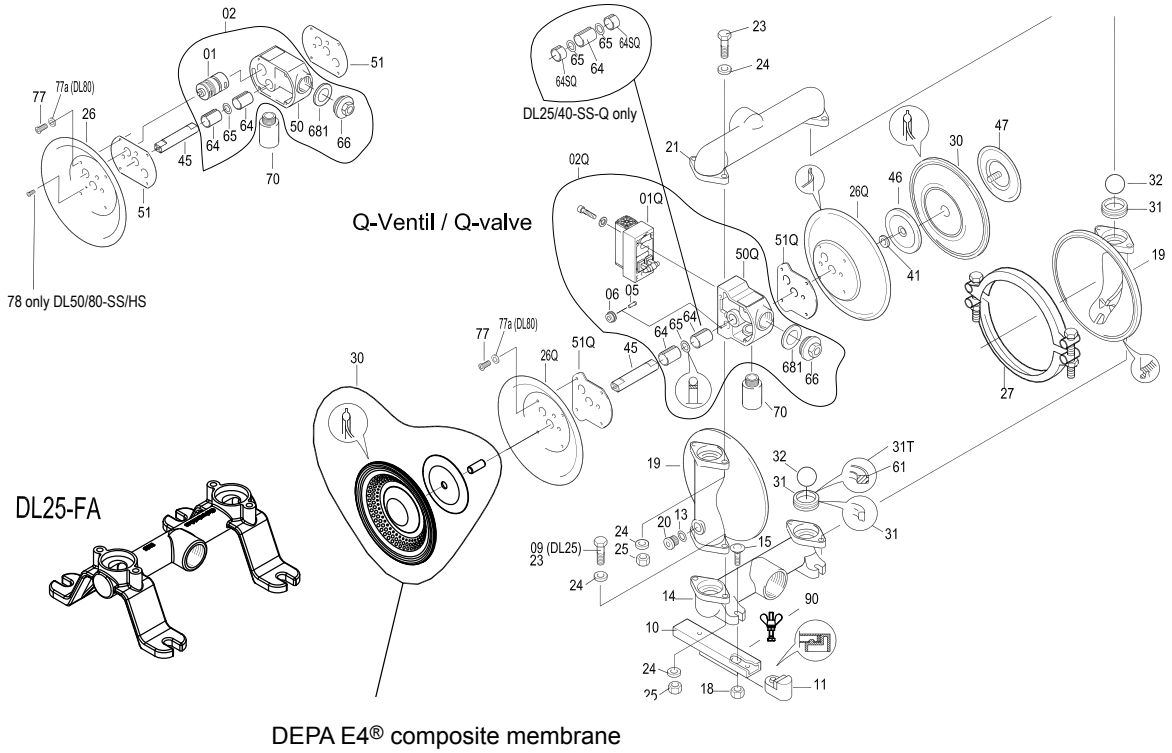
For pump type DP125, no spare part kits (MINI u. MEDI) are available.

DEPA® Air Operated Diaphragm Pumps

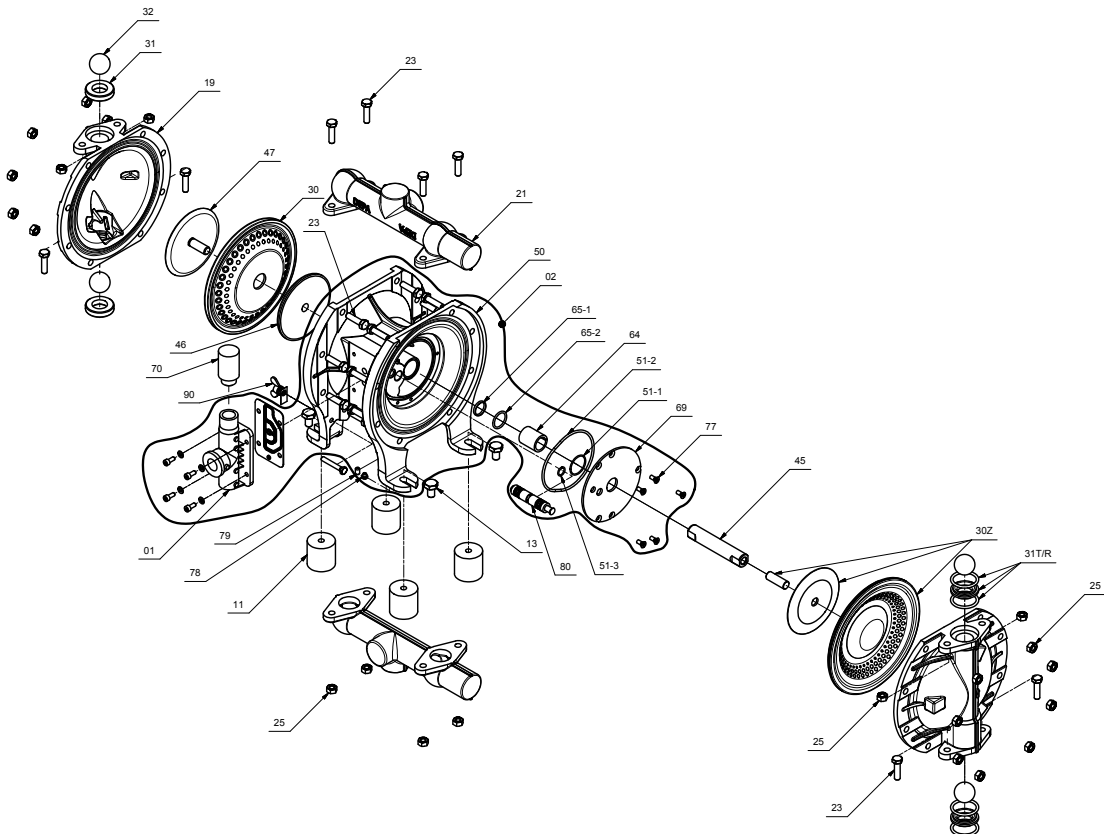
MEDI spare part kits									
Spare part kit type			G	M	P	S	U	X	A
Pump type			DL-PM	DL-SA/SX/ CA/CX/SS	DL-PP/PL	DL-SLV	DL-SUV/ UEV	DH-TP/ TPL	DH-FA / SA/SS
Pump size			15/25/40	15/25/40/ 50/80	15/25/ 40/50/80	25/40/ 50/80	25/40/ 50/80	15/25/ 40/50	15/25/40/ 50/80
	Item	Quantity							
Diaphragm	30	2	●	●	●	●	●	●	●
valve seat	31	4	●	●	●	--	--	--	●
Valve ball	32	4	●	●	●	●	●	●	●
Spring washer	40	2	●	--	●	--	--	--	--
Flat gasket air chamber/ control block and control block cover (interior valve)	51	2	●	●	●	●	●	●	● size 15 only
Flat gasket air chamber/ control block and con- trol block cover (exterior valve)	51Q	2	--	● not type SS	--	--	--	--	--
Shaft bearing	64	2	●	●	●	●	●	●	--
Shaft bearing	64	1	--	--	--	--	--	●	●
Glide ring + O-ring	65	1 Nom- inal width 15, 2 Qty	●	●	●	●	●	●	●
O-Ring ((valve-) housing)	16	4	● size 40 only	--	●	--	--	●	--
O-ring (exterior dia- phragm plate)	38	2	● not size 15	--	● not size 15	--	--	--	--
O-ring	31	8	--	--	--	●	●	--	--
O-ring air filter	68	1	--	● not size 15	--	●	●	--	--
O-ring air inlet	681	1	--	●	●	●	●	--	--
O-ring control block cover	51-1	1	--	--	--	--	--	● not size 15	● not size 15
O-ring control block cover	51-2	1	--	--	--	--	--	● not size 15	● not size 15
O-ring control block cover	51-3	1	--	--	--	--	--	● not size 15	● not size 15
Muffler solenoid valve control block	78M	1	--	--	--	--	--	--	●
O-ring control block	74	1	--	--	● DL80- PP only	--	--	--	--
O-ring T-piece	20	4	--	--	--	--	●	--	--
Product header seal	22	2	--	--	--	●	●	--	--

Spare part kit type M

A-valve

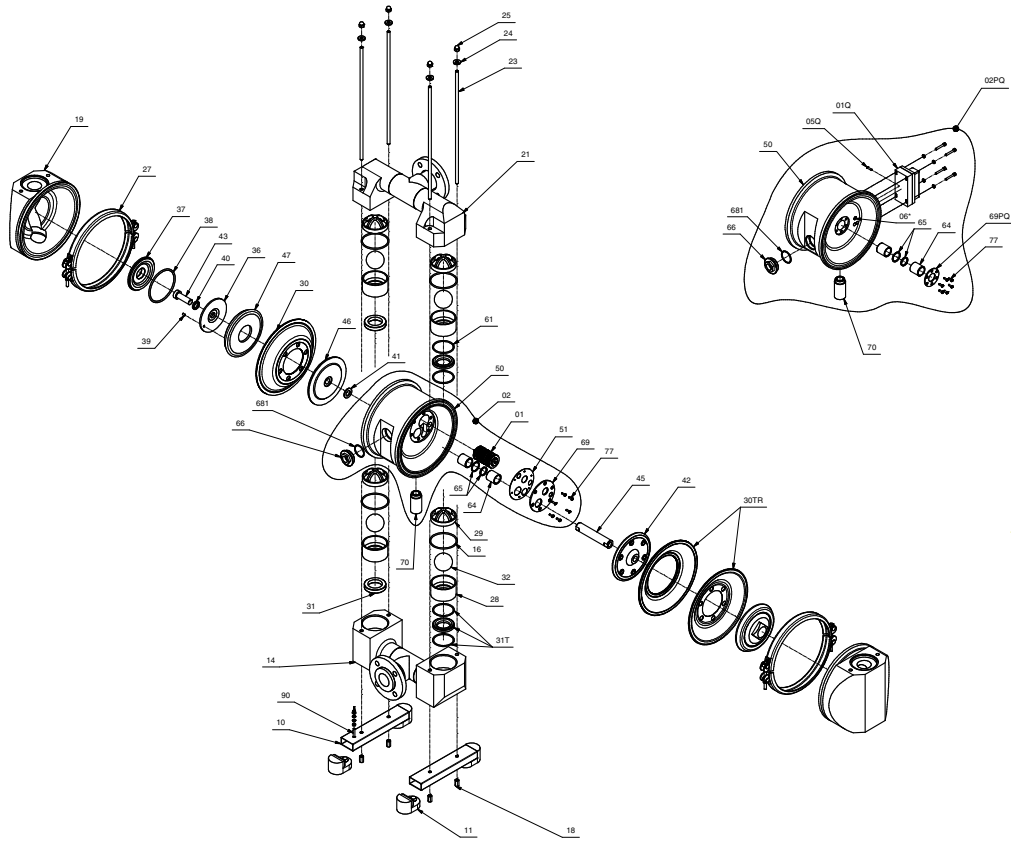


Spare part kit type A

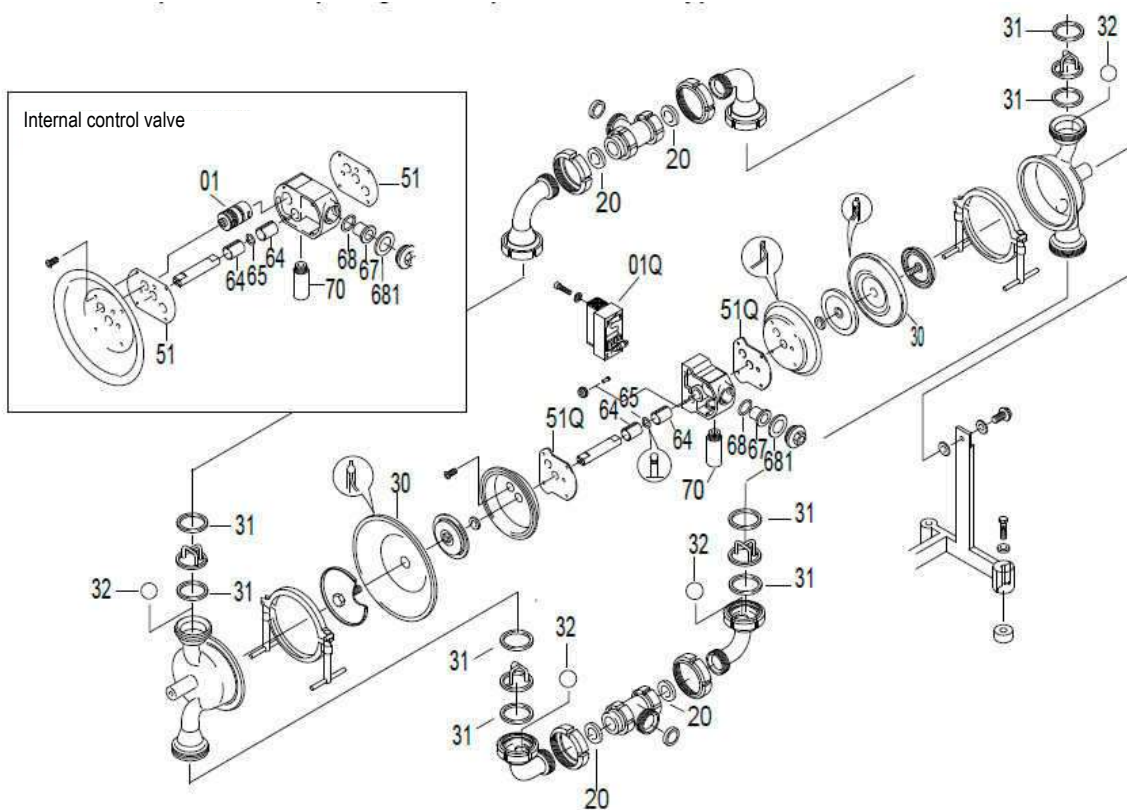


DEPA® Air Operated Diaphragm Pumps

Spare part kit group G / P



Spare part kit type SU / U



9.0 Materials and pump coding

Series	
Standard series made of cast metal, plastic and stainless steel, polished	DL
Cast metal, non metallic (flanged design)	DH
Drum pump	DF
Double pump	DZ
Powder pump	DP
High pressure pump	DB
Special pump without own control valve	DJ/ DH...J

DL 40 - PP - E E E

Pump size			
Connections	G1/2"	DN 15	15
Connections	G1"	DN 25	25
Connections	G1 1/2"	DN 40	40
Connections	G2"	DN 50	50
Connections	G3"	DN 80	80
Connections	suction side flange DN 125 discharge side flange DN 100	DN125	125

Max. pressure range	
All types as specified	E
DB pumps to 21 bar	E
DB pumps to 14 bar	F

Frame or special design	
Polished stainless steel pumps, V-frame construction	V

Material assembly groups			
Housing	Diaphragm plate*****	Centre block	
Cast aluminium	High-grade steel	Cast aluminium	FA
Nodular cast iron***	Steel	Cast aluminium	CA
Nodular cast iron***	Steel	Cast bronze***	CX
Cast high-grade steel	stainless steel	Cast aluminium	SA
Cast high-grade steel electropolished ***	Stainless steel	Cast aluminium	SF
Cast high-grade steel***	Stainless steel	Cast bronze	SX
Cast high-grade steel High grade steel (AISI/BS 304)	Stainless steel Polished stainless (AISI/BS 304)	Stainless steel Cast aluminium	SS
High grade steel AISI/BS 316L (1.4404)	Polished stainless AISI/BS 316L (1.4404)	Cast polished nickel -plated	UL/ SU/ UE
PP*	PP*	PP*	PP
PP injection moulded****	PP*	PP*	PM
PP* electr. conductive	PP* electr. conductive	PP* electr. conductive	PL
PTFE**	PTFE**	PP*	PT
PTFE** electr. conductive	PTFE** electr. conductive	PP* electr. conductive	TPL
Hastelloy	Hastelloy	Stainless steel	HS

Interior equipment	Diaphragm	Seats	Balls
NRS	B	B	B***
NBR	N	N	N***
EPDM	E	E	E***
EPDM (grey)	G	G	G***
FKM (Viton®)	F	F	-
PTFE	T	T	T
EPDM grey for series DH (polished stainless steel pumps)	U	-	-
PTFE ** for series DH (polished stainless steel pumps)	P	-	-
nopped E4® PTFE compound	Z	-	-
Stainless steel	-	R	R
Stainless steel DB	-	H	R***
NBR, steel core***	-	-	Y***
EPDM, steel core***	-	-	W***
EPDM, grau with steel core***	-	-	X***
PTFE**, steel core***	-	-	Z***
NRS, steel core***	-	-	V***
Hytrel®	H	-	-
DEPA® nopped S4	S	-	-
noppedE4® NRS	5	-	-
noppedE4® NBR	1	-	-
noppedE4® EPDM	2	-	-
noppedE4® EPDM (gray)	3	-	-
noppedE4® FKM (Viton®)	4	-	-

- * Polypropylene solid
- ** Polytetrafluoroethylene
- *** not for DL 15
- **** PP-injection molding, only size 15/25/40
- ***** For diaphragms with diaphragm plate attachment

9.1 Pump weights in kg (for combinations with stainless steel seats or balls with core increase the weight of the pump)

Pump size	DH-FA	CA	CX	DL- SA/SF	DH- SA	DH- SS	SX	PM	PP/PL	DH-TP/TPL	DL-SL/SU/UE	DH-UE	DB
15	2	-	-	4,8	7	9,5	-	6	5	11,2	9	10	-
25	8,2	13	16	14	12	17	17	8,4	10	27	21	27	35
40	12	23	24	29	20	24	31	13	17	45,8	30	33	49
50	35,4	50	51	51	42	51	53	-	37	89	57	73	90
80	55	100	105	119	73	85	125	-	75	-	94	-	-

10.0 Category 1 and 2 equipment intended for use in potentially explosive environments

10.1 Equipment category 1

10.1.1 Design, housing and materials

Material type	Pump type code	Min (°C)	Max (°C)	Max. operating pressure (bar)
Stainless steel	DHxx SS	Temperature range is limited by interior fittings		7*

* Max. operating pressure for DHxx- SS outside zone 0 is 8.6 bar

Table 5 Materials and pump types

10.1.2 Usage instructions

The pumps can be used to convey fluids with medium and high conductivity ($k > 50 \text{ pS/m}$) – also flammable fluids – and do not have any time restrictions regarding dry running which occurs when vent the pump/pipelines or during emptying with a resulting droplet/particle/air mixture in the membrane chambers or in the lines.

Only when conveying suspensions or fluids with a low conductivity ($k \leq 50 \text{ pS/m}$), which may also be fluids in the classes IIA and IIB, is dry running to be prevented; i.e. longer than 30 s, when vent the pump, or during empty conveyance with a resulting droplet/particle/air mixture in the diaphragm chambers or in the pipelines.

The DH80-SS type must only be used for the transport of fluids with an average or high conductivity.



If substances penetrate the sealed air valve through defective diaphragms (diaphragm rupture), pump operation must be stopped immediately.

In explosive environments, the pump must be monitored in the case of incomplete media filling (e.g. suction and snore mode), and if there is fluid leak-

age at the exhaust outlet (e.g. muffler), the pump must be switched off and only put back into operation further to being checked (see Section 6.0).

The muffler permanently discharges relieved compressed air. This air can whirl up dust and thus generate an explosive atmosphere.



When using nopped E4® PTFE compound diaphragms and PTFE diaphragms, in each case size 80, microfilters in the pump inlet are not permitted. Multiphase insulating liquids must not be pumped with DEPA nopped E4® compound diaphragms as well as PTFE diaphragms and PTFE valve balls, in each case size 80.

In order to ensure correct functioning of the pump the maximum pumped medium particle sizes listed in the following table must not be exceeded.

Pump type DH SS	Pump size				
	15	25	40	50	80
Particle size (mm)	5	8	11	13	18

Table 6: max. particle sizes

10.1.3 Equipotential bonding

Earthing of pump and pulsation damper by means of earthing screw or discharging hoses must take place before bringing the pump into the potentially explosive environment.



All connected pipes, components and hoses must be electro-conductive (discharge resistance <1 mega ohm meter; surface resistance <1 giga ohm).



When using the pump in zone 0, the exhaust air from the pump must be discharged from the explosive environment via electro-conductive piping or an electro-conductive hose.



When using the pump in zone 0, the pump must be fixed directly to the ground without any damping elements.

10.1.4 Vibration distance

When installing the pump, ensure a sufficient distance (DH15 to DH40 of at least 5 cm; DH50 and DH80 of at least 10 cm) between pump and other components, except the connections.

10.1.5 Equipment category 1 accessories

For installed electrical components, the manufacturer's own declaration of conformity must be observed.

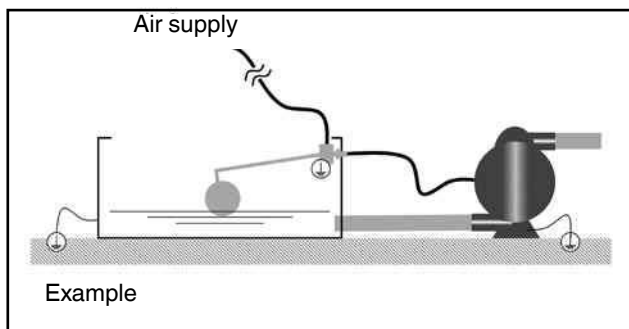


Fig. 24: Installation instructions for the level control

10.1.5.1 The level control



Earthing must be provided when a level control is installed

10.2 Equipment category 2

see 3.11, 3.13 10.1.3, 10.1.5.1, 10.4,

10.3 Temperature information for category 1 and 2 equipment

10.3.1 Surface temperature

When used as intended, the pump will not get hot, ensuring a near-ambient or pumped medium temperature. All moving parts are cooled by the expanding drive air (gas). However, due to the high medium temperature the surface of the pump may also reach the temperature of the medium.

10.3.2 Pumped medium temperature



Note: The pump's maximum pumped medium temperature is limited by the diaphragm materials, see Table 7:



The temperature class of the pump T6-T4 indicates that the pump does not act as its own additional heat source.

Diaphragm materials	Code	Max (°C)
nopped E4® PTFE compound	Z	130
EPDM	2	105
NBR	1	90

Table 7: max. pumped medium temperature

10.3.3 Ambient temperatures

Ambient temperature range for operation: -20°C to +40°Celsius.

10.4 Maintenance instructions for category 1 and 2 equipment



Check all lines and fittings regularly for leaks and externally visible damage! Repair any damage immediately!

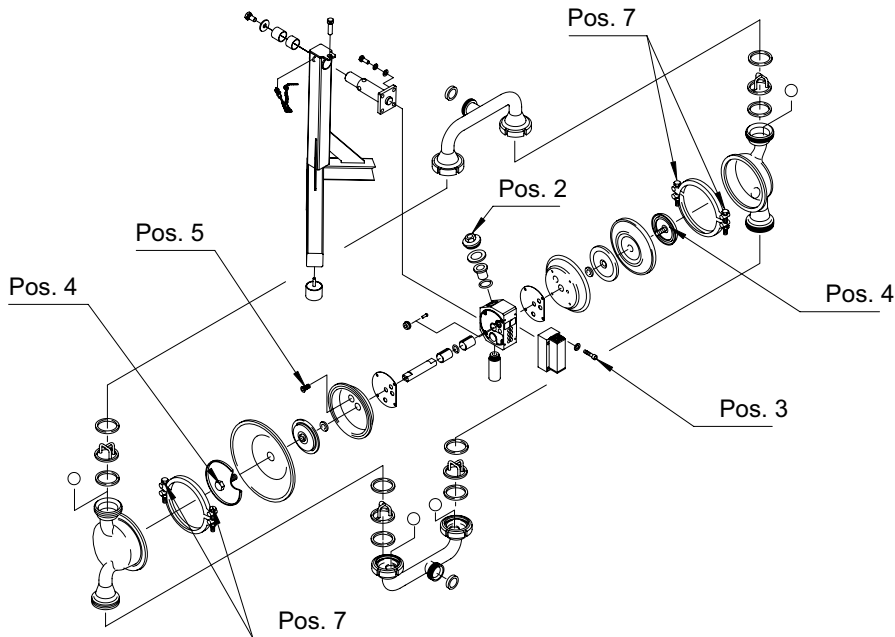


Danger! Before working with the pump, the pump must be moved from the ATEX area to a work area.



Pumps intended for use in potentially explosive environments must always be kept free of dust deposits.

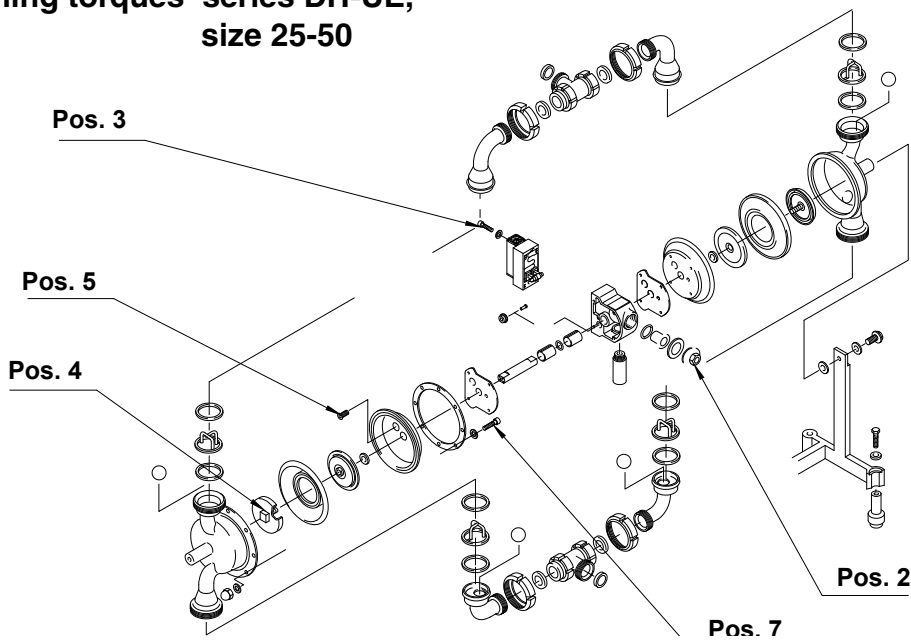
11.0 Tightening torques
Tightening torques series L, size 25-80



Pump size	Air inlet Pos. 2	Air valve Pos. 3	Piston Pos.4	Air chamber Pos. 5	Clamp band Pos. 7
DL25-L	50 Nm	8 Nm	-	20 Nm	max. 23 Nm
DL40-L	50 Nm	8 Nm	90 Nm	20 Nm	max. 23 Nm
DL50-L	85 Nm	8 Nm	150 Nm	39 Nm	max. 23 Nm
DL80-L	85 Nm	8 Nm	150 Nm	39 Nm	max. 23 Nm

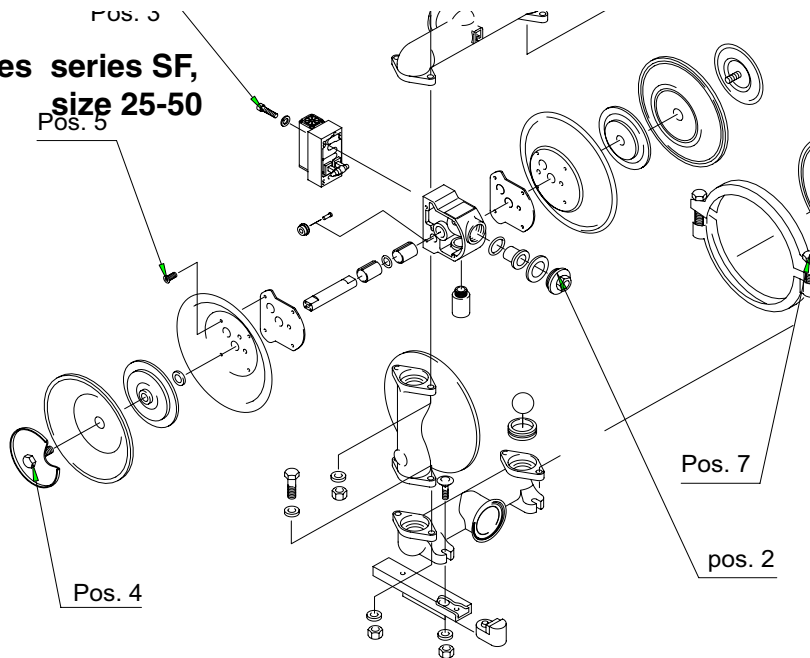
DEPA® Air Operated Diaphragm Pumps

Tightening torques series DH-UE, size 25-50



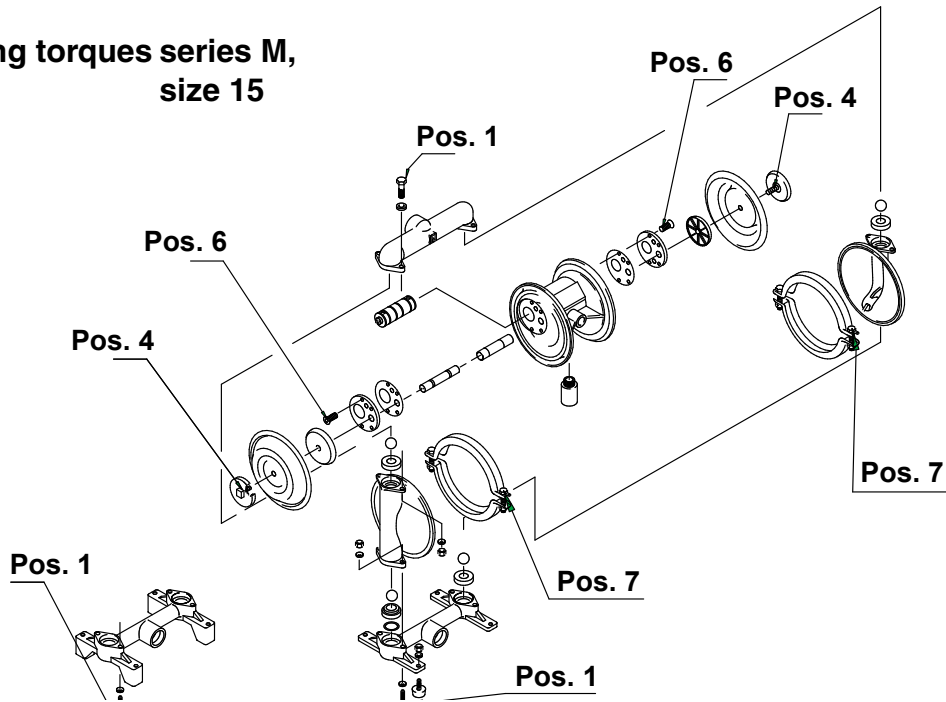
Pump size	Air inlet Pos. 2	Air valve Pos. 3	Piston Pos. 4	Air chamber Pos. 5	Pump chamber / Flange, Pos. 7
DH25-UE	50 Nm	8 Nm	90 Nm	20 Nm	25 Nm
DH40-UE	50 Nm	8 Nm	90 Nm	20 Nm	25 Nm
DH50-UE	85 Nm	8 Nm	150 Nm	39 Nm	49 Nm

Tightening torques series SF, size 25-50



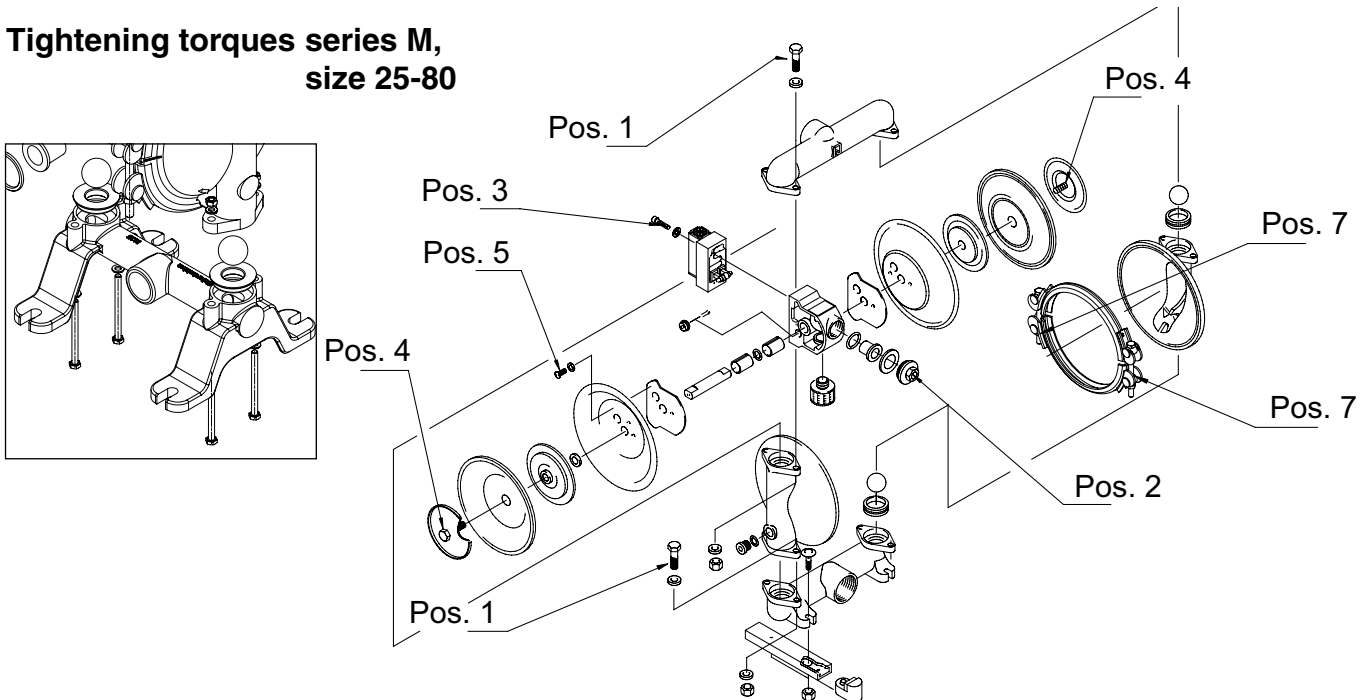
Pump size	Suction / Discharge manifold, Pos. 1	Air inlet Pos. 2	Air valve Pos. 3	Piston Pos. 4	Air chamber Pos. 5	Clamp band Pos. 7
DL25-SF	10 Nm	50 Nm	8 Nm	70 Nm	20 Nm	max. 23 Nm
DL40-SF	25 Nm	50 Nm	8 Nm	90 Nm	20 Nm	max. 23 Nm
DL50-SF	49 Nm	85 Nm	8 Nm	150 Nm	39 Nm	max. 23 Nm

Tightening torques series M, size 15



Pump size	Suction / Discharge manifold, Pos. 1	Piston Pos. 4	Centre block cover Pos. 6	Clamp band Pos. 7
DL15-M	7 Nm	6 Nm	3 Nm	max. 23 Nm

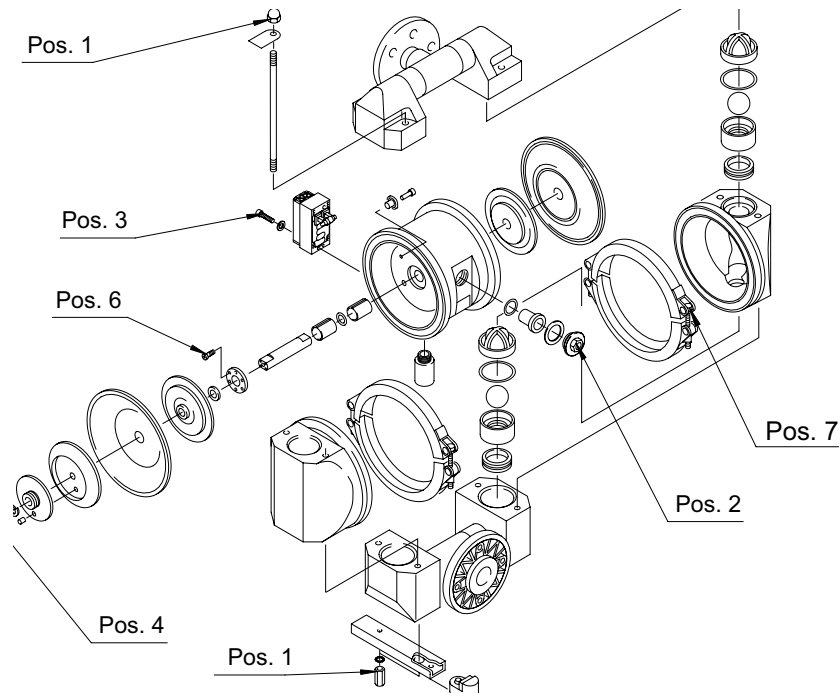
Tightening torques series M, size 25-80



Pump size	Suction / Discharge manifold, Pos. 1	Air inlet Pos. 2	Air valve Pos. 3	Piston Pos. 4	Air chamber Pos. 5	Clamp band Pos. 7
DL25-M	25 Nm	50 Nm	8 Nm	70 Nm	20 Nm	max. 23 Nm
DL40-M	25 Nm	50 Nm	8 Nm	90 Nm	20 Nm	max. 23 Nm
DL50-M	49 Nm	85 Nm	8 Nm	150 Nm	39 Nm	max. 23 Nm
DL80-M	49 Nm	85 Nm	8 Nm	150 Nm	39 Nm	max. 23 Nm

DEPA® Air Operated Diaphragm Pumps

Tightening torques series P, size 15-80



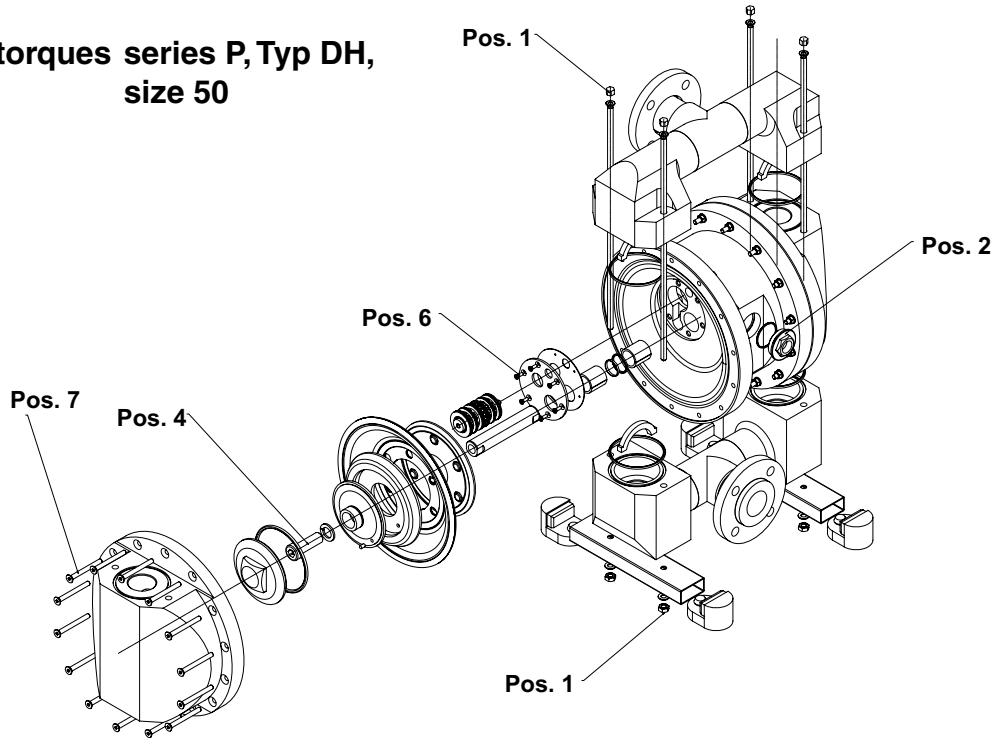
Pump size	Anchor rod Pos. 1	Air inlet Pos. 2	Air valve Pos. 3	Piston Pos. 4	Centre block cover, Pos. 6	Clamp band Pos. 7
DL15-P	10 Nm	-	-	6 Nm	2,5 Nm	7 Nm
DL25-P	10 Nm	50 Nm	8 Nm	70 Nm	2,5 Nm	8 Nm
DL40-P	25 Nm	50 Nm	8 Nm	90 Nm	2,5 Nm	10 Nm
DL50-P	49 Nm	85 Nm	8 Nm	150 Nm	5,5 Nm	12 Nm
DL80-P	49 Nm	85 Nm	8 Nm	150 Nm	5,5 Nm	15 Nm

Tightening torques series PT, size 15-80 (drawing see above)

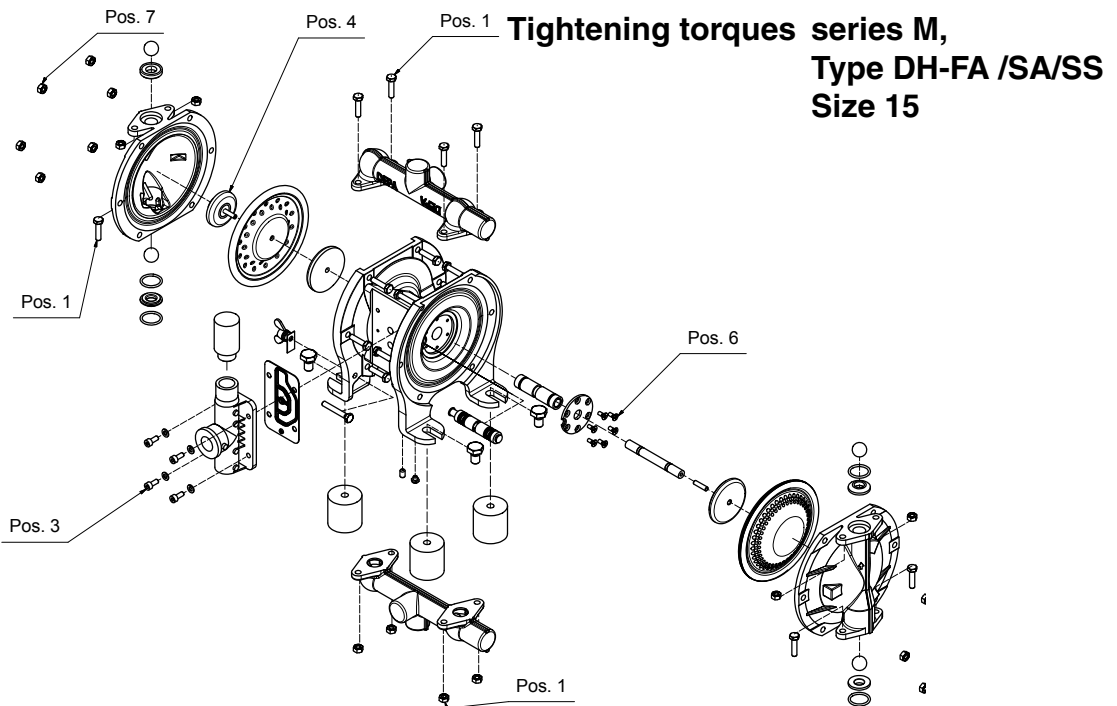
Pump size	Anchor rod Pos. 1	Air inlet Pos. 2	Air valve Pos. 3	Piston Pos. 4	Centre block cover, Pos. 6	Clamp band Pos. 7
DL15-PT	10 Nm	-	-	5 Nm	2,5 Nm	7 Nm
DL25-PT	10 Nm	50 Nm	8 Nm	70 Nm	2,5 Nm	8 Nm
DL40-PT	22 Nm	50 Nm	8 Nm	90 Nm	2,5 Nm	10 Nm
DL50-PT	25 Nm	85 Nm	8 Nm	150 Nm	5,5 Nm	12 Nm

DEPA® Air Operated Diaphragm Pumps

Tightening torques series P, Typ DH, size 50



Pump size	Anchor rod Pos. 1	Air inlet Pos. 2	Air valve Pos. 3	One piece diaphragm Pos. 4	Piston Pos. 4	Centre block cover Pos. 6	Pump chamber/ Centre block Pos. 7
DH50-P	35 Nm	85 Nm	8 Nm	-	150 Nm	5,5 Nm	12 Nm

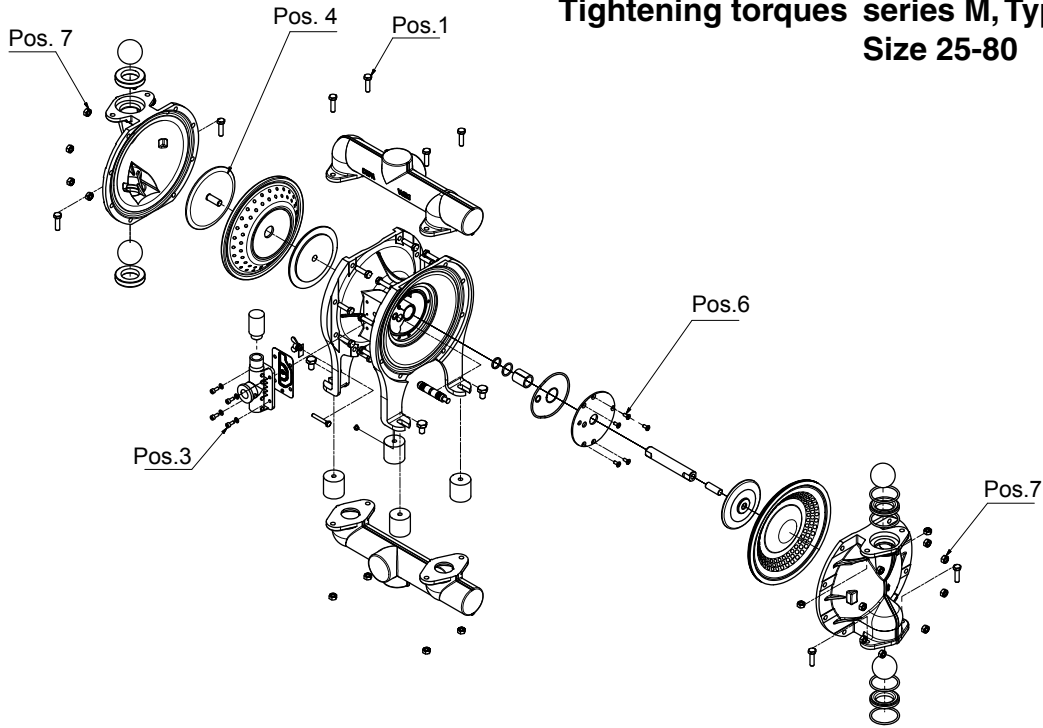


Tightening torques series M, Type DH-FA /SA/SS Size 15

Pump size	Suction / Discharge manifold Pos. 1	External air valve Pos. 3	Piston rod Pos. 4	Centre block cover Pos. 6	Pump chamber Pos. 7
DH15-FA	9 Nm	8 Nm	6 Nm	3 Nm	9 Nm

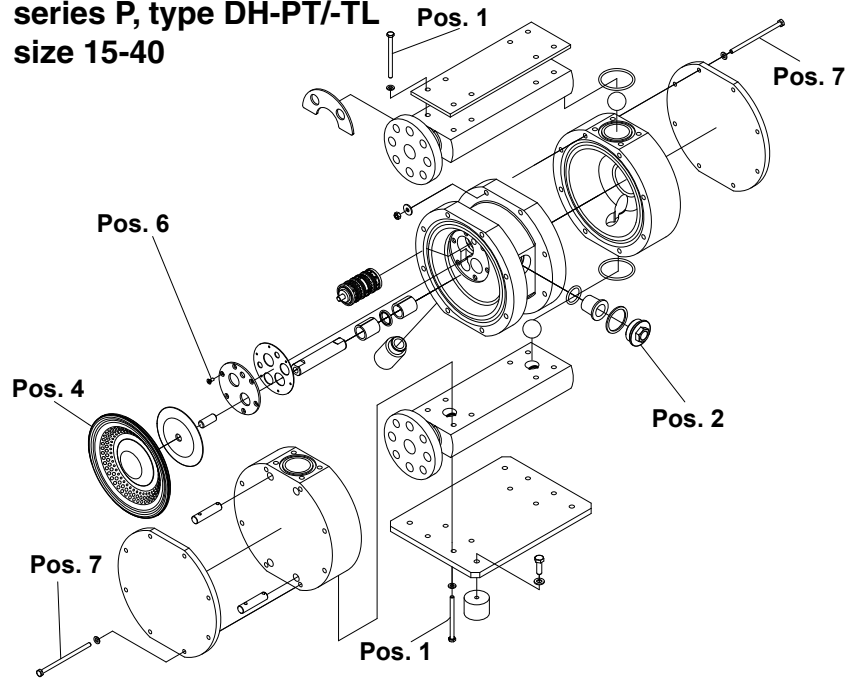
DEPA® Air Operated Diaphragm Pumps

Tightening torques series M, Type DH-FA /SA/SS Size 25-80



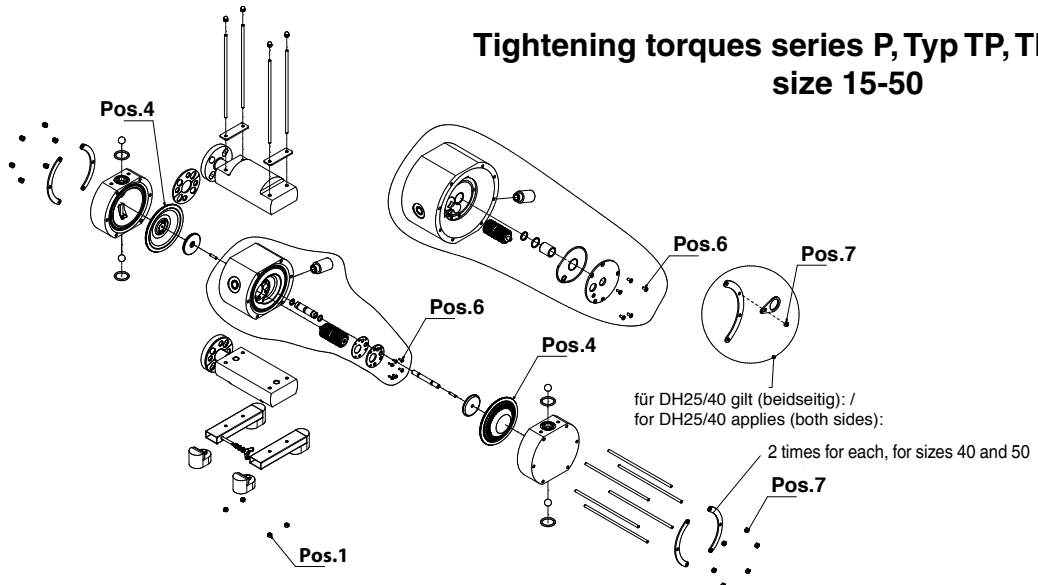
Pump size	Suction / Discharge manifold Pos. 1	External air valve Pos. 3	Piston rod Pos. 4	Centre block cover Pos. 6	Pump chamber Pos. 7
DH25-FA	25 Nm	8 Nm	70 Nm	5 Nm	25 Nm
DH40-FA	25 Nm	8 Nm	90 Nm	5 Nm	25 Nm
DH50-FA	50 Nm	-	150 Nm	5 Nm	50 Nm
DH80-FA	50 Nm	-	150 Nm	5 Nm	50 Nm

Tightening torques series P, type DH-PT/-TL size 15-40



Pump size	Manifold / Pump chamber Pos. 1	Air inlet Pos. 2	Diaphragm Pos. 4	Centre block cover Pos. 6	Pump chamber / Centre block Pos. 7
DH15-PT/TL	3 Nm	50 Nm	1 Nm	2,5 Nm	6 Nm
DH25-PT/TL	5 Nm	50 Nm	1 Nm	2,5 Nm	6 Nm
DH40-PT/TL	5 Nm	50 Nm	1 Nm	2,5 Nm	6 Nm

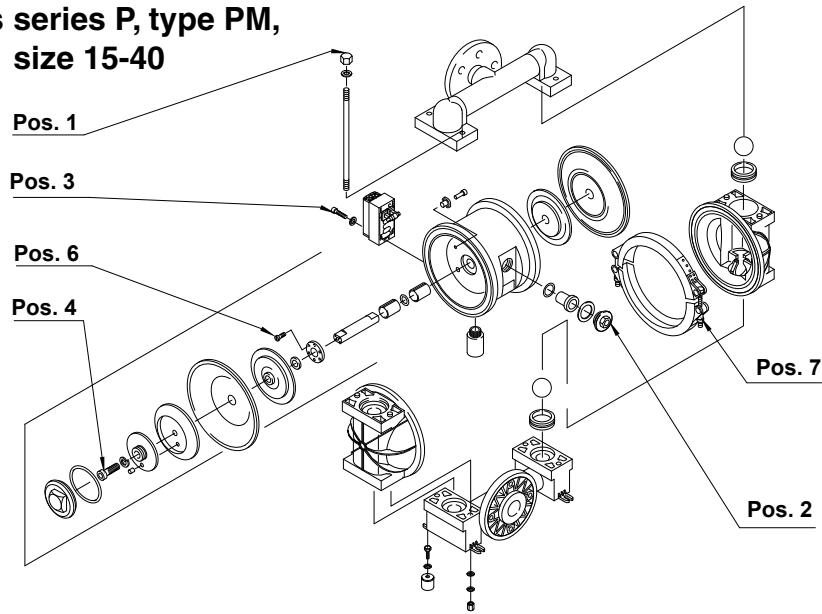
Tightening torques series P, Typ TP, TPL size 15-50



Pump size	Manifold Pos. 1	Diaphragm Pos. 4	Centre block cover Pos. 6	Pump chamber Pos. 7
DH15-TP, TPL	4 Nm	1 Nm	3 Nm	4 Nm
DH25-TP, TPL	4 Nm	1 Nm	5 Nm	4 Nm
DH 40-TP, TPL	8 Nm	1 Nm	5 Nm	8 Nm
DH 50-TP, TPL	12 Nm	1 Nm	5 Nm	26 Nm

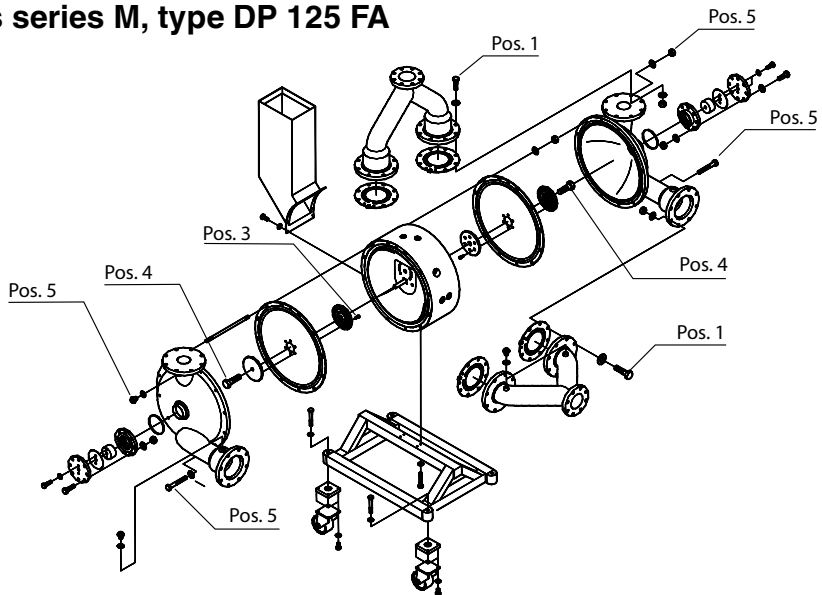
DEPA® Air Operated Diaphragm Pumps

Tightening torques series P, type PM, size 15-40



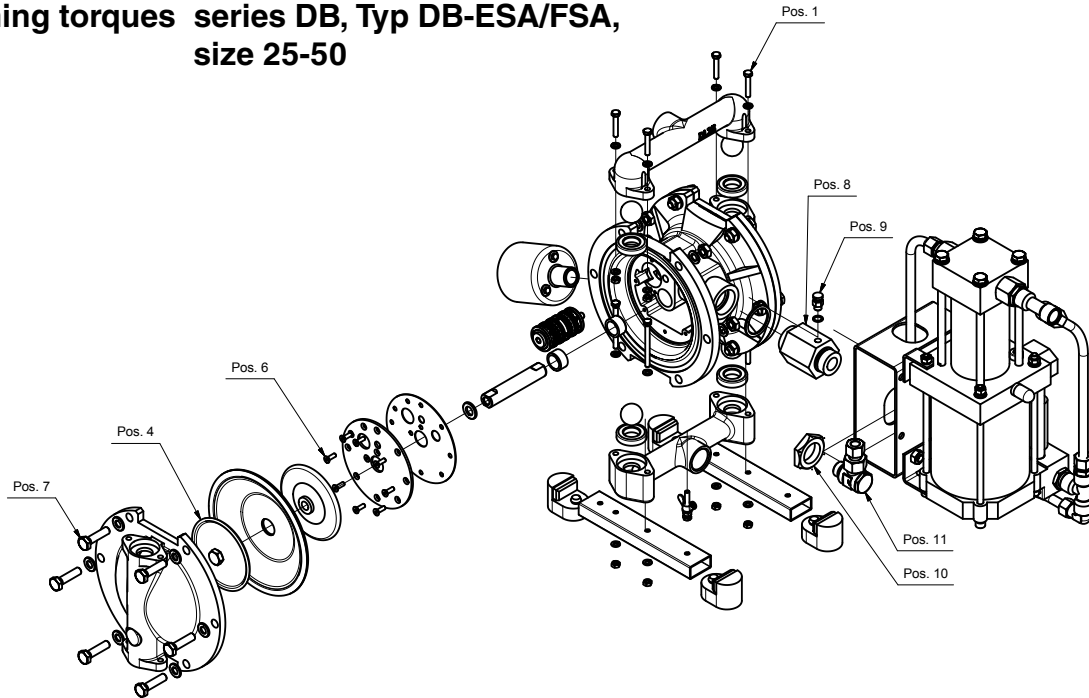
Pump size	Anchor rod Pos. 1	Air inlet Pos. 2	Air valve Pos. 3	Piston Pos. 4	Centre block cover, Pos. 6	Clamp band Pos. 7
DL15-PM	5 Nm	-	-	6 Nm	2,5 Nm	7 Nm
DL25-PM	10 Nm	50 Nm	8 Nm	70 Nm	2,5 Nm	8 Nm
DL40-PM	25 Nm	50 Nm	8 Nm	90 Nm	2,5 Nm	10 Nm

Tightening torques series M, type DP 125 FA



Pump size	Suction / pressure socket Pos. 1	Diaphragm plate inside	Diaphragm plate Pos. 3	Pump chamber / control block Pos. 5
DP125-FA	75 Nm	37 Nm	150 Nm	60 Nm

Tightening torques series DB, Typ DB-ESA/FSA, size 25-50



Pump size	Suction / pressure socket Pos. 1	Diaphragm plate Pos. 4	Centre block cover Pos. 6	Pump chamber Pos. 7	Adapter Pos. 8	Valve Pos. 9	Screw nut Pos. 10	Screw connection Pos. 11
DB25-SA	9 Nm	70 Nm	5 Nm	50 Nm	50 Nm	12 Nm	190 Nm	110 Nm
DB40-SA	25 Nm	90 Nm	5 Nm	50 Nm	50 Nm	12 Nm	190 Nm	110 Nm
DB50-SA	50 Nm	150 Nm	5 Nm	50 Nm	85 Nm	12 Nm	190 Nm	110 Nm