

# DIAPHRAGM DRY VACUUM PUMP

## INSTRUCTION MANUAL

MODEL DA-20D  
MODEL DA-40S

### Prior to use

For safe and efficient use of this pump, please read this manual carefully before operation.

After reading the manual, keep it in your file for future reference.

Specifications in this manual are subject to change without notice due to future improvement.

ULVAC KIKO, Inc.

## Contents

Pages with a shaded background are those, which contain items related to safety.

Before Using the Equipment	01
Checks When Opening Packaging	02
Using the Pump Safely	03
Safety icons	03
Cautions for Safety in Use	03
1. Product Outline	1
1.1 Purpose of Use and Prohibitions	1
1.2 Specifications	1
1.3 Thermal Protector	1
2. Dimensions	2
3. Installation and Storage	3
3.1 Cautions for Installation and Storage	3
3.2 Environmental Conditions for Installation, Storage, and Operation	3
3.3 Location	3
3.4 Electric Wiring	4
3.5 Fluctuations in the power voltage and frequency	5
3.6 Checking Operation After Installation	6
3.7 Piping	6
3.8 Storage	6
4. Cautions for Operation	6
4.1 Cautions for Operation	6
4.2 Operation of the Thermal Protector	7
4.3 Starting in Cold Weather	7
5. Pump Performance	7
5.1 Pressure Achieved	7
5.2 Evacuation Rate	7
5.3 Power Requirements	7

6. Maintenance, Inspection, and Repair .....	8
6.1 Cautions for Maintenance, Inspection, and Repair .....	8
6.2 Maintenance .....	8
6.3 Regular Inspections .....	8
6.4 Replacing and Cleaning Consumables .....	9
6.5. Troubleshooting List .....	16
7. In Conclusion .....	17
Warranty .....	17
Usage Status Check Sheet	

#### Figures and Tables

Fig.1 DA-20D Dimensions .....	2
Fig.2 DA-40S Dimensions .....	2
Fig.3 Attaching Anti-vibration Rubbers .....	4
Fig.4 Screws for Anti-vibration Rubbers .....	4
Fig.5 Change region of the voltage and frequency .....	5
Fig.6 Example of Piping Used When Evacuating a Vessel .....	6
Table 1 Specifications .....	1
Table 2 Consumables List .....	8
Table 3 Locations for Maintenance and Inspection .....	9
Table 4 Troubleshooting List .....	16

## Before Using the Equipment

Thank you for purchasing this product. Your custom is very much appreciated.

This pump is designed solely for vacuum discharge, and may malfunction or cause accidents if not handled appropriately. Read the manual thoroughly, and pay due attention to inspections, maintenance, and safety.

## Personnel Handling the Equipment

Only persons who have read this manual thoroughly, and have sufficient understanding of safety, pump specifications, and method of operation, may operate this pump.

## Read the Manual Thoroughly

Read the manual thoroughly in order to use the equipment correctly. Read the section on Safe Use particularly closely.

## Keep This Manual in a Safe Place

After reading this manual, be sure to keep it in a safe place, which is readily accessible to others needing to use it.

## Copying This Manual Is Prohibited

No part of this manual may be copied for use by a third party without the express permission of the manufacturer.

## Statutory Requirements for Disposal

Follow all statutory and local authority regulations when disposing of this pump.

## Safety During Repair

Please provide a full description of the circumstances of use (particularly the use of dangerous materials) for the safety of repair personnel when requesting the manufacturer for repairs to the pump. Your request for repair of may be refused if these circumstances are unclear.

## Checks When Opening Packaging

Check the following after opening the packaging.

(1) Is the product as you requested?

(2) Are the accessories and necessary parts included?

Standard accessories

- User's manual ----- x1
- Inlet and outlet caps (fitted to inlet and outlet) ----- x2

〈In case motor specification is 100V〉

- Power plug adapter (attached to power cord) ----- x1

(3) Is the pump damaged in any way?

(4) Are any external screws or inlet and outlet pipes loose? Are any components missing?

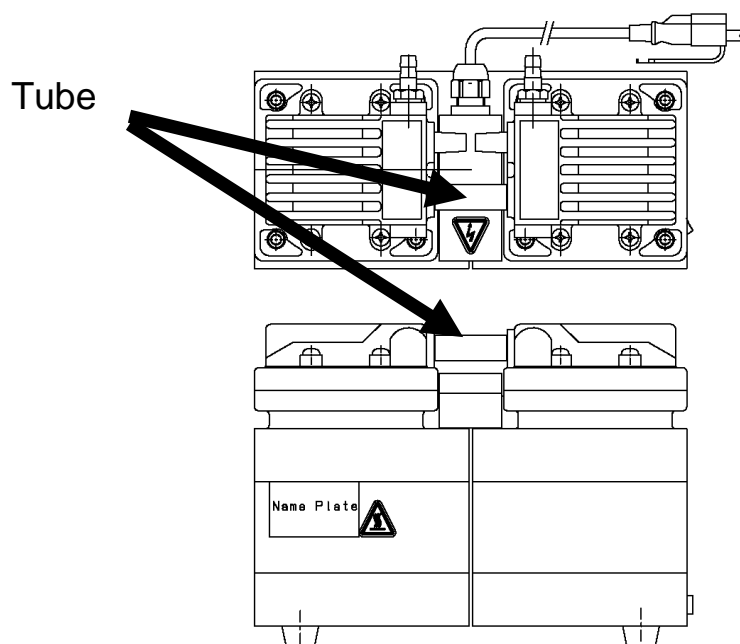
Contact your agent or the sales division of the manufacturer if there are any problems with the pump.



## Note

Do not hold or push the tube at the top of the pump while removing it from the packaging.

Damage to the tube may affect performance of the pump.









## Using the Pump Safely

To ensure that the pump is handled correctly, read this section thoroughly before use.

This manual and the warning labels on the pump include safety icons as an aid to understanding safety requirements.

These safety icons warn the operator and others of possible dangers and damage and should always be followed.

- **Safety icons** The meanings of the safety icons are as follows.

 <b>Danger</b>	Incorrect handling of the equipment is very likely to result in death or serious injury to the operator.
 <b>Warning</b>	Incorrect handling of the equipment may result in death or serious injury to the operator.
 <b>Caution</b>	Incorrect handling of the equipment may result in light or medium injuries to the operator or damage to the equipment.
 <b>Note</b>	Incorrect handling of the equipment may result in damage to the equipment and hinder its correct operation.
 <b>High Temperatures</b>	Some components reach surface temperatures in excess of 60°C during pump operation. Burns may result if these components are touched during operation.
 <b>Electric Shock</b>	To prevent electric shock, always shut-off the primary power supply before working on electrical wiring, or engaging in any electrical work.

- **Cautions for Safety in Use**

## **Danger**

### Applications

- (1) This pump is not designed to be explosion-proof, and should therefore not be used to discharge explosive gases. Such use may result in injury and fire.
- (2) In addition to discharge of gas via the outlet, gas may also leak from other parts of the pump, and it should therefore not be used with toxic gases. If toxic gas is discharged for any reason it is important to note that the interior of the pump will be contaminated by the gas, requiring appropriate caution during maintenance.

### Maintenance and Repair

- (3) When requesting the manufacturer's service division to dismantle and repair the pump, always note the gas which the pump has been used with on the Usage Check Sheet. Note that if it has been used to discharge toxic gas for any reason it will be contaminated. **Please be aware that use with some gases will preclude dismantling and repair.**

## **Warning**

### Installation

- (1) Do not use the pump in an explosive atmosphere. Such use may result in injury and fire.
- (2) Ensure that there are no inflammable materials such as solvents in the vicinity when using the pump.
- (3) Ensure that the pump is freely ventilated to prevent overheating, which may result in fire or burns.
- (4) When replacing rubber legs with anti-vibration rubbers, ensure that screws used for their attachment to the pump are 3.5 – 4 mm in length. If these screws are longer than 4 mm, they may interfere with internal components, and result in electric shock.

### Power Supply

- (5) Always check the pump and install wiring with the power cord disconnected. Working with power connected may result in electric shock, or the pump starting unexpectedly.
- (6) Ensure that wiring is installed by persons qualified in accordance with regulations for wiring (e.g. technical standards for electrical equipment, requirements for internal wiring). Incorrect wiring may result in fire.
- (7) Ensure that lead wiring is properly connected and insulated with insulation tape (or an insulating cap).
- (8) Always ensure that the pump is correctly earthed. A dedicated earth leakage breaker is recommended. Failure to earth the pump correctly may result in electric shock if a fault or earth leakage occurs.
- (9) Use the pump only at the rated voltage. Use at other than the rated voltage will interfere with operation of the overload protection device, and this may result in the motor burning out, or fire.
- (10) Do not damage, modify, and pull the power cord, or place objects on it. Damage to the cord may result in electric shock or fire.
- (11) Always fully insert the power cord into the socket. Partial insertion may result in electric shock.
- (12) Remove the cord from the socket while holding the plug. Failure to do so may result in electric shock.
- (13) Touching the power cord with wet hands may result in electric shock.
- (14) Touching electrical wiring etc while inserting the power plug may result in electric shock.
- (15) The electric motor fitted to this pump incorporates a thermal protector, however it is not guaranteed to be open when it eventually fails at some time. For safety reasons therefore, it is necessary to fit an overload (over current), protection device and an earth leakage breaker.

### Operation

- (16) This pump is not designed to be explosion-proof. When using the pump, ensure that there are no inflammable materials such as solvents, or explosive gases, in the vicinity. Use under such conditions may result in injury or fire.
- (17) Inserting fingers or objects into the motor inlet may result in electric shock, injury, or fire.
- (18) Operating the pump with the discharge outlet blocked, or with a device which prevents passage of gas to the discharge outlet, may result in rupture of the pump. The internal pressure of the pump rises and the pump body may rupture and the motor become overloaded.  
This pump is not designed to be pressure-resistant. The internal pressure of the pump is limited to 0.03 MPa (gauge pressure).

### Maintenance and Repair

- (19) The pump should be dismantled or repaired only by a repair technician trained by the manufacturer.
- (20) To prevent ingestion of microscopic particles resulting from wear of components, use a dust mask and gloves during repair work.



## Caution

### Installation

- (1) The fine clearances used in this pump require that the following conditions be satisfied during storage, installation, and operation.
  1. Ambient temperature of 7~40°C and maximum relative humidity of 85% during operation.
  2. Equal to or less than meters above the sea level 1000m storage and operation.
  3. Other conditions for storage and operation.
    - a) Level floor of sufficient strength.
    - b) No condensation
    - c) Dust-free environment
    - d) Well ventilated
    - e) Environment free of corrosive or explosive gas.
    - f) Not subject to direct sunlight.
    - g) No danger of fire.
    - h) Maximum ambient temperature of 40°C during assembly of pump.
    - i) Free of soot and oil.
    - j) Free of splashing or flooding.
    - k) Keep it indoor ventilated.
    - l) When installing the pump, avoid mounting a vacuum pump directly on the base. Employ anti-vibration rubber between the base and the vacuum pump.
- (2) To prevent back injury, **always use both hands to lift pumps.**
- (3) Microscopic particles resulting from wear of components are discharged from the outlet and contaminate the room. If necessary, connect a pipe from the discharge outlet to the outside of the building.

### Operation

- (4) **Do not use in applications involving organ transplants, or contact with body fluids or living tissue.**
- (5) Touching rotating components (eg motor, main shaft, axial joints, cooling fan) while the pump is in operation may result in injury.
- (6) The overload protector operates when the pump becomes excessively hot. Touching it in this condition may result in burns.
- (7) Touching the motor while the pump is in operation or while it is still hot immediately after having been switched off may result in burns.
- (8) Do not insert fingers or objects into, or peer into, the inlet or outlet during operation.
- (9) Ensure that the customer installs a trap if steam is generated. Ensure that condensate does not enter the vacuum pump. A malfunction may result if condensate enters the pump.





## Caution

### Maintenance and Repair

- (10) Dispose in accordance with legislation for disposal and cleaning of waste products, handle as industrial waste, and do not incinerate.
- (11) If the pump ceases operation, turn power OFF (set switch to O) immediately to prevent accidents, remove the power cord from the wall outlet, and contact your dealer or the manufacturer for inspection and repair.
- (12) Leave the pump for at least 30 minutes until it has cooled, and begin operation again. Touching the pump immediately after it has stopped may result in burns.
- (13) As the pump is not protected against entry of water, it is not guaranteed against splashing or flooding.



## Note

### Installation

- (1) The pump may malfunction if it is subjected to shocks or tipped over on its side.
- (2) Do not place objects on, or stand on, the pump. A malfunction may result if the pump is handled in this manner.
- (3) Float the pump from the system using a rubber shock absorber; install the pump so that vibration is not transmitted to the system.
- (4) By removing the fixed rubber legs, do not install the pump directly to the system. There would be a case that the pump casing is deformed and a load occurs to the motor bearing.

### Applications

- (5) This pump is not designed to be corrosion-proof. Use it only with clean air at normal temperature, or with gases of equivalent characteristics.
- (6) Do not use the pump for pressurization (Do not use the pump with a pressurized air supply).
- (7) Ingestion of liquids into the pump will result in damage and prevent proper operation.
- (8) Ingestion of rubbish and dust in the air entering the pump will interfere with its proper function. If the air is likely to contain rubbish or dust, a filter should be fitted to the inlet to protect the pump.

### Operation

- (9) Ensure that the pump is used within an ambient temperature range of 7 - 40°C. Use at high temperatures will dramatically reduce the life of the pump.
- (10) Back pressure at the outlet while the pump is starting may overload the motor.
- (11) The thermal protector operates when the pump reaches a very high temperature. Touching the pump in this condition may result in burns.

### Maintenance and Repair



- (12) The fine clearances used in this pump require skill in its assembly. If a repair technician is unavailable, replacement of all consumables should be left to the manufacturer's service division.

## 1. Product Outline

### 1.1 Purpose of Use and Prohibitions

This product is a dry vacuum pump which employs reciprocating motion of a rubber diaphragm for vacuum discharge.

Observe the following prohibitions to ensure normal operation of the pump.

< Prohibitions >	
 <b>Warning</b>	(1) This pump employs only vacuum operation, and must not be pressurized. (2) Do not re-sell, repair, or modify this pump without the approval of the manufacturer.
 <b>Note</b>	(3) Ensure that the gas entering the pump does not contain rubbish, dust, or water (except steam). (4) Do not operate the pump for long periods at near-atmospheric pressure.

### 1.2 Specifications

Table.1 Specifications



Model	DA-20D	DA-40S
PumpingSpeed (50Hz/60Hz)	20/24 L/min	40/46 L/min
Ultimate Pressure	$5.33 \times 10^3$ Pa (* $9.33 \times 10^3$ Pa)	$19.9 \times 10^3$ Pa (* $22.6 \times 10^3$ Pa)
Weight	7.2 kg	
Suction/Exhaust Pipe	O.D. $\phi 9$ x I.D. $\phi 5$ mm (R1/4)	
Operating Ambient Temperature	7°C ~ 40°C	
Outside dimensions	118(W) x 242(L) x 178(H) mm	128(W) x 242(L) x 178(H) mm

\* with unloader valve

Motor	100V	115V	200V	220V
	1 $\phi$ , 60W, 4P, Capacitor run			
Rated Current (50Hz/60Hz)	1.60/1.60 A	1.50/1.50 A	0.80/0.80 A	0.80/0.80 A
Revolution (50Hz/60Hz)	1,250/1,450 r/min	1,395/1,683 r/min	1,250/1,450 r/min	1,390/1,680 r/min

### 1.3 Thermal Protector

- 1) This pump is fitted with an automatic reset thermal protector for overload protection. This device shuts off the motor power supply circuit automatically to prevent burn-out if the motor temperature rises due to a pump fault which prevents rotation, or if load becomes excessive.
- 2) It is recommended that additional protective devices (eg. earth leakage breaker, motor breaker) be fitted.

 <b>Warning</b>	See Warning (8)(14), P04
 <b>Caution</b>	See Caution (6), P05

## 2. DIMENSIONAL DRAWING

※ When motor specifications are 115V, 200V, and 220V, a power cord is three core cable. Plug adapter is not attached.

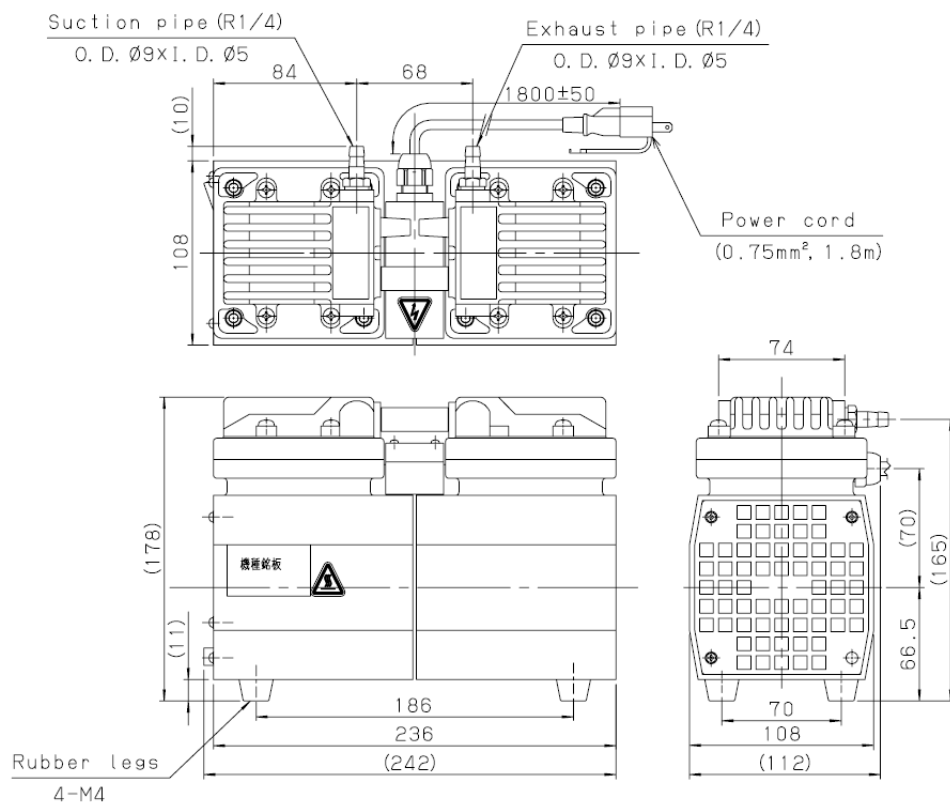


Fig.1 DA-20D Dimensions

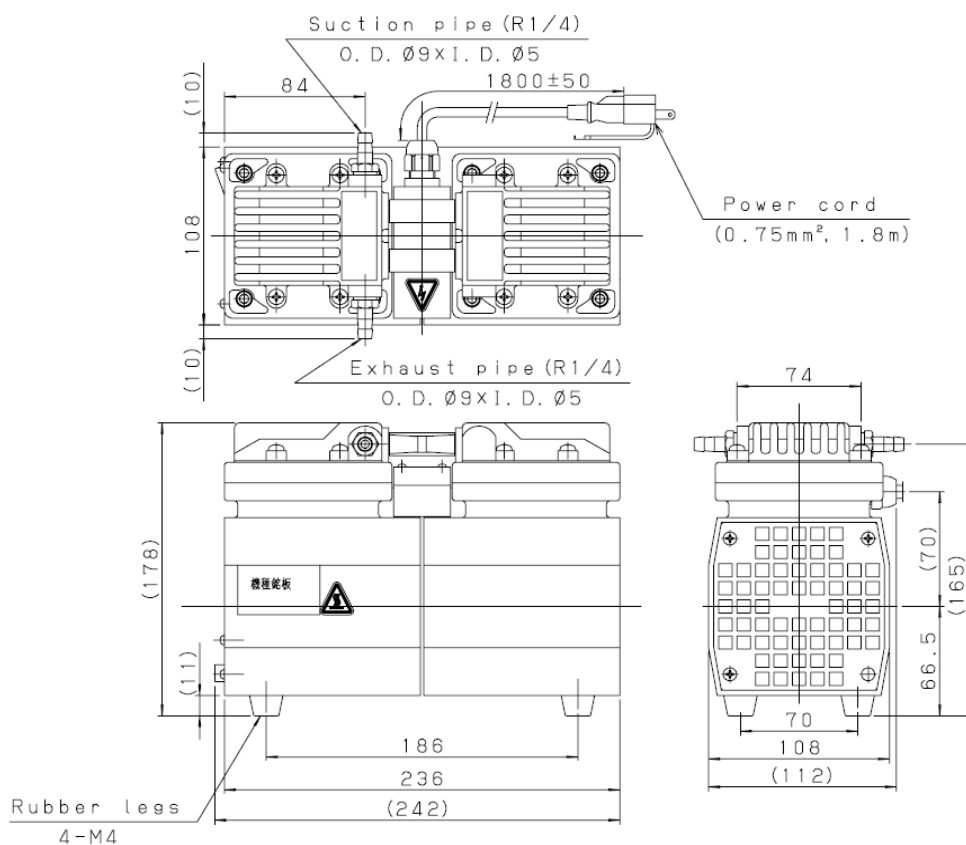





Fig.2 DA-40S Dimensions

### 3. Installation and Storage

#### 3.1 Cautions for Installation and Storage

 <b>Warning</b>	See Warning (1)(2)(3)(5)(6)(7)(8)(9)(10)(11)(12)(13)(15), P04
 <b>Caution</b>	See Caution (1)(2)(3), P05
 <b>Note</b>	See Note (1)(2)(3)(4)(8), P06

#### 3.2 Environmental Conditions for Installation, Storage, and Operation

The fine clearances used in this pump require that the following conditions be satisfied during storage, installation, and operation.

1. Ambient temperature of 7~40°C and maximum relative humidity of 85% during operation.
2. Equal to or less than meters above the sea level 1000m storage and operation.
3. Other conditions for storage and operation.
  - a) Level floor of sufficient strength.
  - b) No condensation
  - c) Dust-free environment
  - d) Well ventilated
  - e) Environment free of corrosive or explosive gas.
  - f) Not subject to direct sunlight.
  - g) No danger of fire.
  - h) Maximum ambient temperature of 40°C during assembly of pump.
  - i) Free of soot and oil.
  - j) Free of splashing or flooding.
  - k) Keep it indoor ventilated.
  - l) When installing the pump, avoid mounting a vacuum pump directly on the base. Employ anti-vibration rubber between the base and the vacuum pump.

#### 3.3 Location

The pump should be installed level in a location with minimal dust and humidity. This location should be selected in consideration of ease of installation and removal, inspection, and cleaning.

Particular attention should be paid to ambient temperature when fitting the pump to equipment. Use anti-vibration rubbers to isolate the pump from vibrations in the equipment. See 3.2 Environmental Conditions for Installation, Storage, and Operation for details.

When replacing rubber legs with anti-vibration rubbers, ensure that screws used for their attachment to the pump are 3.5 – 4 mm in length. If these screws are longer than 4 mm they may interfere with internal components (insertion-type connectors), resulting in electric shock.

We have specialized anti-vibration rubbers available, and can supply upon request.

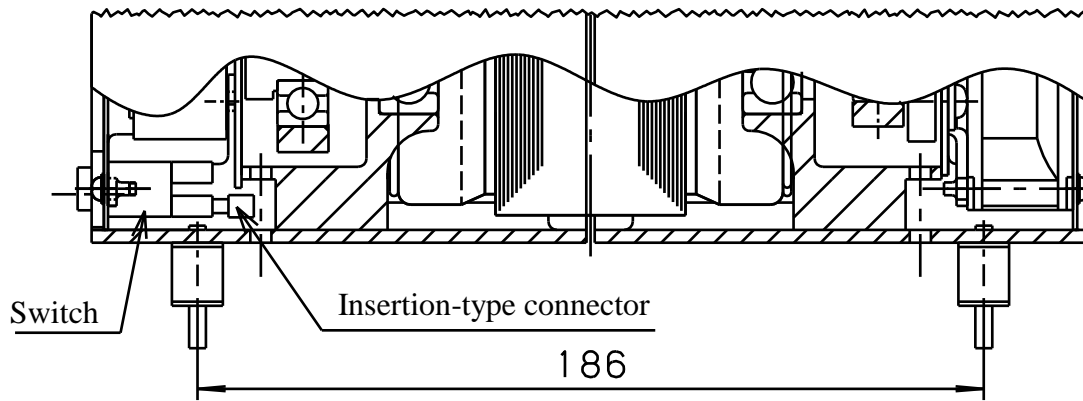


Fig.3 Attaching Anti-vibration Rubbers

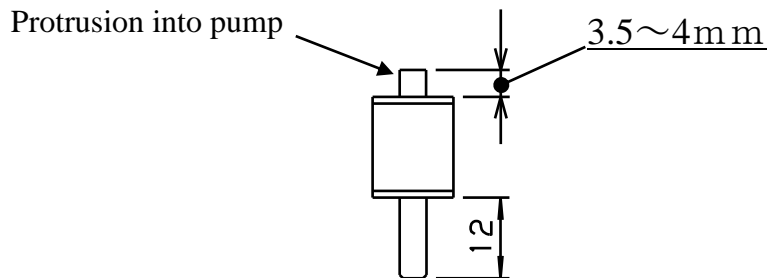


Fig.4 Screws for Anti-vibration Rubbers

### 3-4 Electric Wiring

- (1) The wire diameter of power cord must be  $\phi 0.75\text{mm}^2$  or more.
  - (2) We recommend end-user to equip protection device such as earth leakage breaker motor breaker on electric wiring to prevent from motor burnout which may occur by overcurrent.
  - (3) The attaching screw for earth terminal must have earth mark indicated.
  - (4) The electric wire which will be connected to the earth must be a green colored insulating coating wire, with or without yellow stripes. Its wire diameter must be  $\phi 0.75\text{mm}^2$  or more.
- Notice: Before operating wire connection, be sure to unplug the power plug.

### 3.5 Fluctuations in the power voltage and frequency

Standard: Rotation electricity machine general rules

JIS C 4034-1:1999, JEC-2137-2000

To the voltage change and frequency change in Domain A, in main rated values, it operates continuously, and can be used practically convenient, and to the voltage change and frequency change in Domain B, it shall operate with main rated values and shall be used practically convenient.

However, operation with "it is convenient and safe is maintained on "practical use, it means not resulting in the grade which shortens a life remarkably, and the characteristic, a temperature rise, etc. do not apply correspondingly in the state of rating. Moreover, main rating shows rated torque (N·m).

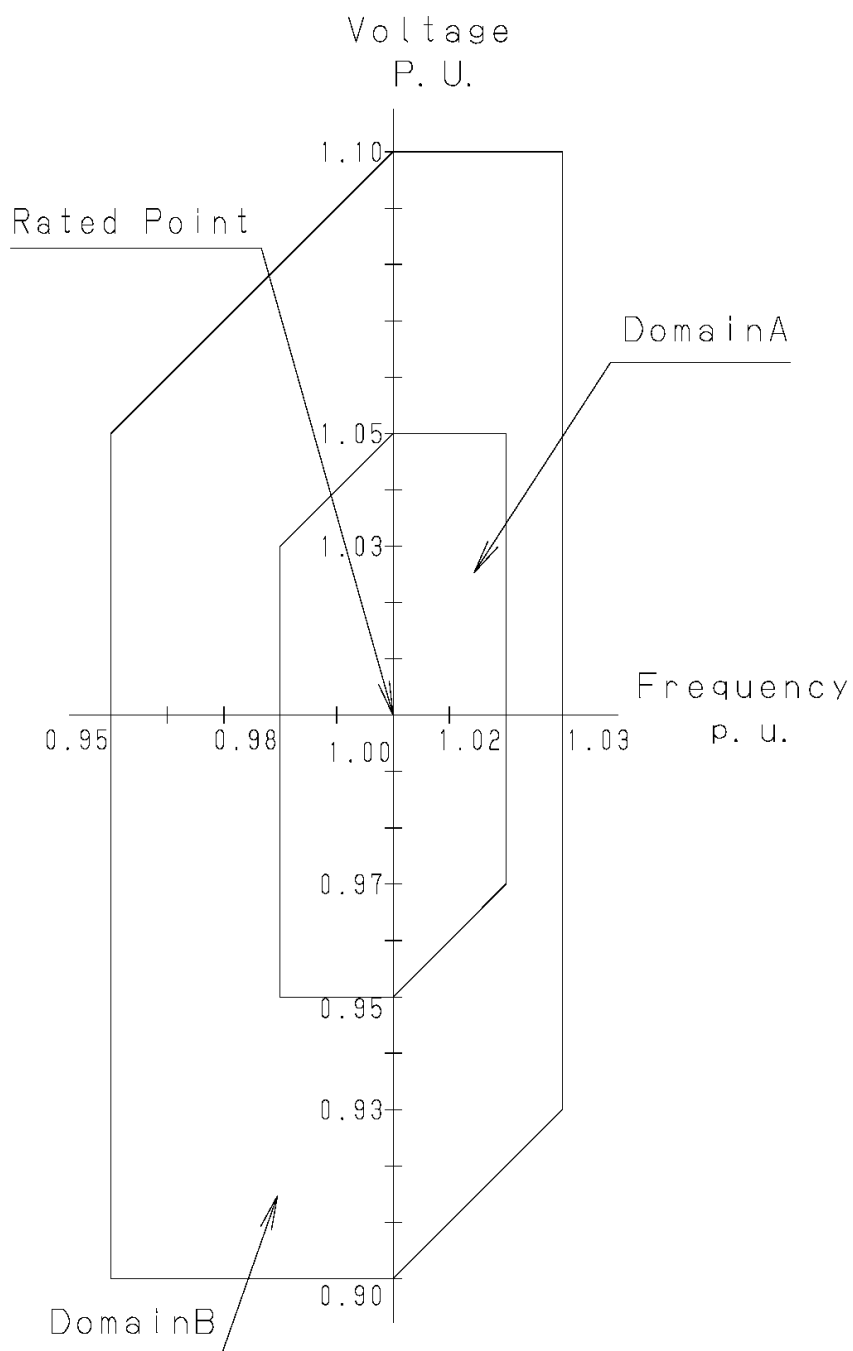


Fig. 5 Change region of the voltage and frequency

### 3.6 Checking Operation After Installation

- 1) Remove the rubber caps from the inlet and outlet.
- 2) Check that the pump switch is OFF, and insert the plug into the 100 V wall socket.  
Note: Ensure that the power plug is sufficient for the rated voltage and current.
- 3) Turn the switch ON and check that gas is being drawn into the inlet.
- 4) When this check is complete, turn the power switch OFF to stop the pump.

### 3.7 Piping

- 1) Install piping carefully to prevent leaks.
- 2) Piping connected to the inlet should be at least **10** mm inside diameter.
- 3) Maximum back pressure is 0.03 MPa (gauge pressure).
- 4) In case of selecting the inlet pipe and exhaust pipe that are not from our products, please select the exhaust pipe that has same or larger inner diameter length with the inlet pipe.
- 5) When evacuating a vessel, ensure that a shut-off valve is placed between the pump inlet pipe and the vessel (see Fig.4).

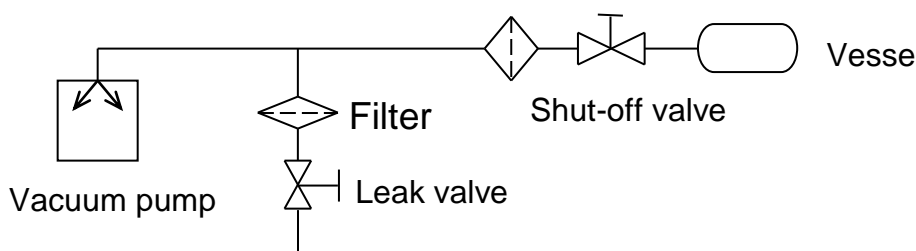






Fig.6 Example of Piping Used When Evacuating a Vessel

### 3.8 Storage

Turn the switch OFF, remove the power plug from the outlet, place the rubber caps over the inlet and outlet, and store the pump in an area of low humidity.

## 4. Cautions for Operation

### 4.1 Cautions for Operation

 <b>Danger</b>	See Danger (1)(2), P03
 <b>Warning</b>	See Warning (8)(15)(16)(17), P04
 <b>Caution</b>	See Caution (4)(5)(6)(7)(8), P05
 <b>Note</b>	See Note (3)(4)(5)(6)(7)(8)(9)(10)(11)(12), P06

Consult the manufacturer if the pump is to be used in a special application.

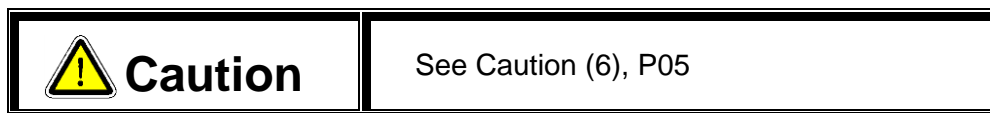
#### 4.2 Operation of the Thermal Protector

- 1) When the thermal protector operates, switch the pump power supply OFF, remove the power cord from the outlet, and contact the manufacturer. Note that the pump will be very hot and should not be touched.
- 2) The pump operates automatically when temperature drops. Shut-off the power supply, and determine the cause of operation of the thermal protector.
- 3) Once the cause of the fault has been removed, wait until the motor cools and restart operation.

Automatic reset thermal protector

Operation temperature  $135\pm 5^{\circ}\text{C}$

Reset temperature  $85\pm 10^{\circ}\text{C}$



#### 4.3 Starting in Cold Weather

Cold weather will increase the viscosity of bearing grease and harden diaphragms, resulting in the pump being difficult to start. Follow the procedure below in such conditions.

- 1) Turn the switch ON/OFF 2~3 times with the inlet open to atmosphere until the pump starts. If the pump still does not start, raise the ambient temperature to beyond  $7^{\circ}\text{C}$ .
- 2) With the inlet open to atmosphere, run the pump for a few minutes to warm it.
- 3) Commence normal operation once the pump has warmed.

### 5. Pump Performance

#### 5.1 Pressure Achieved

The term “pressure achieved” as employed in the catalogue and in this manual is defined as “the minimum pressure obtained by the pump without introduction of gas from the pump inlet (ie the no-load condition)”.

Note that the indicator values for pressure may differ between types of vacuum gauges.

The pressure achieved in practice is higher than that noted in the catalogue for the following reasons.

- (1) The fact that the vacuum gauge is mounted a distance from the pump, the steam generated by water droplets and rust etc on the inside walls of the pump and piping, and a variety of gases present in the system result in increased pressure.
- (2) Leaks into the vacuum system introduce other gases, resulting in increased pressure.

#### 5.2 Evacuation Rate

The maximum rate of evacuation is reached when air is introduced, and decreases slightly as pressure is reduced.

The resistance of the piping system increases with small bore piping which extends over long distances, and this reduces the rate of evacuation.

The declared rate of evacuation for this pump is the maximum value achieved with dry air.





#### 5.3 Power Requirements

The power required to drive the pump is the total of the work required to overcome the rotational resistance of the pump (mechanical work), and the work required to compress the air (compression work), and is at a maximum at an inlet pressure of  $5.0 \times 10^4 \sim 8.0 \times 10^4 \text{ Pa}$ . At pressures below this range the compression work is considerably reduced and power is expended in mechanical work.



## 6. Maintenance, Inspection, and Repair

### 6.1. Cautions for Maintenance, Inspection, and Repair

 <b>Danger</b>	See Danger (3), P03
 <b>Warning</b>	See Warning (4)(18)(19), P04
 <b>Caution</b>	See Caution (10)(11)(12)(13), P06
 <b>Note</b>	See Note (12), P06

Maintenance and repair by the customer's repair technician is limited to the following procedures. Do not undertake other repairs, or make modifications other than the standard options supplied by the manufacturer.

- 1) Replacing diaphragms
- 2) Replacing suction / exhaust valves
- 3) Replacing pump head cover gaskets
- 4) Replacing air filters

### 6.2 Maintenance

The following checks are required at least once every three days during operation.

- (1) Check for abnormal noises.
- (2) Check for abnormal heating of the pump.
- (3) Check that gas is discharged normally.

If a problem is found, take the measures described in 6.5 Troubleshooting List.

### 6.3 Regular Inspections

Inspect consumables after the first 6000 hours of operation, and replace and clean in accordance with the Replacement and Cleaning Guide on the following page. Refer to 6.4 Replacing and Cleaning Consumables for procedures.

Request replacement by the manufacturer's service division if a repair technician is not available.

Table.2 Consumables List

Description	Qty	Material	Life expectancy
Diaphragm	2 pcs	NBR	6,000~8,000 hrs
Suction / exhaust valve	4 pcs	SUS	6,000~8,000 hrs
Pump head cover gasket	2 pcs	NBR	6,000~8,000 hrs
Air filter	2 pcs	Urethane foam	6,000~8,000 hrs
Bearing	1 set	—	Approx. 15,000 hrs

Note that the average life for a component varies with the conditions of use.

Always follow 4.1 Cautions for Operation, and remember that life is extended by running the pump at minimal load (running the pump at minimal load is operation at the achieved pressure (inlet closed)). Bearings are replaced by the manufacturer's service division.



### <Replacement Guide>

Replace or clean components if performance is reduced or the following symptoms become apparent.

Table.3 Locations for Maintenance and Inspection

Period of operation	Inspection item	Replacement guidelines	Method of inspection
6,000 hr	Diaphragm	Deformation, crack and hardening	Visual check
	Suction / exhaust valve	Deformation and crack	Visual check
	Pump head cover gasket	Hardening, deformation, crack and leak	Visual check
	Air filter	Dirt, clogged and hardening	Visual check
	Bearing	Unusual sound	Auditory check

### 6.4 Replacing and Cleaning Consumables

 <b>Warning</b>	See Warning (19), P04
 <b>Caution</b>	See Caution (11)(12), P06

- ※ The pump becomes very hot after operation. After stopping the pump, leave it for 30 minutes to cool, and replace and clean components only after it has cooled to a safe temperature.
- ※ Always put on dust mask and gloves before replacing diaphragms and valves. Any fine particles produced by mechanical wearing may become airborne causing a health risk if inhaled.
- ※ Always use gloves to prevent injury when replacing diaphragms.

### Tools Required for Setup

Have the following tools on hand and perform the replacement while referring to the diagram.

**If there is no repair technician available,** or if you do not have access to the required tools, please make the appropriate request to our repair services department.

#### Required Tools

1. Torque wrench- bit size 5 mm (15.0 Nm), bit size 4 mm (5.0 Nm)
2. Phillips head (+) screwdriver- No.2
3. Torque screwdriver- No.2 (0.8 Nm, 2.0 Nm, 5.0 Nm)
4. Wrench- width across flat 19 mm
5. Rag
6. Solvent for wiping (something that has no effect on rubber, such as ethanol)
7. Dust mask (for nose and mouth), gloves, protective eyewear
8. Loctite 242

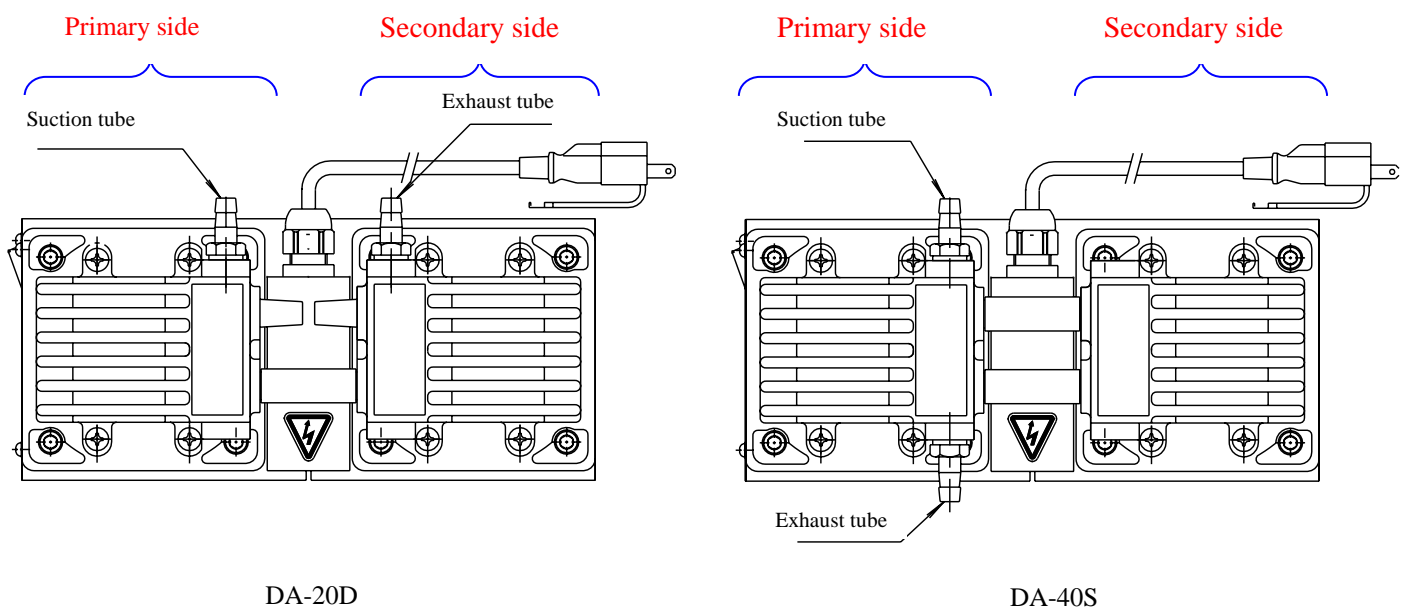
\*Use items No.5 and 6 to wipe down any dirty area when replacing the part.

### Part Replacement Procedure

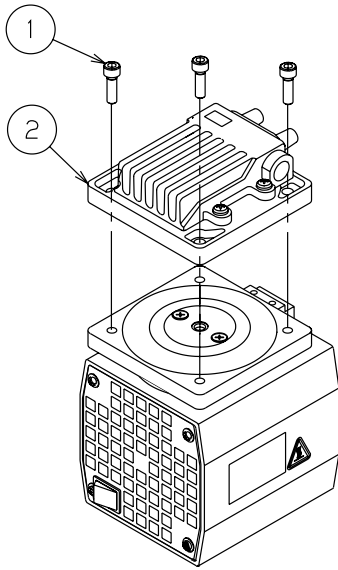
#### Definition of Terms

In the replacement procedure, the terms “primary side” and “secondary side” shall be used to refer to specific locations.

Refer to the terms and diagram below when performing the replacement.



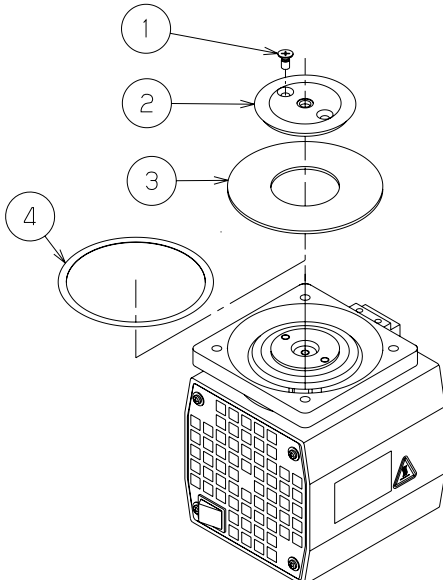
## i. Parts Removal



\*First unplug the pump's power cable from the main power supply.

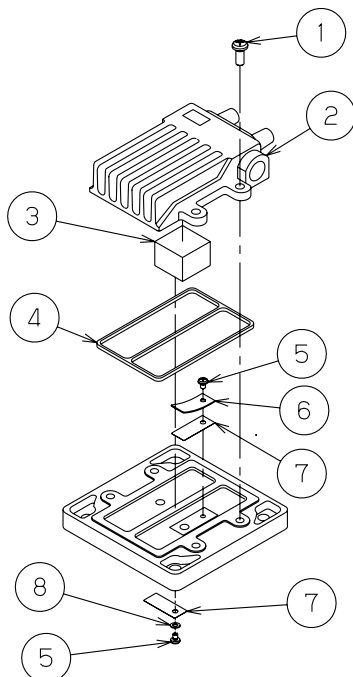
Step 1: Remove (1) the hex socket bolts (M6×18) × Qty.4, and then remove (2) the pump head.

Do the same on the opposing pump head.



Step 2: First, remove (1) the small flat head screws (M5×10) × Qty. 2, and then remove (2) the push plate for the diaphragm and (3) the diaphragm. (4) The Teflon liner placed under the diaphragm does not need to be replaced, so please leave it where it is and ensure it doesn't get lost.

Do the same on the opposing diaphragm.

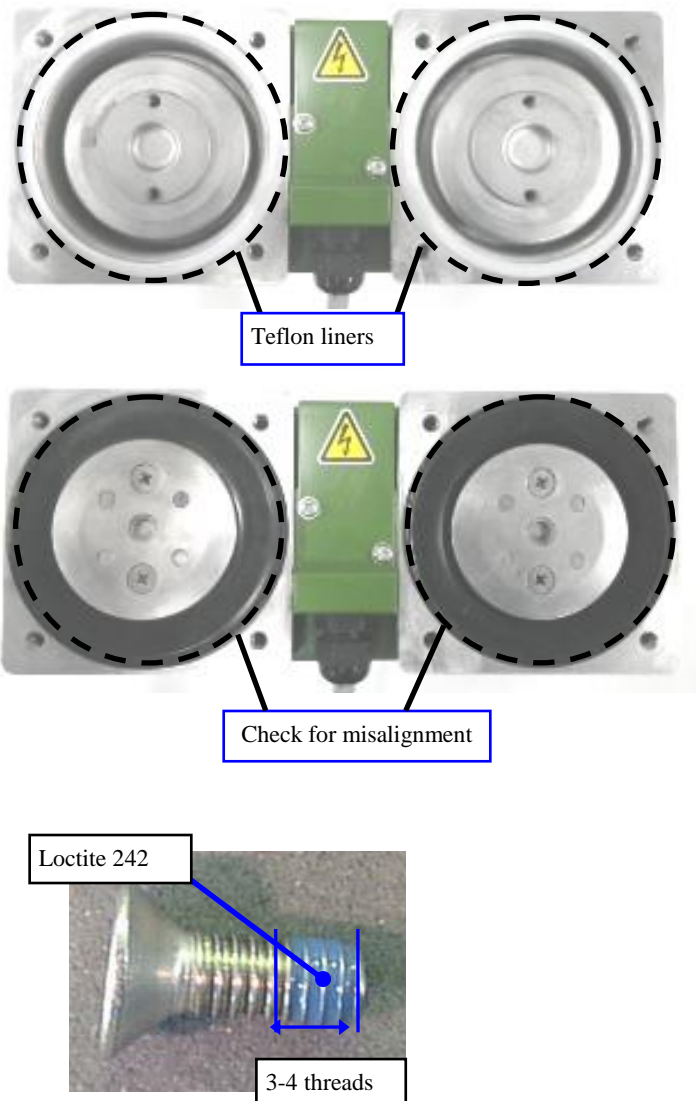


Step 3: Remove the connecting tubes linking the primary and the secondary side pump head covers. Remove (1) the small pan head screws (M5×12) × Qty. 4, and then remove (2) the pump head, (3) the filter and (4) the head gasket. The filter and the head gasket are inserted inside the pump head. Next, remove (5) the small pan head screw (M3×5) and then remove (6) the exhaust valve holder and (7) the air release valve. Inside the pump head is (8) the plain washer instead of (6) the exhaust valve holder. Remove this following the same procedure.

Do the same on the opposing pump head.

This step completes the parts removal procedure. The next section is the assembly.

## ii. Attaching Parts & Assembly



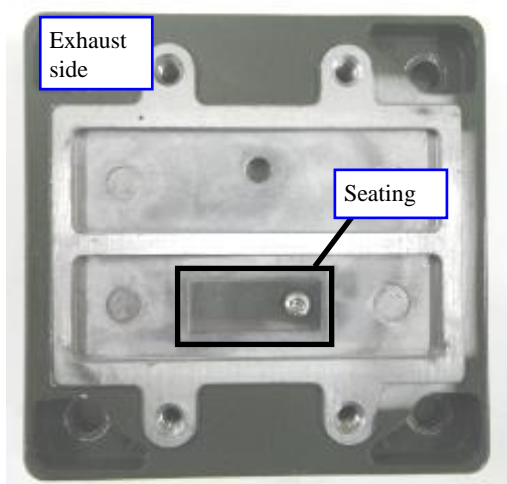
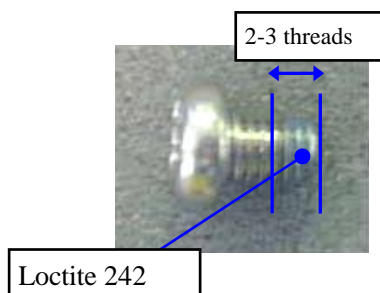
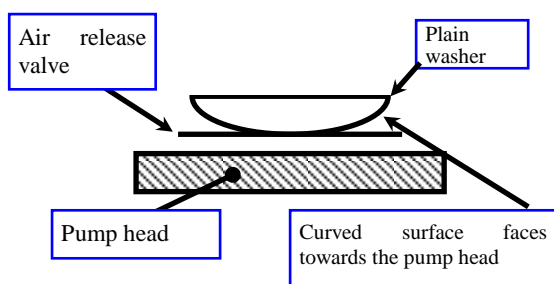
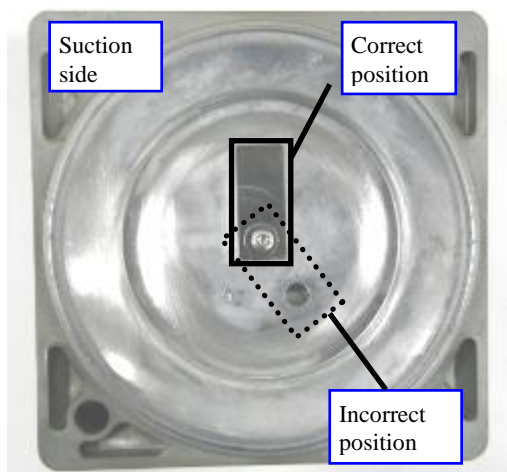
Step 4: Attach the diaphragm. Check that the Teflon liner is placed on the circumference of the diaphragm.

Step 5: Replace the diaphragm with a new one and place the push plate for the diaphragm on top of it. Then, using a torque screwdriver (5.0 Nm), fasten them with small flat head screws (M5×10). In addition, when tightening the screws with the torque screwdriver, tighten each screw twice to ensure they are properly tightened. Also, before tightening the screw, apply the Loctite 242 onto the 3-4 threads from the screw tip.

\*Be careful when applying Loctite 242, as too much or too little can cause damage.

\*Be sure to always follow the appropriate tightening torque. Failure to do so can lead to product damage.

\*After attaching the small flat head screws, check the alignment of the diaphragm.



Step 6: Attach the air release valve on the suction side. Replace the old air release valve removed in Step 3 with a new one. Attach the parts in the order of the air release valve, plain washer and then the small pan head screw (M3×5). Also, the plain washer should be placed so that its curved surface faces towards the pump head. Before inserting the screw, apply the Loctite 242 onto the 2-3 threads from the screw tip and then tighten it using the torque screwdriver (0.8 Nm). Refer to the picture on the left to make sure that the air release valve is attached at the correct position.

\* After tightening, make sure that there is no gap between the suction valve and the pump head, or that the valve does not move to right or left, as these will lead to poor performance. \*Be careful when applying Loctite 242, as too much or too little can cause damage.

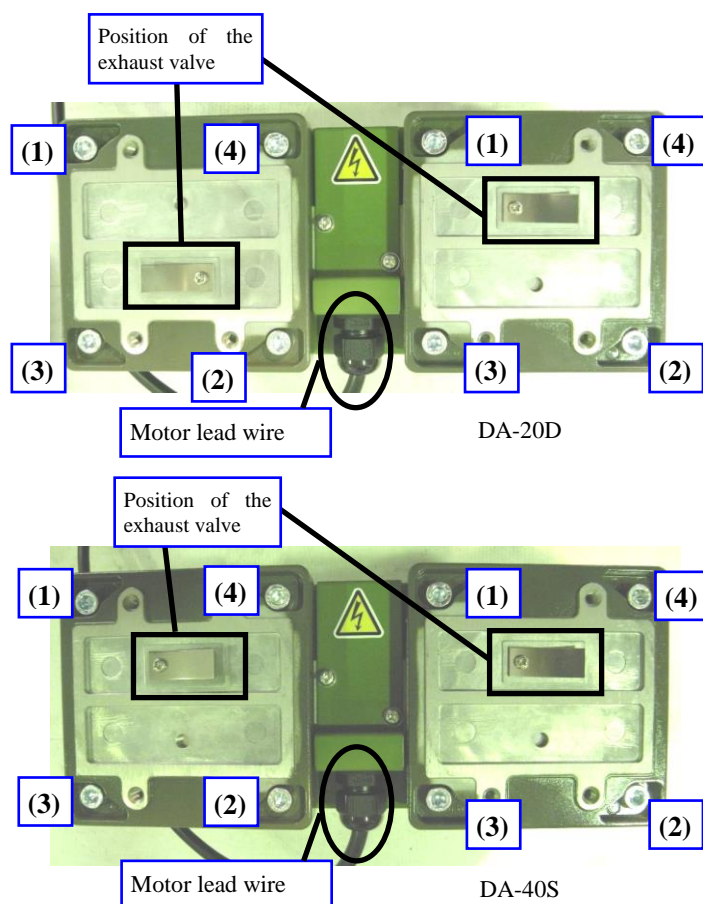
\*Be sure to always follow the appropriate tightening torque. Failure to do so can lead to product damage.

Step 7: Attach the air release valve on the exhaust side. Replace the old air release valve removed in Step 3 with a new one. For the exhaust side, attach the air release valve on the seating at the location as seen in the picture on the left. On the exhaust side, attach the parts in the order of the air release valve, exhaust valve holder and then the small pan head screw (M3×5). Before inserting the screw, apply the Loctite 242 onto the 2-3 threads from the screw tip and then tighten it using the torque screwdriver (0.8 Nm).

\* After tightening, make sure that there is no gap between the suction valve and the pump head, or that the valve does not move to right or left, as these will lead to poor performance. \*Be careful when applying Loctite 242, as too much or too little can cause damage.

\*Be sure to always follow the appropriate tightening torque. Failure to do so can lead to product damage.





Step 8: Attach the pump head. Please note that the mounting orientation of the pump head is different for DA-20D and DA-40S. Refer to the pictures on the left to make sure that the pump heads are attached correctly.

\*Pump heads attached in an incorrect orientation will lead to poor performance.

Place the pump heads on the diaphragms, then using a torque wrench with a bit size 5 mm (15.0 Nm), fasten them with hex socket bolts (M6×18) × Qty. 8.

When tightening the screws, do so in order (1) through (4), going over them three times, gradually tightening each one of them.

\*Be sure to always follow the appropriate tightening torque. Failure to do so can lead to product damage.

\*After tightening the screws, check that the diaphragms are not caught in any other components.



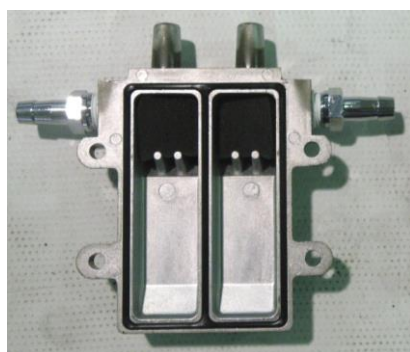
DA-20D: primary side



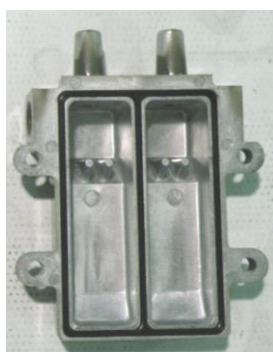
DA-20D: secondary side

Step 9: Attach the filter and the head gasket to the pump head cover. Insert the head gasket into the groove on the inner side of the pump head cover. The location of the filter is different for the primary and the secondary side. Please check the pictures on the left to make sure that they are not attached incorrectly.

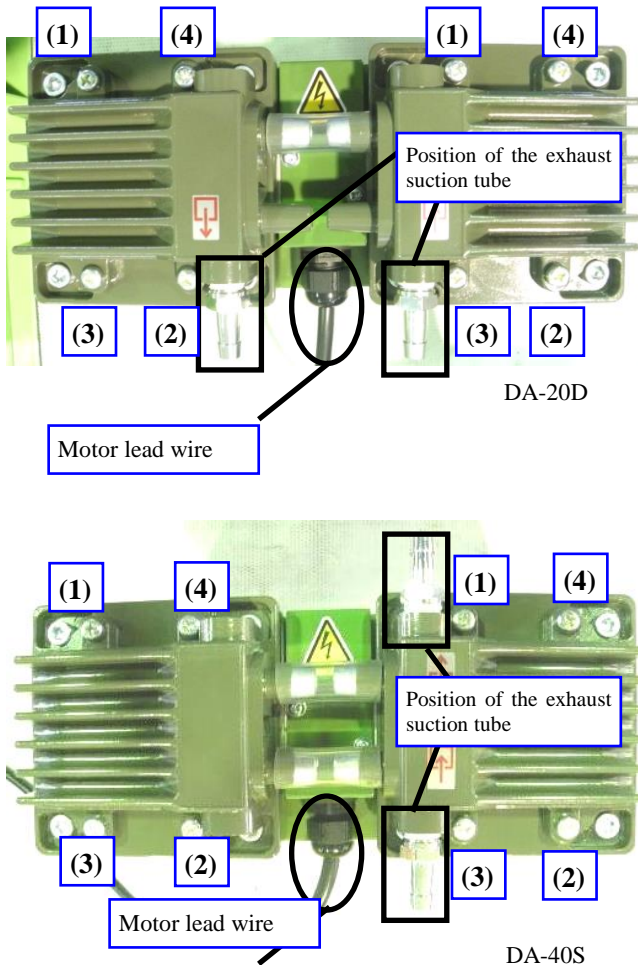
\*Make sure that the head gaskets are fitted tightly into the groove and are not twisted.



DA-40S: primary side



DA-40S: secondary side



Step 10: Attach the pump head cover. Please note that the mounting orientation of the pump head cover is different for DA-20D and DA-40S. Refer to the pictures on the left to make sure that the pump heads are attached correctly.

\*Pump head covers attached in an incorrect orientation will lead to poor performance.

Connect the primary and the secondary side pump heads with connecting tubes, place the head covers on the pump heads, and then fasten them with small pan head screws (M5×12) × Qty. 8 using a screwdriver. When tightening the screws, do so in order (1) through (4), going over them three times, gradually tightening each one of them.

The consumable parts replacement procedure is now complete.



## 6.5 Troubleshooting List

Table.4 Troubleshooting List

Problem	Causes	Solutions	Reference
Problems with starting and rotation of pump	(1) Not connected to power supply. (2) Switch is OFF. (3) Problem with power supply voltage. (4) Problem with pump wiring. (5) The breaker has operated. (6) The thermal protector has operated. (7) Low ambient temperature. (8) Low voltage. (9) Fault in power supply. (10) Problem with power supply switch. (11) Broken wire in power cord. (12) Problem with motor. (13) Damaged condenser, or connection problem. (14) Locked connecting rod. (15) Problem with bearings. (16) Miscellaneous damage to pump components.	(1) Connect power supply. (2) Set switch to I. (3) Ensure that voltage variation is within $\pm 10\%$ . (4) Rewire the pump. Contact the manufacturer. (5) Investigate the reasons for operation. (6) Switch power OFF, and eliminate the cause of operation of the relay. Contact the manufacturer. (7) Ensure that ambient temperature is $7\sim 40\text{ }^{\circ}\text{C}$ . (8) Adjust the power supply voltage, and check the power supply cable. (9) Replace or repair. (10) Replace or repair. (11) Replace or repair. (12) Replace or repair. (13) Replace or repair. (14) Disassemble pump head and check interior. (15) Replace or repair. (16) Disassemble and repair (replace damaged components).	3-4.      4-2.  4-3.           6-3.  6-3.
Pressure does not diminish	(1) Pump is too small for capacity of vacuum vessel. (2) Pressure measurement is incorrect. (3) Vacuum gauge is unsuitable. (4) The inlet piping is too small in diameter, or too long. (5) Low voltage (6) Ambient temperature unsuitable. (7) Leaks in inlet piping. (8) Leaks from piping or connections. (9) Foreign matter inside pump. (10) Foreign matter inside pump. (11) Damage to motor (12) Problem due to ingestion of liquid or compressed gas into the pump. (13) Damage to diaphragm. (14) Miscellaneous damage to pump components.	(1) Select another pump. (2) Measure the pressure correctly. (3) Measure with a calibrated vacuum gauge suitable for the pressure range. (4) Connect piping of an inside diameter greater than the inlet diameter, or reduce the distance between the pump and vacuum vessel. (5) Adjust the voltage, and check the power supply cable. (6) Ensure that ambient temperature is $0\sim 40\text{ }^{\circ}\text{C}$ . (7) Clean and replace. (8) Check for leaks in piping, check diameter and length of piping, and repair. (9) Remove foreign matter, disassemble and clean, and replace components. (10) Disassemble and repair (replace valves and diaphragm etc). (11) Replace or repair. (12) Replace. (13) Replace. (14) Disassemble and repair (replace damaged components).	5-1.  5-1.  5-1.           6-4.           6-4.  6-4.
Pump surfaces are abnormally hot (more than room temperature + $30\text{ }^{\circ}\text{C}$ )	(1) Continuous operation with high pressure gas. (2) High temperature gas. (3) Problem with power supply voltage. (4) Motor has seized.	(1) Do not run the pump continuously at near-atmospheric pressure. (2) Fit cooling equipment (eg. gas cooler) to the inlet. (3) Ensure that voltage variation is within $\pm 10\%$ . (4) See the section on problems with pump rotation.	

## 7. In Conclusion

This manual contains only general information about pump operation. Therefore, if you come up with any question or trouble, contact our representative or ULVAC KIKO.

### **Warranty**

- (1) The warranty for this pump (this equipment) extends for a period of one year from the date of shipment.
- (2) Any malfunctions or defects which occur under normal usage conditions during the warranty period will be repaired free of charge.

Note, the warranty stated here is an individual warranty covering the pump. In addition, the scope of the warranty coverage concerning repairs is limited to the repair and/or replacement of parts.

Normal usage conditions refer to the following:

- a) Ambient temperature and humidity during operation: 7 - 40°C, below 85% RH
  - b) Operation in accordance with the user manual
- (3) Repair fees will incur during the warranty period for the following cases:
- a) Malfunctions due to a natural disaster or fire.
  - b) Malfunctions caused by special atmospheric conditions, such as salt damage, inflammable gas, corrosive gas, radiation or pollution.
  - c) Malfunctions caused by usage conditions that differ from those stated in the user manual (performance specifications, maintenance and inspection, etc.).
  - d) Malfunctions caused by modifications or repairs carried out by a party other than the manufacturer, or by a service company not approved by the manufacturer.
  - e) Malfunctions caused by noise (electric disturbance).
  - f) Malfunctions that occur when not using a rated power supply.
  - g) Malfunctions that occur when there is an abnormal rise in internal pressure due to the pump exhaust outlet being blocked during operation, etc.
  - h) Malfunctions that occur, when the pump is damaged as a result of being dropped or falling, etc.
  - i) Malfunctions which are determined by the manufacturer's technical personnel to be caused by conditions that do not comply with the usage conditions for this vacuum pump.
  - j) Malfunctions due to the replacement of consumables.
- (4) Disclaimer
- a) We shall not be liable for any malfunctions of our products caused by the customer, regardless if the malfunction does not fall within the warranty period, nor shall we be liable for any loss of opportunity for the customer's clients or for compensation for any damages to other products, labor costs, production loss, transportation expenses and other related work.
  - b) We shall not be liable for any claims and patent infringements, including secondary damages, filed a claim by a third party against the customer.

## Usage Status Check Sheet (for use in Instruction Manual)

- \* For the purpose of safety control of repair personnel, fill in within the heavy line frame and attach the sheet to the item of which repair is requested.
- \* In case this sheet were not attached or filled in, your request of repair and service may not be accepted.
- \* In accordance with the Private Information Protection Law, the provided information will be used only for determining the cause of failure and whether detoxifying washing should be conducted. It will never be provided to any third person.

Model Name: \_\_\_\_\_ Manufacturer's Serial No.: \_\_\_\_\_

1. Inhaled Gas \* Please be sure to fill in.

(1) Whether there is harmful effect on human bodies Yes No (Sing your name below.)

(2) Whether there is unusual smell Yes No

(3) Type and Name of Gas: \_\_\_\_\_

\* Industrial Safety and Health Law designates particular substances as the materials to be notified.

2. Usage Status

Operation Method: Approx. ( ) hours per day, ( ) years and ( ) months

☐ Continuous Operation ☐ Intermittent Operation

Usage: \_\_\_\_\_

3. Failure Status ☐ Unusual Noise ☐ Abnormal Pressure ☐ Abnormal Actuation ☐ Oil Leakage

Other Symptoms: \_\_\_\_\_

4. Detail of Request ☐ Repair (Overhaul) ☐ Regular Checks

5. Others: \_\_\_\_\_

Company Name: \_\_\_\_\_ Personnel in charge: \_\_\_\_\_

Address: \_\_\_\_\_

Tel: \_\_\_\_\_ Fax: \_\_\_\_\_ E-mail: \_\_\_\_\_

Agent Name: \_\_\_\_\_ Personnel in charge: \_\_\_\_\_

Address: \_\_\_\_\_

Tel: \_\_\_\_\_ Fax: \_\_\_\_\_

\* In case you do not have any direct transaction with us, please be sure to fill in the agent name.

6. Confirmation

The gas and substance used in this pump or unit is harmless to human bodies, or it is not contaminated by any substance harmful to human bodies.

Signed \_\_\_\_\_ (seal) Date: \_\_\_\_\_

\* Please send the parcel to our Service Division. (See attached contact information.)

\* In order to avoid a trouble during transportation, please evacuate oil from any oil pump before shipping.

アルバック機工株式会社

<https://ulvac-kiko.com>

製品情報・サービス拠点・お問い合わせはこちらから



<https://showcase.ulvac.co.jp/ja/>

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Please contact us for products, Service Base or other Inquiries from here.



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