	Danger due to seizing of the impeller caused by excessive vibration.
Vibration values higher than Zone B (table of effective vibration velocity value) are considered NOT permissible and can cause damage to the machine and therefore serious injury to operators. - **In case of noise and/or abnormal vibration indicating the possibility of seizing of the impeller, move away and turn the unit off immediately!**	

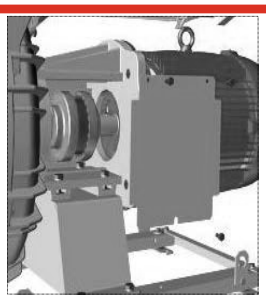
Variations in normal working conditions (increases in power absorption, abnormal noise, vibration, excessive overheating of the service fluid) are signs of a unit malfunction.
Also, compare the measured values with those given in the "SPECIFICATIONS.

B) With the unit stopped and cooled, periodically carry out the following checks:

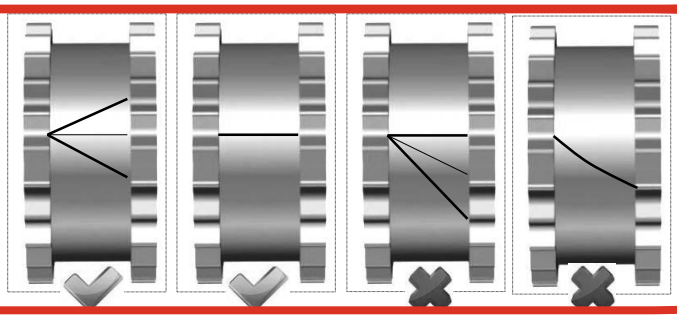
- Dust: check and remove deposits from the external surfaces of the unit.
- Suction filter (if fitted): every 10-15 days, check and clean or replace the filter cartridge. The dirty cartridge creates strong suction resistance and consequently a higher pressure differential, power absorption and operating temperature.
- Check the flexible coupling as follows:
  - Remove the screws and coupling cover (**A**).
  - Manually rotate the coupling to expose the reference lines marked on the elastomer.
  - Check the coupling and appraise its state after 100 hours or up to 1 month of operation; if no deformations are detected, the check can be repeated every 2000 hours or every 3 months.
  - The deformations are detected by the lines marked on the elastomer (**B**).
  - Protect the couplings again with the coupling cover (**C**).

A

C



B



ATTENTION!	To limit the formation of surface layers of dust that can affect the natural heat exchange between the unit and the environment, ensure regular cleaning and removal with suitable equipment. The suction and/or delivery pipes must not be dirty or clogged.

14.2 PERIODICAL MAINTENANCE AND TROUBLESHOOTING

Refer to the following section, "OPERATION PROBLEMS", to identify possible critical situations and types of failures.
In case of periodical maintenance for cleaning and replacement of some components, as well as in case of failure, it is necessary to disconnect and remove the machine from the system.

	Danger due to electricity.
Before carrying out any operation, make sure the machine is NOT powered.	

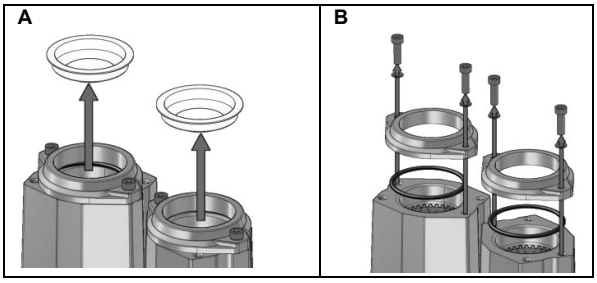
	Risk of injury due to shearing, crushing, catching.
During work on the unit there are risks of injury due to shearing, crushing or catching. Therefore it must be carried out by qualified personnel who handle and install the machine, taking the necessary safety measures and following the instructions given in this manual.	

	Danger due to residual negative pressure or overpressure.
For residual overpressure: possible release of process fluids with risk of injury to the skin and eyes. For negative pressure: possible drawing in of hair and clothing. Disassemble the machine only after closing and draining the system connected to it.	

12.2 HORIZONTAL INSTALLATION GOR – VERTICAL GVR

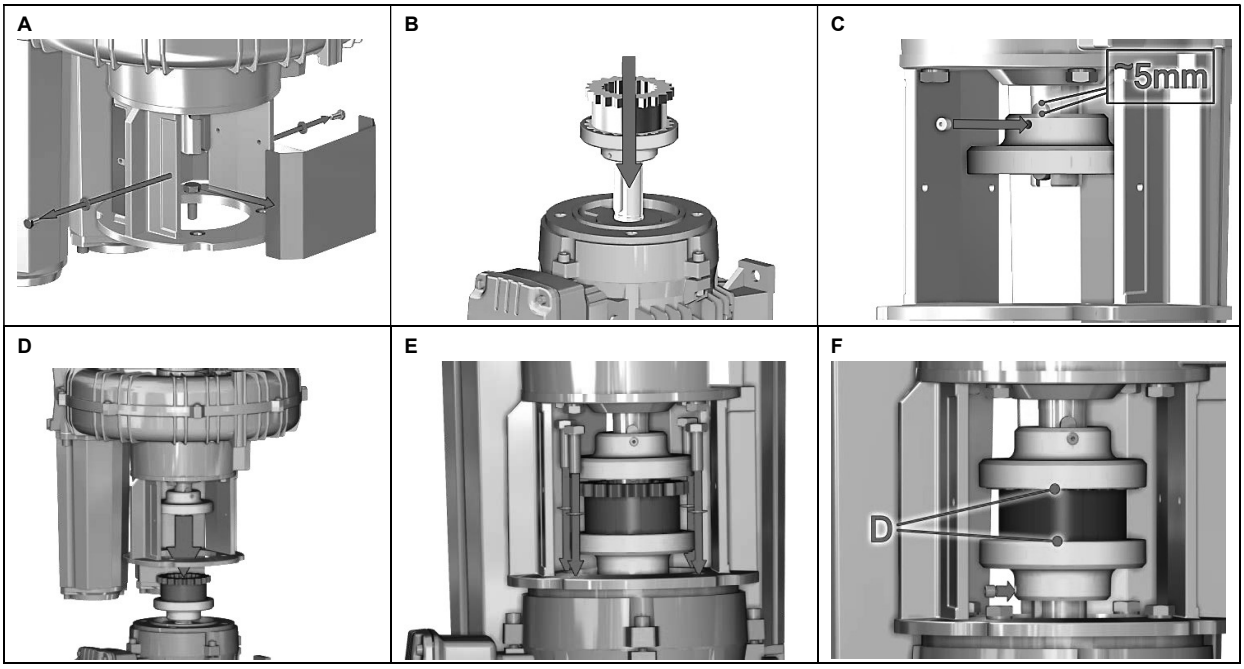
Units supplied with standard set-up are ready to be installed in the horizontal position (GOR), vertical (GVR).

- The feet have holes for fixing; use all the holes and choose the appropriate type of screw.
- Remove the protection on the ports before checking the rotation direction and before final connection (A).
- To connect the unit to the piping, remove the flange from the silencer housings (B).
- Screw the flanges to the pipes and clean from any impurities.
- Refit the flanges on the silencer housings. Provide for a hose, as per the initial diagrams.



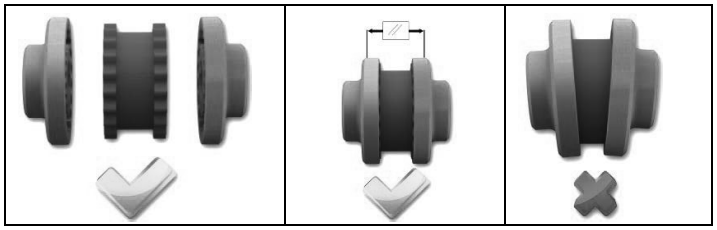
12.3 BLOWER WITHOUT ELECTRIC MOTOR GOR - GVR

- Check the compatibility of the chosen electric motor with the data given in the DIMENSIONS in the first section.
- Remove the screws and coupling cover (A).
- Insert the key supplied with the electric motor and fit the semi-joint with the flexible coupling on the end of the motor shaft without fixing it (B).
- Remove the sticker on the end of the blower shaft. Check that the key is properly positioned in the special seat. Fit the semi-joint, leaving 5mm of key free (C).
- Tighten the Allen screw to fix the semi-joint (C).
- Couple the blower to the motor by means of the connection flange and secure it with the screws (D-E).
- Mate the two semi-joints (F).
- Tighten the Allen screw located on the motor shaft semi-joint and check that the flexible element is free to float (F).



NOTE FOR THE USER	Use pushers or pullers for fitting and removal of the semi-joints from the shafts - DO NOT USE A HAMMER. The percussion can ruin the bearing races and shorten their life. The coupling requires precise axial and angular alignment which, if not satisfactory, compromises the life of the transmission and bearings. Regarding this, also consult the instruction manual for elastomer joints.

- Check the axial alignment of the semi-joints in at least four places using a knife-edge rule or similar.
- Check the angular alignment by measuring the distance of the semi-joints in at least four places.
- Do not turn the transmission in taking the measurements.
- Make sure the correction of one alignment does not change the other.
- Protect the couplings with the coupling covers, fixing them to the connection flange using suitable screws.

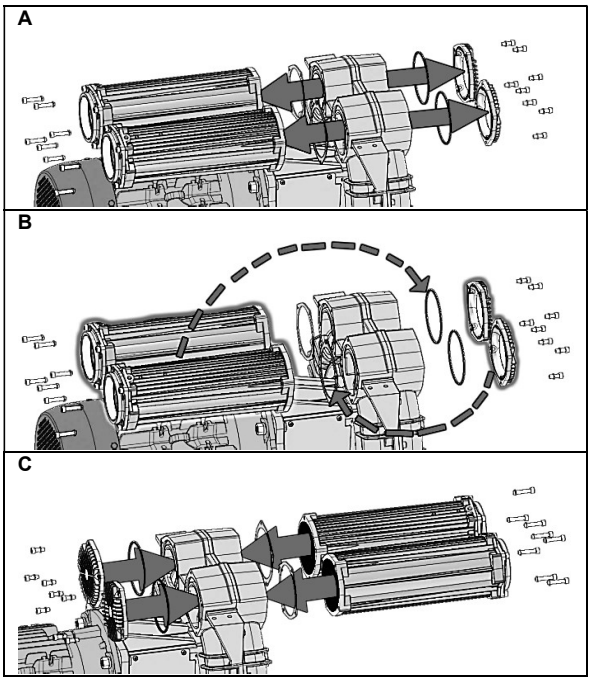


NOTE FOR THE USER	Regarding this, also consult the instruction manual for elastomer joints.

12.4 INSTRUCTIONS FOR REPOSITIONING SILENCER HOUSINGS FROM K07 to K12 - MS GOR

The 'SCL K - GOR' series has been designed for maximum flexibility in positioning the silencer housings in order to allow different installation configurations.

- The blower is normally supplied with silencers fitted on the blower body.
- If this arrangement has to be changed, establish the required arrangement of the silencer housings. See the INSTALLATION DIAGRAMS in the first section.
- Remove and refit the housings and blind flanges according to the diagram to obtain the desired configuration.



Removing the blind flange (A)

- Place the unit horizontal, resting the base on a flat and stable surface.
- Undo the screws, remove the blind flanges, the gasket and the silencer housings.

Positioning of silencer housings and blind flanges (B)

- Invert the positions of the silencer housings, blind flanges and gaskets.

Fitting of blind flanges and silencer housings (C)

- Fit the blind flanges on the housing with screws, not forgetting the gaskets.
- Fit the silencer housings on the cover using screws, not forgetting the gaskets.

	**Danger due to rotating parts: impeller.**
The danger of shearing due to the rotating impeller can exist even when the machine off, if it is started manually. **Therefore use suitable work clothes and personal protection equipment.**	

12.5 ELECTRIC MOTOR

	**Make sure to comply with all the safety measures and instructions given in the electric motor instruction manual.**

	**Make sure the mains power supply voltage and frequency match the values specified on the motor rating plate.**