Operating instructions

VacuStar W900 / W1300 / W1600

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The operating instructions must be read by the machine operator and before start-up!
# Contents

1 **General** ........................................................................................................ 5
   1.1 Information regarding the operating instructions ....... 5
   1.2 Pictogram explanation ........................................ 6
   1.3 Limitation of liability ............................................. 7
   1.4 Copyright protection ............................................. 7
   1.5 Spare parts ........................................................................... 8
   1.6 Warranty conditions ................................................ 8
   1.7 Customer service .................................................... 8
   1.8 Manufacturer’s declaration .................................. 8

2 **Safety** .......................................................................................................... 9
   2.1 Intended use ........................................................................ 9
   2.2 Proper operation .......................................................... 9
   2.3 Acceptance and monitoring ..................................... 10
   2.4 Operator’s responsibility .......................................... 10
   2.5 Operating personnel ................................................ 11
   2.5.1 Requirements ........................................................ 11
   2.6 Personal protective equipment ................................ 12
   2.7 Occupational safety and special dangers .............. 12

3 **Technical data** .......................................................................................... 17

4 **Design and function** .................................................................................. 18
   4.1 Design ........................................................................... 18
   4.2 Function ........................................................................... 18
   4.3 Control and display elements .................................. 19

5 **Transport and storage** ............................................................................. 20
   5.1 Safety notes for transport .......................................... 20
   5.2 Transport ........................................................................... 20
   5.3 Storage .............................................................................. 20

6 **Start-up and operation** .............................................................................. 21
   6.1 Safety during start-up .................................................. 21
   6.2 Start-up ............................................................................. 21
   6.3 Switching off ................................................................. 22
   6.4 Inspections to be performed ..................................... 23

7 **Maintenance** ............................................................................................... 25
   7.1 Safety during maintenance work ............................. 25
   7.2 Maintenance schedule ............................................... 25
   7.3 Performance of maintenance work ........................... 26
## Contents

8 Malfunctions ................................................................. 30  
  8.1 Safety ........................................................................ 30  
  8.2 Recommissioning after corrective action .................... 30  
  8.3 Malfunction table...................................................... 31  

9 Spare parts........................................................................ 33  

10 Decommissioning and disposal ....................................... 33  

Index.................................................................................. 34
1 General

1.1 Information regarding the operating instructions

These operating instructions provide important information on how to deal with the machine. Prerequisite for safe working is the observance of all specified safety notes and instructions.

In addition, the local accident prevention regulations valid at the machine's area of application and general safety regulations have to be complied with.

Carefully read the operating instructions before starting any work! They are a product component and must be kept in direct proximity of the machine, well accessible to the personnel at all times.

When passing the machine on to third parties, the operating instructions must also be handed over.
1.2 Pictogram explanation

Warning notes

Warning notes are characterised by pictograms in these operating instructions. The warning notes are preluded by signal words expressing the scale of the hazard.

It is absolutely essential to observe the notes and to proceed with caution in order to prevent accidents as well as bodily injuries and property damage.

**DANGER!**
… points to an immediately dangerous situation, which will lead to death or serious injuries if it is not avoided.

**WARNING!**
… points to a potentially dangerous situation, which may lead to death or serious injuries if it is not avoided.

**ATTENTION!**
… points to a potentially dangerous situation, which may lead to minor or light injuries if it is not avoided.

**CAUTION!**
… points to a potentially dangerous situation, which may lead to property damage if it is not avoided.

**Safety note ATEX!**
Only for machines with Ex-approval.
This pictogram denotes the special conditions that must be observed according to the approvals when operating the machines in potentially explosive areas.

Hints and recommendations

**NOTE!**
… highlights useful hints and recommendations as well as information for an efficient and trouble-free operation.
1.3 Limitation of liability

All specifications and notes in these operating instructions were compiled with consideration to the valid standards and regulations, the state of the art as well as to our long-standing knowledge and experience.

The manufacturer is not liable for damages caused by:

- Non-observance of the operating instructions
- Improper use
- Deployment of non-trained personnel
- Arbitrary modifications
- Technical changes
- Use of non-approved spare and wear parts

The actual scope of supply may differ from the explanations and illustrations described in this manual in case of special designs, if additional order options are made use of, or due to latest technical changes.

Incidentally, the responsibilities agreed upon in the delivery contract, the general terms and conditions as well as the manufacturer’s conditions of delivery and the statutory provisions valid at the time of contract conclusion shall apply.

Warranty

The manufacturer guarantees the correct functioning of the applied process technology and the performance parameters identified.

The warranty period commences on the date the machine is delivered to the customer.

Wear parts

Wear parts are all components coming into immediate contact with the material to be processed (e.g. bearings, shaft sealing rings, oil pumps, rotor vanes, etc.).

These components are excluded from the warranty and any claims for defects as far as wear and tear damage is concerned.

1.4 Copyright protection

Surrendering the operating instructions to third parties without written permission of the manufacturer is not permitted.

NOTE!

Content details, texts, drawings, pictures and other illustrations are protected by copyright and are subject to industrial property rights. Any improper use shall be liable to prosecution.

Any type and form of duplication – also of extracts – as well as the exploitation and/or communication of the contents are not permitted without the manufacturer's written declaration of consent.
1.5 Spare parts

**WARNING!**
Risk of injury by incorrect spare parts!
Incorrect or defective spare parts can result in damage, malfunctions or total failure and also impair safety.
Therefore:
- Use only the manufacturer's original spare parts.

Procure spare parts from authorised dealers or directly from the manufacturer. Refer to page 2 for address.
A list of spare and wear parts can be found in the enclosure.

1.6 Warranty conditions

The warranty conditions are included in the sales documentation as separate document.

1.7 Customer service

Our customer service can be contacted for any technical advice.
Information about the responsible contact person can be retrieved by telephone, fax, E-mail or via the Internet at any time, refer to manufacturer's address on page 2.

1.8 Manufacturer's declaration

Manufacturer's declaration (pursuant to EC Machinery Directive 98/37/EC, Annex II, refer to enclosure.)
2 Safety

2.1 Intended use

The machines of the VacuStar series are exclusively intended for the compression or extraction of filtered air.

The VacuStar in the explosion proof design complies with Directive 94/9/EC (ATEX) and is suitable for conveying potentially explosive gases and gas mixtures of explosion group IIB, temperature class T2/T3 from potentially explosive zone 1 and zone 2 areas. The machine may not be operated in a potentially explosive area.

Machine identification:

II 2G c IIB T2 (i) (for machines without cell ventilation)
II 2G c IIB T3 (i) (for machines with cell ventilation and no potentially explosive external atmosphere).

The gas temperature in temperature class T2 is restricted to 220 °C and in temperature class T3 to 195 °C.

2.2 Proper operation

The following criteria in essence define the proper operation:

- Machine speed range: 1000...1500 rpm
- Ambient temperature: −20...+40 °C
- No coast down of the cooling system after switching off the machine
- Permissible continuous duty vacuum with cell ventilation: 100 mbar
- Permissible continuous duty vacuum without cell ventilation: 200 mbar
- No back pressure on the pressure side during vacuum operation
- Liquids and solids may not get into the machine or be sucked into the machine.

If potentially explosive gases and gas mixtures are conveyed, the following guidelines must be observed:

- 94/9/E6 (ATEX 95), Requirement on equipment
- 99/92/E6 (ATEX 137), Assembly, installation and operation of equipment
Only use machine for the intended use. All specifications in these operating instructions have to be strictly complied with (technical data, ATEX regulations, etc.)

Any types of claims due to damage arising from improper use are excluded. The operator alone shall be responsible for any damage arising from improper use.

### 2.3 Acceptance and monitoring

The VacuStar W itself is not subject to any acceptance and monitoring obligation.

### 2.4 Operator's responsibility

The machine is used for industrial purposes. The operator of the machine is therefore subject to the legal obligations concerning occupational safety.

The provisions valid at the place of installation as well as the safety and accident prevention regulations of the Institution for statutory accident insurance and prevention must be observed. The operator must in particular:

- inform himself on the valid industrial safety regulations.
- determine the additional hazards that arise from the special working conditions at the machine's place of installation by means of a hazard assessment.
- implement the necessary rules of conduct for operation of the machine at the place of installation by means of user instructions.
- check at regular intervals during the machine's entire period of use whether the user instructions correspond to the current state of the body of rules and regulations.
- adapt the operating instructions – if necessary – to the new regulations, standards, and operating conditions.
- clearly regulate the responsibilities for installing, operating, maintaining and cleaning the device.
- ensure that all employees working on or with the machine have read and understood the operating instructions. In addition he must at regular intervals train the employees in how to deal with the machine and inform them about potential hazards.

In addition, it is the operator's responsibility to ensure that:

- the machine is always in a technically perfect condition.
- the machine is maintained in accordance with specified maintenance intervals.
- all safety equipment is regularly checked for completeness and correct functioning.
2.5 Operating personnel

2.5.1 Requirements

**WARNING!**
Risk of injury in case of inadequate qualification!
Improper handling can lead to considerable bodily injuries and property damage.
Therefore:
– Have any activities only carried out by the individuals designated for that purpose.

The operating instructions specify the following qualification requirements for the different fields of activity:

- **Instructed persons**
  have been instructed during instructions provided by the operator with regard to the work assigned to them and possible hazards arising from improper conduct.

- **Specialised staff**
  is due to its technical training, knowledge and experience as well as due to its knowledge of the pertinent regulations able to carry out the work assigned to it and to independently recognise potential hazards.
2.6 Personal protective equipment

It is necessary to wear personal protective equipment when dealing with the machine so as to minimise health hazards.

- Before carrying out any work, properly don the necessary protective equipment such as gloves, safety goggles, etc. and wear during work.

2.7 Occupational safety and special dangers

The remaining risks that result from the hazard analysis are specified in the following section.

Observe the safety notes listed here and the warning notes in the other chapters of these instructions to reduce health hazards and to avoid dangerous situations.

**Danger pictograms on the device**

The relevant dangerous spots on the machine are identified by these pictograms:

- **DANGER! General danger pictogram!**
  … denotes general dangerous situations for individuals. Non-observance of the safety instructions can result in severe injuries or death.

- **DANGER! Explosion protection pictogram!**
  … denotes regulations and information that need to be observed in potentially explosive areas. Explosion protection class, temperature ranges, etc. must be observed!

- **DANGER! Danger of burns!**
  … denotes the presence of a hot surface.
Hazard notes and occupational safety
For your own safety and that of the machine, the following information must be observed and complied with:

**Improper operation**

**DANGER!**
Danger due to improper operation!

- Only use machine in a perfect technical condition. Malfunctions that are relevant for safety have to be promptly eliminated.
- Conversions of the machine are not permissible and can impair safety.
- Never bridge any safety equipment or put it out of operation.
- Any work on the machine and/or on electrical equipment must be carried out by specialised staff.
- Repair and maintenance work may only be carried out when the machine is stationary. For this, the machine must be secured against restarting!
- The machine may not be under pressure or in a state of vacuum while work is being carried out on it.
  Close shut-off valve on the vehicle side and vent the pipe between machine and shut-off valve or manually relieve excess pressure at safety valve. Observe pressure gauge indication!
- The drive’s protective equipment may only be removed when the machine is stationary and has to be correctly refitted after completion of work.
- Only dismantle accidental contact protection after machine and pressure pipe have cooled down.
- It is an environmental protection requirement that any liquids arising during maintenance work (e.g. cooling oil, cooling water, etc.) are collected and disposed of in an environmentally compatible manner
- The machine may only be opened for maintenance and repair work by specialised staff if the machine is stationary and no potentially explosive atmosphere is present.
Moving components

**WARNING!**
Risk of injury by moving components!
Powered rotating components can cause the most serious injuries!
Therefore during operation:
- It is absolutely forbidden for individuals to stay in the hazard area or in the immediate vicinity!
- Do not put safety devices and/or functions out of operation and do not render them inoperative or bypass them.
- Never reach into open outlets and inlets or into running equipment.

Before entering the hazard area:
- Switch off power supply and secure against restarting.
- Wait for standstill of lagging components.
- Wait for automatic dissipation and/or discharge of residual energies (compressed air).

Compressed air

**WARNING!**
Risk of injury due to compressed air!
Pneumatic energies can cause the most serious injuries.
In the case of damage to individual components, air can be discharged under high pressure and injure e.g. the eyes.
Therefore:
- Before starting any work, first depressurise pressurised components. Pay attention to accumulators. Accumulator pressure must also be completely relieved.
- Do not change pressure settings beyond the maximum values.

Signposting

**WARNING!**
Risk of injury due to illegible pictograms!
Labels and signs can become dirty or unrecognisable in the course of time.
Therefore:
- Always keep safety, warning and operating instructions in a well legible condition.
- Immediately replace damaged or obliterated signs or labels.
Improper transport

DANGER!
Danger by falling down or tilting of the machine!
The weight of the machine may injure a person and cause serious bruising!
Therefore:
– Depending on the dead weight and size of the machine, use a pallet on which the machine can be moved by means of a fork lift.
– For lifting the machine, use suitable lifting gear (slings, etc.) that is designed for the weight of the machine.
– When putting the slings in position, take care to avoid putting stress on individual components.
– Only use attachment points with eye bolts provided for that purpose.

Start-up, operation

WARNING!
Risk of injury due to improper start-up and operation
Improper start-up and operation can lead to serious bodily injuries or property damage.
Therefore:
– Have all work during initial operation exclusively performed by the manufacturer’s employees or by his authorised representatives or by trained personnel.
– Start-up and operation may only be performed by adequately qualified personnel that has been authorised and instructed by the operator.
– Before the start of any work, ensure that all covers and protective devices are correctly installed and function correctly.
– Never override any protective equipment during operation.
– Pay attention to tidiness and cleanliness in the working area! Loosely stacked or scattered components and tools are accident sources.
Electrical system

DANGER!
Mortal danger due to electric current!
There is mortal danger in case of contact with live components.
Activated, electrically driven components may start to move in an uncontrolled manner, thereby causing the most serious injuries.
Therefore:
– Switch off the electric power supply before commencing any work and secure against restarting.
– Work on the electrical system, on individual electrical components and on the connections may only be carried out by electrical specialists.

Maintenance and trouble shooting

WARNING!
Risk of injury due to improper maintenance and trouble shooting!
Improper maintenance and trouble shooting can lead to serious bodily injuries or property damage.
Therefore:
– Maintenance work and trouble shooting work may only be carried out by sufficiently qualified and instructed personnel.
– Secure machine against restarting, switch off drives!
– Before starting any work, provide for sufficient space and freedom of movement during assembly.
– Pay attention to tidiness and cleanliness in the assembly area! Loosely stacked or scattered components and tools are accident sources.
– If components must be replaced:
  – Pay attention to correct installation of spare parts.
  – Properly reassemble all fastening elements.
  – Observe screw tightening torques.
  – Before restarting, ensure that all covers and protective devices are correctly installed and function correctly.
– After completion of maintenance work and trouble shooting, check correct functioning of safety equipment.
3 Technical data

<table>
<thead>
<tr>
<th>VacuStar operating data</th>
<th>Unit</th>
<th>Model W900</th>
<th>Model W1300</th>
<th>Model W1600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nominal operating vacuum</td>
<td>[mbar]</td>
<td>400</td>
<td>400</td>
<td>400</td>
</tr>
<tr>
<td>Permissible continuous duty vacuum</td>
<td>[mbar]</td>
<td>100</td>
<td>100</td>
<td>100</td>
</tr>
<tr>
<td>Maximum final overpressure during compressor operation in case of direct drive</td>
<td>[bar]</td>
<td>2</td>
<td>2</td>
<td>2</td>
</tr>
<tr>
<td>Maximum final overpressure during compressor operation in case of V-belt drive</td>
<td>[bar]</td>
<td>2</td>
<td>1,5</td>
<td>0,5</td>
</tr>
<tr>
<td>Oil reservoir</td>
<td>[l]</td>
<td>7,5</td>
<td>7,5</td>
<td>7,5</td>
</tr>
<tr>
<td>Lubricating oil consumption</td>
<td>[l/h]</td>
<td>0,2</td>
<td>0,3</td>
<td>0,4</td>
</tr>
<tr>
<td>Weight (without accessories)</td>
<td>[kg]</td>
<td>220</td>
<td>279</td>
<td>339</td>
</tr>
</tbody>
</table>

Table 1: Operating data

Lubricating oils

The use of multigrade oils will damage the VacuStar W. In that case, the warranty on the part of CVS Engineering GmbH shall cease. Only single grade oils with the following specification are permitted for operating the VacuStar W:

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>API:</td>
<td>CD/SF or higher</td>
</tr>
<tr>
<td>MIL:</td>
<td>L2104 C or higher.</td>
</tr>
</tbody>
</table>

Table 2: Lubricating oils

Lubricating oil types

<table>
<thead>
<tr>
<th>Brand</th>
<th>Suction temperature &gt;10 °C</th>
<th>Suction temperature 10 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>ARAL</td>
<td>Basic Turboral SAE 40</td>
<td>Basic Turboral SAE 30</td>
</tr>
<tr>
<td>AVIA</td>
<td>Cronos Super SAE 40</td>
<td>Special HDC 30</td>
</tr>
<tr>
<td>BP</td>
<td>Vanellus C3-40 Energol C-DG 40</td>
<td>Vanellus C3-30 Energol C-DG 30</td>
</tr>
<tr>
<td>ESSO</td>
<td>Essolube XD-3 Motor Oil 40  Essolube XD-301 Motor Oil 40</td>
<td>Essolube XD-3 Motor Oil 30 Essolube XD-301 Motor Oil 30</td>
</tr>
<tr>
<td>FUCHS</td>
<td>Titan Universal HD 40      Titan Universal HD 30</td>
<td></td>
</tr>
<tr>
<td>MOBIL</td>
<td>Delvac 1340                Delvac 1330</td>
<td></td>
</tr>
<tr>
<td>SHELL</td>
<td>Rimula X Monograde 40      Rimula X Monograde 30</td>
<td></td>
</tr>
</tbody>
</table>

Table 3: Lubricating oil types

1 Only in conjunction with cell ventilation, without cell ventilation 200mbar (protection via ventilation valve)
2 Protection via a safety valve
4 Design and function

4.1 Design

Fig. 1: View VacuStar and details

1 Centring device and fastening of hydraulic motor mounting flange
2 Drive shaft
3 Cooling water inflow (1")
4 Pressure connection (flange DIN 28459-125)
5 Temperature measuring point (R ½")
6 Connection cell ventilation (R 2")
7 Oil level indicator (bilateral)
8 Crank for manual lubrication
9 Rating plate
10 Oil filler neck cap
11 Sense of rotation arrow
12 Transport and fixing holes (M16)
13 Negative pressure connection (R 3/8")
14 Suction connection (flange DIN 28459-125)
15 Cooling water outflow (R 1")
16 Lubricating oil reservoir

4.2 Function

Functional principle

Sliding vane compressor vacuum pumps work according to the displacement principle. Due to the rotor's eccentric arrangement inside the casing, limited, crescent-shaped working chambers are created by means of the rotor vanes, which are enlarged or reduced with every turn of the rotor. Cleaned air is drawn in via the suction connection (item 14) and reaches the pressure line after being compressed via the pressure connection (item 4).

Machine lubrication

The machine is lubricated by means of an oil pump. Oil is pumped from the oil reservoir via the oil lines to the machine's lubricating points.
Cooling
The machine is water-cooled. The machine is equipped with a cooling jacket inside the casing. The cooling water circulates by means of a circulating pump.

Drives
The VacuStar can be powered via:
- Articulated shaft
- V-belt
- Hydraulic motor
Details about the drives and their design can be found in the separate installation instructions for the VacuStar.

4.3 Control and display elements
Depending on the installation situation, different display elements such as pressure gauge, temperature gauge and vacuum gauge are available.
5 Transport and storage

5.1 Safety notes for transport

Refer to chapter 2.7 Safety!

5.2 Transport

The machine, which is fastened on a base plate, must be transported with a fork lift or suitable straps. The lifting gear must be designed for the weight of the machine.

For future transports:
- Seal all open connections with protective caps (prevents penetration of dirt and water)
- Secure loose cables
- Secure against vibrations
- Drain all process and operating media
- Securely fasten the VacuStar prior to transport (e.g. screw it onto a pallet)
- Transport and put down machine with a fork lift or secure with straps and lift with suitable lifting gear.

5.3 Storage

Storage of packages

Store packages under the following conditions:
- Do not store outdoors.
- Store dry and dust free.
- Do not expose to aggressive media.
- Protect against solar irradiation.
- Avoid mechanical vibrations.
- Storage temperature: −10 to +60 °C
- Relative humidity: max. 95%, non-condensing
- If storage lasts longer than 3 months, regularly check the general condition of all parts and of the packaging. If necessary, brush up or recondition the preservation.
- To keep moisture away from the machine's workspace, bags with desiccant must be placed into the inlets and outlets. These must be removed before start-up.
6 Start-up and operation

6.1 Safety during start-up

Refer to chapter 2.7 Safety!

6.2 Start-up

Inspection prior to initial start-up

The following points must be checked prior to initial start-up:

- Fill in cooling water (clean tap water) up to the maximum mark on the compensation reservoir.
- Add antifreeze according to manufacturer's specifications.
- Top up lubricating oil according to lubricating oil schedule. Fill oil reservoir with oil up to max. 3 cm below filler neck thread.
- Manually prelubricate the VacuStar W by means of the crank handle (refer to lubricating oil inspection Chapter 6.4).

Start-up

Proceed as follows during start-up:

- Open shut-off devices (if available)
- Start the VacuStar drive
- Check operating data

Inspections during operation

The following inspections have to be carried out during operation:

- Prior to every start-up and during operation, the oil level and the coolant level must be checked and topped up if necessary.
- Open shut-off devices. Always switch four way cock up to the limit stop, intermediate positions are not permitted
- Switch on drive and check whether pressure or vacuum are created.
- Pay attention to abnormal noises and leaks during operation, if necessary switch off machine.
- Drain condensate at the condensate and safety traps. Vessel may not be in a state of vacuum when condensate is drained.

Checking the operating data:

- The speed must range between 1000…1500 rpm.
- The cooling water outlet temperature (return flow to radiator) may be max. 60 °C.
- Check positive working pressure at the pressure gauge (permissible pressure refer to rating plate).
- Check the operating vacuum at the vacuum meter (permissible vacuum refer to rating plate).
- The compression end temperature at 20 °C suction temperature may not exceed the following values:
  - 140 °C at 400 mbar operating vacuum
  - 120 °C at 0.5 mbar excess pressure
Safety note ATEX!

If potentially explosive gases and gas mixtures are conveyed, the following points must be observed:

- Prior to every machine start and during operation:
  - Check coolant
  - Check oil level
  - Check for leaks

- During the suction process, pay attention to abnormal noises and switch off machine if necessary

- Regularly examine the machine (daily) for signs of overheating and exceptional deformations. If necessary, switch off machine or do not put into operation.

- Regularly examine the machine for leaks such as leaking oil or water or escaping gas. If necessary, switch off machine or do not put into operation.

If the machine is extremely hot: Switch off machine and only switch on again after approximately half an hour, to prevent the rotor from starting.

6.3 Switching off

To switch off the VacuStar, proceed as follows:

- Switch off drive for the VacuStar
- Close shut-off valves (if available)
6.4 Inspections to be performed

**Lubricating oil inspection**

Only lubricating oils pursuant to the lubricating oil schedule on page 17 are approved for the VacuStar W series.

Check oil level at the inspection glass and if necessary, fill with oil to approx. 3 cm below the filler neck thread. The oil level may not drop below the bottom mark on the oil inspection glass.

Manual prelubrication of the machine is always necessary:

- in case of initial operation
- in case of recommissioning after a standstill of more than 4 weeks
- after sucking over of foreign matter
- after repair work on the VacuStar

Procedure to be followed for manual prelubrication:

- Remove the crank handle from the retaining bracket and push it through the oil filler neck onto the oil pump shaft. Push the crank handle down until the drive dog engages and now prelubricate for approximately 40 full turns.
- Afterwards, clip crank handle back into the retaining bracket and screw locking screw back on again.

---

![Fig. 2: Oil pump](image)

1. Crank handle
2. Oil filler neck screw
3. Lubricating oil pump
4. Lubricating oil drain screw

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The oil reservoir must be filled up before every suction process!
Non-return valve inspection
The non-return valve is maintenance-free, but is subject to wear like all other moving parts. We recommend a visual inspection every 6 months. In this connection, the non-return valve must be dismantled, cleaned, freed of deposits and checked for freedom of motion.

Prior to assembly, the cylinder pin's slide face must be brushed with Loctite No. 8065 lubricant.
Worn out non-return valves must be replaced!

Safety valve inspection
The safety valve is no regulating device!
The operational capability must be checked on start-up and later at weekly intervals.
The safety valve must be secured against misadjustment. Blocking or manipulating the safety valve can have penal consequences if it gives rise to an accident. Any warranty claims shall also be forfeited in such a case.

A maximum pressure pursuant to rating plate is permissible. Depending on the type of drive, this may according to the table Technical data on page 19 be lower.

Inspection of the ventilating valve
As a matter of principle, a ventilating valve must be installed as safety element on the vacuum pump’s suction side. When the set vacuum is reached, the ventilating valve opens and admits atmospheric auxiliary air into the system. The operational capability must be checked weekly with the aid of a vacuum meter at the VacuStar’s inlet. In case of systems without cell ventilation, the vacuum may not drop below the permissible value of 200 mbar.

In case of systems with cell ventilation, the vacuum may not drop below the permissible value of 100 mbar.

Inspection of cell ventilation
The VacuStar W has been prepared for operation with cell ventilation. The connection is located at the upper part of the pressure flange. If your system’s cell ventilation is connected, you may operate the VacuStar up to a vacuum of 100 mbar. A suction filter is located in the cell ventilation line. The filter must be cleaned weekly and replaced in case of visible damage.
7 Maintenance

7.1 Safety during maintenance work

Refer to chapter 2.7 Safety!

Personal protective equipment

The following must be worn during all maintenance work:

- Safety working clothing
- Protective gloves
- Safety shoes
- Safety goggles

Environmental protection

Observe the following information with regard to environmental protection during maintenance:

- Remove emerging, used or excessive grease at all lubricating points that are manually supplied with lubricant and dispose of in accordance with valid local regulations.
- Collect exchanged oil in suitable containers and dispose of in accordance with valid local regulations.

7.2 Maintenance schedule

The following describes the maintenance work that is necessary for an optimum, trouble-free operation. Maintenance intervals must be observed.

If increased wear of individual components or functional groups is determined during regular inspections, the operator has to reduce the required maintenance intervals on the basis of the actual signs of wear.

Changes compared to normal operation (increased power consumption, temperatures, vibrations, noises, etc. or response of monitoring systems) lead to the assumption that the functions are impaired. These then have to be subjected to an inspection by specialised staff.

In case of queries regarding the maintenance work and intervals: contact the manufacturer (service address → page 2).

For maintenance schedule refer to next page.
## Table maintenance schedule

<table>
<thead>
<tr>
<th>Interval</th>
<th>Maintenance work</th>
<th>To be carried out by</th>
</tr>
</thead>
<tbody>
<tr>
<td>Every 15 minutes</td>
<td>Check operating speed</td>
<td>Operator</td>
</tr>
<tr>
<td></td>
<td>Check operating pressure / vacuum</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check air outlet temperature</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check cooling water return temperature</td>
<td></td>
</tr>
<tr>
<td>Daily</td>
<td>Check condensate</td>
<td>Operator</td>
</tr>
<tr>
<td></td>
<td>Check safety trap</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check silencer oil trap</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check oil level and top up with fresh oil if necessary</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check coolant</td>
<td></td>
</tr>
<tr>
<td>Weekly</td>
<td>Check safety valve</td>
<td>Operator</td>
</tr>
<tr>
<td></td>
<td>Check ventilating valve</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Clean cooling unit / water cooler</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Clean compressor / vacuum pump</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Clean vacuum filter</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check V-belt, V-belt tension and re-tension if necessary</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Clean cell ventilation filter, replace if damaged</td>
<td></td>
</tr>
<tr>
<td>Monthly</td>
<td>Clean oil tank</td>
<td>Operator</td>
</tr>
<tr>
<td></td>
<td>Check fastening screws and tighten if necessary</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check shaft sealing rings for tightness (no oil may leak from them)</td>
<td></td>
</tr>
<tr>
<td>Quarterly</td>
<td>Check rotor vanes (wear)</td>
<td>Specialised staff</td>
</tr>
<tr>
<td></td>
<td>Check cell ventilation valve</td>
<td>Specialised staff</td>
</tr>
<tr>
<td>Half-yearly</td>
<td>Check non-return valve of stage</td>
<td>Specialised staff</td>
</tr>
<tr>
<td>10,000 oh / 3 years</td>
<td>Replace shaft sealing rings</td>
<td>Specialised staff</td>
</tr>
<tr>
<td>15,000 oh / 5 years</td>
<td>Replace bearings</td>
<td>Specialised staff</td>
</tr>
</tbody>
</table>

### 7.3 Performance of maintenance work

#### Cleaning the VacuStar

Carrying out cleaning work:

1. Switch off system and secure against restarting.
2. Remove soiling appropriately. Observe the following:
   - Do not use aggressive cleaning agents.
   - Pay attention during cleaning that no water gets into the compression chamber.
   - Exercise special caution when cleaning with high-pressure cleaning systems.
   - Absorb oil deposits with oil-absorbing materials (e.g. sawdust).
   - After cleaning work, check that all previously opened covers and safety equipment are correctly installed and function correctly.
   - After wet cleaning, warm up the machine for a few minutes.
**Water cooling system / cleaning the radiator**

Check cooling water level in compensation reservoir and top up if necessary.

Clean radiator in case of soiling as the cooling air must have free passage.

**Action after lengthy standstill**

If the standstill of the VacuStar installed inside the vehicle lasts for more than a month, we recommend putting the machine into operation once a month for 15 minutes. The machine must be prelubricated prior to start-up (refer to chapter lubricating oil inspection, chapter 6.4.)

**Action after sucking over of foreign matter**

If foreign matter has been sucked over into the machine, proceed as follows:

- Unscrew locking screw in inlet or dismantle fitted additional lubrication line.
- Open vehicle box to allow the VacuStar to be run without vacuum or pressure build-up.
- Switch on machine and allow approx. 0.5...1 l of a diesel-oil-mixture (1:1 mixing ratio) to be sucked into the machine through the hole in the inlet at approx. 1000 rpm.
- Afterwards, allow another 0.5 - 1 l clean oil to be sucked in via the inlet.
- Completely remove this diesel-oil-mixture from the machine and do not allow to collect in the downstream silencer - fire hazard!
- Switch off machine and re-attach locking screw. Prelubricate VacuStar pursuant to chapter Lubricating oil inspection, chapter 6.4 before the machine is restarted.
Cleaning the suction filter

Clean the suction filter depending on accumulated dirt and specification in the maintenance schedule. To open the suction filter 1600 F (fine filter) and 1600 G (coarse filter), it is necessary to open a star handle, on the suction filter 1600 F-D (fine filter, pressure-resistant) and 1600 G-D (coarse filter, pressure-resistant), 5 star handles need to be opened to remove the lid. The hexagon nut on the stud bolt must be unscrewed to remove the filter cartridge.

**NOTE!**
*Pay attention during cleaning that no liquid, dirt or other objects get into the vacuum pump.*

Cleaning procedure:

- Rinse out filter casing with detergent.
- Rinse out stainless steel fabric filter cartridge with detergent.
- Carefully rinse out filter cartridge with fine filter cartridge.
  - Check for damage after cleaning. A damaged cartridge must be replaced.
  - Check round sealing ring on casing lid for damage. Damaged sealing rings must be replaced.
- After cleaning, reassemble the filter in reverse order.

![Diagram of suction filter](image)

**Fig. 3: Suction filter**

1. Star handle
2. Casing
3. Filter cartridge
4. Air inlet soiled air
5. Air outlet filtered air
Check rotor vane's height wear

Carry out the first inspection either after 6 months or after 500 operating hours, depending on which occurs first. The following inspection has to be scheduled according to the measuring result.

**NOTE!**

Pay attention during the inspection that no liquid, dirt or other objects get into the vacuum pump.

**Procedure:**

- Dismantle vacuum filter and if necessary suction line.
- Press rotor vanes into the rotor slit in horizontal position and measure the distance to the rotor surface with the depth gauge.
- The wear measurement of 6 mm may not be exceeded. Replace rotor vane if necessary.

![Diagram of VacuStar](image)

Fig. 4: Cross-section through the VacuStar

1. Depth gauge (max. 6 mm)
2. Rotor vane (6x)
3. Rotor slit (6x)
4. Casing
5. Rotor
8 Malfunctions

This chapter describes possible causes of malfunctions and trouble shooting tasks.
Reduce the maintenance intervals if similar malfunctions occur repeatedly due to above-average intensive use so intervals correspond to the actual load.
Contact the manufacturer in case of malfunctions that cannot be repaired with the aid of the following information (→ page 2)

8.1 Safety

Refer to chapter 2.7 Safety!

Personnel
- The trouble shooting work described at this point can be carried out by the operator, unless otherwise indicated.
- Some work may only be carried out by specially trained specialised staff or exclusively by the manufacturer himself. This is specifically pointed out in the description of the individual malfunctions.
- Only electrical specialists may carry out work on the electrical system.
- Components and parts may only be replaced by specialised staff.

Personal protective equipment
Refer to chapter 7.1.

Environmental protection
Refer to chapter 7.1.

Conduct in the case of malfunctions
The following basically applies:
1. Immediately trigger an emergency-stop in case of malfunctions constituting an immediate danger for individuals or material assets.
2. Switch of all power supplies and secure against restarting.
3. Inform person in charge at the place of installation.
4. Depending on the type of malfunction, have the cause determined and eliminated by responsible and authorised specialised personnel.

8.2 Recommissioning after corrective action

After corrective action or trouble shooting:
1. Reset emergency stops.
2. Acknowledge error message or malfunction at the control system.
3. Ensure that nobody is staying in the hazard area.
4. Start in accordance with the instructions in chapter „start-up“.
### 8.3 Malfunction table

<table>
<thead>
<tr>
<th>Malfunction:</th>
<th>Possible cause</th>
<th>Corrective action</th>
<th>Execution</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Vacuum filter soiled</strong></td>
<td></td>
<td>Clean vacuum filter</td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Leaky suction line / fittings</strong></td>
<td></td>
<td>Look for leaky spots and eliminate leak</td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Speed too low</strong></td>
<td></td>
<td>Adjust speed</td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Wear of rotor vanes, possibly caused by dirt or liquids that have gotten</strong></td>
<td><strong>into the machine (sucking over of foreign matter)</strong></td>
<td>Replace rotor vane, remove dirt and have machine overhauled at an authorised workshop</td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Compressor's / vacuum pump's delivery rate decreases</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Machine is out of alignment</strong></td>
<td>Align machine accurately</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Bearing defective</strong></td>
<td>Replace bearing (or have it replaced)</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Lack of lubricating oil</strong></td>
<td>Top up oil, clean oil reservoir and suction filter</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Unsuitable lubricating oil</strong></td>
<td>Fill in oil according to lubrication schedule</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Rotor vanes are jammed</strong></td>
<td>Check rotor vanes</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Casing bore shows grooves or corrugations due to the aspiration of dirt</strong></td>
<td>Have casing bore re-turned and honed at an authorised workshop. In case of heavily soiled intake air, install fine filter</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Wrong speed</strong></td>
<td>Maintain speed range</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Changed pressure</strong></td>
<td>Maintain nominal pressure</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Changed vacuum</strong></td>
<td>Maintain nominal vacuum, check exhaust system and clean if necessary</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Non-return valve rattles</strong></td>
<td>Check non-return valve</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Foreign matter in the machine</strong></td>
<td>Remove foreign matter. Rinse out machine.</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Slide breakage</strong></td>
<td>Immediately switch off machine and repair</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Compressed air temperature too high</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>End pressure too high</strong></td>
<td>Maintain nominal pressure</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Exhaust silencer clogged</strong></td>
<td>Replace exhaust silencer</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Four way cock in wrong position</strong></td>
<td>Correctly adjust four way cock</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Poor cooling</strong></td>
<td>Replenish cooling water, clean radiator, clean cooling water chamber inside the machine</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Valve plate in non-return valve is jammed</strong></td>
<td>Check non-return valve and clean if necessary</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Vacuum filter clogged</strong></td>
<td>Clean vacuum filter</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Vacuum too high</strong></td>
<td>Maintain nominal vacuum</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Abnormal noise emission</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Wrong speed</strong></td>
<td>Maintain speed range</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Changed pressure</strong></td>
<td>Maintain nominal pressure</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Changed vacuum</strong></td>
<td>Maintain nominal vacuum, check exhaust system and clean if necessary</td>
<td></td>
<td>Operator</td>
</tr>
<tr>
<td><strong>Non-return valve rattles</strong></td>
<td>Check non-return valve</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Foreign matter in the machine</strong></td>
<td>Remove foreign matter. Rinse out machine.</td>
<td></td>
<td>Specialised staff</td>
</tr>
<tr>
<td><strong>Slide breakage</strong></td>
<td>Immediately switch off machine and repair</td>
<td></td>
<td>Specialised staff</td>
</tr>
</tbody>
</table>

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31
## Malfunctions

<table>
<thead>
<tr>
<th>Malfunction:</th>
<th>Possible cause</th>
<th>Corrective action</th>
<th>Execution</th>
</tr>
</thead>
</table>
| Operating pressure or operating vacuum is not obtained | Pressure gauge or vacuum meter do not indicate correctly  
V-belts are slipping  
Four way cock in wrong position  
Condensate drain cock open | Replace pressure gauge or vacuum meter  
Check V-belt tension and re-tension if necessary  
Correctly adjust four way cock  
Close condensate drain cock | Specialised staff  
Operator  
Operator  
Operator |
| Cooling water temperature exceeds 60°C | Too little cooling water in cooling system  
Radiator soiled or compressor cooling water chambers silty | Top up cooling water  
Clean radiator, clean cooling water chambers on compressor | Operator  
Operator |
| Silt or liquid has gotten into the machine | Foreign matter has been sucked over into the machine | Rinse thoroughly with diesel-oil-mixture at lowest permissible speed and without pressure or vacuum, afterwards add lubricating oil according to chapter Lubricating oil inspection page 30. | Operator |
| Power requirement too high | Speed too high  
End pressure too high  
Pressure gauge indicates incorrectly  
Exhaust silencer clogged | Maintain speed limit  
Maintain nominal pressure, actuate / check safety valve  
Replace pressure gauge  
Replace exhaust silencer | Operator  
Operator  
Operator  
Specialised staff |
| Lack of lubricating oil despite full oil tank | Oil intake strainer in oil tank clogged | Clean oil tank and intake strainer, check oil lines | Operator |
| Safety valve blows off | Closed valves in the pressure line  
Clogging in pressure system  
Exhaust silencer clogged | Open valves  
Eliminate clogging  
Replace exhaust silencer | Operator  
Operator  
Specialised staff |
| Ventilating valve responds | Closed valves in the suction line  
Suction filter clogged | Open valves  
Clean suction filter, if necessary replace filter cartridge | Operator  
Operator |
| Compressed air blows off at shaft end and oil is leaking | Sealing parts are damaged | Replace radial shaft sealing rings in sealing cover | Specialised staff |
| Rubber smell (at V-belt drive) | V-belts slip due too insufficient belt tension  
End pressure too high | Check belt tension, re-tension if necessary  
Maintain nominal pressure | Operator  
Operator |
| Reversing of V-belts | Insufficient belt tension  
Worn V-belts  
Pulleys are not aligned  
Worn V-belt pulleys | Check belt tension, re-tension if necessary  
Put on new V-belts  
Align pulleys  
Replace pulleys | Operator  
Operator  
Specialised staff  
Specialised staff |
9  Spare parts

We recommend stocking a service package as well as a suction filter cartridge.

The service package comprises all wear parts that are required for a normal repair.

Customer service

In case of queries regarding the product, spare part orders, repairs, replacement machines and dispatch of fitters, please contact our customer service: Phone.: +49 (0) 7623 71741-31

<table>
<thead>
<tr>
<th>Model</th>
<th>Service package</th>
<th>Filter cartridge</th>
</tr>
</thead>
<tbody>
<tr>
<td>VacuStar W900</td>
<td>900 000-SP</td>
<td></td>
</tr>
<tr>
<td>VacuStar W1300</td>
<td>990 001-SP</td>
<td></td>
</tr>
<tr>
<td>VacuStar W1600</td>
<td>990 002-SP</td>
<td></td>
</tr>
<tr>
<td>Suction filter 1600 F</td>
<td>432 020-00</td>
<td></td>
</tr>
<tr>
<td>Suction filter 1600 G</td>
<td>432 021-00</td>
<td></td>
</tr>
</tbody>
</table>

10  Decommissioning and disposal

A VacuStar unit that is no longer usable should not be recycled as complete unit, but disassembled into individual components and recycled according to material types. Non-recyclable materials have to be disposed of in an environmentally compatible manner.

- Prior to decommissioning and disposal of the machine, it must be completely separated from the surrounding units.
- The disassembly and disposal of the machine may only be carried out by specialised staff.
- If hazardous or poisonous material were conveyed, the machine must be decontaminated prior to disposal.
- The machine has to be disposed of in accordance with the respective country-specific regulations.
## Index

<table>
<thead>
<tr>
<th>A</th>
<th>Acceptance</th>
<th>10</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Action sucking over</td>
<td>27</td>
</tr>
<tr>
<td>ATEX</td>
<td></td>
<td>9, 22</td>
</tr>
<tr>
<td>C</td>
<td>Cleaning</td>
<td></td>
</tr>
<tr>
<td></td>
<td>radiator</td>
<td>27</td>
</tr>
<tr>
<td></td>
<td>suction filter</td>
<td>28</td>
</tr>
<tr>
<td></td>
<td>VacuStar</td>
<td>26</td>
</tr>
<tr>
<td></td>
<td>Components, moving</td>
<td>14</td>
</tr>
<tr>
<td></td>
<td>Compressed air</td>
<td>14</td>
</tr>
<tr>
<td></td>
<td>Contact person</td>
<td>8</td>
</tr>
<tr>
<td></td>
<td>Copyright protection</td>
<td>7</td>
</tr>
<tr>
<td></td>
<td>Customer service</td>
<td>8</td>
</tr>
<tr>
<td>D</td>
<td>Danger of burns</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>Danger pictogram</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>Danger pictograms</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>Dangers</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>Disposal</td>
<td>33</td>
</tr>
<tr>
<td>E</td>
<td>Explosion protection</td>
<td>12</td>
</tr>
<tr>
<td>F</td>
<td>Function</td>
<td>18</td>
</tr>
<tr>
<td>H</td>
<td>Height wear rotor vanes</td>
<td>29</td>
</tr>
<tr>
<td>I</td>
<td>Improper operation</td>
<td>13</td>
</tr>
<tr>
<td></td>
<td>Inspection</td>
<td></td>
</tr>
<tr>
<td></td>
<td>cell ventilation</td>
<td>24</td>
</tr>
<tr>
<td></td>
<td>during operation</td>
<td>21</td>
</tr>
<tr>
<td></td>
<td>lubricating oil</td>
<td>23</td>
</tr>
<tr>
<td></td>
<td>non-return valve</td>
<td>24</td>
</tr>
<tr>
<td></td>
<td>prior to initial start-up</td>
<td>21</td>
</tr>
<tr>
<td></td>
<td>safety valve</td>
<td>24</td>
</tr>
<tr>
<td></td>
<td>ventilating valve</td>
<td>24</td>
</tr>
<tr>
<td>Instructions</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Intended use</td>
<td>11</td>
</tr>
<tr>
<td>L</td>
<td>Lengthy standstill</td>
<td>27</td>
</tr>
<tr>
<td></td>
<td>Liability</td>
<td>7</td>
</tr>
<tr>
<td></td>
<td>Lubricating oil types</td>
<td>17</td>
</tr>
<tr>
<td></td>
<td>Lubricating oils</td>
<td>17</td>
</tr>
<tr>
<td>M</td>
<td>Maintenance</td>
<td>25</td>
</tr>
<tr>
<td></td>
<td>Maintenance schedule</td>
<td>25</td>
</tr>
<tr>
<td></td>
<td>Maintenance work</td>
<td>26</td>
</tr>
<tr>
<td></td>
<td>Malfunction table</td>
<td>31</td>
</tr>
<tr>
<td></td>
<td>Malfunctions</td>
<td>30</td>
</tr>
<tr>
<td></td>
<td>Manufacturer's declaration</td>
<td>8</td>
</tr>
<tr>
<td>O</td>
<td>Occupational safety</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>Operating instructions</td>
<td>5</td>
</tr>
<tr>
<td></td>
<td>Operating personnel</td>
<td>11</td>
</tr>
<tr>
<td></td>
<td>Operator</td>
<td>10</td>
</tr>
<tr>
<td>P</td>
<td>Packaging</td>
<td>20</td>
</tr>
<tr>
<td></td>
<td>Personnel</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Trouble shooting</td>
<td>30</td>
</tr>
<tr>
<td>Pictograms</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>in the operating instructions</td>
<td>6</td>
</tr>
<tr>
<td></td>
<td>Pneumatics</td>
<td>14</td>
</tr>
<tr>
<td></td>
<td>Proper operation</td>
<td>9</td>
</tr>
<tr>
<td></td>
<td>Protective equipment</td>
<td>12</td>
</tr>
<tr>
<td></td>
<td>Maintenance</td>
<td>25</td>
</tr>
<tr>
<td>R</td>
<td>Recommisioning</td>
<td>30</td>
</tr>
<tr>
<td>S</td>
<td>Safety</td>
<td>9</td>
</tr>
<tr>
<td></td>
<td>Signposting</td>
<td>14</td>
</tr>
<tr>
<td></td>
<td>Spare parts</td>
<td>8, 33</td>
</tr>
<tr>
<td></td>
<td>Specialised staff</td>
<td>11</td>
</tr>
</tbody>
</table>
VacuStar W900 / W1300 / W1600

Index

Start-up ............................................................... 21
Start-up ............................................................... 21
Storage ............................................................... 20
Switching off ....................................................... 22
Technical data ....................................................... 17

Transport............................................................... 20

W
Warranty ........................................................... 7, 8
Wear parts ............................................................ 7

35