



Installation and Operating Instructions



Vacuum Pumps
Mink MM 1104 BVD
for V-belt Drive



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Preface

Congratulations on your purchase of the Busch vacuum pump. With watchful observation of the field's requirements, innovation and steady development Busch delivers modern vacuum and pressure solutions worldwide.

These operating instructions contain information for

- product description,
- safety,
- transport,
- storage,
- installation and commissioning,
- maintenance,
- overhaul,
- troubleshooting and
- spare parts

of the vacuum pump.

Version drive with integrated frequency inverter:

The drive with integrated frequency inverter is subject to a separate instruction manual.

The drive motor does not form part of the Busch scope of delivery and is therefore not subject to these instructions.

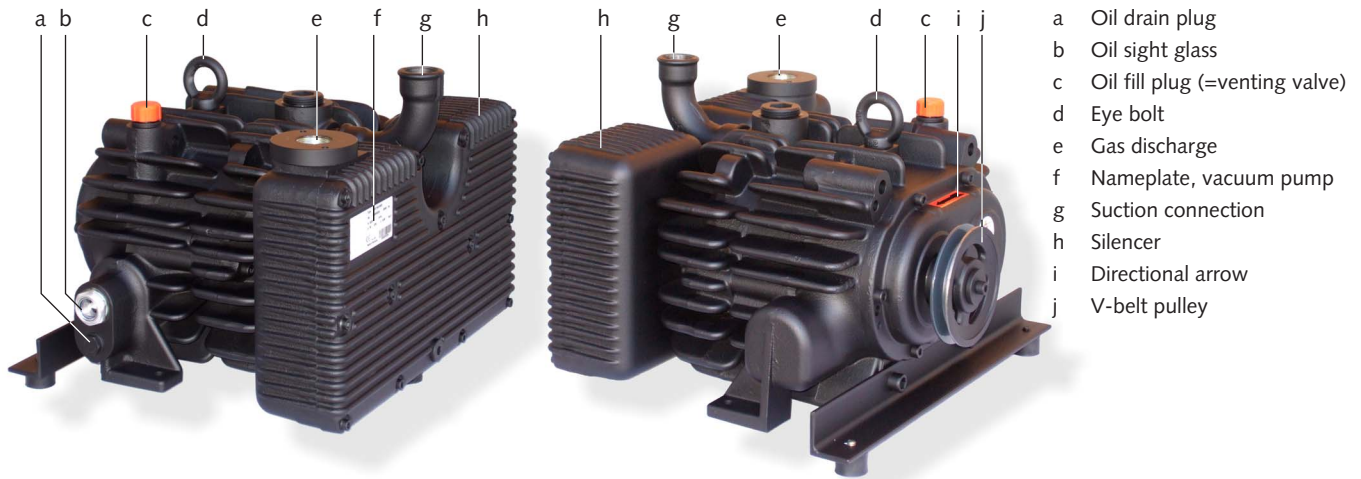
For the purpose of these instructions, "handling" the vacuum pump means the transport, storage, installation, commissioning, influence on operating conditions, maintenance, troubleshooting and overhaul of the vacuum pump.

Prior to handling the vacuum pump these operating instructions shall be read and understood. If anything remains to be clarified please contact your Busch representative!

Keep these operating instructions and, if applicable, other pertinent operating instructions available on site.

Technical Data

Nominal suction capacity	m ³ /h	75
Min. allowed suction pressure	hPa (=mbar) abs	400
Power consumption	kW	1.5
Motor frequency	Hz	60
Pump speed	min ⁻¹	1800
Sound pressure level (EN ISO 2151)	dB (A)	70
Ambient temperature range	°C	0 ... 40
Ambient pressure		Atmospheric pressure
Synchronisation gear oil quantity	l	0.85
Synchronisation gear oil filled ex-works		Busch VE 101
Weight approx. (w/o motor)	kg	~86



- a Oil drain plug
- b Oil sight glass
- c Oil fill plug (=venting valve)
- d Eye bolt
- e Gas discharge
- f Nameplate, vacuum pump
- g Suction connection
- h Silencer
- i Directional arrow
- j V-belt pulley

Product Description

Use

The vacuum pump is intended for

- the suction of
- air and other dry, non-aggressive, non-toxic and non-explosive gases

Conveying media with a lower or higher density than air leads to an increased thermal and/or mechanical load on the vacuum pump and is permissible only after prior consultation with Busch.

Max. allowed temperature of the inlet gas: 40 °C

The gas shall be free from vapours that would condensate under the temperature and pressure conditions inside the vacuum pump.

The vacuum pump is intended for the placement in a non-potentially explosive environment.

The vacuum pump is thermally suitable for continuous operation (100 percent duty).

The vacuum pump is not ultimate pressure proof. Operation with a closed (“blanked”) suction line will damage the vacuum pump.

The minimum allowed intake pressure of the vacuum pump is 400 hPa (=mbar) abs. By means of process control and/or vacuum relief valves it must be made sure that the minimum allowed intake pressure will not be underrun.

Principle of Operation

The vacuum pump works on the claw principle.

The components are dimensioned such, that on the one hand there is never contact between the two claws or between a claw and the cylinder, on the other hand the gaps are small enough to keep the clearance loss between the chambers low.

The vacuum pump compresses the inlet gas absolutely oil-free. A lubrication of the pump chamber is neither necessary nor allowed.

Cooling

The vacuum pump is cooled by

- radiation of heat from the surface of the vacuum pump
- the air flow from the fan wheel of the drive motor
- the process gas

Start Controls

The vacuum pump comes without start controls. The control of the vacuum pump is to be provided in the course of installation.

Safety

Intended Use

Definition: For the purpose of these instructions, “handling” the vacuum pump means the transport, storage, installation, commissioning, influence on operating conditions, maintenance, troubleshooting and overhaul of the vacuum pump.

The vacuum pump is intended for industrial use. It shall be handled only by qualified personnel.

The allowed media and operational limits (→ page 3: Product Description) and the installation prerequisites (→ page 4: Installation Prerequisites) of the vacuum pump shall be observed both by the manufacturer of the machinery into which the vacuum pump is to be incorporated and by the operator.

The maintenance instructions shall be observed.

Prior to handling the vacuum pump these installation and operating instructions shall be read and understood. If anything remains to be clarified please contact your Busch representative!

Safety Notes

The vacuum pump has been designed and manufactured according to state-of-the-art methods. Nevertheless, residual risks may remain. These operating instructions highlight potential hazards where appropriate. Safety notes are tagged with one of the keywords DANGER, WARNING and CAUTION as follows:



DANGER

Disregard of this safety note will always lead to accidents with fatal or serious injuries.



WARNING

Disregard of this safety note may lead to accidents with fatal or serious injuries.



CAUTION

Disregard of this safety note may lead to accidents with minor injuries or property damage.

Noise Emission

For the sound pressure level in free field according to EN ISO 2151
→ page 2: Technical Data.



CAUTION

The vacuum pump emits noise of high intensity in a narrow band.

Risk of damage to the hearing.

Persons staying in the vicinity of a non noise insulated vacuum pump over extended periods shall wear ear protection.

Transport

Transport in Packaging

Packed on a pallet the vacuum pump is to be transported with a forklift.

Transport without Packaging

In case the vacuum pump is packed in a cardboard box with inflated cushions:

- ◆ Remove the inflated cushions from the box

In case the vacuum pump is in a cardboard box cushioned with rolled corrugated cardboard:

- ◆ Remove the corrugated cardboard from the box

In case the vacuum pump is laid in foam:

- ◆ Remove the foam

In case the vacuum pump is bolted to a pallet or a base plate:

- ◆ Remove the bolting between the vacuum pump and the pallet/base plate

In case the vacuum pump is fastened to the pallet by means of tightening straps:

- ◆ Remove the tightening straps



CAUTION

Do not walk, stand or work under suspended loads.

- Make sure that the eyebolt (d) is in faultless condition (replace a damaged, e.g. bent eyebolt with a new one)
- Make sure that the eyebolt (d) is fully screwed in and tightened by hand
- Attach lifting gear securely to the eyebolt (d) on the synchronising gear

When the vacuum pump is equipped with a very heavy drive motor and would hang very inclined (>10 °) on the synchronising gear eyebolt alone:

- ◆ Attach lifting gear securely to the eyebolts on the synchronising gear (d) and on the drive motor

In case the drive motor comes without an eyebolt or the eyebolt on the drive motor is located at an unfavourable position:

- ◆ Loop a belt/rope with suitable length and strength around the flange of the drive motor
- Attach the lifting gear to a crane hook with safety latch
- Lift the vacuum pump with a crane

In case the vacuum pump was bolted to a pallet or a base plate:

- ◆ Remove the stud bolts from the rubber feet

Storage

Short-term Storage

- Make sure that the suction connection and the gas discharge are closed (leave the provided plugs in)
- Store the vacuum pump
 - if possible in original packaging,
 - indoors,
 - dry,
 - dust free and
 - vibration free

Conservation

In case of adverse ambient conditions (e.g. aggressive atmosphere, frequent temperature changes) conserve the vacuum pump immediately. In case of favourable ambient conditions conserve the vacuum pump if a storage of more than 3 months is scheduled.

- Make sure that all ports are firmly closed; seal all ports that are not sealed with PTFE-tape, gaskets or o-rings with adhesive tape

Note: VCI stands for "volatile corrosion inhibitor". VCI-products (film, paper, cardboard, foam) evaporate a substance that condenses in molecular thickness on the packed good and by its electro-chemical properties effectively suppresses corrosion on metallic surfaces. However, VCI-products may attack the surfaces of plastics and elastomers. Seek advice from your local packaging dealer! Busch uses CORTEC VCI 126 R film for the overseas packaging of large equipment.

- Wrap the vacuum pump in VCI film
- Store the vacuum pump
 - if possible in original packing,
 - indoors,
 - dry,
 - dust free and
 - vibration free.

For commissioning after conservation:

- Make sure that all remains of adhesive tape are removed from the ports
- Commission the vacuum pump as described in the chapter Installation and Commissioning (→ page 4)

Installation and Commissioning

Installation Prerequisites



CAUTION

In case of non-compliance with the installation prerequisites, particularly in case of insufficient cooling:

Risk of damage or destruction of the vacuum pump and adjoining plant components!

Risk of injury!

The installation prerequisites must be complied with.

- Make sure that the integration of the vacuum pump is carried out such that the essential safety requirements of the Machine Directive 98/37/EC are complied with (in the responsibility of the designer of the machinery into which the vacuum pump is to be incorporated; → page 14: note in the EC-Declaration of Conformity)

Mounting Position and Space

- Make sure that the environment of the vacuum pump is not potentially explosive
- Make sure that the following ambient conditions will be complied with:
 - ambient temperature: 0 ... 40 °C
 - ambient pressure: atmospheric
- Make sure that the environmental conditions comply with the protection class of the drive motor (according to the nameplate)
- Make sure that the vacuum pump will be placed or mounted horizontally
- Make sure that in order to warrant a sufficient cooling there will be a clearance of minimum 1 m between the vacuum pump and nearby walls
- Make sure that no heat sensitive parts (plastics, wood, cardboard, paper, electronics) will touch the surface of the vacuum pump
- Make sure that the installation space or location is vented such that a sufficient cooling of the vacuum pump is warranted



CAUTION

During operation the surface of the vacuum pump may reach temperatures of more than 70 °C.

Risk of burns!

- Make sure that the vacuum pump will not be touched inadvertently during operation, provide a guard if appropriate
- Make sure that the sight glass (b) of the synchronising gear will remain accessible

In case the synchronising gear oil change is planned to be carried out on location:

- ◆ Make sure that the drain port (a) and the filling port (c) of the synchronising gear will remain easily accessible

Suction Connection



CAUTION

Intruding foreign objects or liquids can destroy the vacuum pump.

In case the inlet gas can contain dust or other foreign solid particles:

- ◆ Make sure that a suitable filter (5 micron or less) is installed upstream the vacuum pump
- Make sure that the suction line fits to the suction connection (g) of the vacuum pump
- Make sure that the gas will be sucked through a vacuum-tight flexible hose or a pipe

In case of using a pipe:

- ◆ Make sure that the pipe will cause no stress on the vacuum pump's connection, if necessary use an expansion joint
- Make sure that the line size of the suction line over the entire length is at least as large as the suction connection (g) of the vacuum pump

In case the length of the suction line exceeds 2 m it is prudent to use larger line sizes in order to avoid a loss of efficiency and an overload of the vacuum pump. Seek advice from your Busch representative!

In case the vacuum shall be maintained after shutdown of the vacuum pump:

- ◆ Provide a manual or automatic operated valve (= non-return valve) in the suction line
- Make sure that the suction line does not contain foreign objects, e.g. welding scales

Gas Discharge

The discharged gas must flow without obstruction. It is not permitted to shut off or throttle the discharge line or to use it as a pressurised air source.

The following guidelines for the discharge line do not apply, if the aspirated air is discharged to the environment right at the vacuum pump.

- Make sure that the discharge line fits to the gas discharge (e) of the vacuum pump

In case of using a pipe:

- ◆ Make sure that the pipe will cause no stress on the vacuum pump's connection, if necessary use an expansion joint
- Make sure that the line size of the discharge line over the entire length is at least as large as the gas discharge (e) of the vacuum pump

In case the length of the discharge line exceeds 2 m it is prudent to use larger line sizes in order to avoid a loss of efficiency and an overload of the vacuum pump. Seek advice from your Busch representative!

- Make sure that the discharge line either slopes away from the vacuum pump or provide a liquid separator or a drip leg with a drain cock, so that no liquids can back up into the vacuum pump

Electrical Connection / Controls

- Make sure that the stipulations acc. to the EMC-Directive 89/336/EEC and Low-Voltage-Directive 73/23/EEC as well as the EN-standards, electrical and occupational safety directives and the local or national regulations, respectively, are complied with (this is in the responsibility of the designer of the machinery into which the vacuum pump is to be incorporated; → page 14: note in the EC-Declaration of Conformity).
- Make sure that the power supply for the drive motor is compatible with the data on the nameplate of the drive motor
- Make sure that an overload protection according to EN 60204-1 is provided for the drive motor
- Make sure that the drive of the vacuum pump will not be affected by electric or electromagnetic disturbance from the mains; if necessary seek advice from the Busch service

In case of mobile installation:

- ◆ Provide the electrical connection with grommets that serve as strain-relief

Installation

Mounting

- Make sure that the Installation Prerequisites (→ page 4) are complied with
- Set down or mount the vacuum pump at its location

Mounting the V-belt Drive

- Mount the v-belt drive according to the instructions of the v-belt drive manufacturer (→ Browning form 8658)

Checking Synchronising Gear Oil

The vacuum pump is delivered with oil filled synchronising gear.

The level shall be slightly above the middle of the sight glass (b).

- Check on the sight glass (b) that the proper amount of oil is filled

Connecting Electrically



WARNING

Risk of electrical shock, risk of damage to equipment.

Electrical installation work must only be executed by qualified personnel that knows and observes the following regulations:

- IEC 364 or CENELEC HD 384 or DIN VDE 0100, respectively,
- IEC-Report 664 or DIN VDE 0110,
- BGV A2 (VBG 4) or corresponding national accident prevention regulation.

Note: The motor is not part of the Busch scope of delivery and is therefore not subject to these instructions.

Note: For the connection of a drive with integrated frequency inverter see the separate operating instructions!

- Electrically connect the drive motor
- Connect the protective earth conductor



CAUTION

Operation in the wrong direction of rotation can destroy the vacuum pump in short time.

Prior to starting-up it must be made sure that the vacuum pump is operated in the proper direction.

- Determine the intended direction of rotation with the arrow (i) (stuck on or cast)
- "Bump" the drive motor
- Watch the fan wheel of the drive motor and determine the direction of rotation just before the fan wheel stops

If the rotation must be changed:

- ◆ Switch any two of the drive motor wires (three-phase motor)
- ◆ Switch the polarity (DC-motor)
- ◆ Replace with a drive motor with the correct direction of rotation (AC-motor)

Connecting Lines/Pipes

- Connect the suction line
- Connect the discharge line

Installation without discharge line:

- ◆ Make sure that the gas discharge (e) is open
- Make sure that all provided covers, guards, hoods etc. are mounted
- Make sure that cooling air inlets and outlets are not covered or obstructed and that the cooling air flow is not affected adversely in any other way

Recording of Operational Parameters

As soon as the vacuum pump is operated under normal operating conditions:

- Measure the drive motor current and record it as reference for future maintenance and troubleshooting work

Operation Notes

Use



CAUTION

The vacuum pump is designed for operation under the conditions described below.

In case of disregard risk of damage or destruction of the vacuum pump and adjoining plant components!

Risk of injury!

The vacuum pump must only be operated under the conditions described below.

The vacuum pump is intended for

- the suction

of

- air and other dry, non-aggressive, non-toxic and non-explosive gases

Conveying media with a lower or higher density than air leads to an increased thermal and/or mechanical load on the vacuum pump and is permissible only after prior consultation with Busch.

Max. allowed temperature of the inlet gas: 40 °C

The gas shall be free from vapours that would condensate under the temperature and pressure conditions inside the vacuum pump.

The vacuum pump is intended for the placement in a non-potentially explosive environment.

The vacuum pump is thermally suitable for continuous operation (100 percent duty).

The vacuum pump is not ultimate pressure proof. Operation with a closed ("blanked") suction line will damage the vacuum pump.

The minimum allowed intake pressure of the vacuum pump is 400 hPa (=mbar) abs. By means of process control and/or vacuum relief valves it must be made sure that the minimum allowed intake pressure will not be underrun.



CAUTION

During operation the surface of the vacuum pump may reach temperatures of more than 70 °C.

Risk of burns!

The vacuum pump shall be protected against contact during operation, it shall cool down prior to a required contact or heat protection gloves shall be worn.



CAUTION

The vacuum pump emits noise of high intensity in a narrow band.

Risk of damage to the hearing.

Persons staying in the vicinity of a non noise insulated vacuum pump over extended periods shall wear ear protection.

- Make sure that all provided covers, guards, hoods etc. remain mounted
- Make sure that protective devices will not be disabled
- Make sure that cooling air inlets and outlets will not be covered or obstructed and that the cooling air flow will not be affected adversely in any other way
- Make sure that the installation prerequisites (→ page 4: Installation Prerequisites) are complied with and will remain complied with, particularly that a sufficient cooling will be ensured

Maintenance



DANGER

In case the vacuum pump conveyed gas that was contaminated with foreign materials which are dangerous to health, harmful material can reside in filters.

Danger to health during inspection, cleaning or replacement of filters.

Danger to the environment.

Personal protective equipment must be worn during the handling of contaminated filters.

Contaminated filters are special waste and must be disposed of separately in compliance with applicable regulations.



CAUTION

During operation the surface of the vacuum pump may reach temperatures of more than 70 °C.

Risk of burns!

- Prior to disconnecting connections make sure that the connected pipes/lines are vented to atmospheric pressure

Maintenance Schedule

Note: The maintenance intervals depend very much on the individual operating conditions. The intervals given below shall be considered as starting values which should be shortened or extended as appropriate. Particularly heavy duty operation, such like high dust loads in the environment or in the process gas, other contaminations or ingress of process material, can make it necessary to shorten the maintenance intervals significantly.

Monthly:

- Make sure that the vacuum pump is shut down and locked against inadvertent start up

In case an inlet air filter is installed:

- ◆ Check the inlet air filter, if necessary replace

In case of operation in a dusty environment:

- ◆ Clean as described under → page 7: Every 6 Months:

Every 3 Months:

- Make sure that the vacuum pump is shut down
- Check the level of the synchronising gear oil

The level shall be slightly above the middle of the sight glass (b).

The level of the synchronising gear should stay constant over the lifetime of the oil. If the level does fall, the gear is leaky and the vacuum pump requires repair (Busch service).

Every 6 Months:

- Make sure that the housing is free from dust and dirt, clean if necessary
- Make sure that the vacuum pump is shut down and locked against inadvertent start up
- Clean the fan cowling, the fan wheel, the ventilation grille and the cooling fins
- Check the tension of the v-belt(s) (→ Browning form 8658)

Every Year:

- Make sure that the vacuum pump is shut down and locked against inadvertent start up

In case an inlet air filter is installed:

- ◆ Replace the inlet air filter

In case an inlet screen is installed:

- ◆ Check the inlet screen, clean if necessary

Every 20000 Operating Hours, At the Latest after 6 Years:

Note: The change interval of 20000 operating hours is valid for the gear oil Busch VE 101 only. Other gear oils reduce the change interval.

- Change the synchronising gear oil

Changing Synchronising Gear Oil

- Make sure that the vacuum pump is shut down and locked against inadvertent start up
- Undo the venting valve (c) for venting
- Place a drain tray underneath the drain plug (a)
- Open the drain plug (a) and drain the oil
- Make sure that the seal ring on the drain plug (a) is serviceable, replace if necessary
- Firmly reinsert the drain plug (a) together with the seal ring
- Remove the venting valve (c) completely
- Fill in new gear oil until the level is slightly above the middle of the sight glass (b)
- Make sure that the seal ring on the venting valve (c) is undamaged, if necessary replace the venting valve (c)
- Firmly reinsert the venting valve (c) together with the seal ring
- Dispose of the used oil in compliance with applicable regulations

Overhaul



CAUTION

In order to achieve best efficiency and a long life the vacuum pump was assembled and adjusted with precisely defined tolerances.

This adjustment will be lost during dismantling of the vacuum pump.

It is therefore strictly recommended that any dismantling of the vacuum pump that is beyond of what is described in this manual shall be done by Busch service.



DANGER

In case the vacuum pump conveyed gas that was contaminated with foreign materials which are dangerous to health, harmful material can reside in pores, gaps and internal spaces of the vacuum pump.

Danger to health during dismantling of the vacuum pump.

Danger to the environment.

Prior to shipping the vacuum pump shall be decontaminated as good as possible and the contamination status shall be stated in a "Declaration of Contamination" (form downloadable from www.busch-vacuum.com).

Busch service will only accept vacuum pumps that come with a completely filled in and legally binding signed "Declaration of Contamination" (form downloadable from www.busch-vacuum.com).

Removal from Service


Temporary Removal from Service

- Prior to disconnecting pipes/lines make sure that all pipes/lines are vented to atmospheric pressure

Recommissioning

- Observe the chapter Installation and Commissioning (→ page 4)

Dismantling and Disposal



DANGER

In case the vacuum pump conveyed gas that was contaminated with foreign materials which are dangerous to health, harmful material can reside in pores, gaps and internal spaces of the vacuum pump.

Danger to health during dismantling of the vacuum pump.

Danger to the environment.

During dismantling of the vacuum pump personal protective equipment must be worn.

The vacuum pump must be decontaminated prior to disposal.

- Drain the oil
- Make sure that materials and components to be treated as special waste have been separated from the vacuum pump
- Make sure that the vacuum pump is not contaminated with harmful foreign material

According to the best knowledge at the time of printing of this manual the materials used for the manufacture of the vacuum pump involve no risk.

- Dispose of the used oil in compliance with applicable regulations
- Dispose of the vacuum pump as scrap metal

Troubleshooting



WARNING

Risk of electrical shock, risk of damage to equipment.

Electrical installation work must only be executed by qualified personnel that knows and observes the following regulations:

- IEC 364 or CENELEC HD 384 or DIN VDE 0100, respectively,
- IEC-Report 664 or DIN VDE 0110,
- BGV A2 (VGB 4) or equivalent national accident prevention regulation.



CAUTION

During operation the surface of the vacuum pump may reach temperatures of more than 70 °C.

Risk of burns!

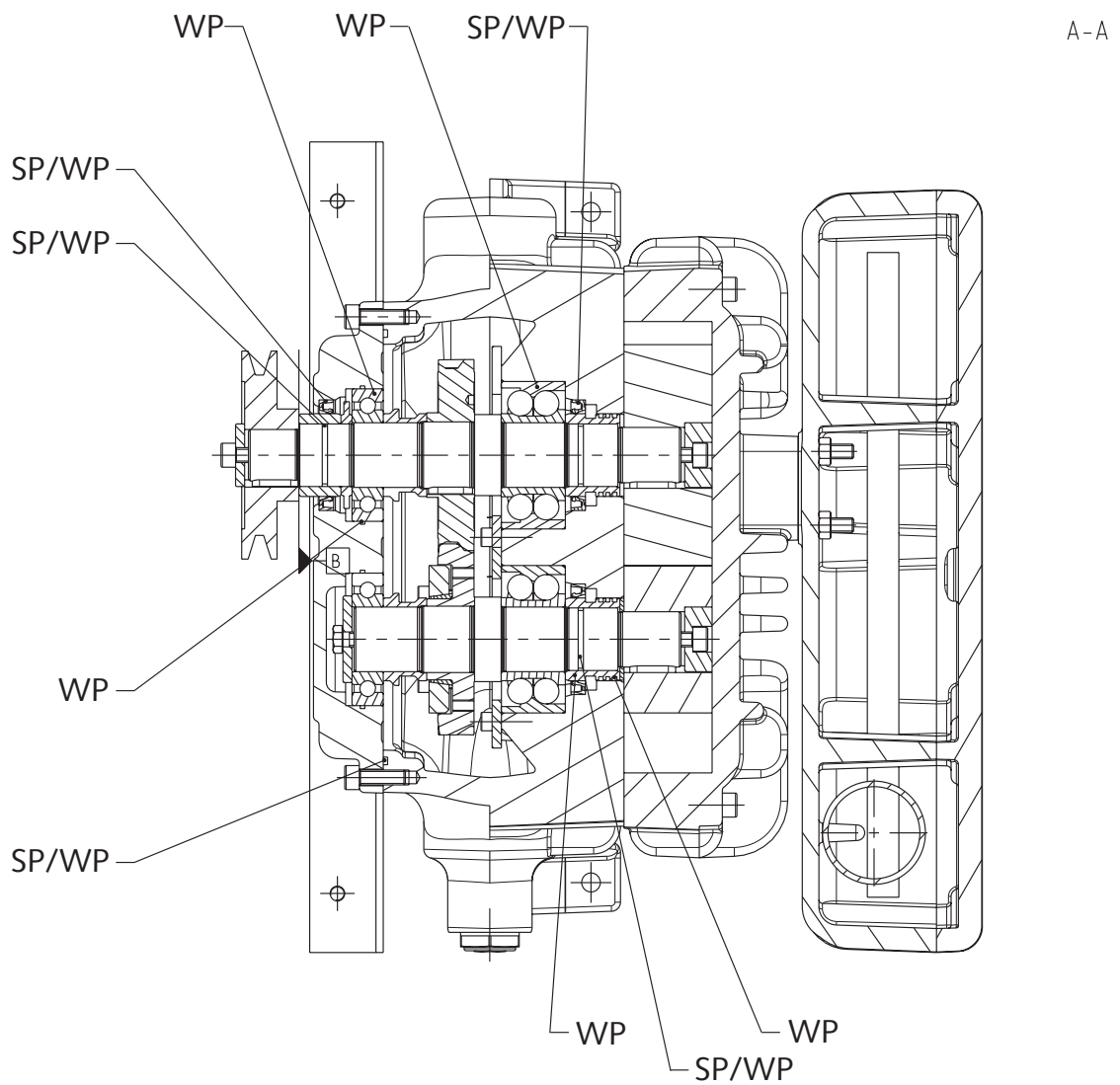
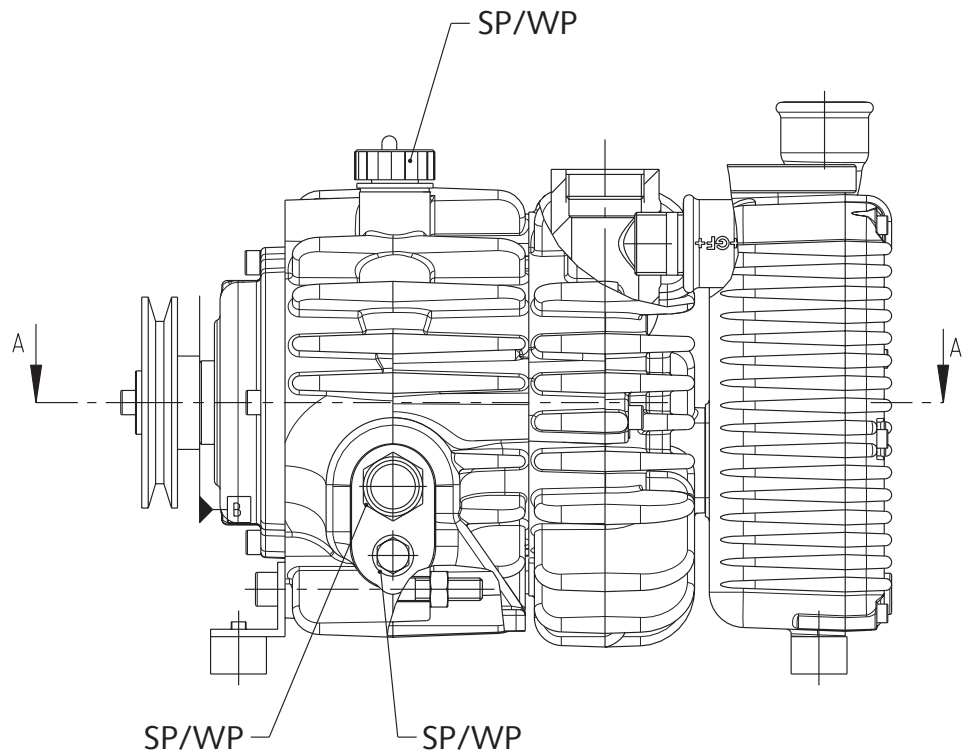
Let the vacuum pump cool down prior to a required contact or wear heat protection gloves.

Problem	Possible Cause	Remedy
The vacuum pump does not reach the usual pressure The drive motor draws a too high current (compare with initial value after commissioning) Evacuation of the system takes too long	The vacuum system or suction line is not leak-tight	Check the hose or pipe connections for possible leak
	In case a vacuum relief valve/regulating system is installed: The vacuum relief valve/regulating system is misadjusted or defective	Adjust, repair or replace, respectively
	In case a screen is installed in the suction connection (g): The screen in the suction connection (g) is partially clogged	Clean the screen If cleaning is required too frequently install a filter upstream
	In case a filter is installed on the suction connection (g): The filter on the suction connection (g) is partially clogged	Clean or replace the inlet air filter, respectively
	Partial clogging in the suction, discharge or pressure line	Remove the clogging
	Long suction, discharge or pressure line with too small diameter	Use larger diameter
	Internal parts are worn or damaged	Repair the vacuum pump (Busch service)
The gas conveyed by the vacuum pump smells displeasing	Process components evaporating under vacuum	Check the process, if applicable
The vacuum pump does not start	The drive motor is not supplied with the correct voltage or is overloaded	Supply the drive motor with the correct voltage
	The drive motor starter overload protection is too small or trip level is too low	Compare the trip level of the drive motor starter overload protection with the data on the nameplate, correct if necessary In case of high ambient temperature: set the trip level of the drive motor starter overload protection 5 percent above the nominal drive motor current
	One of the fuses has blown	Check the fuses
	Version with alternating current motor: The drive motor capacitor is defective	Repair the drive (Busch service)

	The connection cable is too small or too long causing a voltage drop at the vacuum pump	Use sufficiently dimensioned cable
	The vacuum pump or the drive motor is blocked	Make sure the drive motor is disconnected from the power supply Remove the fan cover Try to turn the drive motor with the vacuum pump by hand If the vacuum pump is blocked: Repair the vacuum pump (Busch service)
	The drive motor is defective	Replace the drive motor
The vacuum pump is blocked	Solid foreign matter has entered the vacuum pump	Repair the vacuum pump (Busch service) Make sure the suction line is equipped with a screen If necessary additionally provide a filter
	Corrosion in the vacuum pump from remaining condensate	Repair the vacuum pump (Busch service) Check the process
	Version with three-phase motor: Version with DC motor: The vacuum pump was run in the wrong direction	Repair the vacuum pump (Busch service) When connecting the vacuum pump make sure the vacuum pump will run in the correct direction (→ page 5: Installation)
The drive motor is running, but the vacuum pump stands still	The belt(s) is/are torn	Replace the v-belt(s)
The vacuum pump starts, but labours or runs noisily or rattles The drive motor draws a too high current (compare with initial value after commissioning)	Loose connection(s) in the drive motor terminal box Version with three-phase-motor: Not all drive motor coils are properly connected The drive motor operates on two phases only Version with DC-motor: Carbon brushes are worn	Check the proper connection of the wires against the connection diagram Tighten or replace loose connections Version with DC-motor: Replace the carbon brushes (Busch service) Replace the carbon brushes
	Version with three-phase motor: Version with DC-motor: The vacuum pump runs in the wrong direction	Verification and rectification → page 4: Installation and Commissioning
	Foreign objects in the vacuum pump Stuck bearings	Repair the vacuum pump (Busch service)
The vacuum pump runs very noisily	Defective bearings	Repair the vacuum pump (Busch service)
	Low oil level in the synchronising gear	The synchronising gear is leaky Repair the vacuum pump (Busch service)
	Synchronising gear damaged due to operation with low oil level	Repair the vacuum pump (Busch service)
The vacuum pump runs very hot	Insufficient air ventilation	Make sure that the cooling of the vacuum pump is not impeded by dust/dirt Clean the fan cowling, the fan wheel, the ventilation grille and the cooling fins Install the vacuum pump in a narrow space only if sufficient ventilation is ensured
	Ambient temperature too high	Observe the permitted ambient temperatures
	Temperature of the inlet gas too high	Observe the permitted temperatures for the inlet gas
	Insufficient gas transfer	Provide a vacuum relief valve

Mains frequency or voltage outside tolerance range	Provide a more stable power supply
In case a vacuum relief valve/regulating system is installed: The vacuum relief valve/regulating system is misadjusted or defective	Adjust, repair or replace, respectively
Partial clogging of filters or screens Partial clogging in the suction, discharge or pressure line	Remove the clogging
Long suction, discharge or pressure line with too small diameter	Use larger diameter

Sectional Drawing



Spare Parts Kits

Note: When ordering spare parts or accessories acc. to the table below please always quote the type and the serial no. of the vacuum pump. This will allow Busch service to check if the vacuum pump is compatible with a modified or improved part.

When ordering parts acc. to the drawing please quote the drawing position no., the type and the serial no. of the vacuum pump. Without this data your order cannot be processed.

The exclusive use of genuine spare parts and consumables is a prerequisite for the proper function of the vacuum pump and for the granting of warranty, guarantee or goodwill.

This parts list applies to a typical configuration of the vacuum pump MM 1104 BVD for V-belt Drive. Depending on the specific order deviating parts data may apply.

Your point of contact for service and spare parts in the United Kingdom:

Busch (UK) Ltd.
Hortonwood 30-35
Telford
Shropshire
TF1 7YB
Tel: 01952 677 432
Fax: 01952 677 423

Your point of contact for service and spare parts in Ireland:

Busch Ireland Ltd.
A10-11 Howth Junction Business Centre
Kilbarrack, Dublin 5
Tel: +353 (0)1 8321466
Fax: +353 (0)1 8321470

Your point of contact for service and spare parts in the USA:

Busch Inc.
516-B Viking Drive
Virginia Beach, VA 23452
Tel: 1-800-USA-PUMP (872-7867)

Your point of contact for service and spare parts in Canada:

Busch Vacuum Technics Inc.
1740, Boulevard Lionel Bertrand
Boisbriand (Montréal)
Québec J7H 1N7
Tel: 450 435 6899
Fax: 450 430 5132

Your point of contact for service and spare parts in Australia:

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Fax: (03) 93 55 06 99

Your point of contact for service and spare parts in New Zealand:

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Find the list of Busch companies all over the world (by the time of the publication of these installation and operating instructions) on → page 15 (rear cover page).

Find the up-to-date list of Busch companies and agencies all over the world on the internet at www.busch-vacuum.com.

Spare parts kit	Part no.
Overhaul kit (incl. set of seals, marking "WP" and "SP")	0993 139 854
set of seals (marking "SP")	0990 138 032

Oil

Denomination	Busch VE 101
ISO-VG	100
Base	Diester
Density [g/cm ³]	0.96
Kinematic viscosity at 40 °C [mm ² /s]	95
Kinematic viscosity at 100 °C [mm ² /s]	9.5
	255
Pourpoint [°C]	-30
Part no. 1 l packaging	0831 000 099
Part no. 5 l packaging	0831 000 100
Filling quantity, approx. [l]	0.85

EC-Declaration of Conformity

Note: This Declaration of Conformity and the **CE**-mark affixed to the nameplate are valid for the vacuum pump within the Busch-scope of delivery. When this vacuum pump is integrated into a superordinate machinery the manufacturer of the superordinate machinery (this can be the operating company, too) must conduct the conformity assessment process acc. to the Directive Machinery 98/37/EC for the superordinate machine, issue the Declaration of Conformity for it and affix the **CE**-mark.

We

Busch Produktions GmbH
Schauinslandstr. 1
79689 Maulburg
Germany

declare that vacuum pumps **MM 1104 BVD for V-belt Drive**

in accordance with the European Directive:

- "Machinery" 98/37/EC,
- "Restriction of the use of certain hazardous substances in electrical and electronic equipment" ("RoHS") 2002/95/EC

have been designed and manufactured to the following specifications:

Standard	Title of the Standard
Harmonised Standards	
EN ISO 12100-1 EN ISO 12100-2	Safety of machinery - Basic concepts, general principles of design - Part 1 and 2
EN 294	Safety of machinery - Safety distance to prevent danger zones being reached by the upper limbs
EN 1012-1 EN 1012-2	Compressors and vacuum pumps - Safety requirements - Part 1 and 2
EN ISO 2151	Acoustics - Noise test code for compressors and vacuum pumps - Engineering method (grade 2)



Dr.-Ing. Karl Busch
General director

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