



Installation and Operating Instructions

O₂

Vacuum Pumps

Mink MM 1324, 1202, 1252, 1322, 1200, 1250, 1320 AV Oxygen



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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

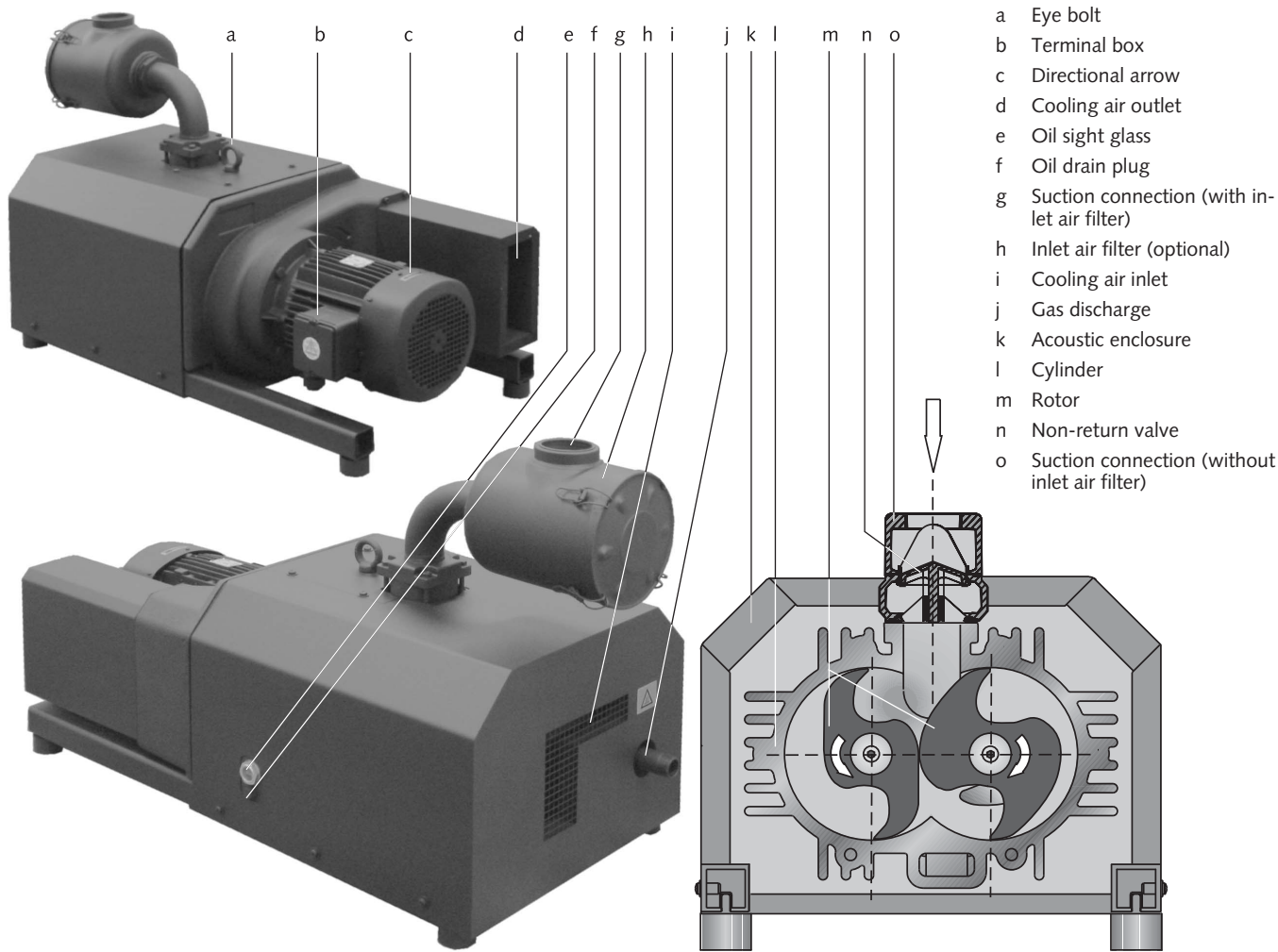
- product description,
- safety,
- transport,
- storage,
- installation and commissioning,
- maintenance,
- overhaul,
- troubleshooting and
- spare parts

of the vacuum pump.

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.



Product Description

Use

The vacuum pump is intended for

- the suction of
- air and other dry, non-aggressive, non-toxic and non-explosive gases with increased oxygen content (volume content greater than 21 percent)

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.

Max. permissible number of startings per hour: 12

Vacuum pumps MM 1324 AV are thermally suitable for continuous operation down to ultimate pressure.

Vacuum pumps MM 1202 AV and MM 1252 AV Oxygen are thermally suitable for continuous operation at intake pressures down to 100 hPa abs (100 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. As a protection against overheating vacuum pumps MM 1202 AV and MM 1252 AV Oxygen are equipped with a safety valve. The safety valve is not designed for frequent use and must therefore not be used as a system pressure regulating valve.

Vacuum pumps MM 1322 AV Oxygen are thermally suitable for continuous operation at intake pressures down to 150 hPa abs (150 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. As a protection against overheating vacuum pumps MM 1322 AV Oxygen are equipped with a safety valve. The safety valve is not designed for frequent use and must therefore not be used as a system pressure regulating valve.



WARNING

Organic matter and oxygen constitute potentially explosive mixtures.

Risk of explosion!

No foreign matter is permitted inside the vacuum pump.

For the lubrication of the vacuum pump only special operating substances may be used, mineral or synthetic oil or grease must not be used!

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.

In order to avoid the suction of solids, the vacuum pump is equipped with a screen (715) in the suction connection.

In order to avoid reverse rotation after switching off, the vacuum pump is equipped with a non-return valve (n).

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
- the air flow from the fan wheel on the shaft of the vacuum pump

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 5: 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 16: 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 (a) is in faultless condition (replace a damaged, e.g. bent eyebolt with a new one)
- Make sure that the eyebolt (a) is fully screwed in and tightened by hand
- Attach lifting gear securely to the eyebolt (a) 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 (a) 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 5)

Installation and Commissioning



WARNING

Installation and commissioning must only be performed by professionals who are informed about the applicable safety regulations and trained in the handling of oxygen.

The German accident prevention regulation Oxygen, BGR 500 chapter 2.32 (BGV B7) or the corresponding national accident prevention regulation resp. must be complied with unconditionally.

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 2006/42/EC are complied with (in the responsibility of the designer of the machinery into which the vacuum pump is to be incorporated; → page 15: 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 can neither inadvertently nor intentionally be stepped on and cannot be used as a support for heavy objects
- Make sure that the vacuum pump cannot be hit by falling objects
- Make sure that the vacuum pump will be placed or mounted horizontally
- Make sure that the base for placement / mounting base is even
- 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



CAUTION

The vacuum pump is not absolutely gas tight.

Risk of explosion!

The installation space or location must be vented such that no impermissible accumulation of oxygen will occur.

- 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 (e, 76) of the synchronising gear will remain accessible

Suction Connection



WARNING

Any contamination of the vacuum pump with foreign material, particularly with organic material leads to imminent risk of explosion.

By means of suitable filters it must be made sure that no foreign material, particularly no organic material will find its way into the vacuum pump.



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 filter is approved for oxygen applications
- Make sure that the suction line fits to the suction connection (o) 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 (o) 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



CAUTION

Prior to starting up it must be made sure that the plug screws are removed from gas discharge.

Risk of damage to the vacuum pump!

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 (j) 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 2"

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 2004/108/EC and Low-Voltage-Directive 2006/95/EC as well as the EN-standards, electrical and occupational safety directives and the local or national regulations, respectively, are complied with (this is the responsibility of the designer of the machinery into which the vacuum pump is to be incorporated; → page 15: 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 5) are complied with
- Set down or mount the vacuum pump at its location

Checking Synchronising Gear Operating Fluid



WARNING

The synchronising gear of the vacuum pump must only be operated with a special operating fluid.

This operating fluid is absolutely inert and does not contribute to the generation of potentially explosive gas mixtures.

Any contamination with organic matter compromises the explosion safety of the operating fluid!

In order to protect the gear of the vacuum pump against inadvertent filling with improper fluids, various ports are equipped with lead seals.

Removal or placement of lead seals or work that require the removal of lead seals must only be carried out by specially authorised and trained personnel.

The vacuum pump is delivered with operating fluid filled synchronising gear.

The level shall be slightly above the middle of the sight glass (e, 76).

- Check on the sight glass (e, 76) that the proper amount of operating fluid 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.



CAUTION

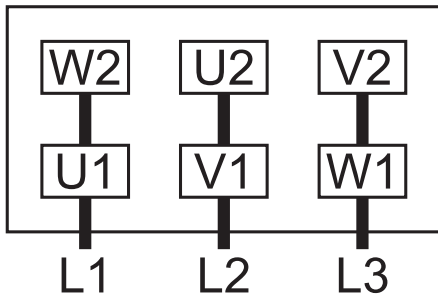
The connection schemes given below are typical. Depending on the specific order or for certain markets deviating connection schemes may apply.

Risk of damage to the drive motor!

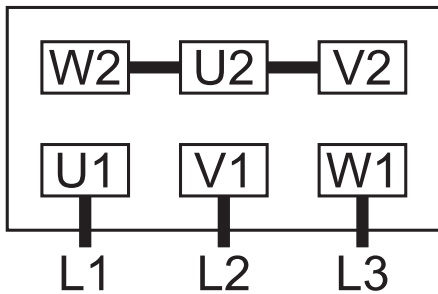
The inside of the terminal box shall be checked for drive motor connection instructions/schemes.

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

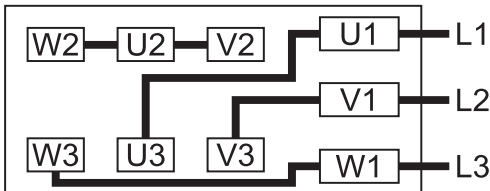
Delta connection (low voltage):



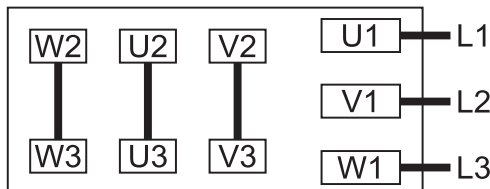
Star connection (high voltage):



Double star connection, multi-voltage motor (low voltage):



Star connection, multi-voltage motor (high voltage):



CAUTION

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

Risk of explosion!

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

- Determine the intended direction of rotation with the arrow (c) (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

Connecting Lines/Pipes

- Connect the suction line
- Connect the discharge line

Installation without discharge line:

- ◆ Make sure that the gas discharge (j) 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
- Make sure that the lead seals are applied

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



WARNING

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

In case of disregard risk of explosion!

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



WARNING

Operating a faulty vacuum pump puts the explosion safety at risk.

Risk of explosion!

The vacuum pump must only be operated in faultless condition. A faulty vacuum pump must immediately be removed from service.

The vacuum pump is intended for

- the suction of
- air and other dry, non-aggressive, non-toxic and non-explosive gases with increased oxygen content (volume content greater than 21 percent)

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.

Max. permissible number of startings per hour: 12

Vacuum pumps MM 1324 AV are thermally suitable for continuous operation down to ultimate pressure.

Vacuum pumps MM 1202 AV and MM 1252 AV Oxygen are thermally suitable for continuous operation at intake pressures down to 100 hPa abs (100 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. As a protection against overheating vacuum pumps MM 1202 AV and MM 1252 AV Oxygen are equipped with a safety valve. The safety valve is not designed for frequent use and must therefore not be used as a system pressure regulating valve.

Vacuum pumps MM 1322 AV Oxygen are thermally suitable for continuous operation at intake pressures down to 150 hPa abs (150 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. As a protection against overheating vacuum pumps MM 1322 AV Oxygen are equipped with a safety valve. The safety valve is not designed for frequent use and must therefore not be used as a system pressure regulating valve.



WARNING

Organic matter and oxygen constitute potentially explosive mixtures.

Risk of explosion!

No foreign matter is permitted inside the vacuum pump.

For the lubrication of the vacuum pump only special operating substances may be used, mineral or synthetic oil or grease must not be used!



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 5: Installation Prerequisites) are complied with and will remain complied with, particularly that a sufficient cooling will be ensured

Maintenance



WARNING

The approval of the vacuum pump for the conveyance of gases with increased oxygen content remains valid only if the maintenance is conducted regularly according to the maintenance schedule below and genuine spare parts and consumables, approved for oxygen applications by Busch, are used exclusively.

Maintenance work must only be executed by qualified personnel that is trained in the handling of oxygen, informed about the relevant safety regulations and instructed in the handling of oxygen vacuum pumps by Busch.

The German accident prevention regulation Oxygen, BGR 500 chapter 2.32 (BGV B7) or the corresponding national accident prevention regulation resp. must be complied with unconditionally.



WARNING

The operating fluid is inert and does not contribute to the generation of potentially explosive gas mixtures.

Any contamination with organic matter compromises the explosion safety of the operating fluid!

In order to protect the gear of the vacuum pump against inadvertent filling with improper fluids, one or more ports are equipped with lead seals.

Removal or placement of lead seals or work that require the removal of lead seals must only be carried out by specially authorised and trained personnel.



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 are upper limits that must not be exceeded.

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 (h) is installed:

- ◆ Check the inlet air filter (h), if necessary replace

In case of operation in a dusty environment:

- ◆ Clean as described under → page 9: Every 6 Months:

Every 3 Months:

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

The level shall be slightly above the middle of the sight glass (e, 76).

The level of the synchronising gear should stay constant. 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
- Remove the acoustic enclosure
- Clean the fan cowlings, fan wheels, the ventilation grilles and cooling fins
- Mount the acoustic enclosure

Every Year:

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

In case an inlet air filter (h) is installed:

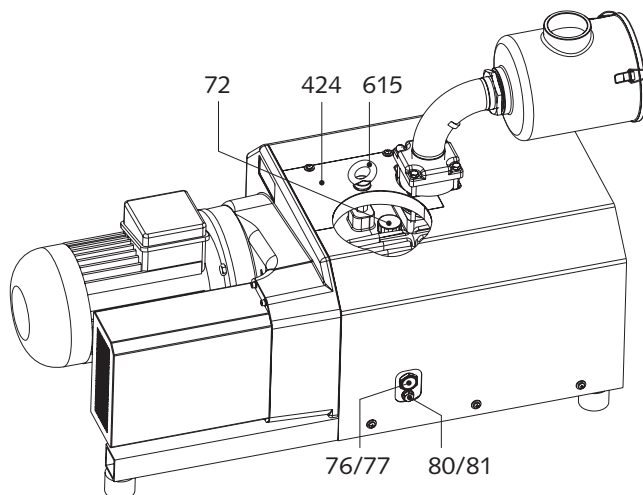
- ◆ Replace the inlet air filter (h)
- Check the inlet screen (715), clean if necessary

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

- Change the synchronising gear operating fluid

Changing Synchronising Gear Operating Fluid

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



- Remove the eyebolt (a)
- Remove the lid (424)
- Undo the venting valve (72) for venting
- Place a drain tray underneath the drain plug (f, 80)

- Open the drain plug (f, 80) and drain the operating fluid
- Make sure that the seal ring (81) on the drain plug (f, 80) is serviceable, replace if necessary
- Firmly reinsert the drain plug (f, 80) together with the seal ring (81)
- Remove the venting valve (72) completely
- Fill in new operating fluid until the level is slightly above the middle of the sight glass (e, 76)
- Make sure that the seal ring on the venting valve (72) is undamaged, if necessary replace the venting valve (72)
- Firmly reinsert the venting valve (72) together with the seal ring
- Mount the lid (424)
- Reinsert the eyebolt (a)
- Reapply lead seals to the ports
- Dispose of the used operating fluid in compliance with applicable regulations

Overhaul



Improper work on the vacuum pump puts the operating safety at risk.

Risk of explosion!

Approval for operation will be void!

Any dismantling of the vacuum pump that is beyond of what is described in this manual must be done by specially trained Busch service personnel only.



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 5)

Dismantling and Disposal



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 operating fluid
- 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 operating fluid 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
	The screen (715) in the suction connection (o) is partially clogged	Clean the screen (715) If cleaning is required too frequently install a filter upstream
	In case a filter (h) is installed on the suction connection (o): The filter (h) on the suction connection (o) is partially clogged	Clean or replace the inlet air filter (h), 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
	The valve disk of the inlet non-return valve is stuck in closed or partially open position	Disassemble the inlet, clean the screen (715) and the valve (n) as required and reassemble
	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
	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	<p>Make sure the drive motor is disconnected from the power supply</p> <p>Remove the fan cover</p> <p>Try to turn the drive motor with the vacuum pump by hand</p> <p>If the vacuum pump is blocked:</p> <p>Repair the vacuum pump (Busch service)</p>
	The drive motor is defective	<p>Replace the drive motor (Busch service)</p> <p>(the proper function of the fan wheel requires the precise adjustment of the coupling on the motor shaft and on the pump shaft; therefore the motor can be mounted by the Busch service only)</p>
The vacuum pump is blocked	Solid foreign matter has entered the vacuum pump	<p>Repair the vacuum pump (Busch service)</p> <p>Make sure the suction line is equipped with a screen</p> <p>If necessary additionally provide a filter</p>
	Corrosion in the vacuum pump from remaining condensate	<p>Repair the vacuum pump (Busch service)</p> <p>Check the process</p>
	The vacuum pump was run in the wrong direction	<p>Repair the vacuum pump (Busch service)</p> <p>When connecting the vacuum pump make sure the vacuum pump will run in the correct direction (→ page 6: Installation)</p>
The drive motor is running, but the vacuum pump stands still	The coupling between the drive motor and the vacuum pump is defective	<p>Replace the coupling element</p> <p>(the proper function of the fan wheel requires the precise adjustment of the coupling on the motor shaft and on the pump shaft; therefore the coupling element can be replaced by the Busch service only)</p>
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 Not all drive motor coils are properly connected The drive motor operates on two phases only	<p>Check the proper connection of the wires against the connection diagram (particularly on motors with six coils)</p> <p>Tighten or replace loose connections</p>
	The vacuum pump runs in the wrong direction	Verification and rectification → page 5: 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)
	Worn coupling element	Replace the coupling element
	Low operating fluid level in the synchronising gear	Top up operating fluid
	Synchronising gear damaged due to operation with low operating fluid level	Repair the vacuum pump (Busch service)
The vacuum pump runs very hot	Insufficient air ventilation	<p>Make sure that the cooling of the vacuum pump is not impeded by dust/dirt</p> <p>Clean the fan cowlings, the fan wheels, the ventilation grilles and the cooling fins</p> <p>Install the vacuum pump in a narrow space only if sufficient ventilation is ensured</p>
	Ambient temperature too high	Observe the permitted ambient temperatures
	Temperature of the inlet gas too high	Observe the permitted temperatures for the inlet gas
	Mains frequency or voltage outside tolerance range	Provide a more stable power supply

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

Spare Parts

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

The approval of the vacuum pump for the conveyance of gases with increased oxygen content remains valid only if genuine spare parts and consumables, which are approved for oxygen applications by Busch, are used exclusively.

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

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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 17 (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.

Pos.	Part	Qty	Part no.
72	Venting valve (=oil fill plug) with seal ring	1	0543 133 015
76	Sight glass	1	0583 000 001
77	Seal ring for sight glass	1	0480 000 271
80	Plug	1	0415 124 720
81	Seal ring for plug	1	0484 000 046
510	Coupling element	1	0512 135 985

715	Screen	1	0534 000 041
—	Filter cartridge, paper, for inlet filter (optional)	1	0532 000 004
—	Filter cartridge, polyester, for inlet filter (optional)	1	0532 121 864

Accessories

Accessories	Description	Part no.
Inlet air filter	inlet-side, horizontal, with paper cartridge, to separate solids	0945 000 071

Operating Fluid

Denomination	YLC 250 B
Base	PFPE
Density [g/cm ³]	1.9
Kinematic viscosity at 20 °C [mm ² /s]	270
Pourpoint [°C]	-35
Part no. 0.5 l packaging	0831 131 400
Part no. 1 l packaging	0831 108 878
Filling quantity, approx. [l]	1

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 2006/42/EC for the superordinate machine, issue the Declaration of Conformity for it and affix the **CE**-mark.

For maintenance of this Declaration of Conformity of vacuum pumps without a drive may only be used a drive with a written consent of Busch.

We

Busch Produktions GmbH
Schauinslandstr. 1
79689 Maulburg
Germany

declare that vacuum pumps **MM 1324, 1202, 1252, 1322, 1200, 1250, 1320 AV Oxygen**

in accordance with the European Directives:

- "Machinery" 2006/42/EC,
- "Electrical Equipment Designed for Use within Certain Voltage Limits" (so called "Low Voltage") 2006/95/EC,
- "Electromagnetic Compatibility" 2004/108/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 ISO 13857	Safety of machinery - Safety distances to prevent hazard zones being reached by the upper and lower 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)
EN 60204-1	Safety of machinery - Electrical equipment of machines - Part 1: General requirements
EN 61000-6-1 EN 61000-6-2	Electromagnetic compatibility (EMC) - Generic immunity standards
EN 61000-6-3 EN 61000-6-4	Electromagnetic compatibility (EMC) - Generic emission standards

<p>Manufacturer</p>  <p>Dr.-Ing. Karl Busch General director</p>	<p>Person authorised to compile the technical file</p>  <p>Andrej Riwe Technical writer</p>
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Technical Data

For motor connection parameters see nameplate

Type	Frequency [Hz]	Ultimate pressure [hPa abs = mbar abs]	Nominal motor rating [kW]	Nominal speed [min ⁻¹]	Nominal suction capacity [m ³ /h]	Sound pressure level (EN ISO 2151) at 400 hPa (=mbar) abs. suction pressure [db(A)]	Weight [kg]	Ambient temperature range [°C]	Ambient pressure	Synchronising gear operating fluid qty [l]	Synchronising gear operating fluid filled ex-works
MM 1324 AV	50	100	3.0	1500	160	72	~245 ... 260	0 ... 40	atmospheric	1	Busch YLC 250 B
	60		3.6	1800	192	76					
MM 1202 AV	50	100*	4.0	3000	200	77	~230				
	60		4.8	3600	240	81					
MM 1252 AV	50		4.5	3000	250	77	~240 ... 250				
	60		5.5	3600	300	81					
MM 1322 AV	50		5.5	3000	300	79	~260 ... 285				
	60		6.5	3600	360	84					
MM 1200 AV	50/60	150*	5.5	600-3600	max. 240	81	~240				
MM 1250 AV					max. 300		~250				
MM 1320 AV					max. 360		~260				

*to be limited by means of process control and/or vacuum relief valves

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