Translation of the Original Instructions

Operating manual

Single Stage Radial Fan

Design RHE/RGE

See chapter 14 of this operating manual for detailed addresses of all companies of the REITZ Group.
Please read this operating manual carefully. In case of doubts or if uncertain points occur, please clarify them with REITZ first.

The operating manual is, like spare parts lists and documentations of sub-suppliers, a separate part of the complete documentation. The complete documentation must be made available to the personnel appointed to operating and maintenance works.

OPERATING MANUAL: RADIAL FAN RHE/RGE

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This operating manual is intended for technical personnel that performs the following work related to the fan: transport, mounting, commissioning and start-up, operation, operating, troubleshooting, maintenance, repair, shutting-down, dismantling, disposal. Instructions and drawings of technical nature must not be copied in parts or completely, distributed or used without authorization for the purpose of competition or information of third parties.

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This document is a translation. In case of discrepancy the original and obligatory version is the German original.
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1. Introduction

This general operating manual is valid for all fans of this structural design including those that are designed in accordance to the Directive 94/9/EC on the approximation of the laws of the Member States concerning equipment and protective systems intended for use in potentially explosive atmospheres (ATEX). All fans are designed and produced in accordance with EC Machinery Directive 2006/42/EC.

1.1 EC Declaration of conformity and EC Declaration of incorporation

Being part of the overall documentation, these declarations are attached as separate documents to this operating manual (see enclosure).

The fan design in accordance with EC directive 94/9/EC (ATEX) will be certified by correspondent declaration of conformity.

1.2 Fan data sheet

The fan data sheet (see enclosure) is also attached as a separate document to this operating manual. All relevant technical data of the fan is clearly given in the fan data sheet. It may also be called technical data sheet and is generated for each individual fan.

The fan data sheet contains the following information:
- Serial fan number
- Fan type
- Flow data (nominal data and operating points)
- Motor data
- Acoustic data
- Material data
- Type of coating
- Bearing details
- Details about V-belt drive
- Fan equipment and accessories
- Customer’s order number
- Customer’s type designation

For fans according to EC directive 94/9/EC (ATEX), an additional part of the documentation is the completed and signed form of the questionnaire (RKU0063-- as amended from time to time) and – if applicable – the indication of the certification body where the documentation for fans of category II was lodged.
1.3 Description

The fan of RHE/RGE design is a welded single-stage radial fan.

Power is transmitted from motor shaft to fan shaft by a V-belt drive. The motor is mounted on an additional common base of sectional steel. The motor of RHE fans is arranged at the rear side of the base frame, RGE fan motors are installed sideways.

Depending on the design type, the fan shaft runs

- in two grease-lubricated anti-friction bearings in single bearing housings or
- in two grease-lubricated anti-friction bearings in a multiple bearing block.

Further technical information that is not covered by this operating manual can be requested from the manufacturer.

The fan can be designed for use in potentially explosive atmosphere. An individual nameplate indicates the equipment group and category as per directive 94/9/EC (ATEX)

1.4 Intended use

The fan is designed, calculated, produced, tested and delivered in accordance with the design conditions stated in the order.

The values given in the fan data sheet must not be exceeded.

Any other or exceeding use is considered to be improper use. Damages resulting from improper use are excluded from the manufacturer’s liability.

1.4.1 Fans according to 94/9/EG

If the fan is designed in accordance to EC directive 94/9/EC (ATEX), the intended use is restricted to

- the field of application
- the equipment group and category
- the explosion group for gases and vapours
- the gas or dust type
- the temperature class

These specifications can be found on the ATEX nameplate at the fan and in the corresponding ATEX questionnaire.

Any other use or application in installation conditions deviating from those there stipulated is prohibited.
1.4.2 Limits for use of fans acc. to 94/9/EG (ATEX)

The limiting conditions for the use of fans that are designed according to Directive 94/9/EG are:

- Maximum inlet temperature under ambient atmospheres in the temperature range from -20°C to +60°C
- Absolute pressure from 0.8 to 1.1 bar
- Maximum 21% oxygen share in volume flow

If the operating conditions differ from the stated limiting conditions, a special contract of work and labour has to be concluded with REITZ. The design must be documented by a separate ignition hazard assessment.
1.5 Installations and mounting instructions to reduce noise and vibrations

Take the following measures to reduce noise and to protect the operating personnel's health:
- Connect the fan to the duct work at inlet and discharge prior to fan start-up
- Mount the sound protection covers and hoods for motor and bearing (if included in the delivery)
- Isolate the housing on-site if the fan is prepared for insulation and this is included in the delivery
- Wear personal protective equipment (especially ear protection) → see also chapter 2.2 Danger outline

Take the following measures to reduce the vibrations and to avoid the transmission of vibrations to the duct work:
- Check the impeller according to the maintenance plan (see chapter 7.10 Maintenance schedule) with regard to sticking material, wear and tear, etc. since out-of-balance might result in an increase in fan vibrations → see chapter 9.1.2 Limiting values vibrations
- Mount the flexible connections at inlet and discharge prior to fan start-up (see also chapter 3.7.5 Use of flexible connections)
- If the fan is intended for resilient mounting: mount the fan on anti-vibration mounts (see chapter 3.6.4 Mounting and Alignment)
1.6 General remarks

This universal operating manual assists the operating company to carry out the safe and proper transport, installation, commissioning, start-up and maintenance of the fan.

This operating manual exclusively refers to the fan, but not to the electrical equipment like drive motors and other auxiliary drives. The unit “fan and motor” will not turn into electrical equipment when an electric drive is mounted. Please observe the operating and maintenance instructions of the motor manufacturer for mounting, installation and maintenance of the electric motors and auxiliary drives.

This operating manual describes and represents components that may not be included in your delivery.

In addition, our scope of delivery can include components and additional equipment that are not mentioned in these instructions. In that case, please observe the corresponding operating manuals of the relative producers. If applicable, request them from REITZ.

This operating manual is subject to modifications due to further technical development of the fan described herein.

Many images and drawings of this operating manual are simplified representations. Due to improvements and modifications the fan operated by your company might vary from the representations.

We reserve the copyright in this operating manual and the attached drawings and further documents.

The manufacturer will not undertake liability for damages that

- occur during the warranty period resulting from:
  - inadequate maintenance,
  - improper operating and another than the intended use
  - faulty mounting and installation,
  - incorrect or inexpert connection of electric or mechanic machines and devices.

- result or originate from unauthorized modifications or from disregarding the manufacturer’s recommendations and instructions.

- result from the use of accessories, equipment and/or spare parts that are not recommended by or delivered from the manufacturer.
This operating manual serves to avoid personal injury, property damage, functional failure as well as environmental damage.

Read these instructions carefully and completely before start of work. Should you have any questions or in case of doubts please do not hesitate to contact REITZ.

Keep these instructions in a safe place. They must be accessible for the operating company at any time. Protect them against harmful environmental influences and keep them in a legible and complete condition. Store them near to the fan.

The following additional instructions apply for fans according to directive 94/9/EC (ATEX):

If any technical modification at a fan that was designed and constructed in accordance with directive 94/9/EC (ATEX), that has not been agreed upon prior to the modification with Reitz, is carried out the originally issued declaration of conformity will become invalid.

The validity of the declaration of conformity can be maintained, if a qualified person carries out applicable tests and examinations after the technical modifications and prior to recommissioning of the fan and keeps records of the tests. In particular, these inspections are the check of the gap measure, vibration test and further checks to ensure that the formation of sparks is eliminated. The qualified person must be authorized to install and mount the components in accordance with §§ 14 and 15 of the German Health and Safety at Work Regulations („Betriebssicherheitsverordnung BetrSichV“). In addition, the qualified person must be able to recognize possible dangers for persons, property and environment and to avoid them. A written confirmation of the checks and examinations along with corresponding test reports must be sent to Reitz without further request. Please contact REITZ if any questions or uncertainties occur.

If the fan is of category II, we will inform the certification body, to which the documentation has been sent, accordingly.
1.7 Nameplate

The nameplate shows the following information:
- Manufacturer
- Address
- Designation of the machine
- Type designation
- Serial number
- Year of construction
- Technical data
- CE - sign

If technical information is or spare parts are required, all above mentioned data must be communicated.

If the fan is designed in accordance with directive 94/9/EC (ATEX), it has an additional nameplate with the following information:
- manufacturer
- address
- ATEX marking
- type designation
- serial number
- certification body

Figure 1: Example of an ATEX-nameplate
2. Safety instructions

2.1 General remarks

It is essential to read the operating manual prior to transport, installation, commissioning, start-up, operating, repair and maintenance. The instructions have to be observed.

2.2 Danger outline

Radial fan – single-stage, structural design RHE/RGE

<table>
<thead>
<tr>
<th>Kind of danger</th>
<th>Location of danger</th>
<th>Danger</th>
<th>Additional measures</th>
</tr>
</thead>
<tbody>
<tr>
<td>rubbing and abrasing</td>
<td>brake (optional), all rotating parts</td>
<td>explosion hazard by sparking and/or hot surfaces</td>
<td>observe operating manual, wear personal protective equipment</td>
</tr>
<tr>
<td>impact and rubbing</td>
<td>housing, impeller, motor, improper handling during transport</td>
<td>explosion hazard by sparking and/or hot surfaces</td>
<td>observe operating manual and transport instructions</td>
</tr>
<tr>
<td>corrosion</td>
<td>housing, impeller, motor, improper storage or intermediate storage</td>
<td>deposits of corrosion increase the risk of ignition and sparking, explosion hazard</td>
<td>observe operating manual and the storage and corrosion protection instructions</td>
</tr>
<tr>
<td>crushing, shearing, impact</td>
<td>unloading, lifting, mounting and installation of the fan</td>
<td>danger to life, risk of injury and property damage</td>
<td>pay attention to safe fastening and safe foundation / floor conditions</td>
</tr>
<tr>
<td>entangling, winding, drawing-in, trapping, faulty installation</td>
<td>heat flinger, impeller, all rotating parts, brake (optional)</td>
<td>danger to life, risk of injury and property damage</td>
<td>observe operating manual</td>
</tr>
<tr>
<td>electrical hazard</td>
<td>directly by alive parts</td>
<td>danger to life</td>
<td>observe motor manufacturer’s operating manual</td>
</tr>
<tr>
<td></td>
<td>indirectly by faulty alive parts</td>
<td>danger to life</td>
<td>observe safety regulations</td>
</tr>
<tr>
<td>thermal hazard caused by contact and burn</td>
<td>hot surfaces</td>
<td>danger to life, risk of injury and property damage, risk of explosion due to heightened ignition risk</td>
<td>wearing of personal protective equipment by staff, if necessary, customer must install safety areas</td>
</tr>
<tr>
<td>thermal hazard caused by improper installation, commissioning and start-up</td>
<td>hot surfaces e.g. housing, lifting lugs, drain, fan pedestal</td>
<td>danger to life, risk of injury and property damage, risk of explosion due to heightened ignition risk</td>
<td>wearing of personal protective equipment by staff, if necessary, customer must install safety areas</td>
</tr>
<tr>
<td>hazard generated by materials and foreign substances and improper use</td>
<td>housing, impeller, bearings, driving elements, monitoring devices</td>
<td>risk of property damages and danger of injury</td>
<td>observe operating manual, provide sufficient ventilation, avoid penetration and drag-in of foreign substances</td>
</tr>
<tr>
<td>high pressure ingress and ejection of fluids and gases</td>
<td>shaft seal with purge medium connection</td>
<td>danger to life, risk of injury and property damage</td>
<td>observe the operating manual, wearing of personal protective equipment</td>
</tr>
<tr>
<td>hazard generated by noise</td>
<td>during operation the sound emission exceeds 70 dB(A)</td>
<td>impairment of hearing ability, danger of injury</td>
<td>observe the operating manual, wearing of personal protective equipment</td>
</tr>
<tr>
<td>Kind of danger</td>
<td>Location of danger</td>
<td>Danger</td>
<td>Additional measures</td>
</tr>
<tr>
<td>--------------------------</td>
<td>------------------------------------------------------------------------------------</td>
<td>------------------------------------------------------------------------</td>
<td>-------------------------------------------</td>
</tr>
<tr>
<td>combination of hazards</td>
<td>danger for machinery, personnel and environment if the commissioning, start-</td>
<td>danger of injury, property damages, environmental damages</td>
<td>observe operating manual</td>
</tr>
<tr>
<td></td>
<td>up of the fan is not carried out by sufficiently trained staff members</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Table 1 – danger outline**
2.3 Symbols

The following symbols used in this operating manual need to be particularly observed:

Observe carefully the safety instructions that are listed next to the symbols in the following chapters. A label with these symbols and the corresponding instructions is also fixed to the fan.

**DANGER!**
Danger to life!
Serious physical injury with potential fatal consequences.

**DANGER!**
Danger of death by electrocution!
Serious physical injury with potential fatal consequences.
Working must exclusively be carried out by authorized electrician

**DANGER!**
Risk of fatal injury from entangling, drawing-in or trapping
Serious physical injury with potential fatal consequences.
Beware of automatic operation

**DANGER!**
Explosion hazard!
Spark formation or hot surfaces
Serious physical injury with potential fatal consequences.

**WARNING!**
Very hot surface – Do not touch!
Risk of burns. Severe personal injury

**WARNING!**
Risk of escaping of hot or dangerous gases.

**CAUTION!**
Risk related to exposure to noise!
Physical injury
Wear ear protection when fan is in operation.
WARNING!
Environmental harm!
Considerable damage caused to the environment.

NOTICE!
Read the operating manual.

NOTICE!
Refers to useful information and explanations.
2.4 Safety regulations

The following instructions and regulations that are part of the operating manual are strictly to be observed.

- safety regulations,
- regulations for the prevention of accidents,
- directives and accepted engineering standards.

Disregarding the safety regulations causes the risks of personal injury and damage to the fan.

Any work on fans that are marked according to directive 94/9/EC (ATEX) must exclusively be carried out by qualified persons that are authorised as per §§ 14 and 15 of the German Health and Safety at Work Regulations („Betriebssicherheitsverordnung BetrSichV“), unless these works are carried out by trained personnel of Reitz.
2.5 Regulations, standards

Working on the fan must comply with the valid rules for the prevention of accidents and the accepted engineering standards.

- Betriebssicherheitsverordnung (German Health and Safety at Work Regulations (BetrSichV) – "Regulations on safety and health protection for the provision of work equipment and their use for work, on the safety of the operation of plants that require special monitoring and on the organisation of health and safety protection at factory level" (translation of the full German title).

- VDMA 24165 “Ventilatoren – Sicherheitsanforderungen” (Industrial fans, safety requirements - VDMA – Verband Deutscher Maschinen- und Anlagenbau eV – German Engineering Federation)

- Regulations for the prevention of accidents (BGVs) of the “Berufsgenossenschaften (BGs)” (institutions for statutory accident insurance and prevention in Germany)
  - „Grundsätze der Prävention“ BGV A1 (General prescriptions) BGV A1
  - „Elektrische Anlagen und Betriebsmittel“ BGV A3 (Electrical installations and operating material) BGV A3
  - „Lärm“ BGV B3 (Noise) BGV B3

- Occupational Safety Regulations for safety and health at work (BG rules -BGR)
  - „Explosionsschutz-Regeln - Regeln für das Vermeiden der Gefahren durch explosionsfähige Atmosphäre“ BGR 104 (bisher ZH 1/10). (Explosion protection regulations – regulations for the prevention of dangers caused by ignitable atmospheres BGR 104 (so far ZH1/10)
  - „Vermeidung von Zündgefahren infolge elektrostatischer Aufladungen“ BGR132 (bisherige ZH 1/200) (Prevention of the ignition risk due to electro-static charging – BGR 132 (so far ZH 1/200)
  - “Betreiben von Arbeitsmitteln” BGR 500, Kap. 2.8 (Use of work equipment BRG 500 chap. 2)
• Harmonised European standards and national standards
  - EN 1127-1 „Explosive atmospheres – Explosion prevention and protection“
  - DIN 24166 „Technische Lieferbedingungen für Ventilatoren“
    (German Industrial Standard - Technical delivery conditions for fans)
  - DIN EN 14986 „Konstruktion von Ventilatoren für den Einsatz in explosionsgefährdeten Bereichen“
    (Design of fans working in potentially explosive atmospheres)^2
• EU Directive
  - 89/686/ECC “Personal protective equipment“
  - 2009/104/EC „Use of work equipment“
2.6 Electric connection conditions

The operating company has to observe the instructions and to meet the connection conditions of the local electric supply company for the electric connection of the motor and the auxiliary drives (if any) and the system.

All electric works on the machine and its connections must exclusively be carried out by professional electricians that are authorized by the definition regarding professionals (e.g. German definition DIN VDE 0105 and IEC 364).

It has to be ensured that type of current, voltage and frequency of the electric power supply are suitable for the below enlisted components and that the electric connections are expertly made for:
- drive motor/s fan
- actuator/s damper/s
- monitoring devices
- other electric parts

If the fan is of explosion-proof design, the electric installation has to meet the requirements of DIN EN 60079-14.
2.7 Marking, danger signs

Information directly arranged on the fan, e.g. sense of rotation arrows, information signs, markings or danger signs must be observed and kept in legible condition.

See an example of nameplate, danger signs and other markings positioning at the fan in chapter 7.7 Marking, information sign.

2.8 Qualified person

Qualified persons in terms of the § 2, clause 7 German Health and Safety at Work Regulations („Betriebssicherheitsverordnung BetrSichV“) is personnel that due to professional training, work experience and their current occupational activity has the necessary expert knowledge for testing the working devices.

Qualified persons only are allowed to carry out all works at the fan, at fan components, at the fan equipment, maintenance devices and electric components. Authorised personnel must also have sufficient knowledge about

- currently valid safety regulations,
- currently valid regulations for the prevention of accidents,
- directives and accepted engineering standards.

In addition, qualified personnel must:

- be authorized to carry out the necessary works
- be able to assess the works allocated to them with regard to dangers, be able to recognize possible dangers and to avoid them.
- have read these instructions prior to working

The person who is responsible for the safety of the system authorises the personnel to carry out the works.
2.9 Personal protective equipment

The operating company and the plant engineering company are responsible for the required protective measures on site like coverage, barriers or personal protective equipment.

Operating personnel are all staff members that are in charge of installation, mounting, operation, setting, maintenance, cleaning, repair and transport of machinery.

Carrying out dangerous works and activities requires wearing personal protective equipment in terms of EU Directive 89/689/EWG in order to avoid injuries or minimise the risk of injury that might not be prevented through other measures.

The minimum equipment includes:
- helmet
- eye protection
- foot guard
- hand guard
- ear protection
- reflective jacket
- appropriate working clothes.

In dependence of the type of the works or their dangerousness, wearing of further personal protective equipment and taking further safety precautions (e.g. fall protection) may become necessary.

When working on the fan, the following “Occupational Safety Regulations for safety and health at work (BG rules -BGR) are to be observed:
- „Wearing of protective clothing “ BGR 189
- „Wearing of foot and leg guards“ BGR 191
- „Use of head protection“ BGR 193
- „Use of ear protection“ BGR 194
- „Wearing of protective gloves“ BGR195
- „Use of protective equipment against falling“ BGR 198
2.10 Risk of slipping, tripping or falling

The operating company and the plant engineering company are responsible for necessary precautionary protective measures on site.

- Mark the transport aisles and keep them clear
- Sufficiently light the transport aisles and workplaces
- Remove unevenness of floor and installation sites
- Keep the working environment tidy and clean
- Treads must be anti-slip and undamaged
- Eliminate the slip danger (e.g. remove packed snow and black ice, keep the place in a dry condition)
- Apply fall protection (e.g. safety harness) when ladders are used to access the workplace
- There is the risk of falling from heights of more than 1 metre above the floor and in case of hollows or floor openings → install safety fence (e.g. guard railing, barriers), use fast devices instead of warning tape
- Ladders cannot serve as working places. It is not allowed to carry out certain works from the ladder, when for example the ladder lacks stability, the tool's weight exceeds 10 kg, the area exposed to wind exceeds 1 m².
- Install working platforms at places that have to be maintained on a regular basis.
- Spilt working material is to be removed with suitable oil binding agent. Dispose of it in a safe manner consistent with all applicable regulations.
- Remove completely leaked grease and dispose of it properly and professionally in view of environmental protection requirements.

2.11 Measures in case of electrical power outage

In case of main and/or auxiliary electrical power failure, the fan has to be put into a safe condition. The control system must be designed so that the power breakdown or the control system itself does not result in a dangerous situation, neither at the time of the mains failure nor at the time when the energy is re-established or the control system is again ready for operation.

Additional measures for fans, whose handled gas temperature exceeds 80°C: In case the power fails, the hot handled gas must absolutely be prevented from flowing in at inlet of the fan and also from flowing back or backing up at discharge of the fan. Install proper shut-off devices including appropriate control systems on-site and keep them in an operable state.
3. Transport, Installation

3.1 General remarks

The fan and the equipment should only be transported and lifted at the provided marked lifting lugs. Load suspension devices as well as sling devices have to be in perfect condition and should only to be fastened at the provided lifting lugs.

Personnel that lifts and transports the fan must:
- have read the operating manual,
- have understood the content of the chapter transport, especially the safety regulations, the regulations for the prevention of accidents and the instructions for the transport of the fan,
- be familiar with the hoists, the required load suspension devices and the sling devices.

3.2 Safety instructions

The safety instructions for lifting and transport of the fan must be observed.

- Use hoists, load suspension devices and sling devices with sufficient load capacity only (for load / weight see fan data sheet or fan drawing)
- The angle of spread must not exceed 120° (see Figure 3).
- Do not knot steel wire ropes and chains.
- Do not tie ropes from fibres with knots.
- Do not distort the ropes.
- Untwist distorted ropes prior to lifting.
- Do not kink the ropes at wire rope clamps.
- Thimbles (cable eye stiffeners), rope eyes, suspension hooks and other lifting links must suspend freely on the lifting hook.
- Use edge guards when the slings are laid on sharp edges.
- Lift up the hook tackle when it is not used.
- Do not lift loads over people.

Observe the regulations for the prevention of accidents.

Auxiliary lifting lugs (e.g. at the motor) – if any – are suitable only for lifting the corresponding single component.

We recommend an installation performed by manufacturer's skilled staff.
3.3 Regulations, standards

The valid regulations for the prevention of accidents and the accepted engineering standards apply to the lifting and transport of the fan.

- Regulations for the prevention of accidents (e.g. German BG regulations)
  - „Allgemeine Vorschriften“ (General Instructions) BGV A1
  - „Krane“ (Cranes) BGV D6 (VBG 9)
  - “Betreiben von Arbeitsmitteln” BGR 500, Kap. 2.8 (Use of work equipment BRG 500 chap. 2)
- National standards (e.g. Standards of the German Institute for Standardisation)
  - „Hebezeuge, Lastaufnahmeeinrichtungen“ (Hoists, load suspension devices ) DIN 15003
  - „Ösenhaken, Güteklasse 5“ (Eye hooks, quality class 5) DIN 7540
  - „Schäkel“ (Shackles) DIN 82101
3.3.1 Load suspension devices

- Fans are only to be lifted and transported with the appropriate hoists and means of transport (weight indication see fan data sheet or fan drawing).
- Fasten sling devices at the especially provided lifting lugs only (see Figure 2)
- Do not damage components or fan when fastening sling devices.
- Do not fasten sling devices to the inlet, discharge, bearings, motor or base frame. This damages the fan and excludes and limits the liability of the manufacturer.
- Use sling devices of appropriate length. Pay attention to an even weight distribution. Attention: Transport of fan is only permitted when the weight is evenly distributed. The fan must be kept in a nearly horizontal position throughout complete fan lifting and transport activities.

- Observe the spread angle and the inclination angle (see Figure 3)
  The inclination angle $\alpha_N$ must not exceed 60°, that is to say the spread angle $\alpha_S$ must not exceed 120°.
- Wear personal protective equipment (see chapter 2.9)
3.4 Packing

The fan and the equipment are packed in the factory in accordance with
- the transport route,
- the storage at customer’s premises
- and / or customer’s requirements

If the impeller-shaft-bearing unit has not yet been assembled with the fan at the factory, these fans are prepared in the factory for the transport by covering the area of the bearing housings with weather protection foil.

Remove the foil covering only shortly before the first start-up and commissioning in order to maintain warranty claims.

Bearing housings that have already been assembled to the fan are protected by a cover hood made of galvanized steel sheet, where applicable.
Types of packing:

- Fan components mounted on wooden pallet with protection covering (welded in plastic foil).
- Fan components mounted on wooden pallet with protection covering (welded in plastic foil) and special bearing protection.
- Fan components mounted on wooden crate, protection covering (welded in plastic foil) and special bearing protection.
- Seaworthy packing in closed wooden case → Figure 4).

Fan components must only be transported with transport safety contrivances, with a protection covering (foil) and desiccants, so that no dirt and humidity can enter in the fan, in the anti-friction bearings or in the electric components.

The protection covering must be removed prior to that installation of the fan components.

Symbol legend:

- Keep dry
- This side up
- Glass - fragile
- Centre of gravity
- Fasten sling devices here

In case the fan or the equipment is packed and corrosion protected for an extended period of time at the factory, the separate „Instructions for Storage and Corrosion Protection of Radial Fans“ must be observed.
3.5 Transport

For lifting and transport of the fan components and the equipment observe

- 2.4 Safety regulations,
- 2.5 Regulations, standards,
- 3.3.1 Load suspension devices

- Sling devices, e.g.
  - wire ropes,
  - ropes from fibres,
  - steel cables

must be fixed at lifting lugs and suspension hooks.

- Unload the fan with suitable hoists only. Disregard of this instruction may cause the danger of crushing or shearing of parts of the body.

Caution: place the fan onto the floor or foundation to avoid damages to the fan, the bearings and other components.

- Observe permitted ground, floor, foundation or ceiling load capacities.

- After unloading of fan components and equipment
  - remove packing (depending on type of packing),
  - check fan and equipment for damages,
  - check accessories for completeness in accordance with the delivery note,
  - do not remove the cover foil and/or weather protection hood of the anti-friction bearings.

- Transport the fan components and the equipment by suitable hoists / means of transport to the installation location or storage place only.

- If the fan is transported to the installation location by vehicle:
  - lift the fan with suitable hoists onto the platform of the vehicle,
  - secure the fan against shifting and displacing by fastening belts.
3.5.1 Transport damages

Document any transport damage preferably with photographs and immediately report them to the forwarding agent, insurance company and manufacturer.

3.5.2 Intermediate storage

Please observe our separate “Instructions for Storage and Corrosion Protection” for proper storage of fan, bearings, shaft seal, V-belts, drives, actuators, monitoring devices and other equipment.
3.6 Installation

If the fan is not delivered in a completely assembled condition, observe the separate mounting instructions for the assembly of fan which can be ordered from Reitz.

Further action to be taken if the fan has been partly pre-assembled at REITZ:

Pay particular attention to the Reitz serial number when the fans are assembled. Only assemble fan parts of the same serial number. If several pre-assembled fans of the same design are supplied, the following fan parts are clearly marked with the individual corresponding Reitz serial no.:

- lower housing parts
- upper housing parts
- rotor

In case the rotor is delivered in a transport safety contrivance, keep this transport stand for possible future rotor dismantling, rotor intermediate storage or transport on site.

Fans of sectional splitting housing design:
Before the fan housing is assembled, seal the sectional splitting flanges as per the separate sealing instructions. The sealing instructions are part of the separate mounting instructions for the assembly of fans. Observe further instructions of the mounting and assembly drawing, if any.
3.6.1 General remarks

- Design conditions
  The fan and the equipment are designed, tested and delivered in accordance with the design conditions specified in the order.
  The specifications made in the order are documented in the fan data sheet. It is not permitted to deviate from the conditions shown in the fan data sheet (e.g. different handled gas).

  Unless otherwise agreed upon, the electric components of the machine are designed for a maximum ambient temperature of 40°C and an altitude of site up to 1000 m asl in accordance with the instructions of the German standard VDE0530.. Please observe the installation instructions in the operating manual of the motor producers.

- Warranty
  The warranty details refer to single values and testing conditions in accordance with the applicable EN DIN standards and/or the valid standards and regulations. The system's specific special characteristics and local conditions must be taken into account by the system designer or the project engineer when the order data are specified.

  It is essential to convert the data for the operating conditions in accordance with the existing local conditions.

3.6.2 Safety instructions

Installation works must exclusively be carried out by specialist personnel (see chapter 2.8)

  It is recommended to request installation specialists of the manufacturer.
3.6.3 Preparation for installation

- Substructure of the fan like base plates, additional base frames, sole plates, steel stages or foundations must:
  - be designed in accordance with the weight and the foundation load (→ dimension sheet),
  - ensure a vibration-free installation for operation or standstill.
- Compare foundation dimensions with the fan dimension sheet and the foundation plan and ensure that:
  - there is sufficient space for installation, maintenance and repair works,
  - there is sufficient space for the intake and discharge of the cooling air for the rotary current motor.
- Carry out required corrections on the foundation and clean treated surfaces.
- Transport fan to the location of installation by suitable hoists / means of transport (see chapter 3.3.1 Load suspension devices)
3.6.4 Mounting and Alignment

3.6.4.1 General remarks

Stability of fan is at risk when the installation site is not even. This might increase the danger of crushing and shearing of parts of the body.

Prior to the start of the installation the mounting place has to be checked for evenness and dimension accuracy.

Steel foundations, foundation blocks and concrete foundations that ensure a safe operation free from impact, vibration and distortion are appropriate sub-structures for the fan.

Assembling auxiliaries like alignment plates, fastening screws, etc. can be obtained from the manufacturer.

Request installation specialists from the manufacturer, if necessary.

After mounting on the foundation the fan must be aligned. Use appropriate measuring instruments, tools, jack screws and shims for this work.

If the fan is installed within chemically aggressive atmosphere or outdoor → use alignment sheets made of rustproof material.

3.6.4.2 Sequence of mounting

The sequence of mounting depends on the fan design. Take the appropriate fan design from the separate dimension sheet or any additional order-related drawings.

<table>
<thead>
<tr>
<th>mounting on</th>
<th>without anti-vibration mounts</th>
<th>with anti-vibration mounts</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>anti-vibration mounts without mounting plate</td>
<td>anti-vibration mounts with mounting plate</td>
</tr>
<tr>
<td>steel foundation</td>
<td>X</td>
<td>X</td>
</tr>
<tr>
<td>concrete foundation</td>
<td>X</td>
<td>-</td>
</tr>
</tbody>
</table>

X = possible
- = not possible

Table 2
• Fan **without anti-vibration mounts** and mounting on **steel foundation**
  Align the fan horizontally (if necessary, use alignment plates) and fasten the fan with hexagon head screws. For tightening moments see chapter 9.1.1 Tightening moments for fastening screws.

• Fan **without anti-vibration mounts** and mounting on **concrete foundation**
  Align the fan horizontally (if necessary, use alignment plates) and screw the fan to the concrete foundation with suitable fastening devices (e.g. heavy duty anchor bolts, stone bolts). For tightening moments see chapter 9.1.1 Tightening moments for fastening screws.

• Fan **with anti-vibration mounts** and mounting on **steel foundation**
  - Anti-vibration mounts without mounting plate
    - Screw the anti-vibration mounts to the steel foundation
    - Carefully place the fan on the anti-vibration mounts (correctly fit the set screw in the bore holes)
    - Align the fan and screw it to the steel foundation.
  - Anti-vibration mounts with mounting plate
    - Carefully place the fan including the anti-vibration mounts on the steel foundation
    - Align the fan and screw it to the steel foundation.
  - Anti-vibration mounts (spring type) – spring phonolators
    - Screw the anti-vibration mounts (spring type) to the steel foundation
    - Carefully place the fan on the anti-vibration mounts (spring type), correctly fit the set screw in the bore holes.
    - Align the fan and screw it to the steel foundation.
    - Observe the mounting instructions of the producer of the anti-vibration mounts (spring type), which can be obtained from Reitz.
- Fan with anti-vibration mounts and mounting on concrete foundation
  - Anti-vibration mount with mounting plate
    - Carefully place the fan including the anti-vibration mounts on the concrete foundation
  - Align the fan and bore the foundation holes for the heavy duty anchor bolts through the bores provided on the mounting plates.
  - Screw the fan to the concrete foundation with suitable fastening devices (e.g. heavy duty anchor bolts, stone bolts). And observe the tightening moments see chapter 9.1.1
  - Anti-vibration mounts (spring type) – spring phonolators
    - Screw the anti-vibration mounts (spring type) to the concrete foundation
    - Carefully place the fan on the anti-vibration mounts (spring type), correctly fit the set screw in the bore holes.
    - Observe the mounting instructions of the producer of the anti-vibration mounts (spring type), which can be obtained from Reitz
Transport, Installation

3.6.4.3 Alignment of the belt pulleys

During transport motor and bearing can get displaced.

The pulleys of fan and motor must be aligned to avoid unacceptable operating conditions. Therefore, check the V-belt drive for proper alignment before initial start-up and re-align it if necessary.

Manufacturer’s skilled service staff has to be requested for alignment.

- Remove protective cover of V-belt drive.

- Check the alignment of the belt pulleys with appropriate measuring tools.
  
  - angular offset = 0.5°

- parallel offset, see table
  Clearance values must fall short of the given values for the clearances.

<table>
<thead>
<tr>
<th>pulley-Ø</th>
<th>max. permissible clearance</th>
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<td>d₁/d₂</td>
<td>X₁, X₂</td>
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<td>112 mm</td>
<td>0.5 mm</td>
</tr>
<tr>
<td>224 mm</td>
<td>1.0 mm</td>
</tr>
<tr>
<td>450 mm</td>
<td>2.0 mm</td>
</tr>
<tr>
<td>630 mm</td>
<td>3.0 mm</td>
</tr>
</tbody>
</table>

The alignment of the V-belt pulleys can be examined with a ruler for parallel offset and for being conform with regard to angles.

The accuracy of alignment can be improved by using a dial gauge or a laser-type optical sensor.

See chapter 7.6.2 Belt tension for the examination and alteration of the belt tension.
3.6.4.4 Screw connections

In principle, make sure for all screwed connections that there is sufficient excess length after the screw or nut has been tightened. The screw must project from the nut not less than the length of the screw diameter.

Always position the screw head so that a loosening or even loss of the screw can be immediately recognized. Always position the nut on top in case of vertical screwing.

Figure 8

Figure 9  Example bearing screwing

Figure 10  Example motor screwing

Figure 11  Example frame screwing
Exception from the prescribed screw heat position:
When flexible connections are screwed, the screw ends must always be turned away from the flexible connection.

Figure 12: representation of flexible connection with correct screwed connections (example)

Tighten all screw connections with the proper tightening moment, see chapter 9.1.1 Tightening moments for fastening screws
3.7 Connections

3.7.1 General remarks
The connection of the electric components of the fan must be carried out in accordance with the following regulations, as amended:

- Regulations issued by the local electric supply company (e.g. German EVU),
- national associations for electronic regulations (e.g. EN DIN VDE regulations: VDE – German Association for Electrical, Electronic & Information Technologies.)
- Installation and mounting instructions in the operating manual of the motor producer.

3.7.2 Safety instructions
Works on the fan or the equipment must exclusively be carried out by specialist personnel, that due to professional training, experiences and instructions has sufficient knowledge about:

- Safety regulations,
- regulations for prevention of accidents,
- directives and accepted engineering standards (e.g. VDE directives, DIN EN standards)

The specialist personnel must:

- be able to assess the works allocated to them, to recognize possible dangers and to avoid them,
- be authorized by the person who is responsible for the safety of the system to carry out the required works and tasks.

All electric works on the components of the fan must exclusively be carried out by professional electricians that are authorized by definition regarding professionals (e.g. German definition DIN VDE 0105 and IEC 364). The electricians must observe the following regulations and instructions, as amended:

- EN DIN VDE-regulations (e.g. Germany),
- IEC-regulations (International Electrotechnical Association),
- Safety instructions,
- Transport, installation and maintenance instructions

Professional electricians are specialists, who due to professional training, experiences and instructions have knowledge about valid appropriate standards, regulations and regulations for prevention of accidents.

Furthermore they must be able to assess the works allocated to them and to recognize and to eliminate possible dangers.

The professional electricians must be authorized by the person who is responsible for the safety of the system to carry out the required works and tasks.
3.7.3 Ducting of fan

Distortions of the fan at the connections caused by the ductwork are not permitted. Distortions cause alterations, e.g. the gap at the nozzle decreases at one side which might lead to rubbing in the inlet.

- Remove the transport covers from the connections.
- Move the duct work to be connected to the inlet and discharge openings of the fan without causing offsets between the ducts and openings.
- Connect duct and conduits to the fan free-of-load.
3.7.4 Check of clearances

Prior to the first commissioning of the fan, the radial clearance between inlet cone and impeller nozzle must be checked and recorded pursuant to the following instructions. We cannot exclude possible shifts resulting from the transport between inlet cone and impeller. The fan can only be operated safely and trouble-free when the minimum clearance is observed. Any warranty claim will be invalidated if the minimum clearance is not maintained.

There are two different impeller designs:
- impeller with shroud (Figure 13)
  incl. representation of the check points ① to ⑧

Figure 13

- unshrouded impeller (Figure 14)
  * number of check points according to the number of blades

Figure 14

In dependence on impeller design start to check the gap in case of:
- impeller with shroud:
  check the gap at eight check points (see Figure 13)
- unshrouded impeller:
  number of check points according to the number of the blades (see Figure 14)

Then turn the impeller by 90° and again check the gap at all check points. Repeat this process three times.

For fans of earlier design and for replacement deliveries of impeller or unshrouded impeller, the clearance dimensions can differ from the values given in the table.
3.7.4.1 Check of clearance for impeller with shroud

The minimum radial clearance must amount to 3 mm at least.
Take further clearance measures from Table 3 minimum clearance table.

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</table>

Table 3 minimum clearance table

Figure 15 Representation of different installation situation:
impeller "inlet cone extends into the impeller nozzle and "nozzle with gap"
3.7.4.2 Check of clearance for unshrouded impeller

The minimum axial clearance must amount to 10 at least.
Take further clearance measures from Table 4 minimum clearance table.

### Table 4 minimum clearance table

<table>
<thead>
<tr>
<th>DN</th>
<th>D1</th>
<th>Standard</th>
<th>Atex</th>
</tr>
</thead>
<tbody>
<tr>
<td>100</td>
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<td>1400</td>
<td>1403</td>
<td>15</td>
<td>15</td>
</tr>
<tr>
<td>1600</td>
<td>1575</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>1800</td>
<td>1768</td>
<td>20</td>
<td>20</td>
</tr>
<tr>
<td>2000</td>
<td>1985</td>
<td>20</td>
<td>20</td>
</tr>
</tbody>
</table>

Figure 16 representation of installation situation unshrouded impeller
3.7.5 Use of flexible connections

Flexible connections are intended to prevent the transmission of structure-borne sound and vibration forces. They are also used to reduce / prevent the transmission of forces from the duct work to the fan. Furthermore alignment errors of the ducts are reduced. The flexible connections should always be arranged directly at the fan connection flange (except when a damper is mounted on the fan).

If the fan is mounted on anti-vibration mounts, flexible connections must be provided at the inlet and discharge on principle.

3.7.5.1 Installation of flexible connections

Do not install flexible connections before completion of the duct work.

Flexible connections with hose clamps:
Pull flexible hose-type connections on the duct cautiously and fix them with hose clamps.

Flexible connection with back flanges:
Pull flanged flexible connections cautiously (inclusive back flanges) over the chute and arrange them between the fastening flanges. Apply sealing or sealing cord under the chute and fasten it by screw. All fastening screws must be tightened equally and – if possible – crosswise.
For tightening moments see annex (→ chapter 9.1.1).

3.7.6 Use of chutes

Depending on arrangement and load, chutes must be provided if:
- temperatures exceed 90 °C,
- velocities of flow exceed 30 m/s,
- pressure loads exceed 1000 daPa,
- aggressive or abrasive media are conveyed,
- the flexible connection is arranged at the inlet (as the flexible connection is supported by the chute against the existing negative pressure and does not reduce the inlet cross section of the fan),
- there are high noise level demands (the chute acts as a connected duct with corresponding attenuation values).
- Fans working with potentially explosive atmosphere should always be equipped with chutes for flexible connections. The chutes have to operate in the direction of flow.
- Always observe the flow direction when chutes are installed (see arrow in Figure 17 representation chute and direction of flow)

Figure 17 representation of chute and direction of flow
3.7.7 Electric connection conditions

Connect the power supply lead according to the valid regulations of the local electric supply company and observe in addition:

- the EN DIN VDE-regulations (e.g. Germany),
- the safety regulations,
- the regulations for the prevention of accidents.

As far as the low-voltage line is concerned, use for example

- earthing wire acc. DIN VDE 0255,
- plastic cable acc. DIN VDE 0273,
- cable lugs acc. DIN 46235
- terminal screws

and observe the instructions of the cable and sealing end manufacturers.

The cross section of the power supply lead depends on the type of cabling, rated voltage and rated power of the machine.

Cable ends with pressed-on cable lugs must be arranged and connected in accordance with the connecting plan that is to be found in the terminal box cover.

The power supply lead and the cable ends must not exert any lateral and/or torsional power on the terminal studs during or after the cable connecting work.

In case the fan is provided with electric protection devices (e.g. position switch), adhere to the instructions of DIN EN 60204-1 Safety of machinery – Electrical equipment of machines.

3.7.7.1 Earthing

If the fan and/or its equipment are provided with earthing clamps, connect the system’s earthing to them.

Figure 18

Figure 18 → earthing link
3.7.7.2 Monitoring devices

The fan can be equipped with vibration monitoring, bearing condition monitoring and bearing temperature monitoring. Furthermore, the temperature probes can be installed for monitoring the temperature of the handled gas. Additional monitoring devices are described in separate operating manuals.

Connections of the monitoring devices must be connected in accordance with the detailed wiring diagram.

Please observe the instructions in the annex of this operating manual.

- The annex shows the maximum warning and disconnecting values.
  - Chapter 9.1.2 Limiting values vibrations
  - Chapter 9.1.3 Limiting values bearing temperatures

3.7.8 Seal connection

The shaft seal for a sealing medium has a G ½" connection for a grease injector or a barrier gas connection provided on-site by customer.

Figure 19 ➔ shaft seal with grease seal

In general, the shaft seals are continuously to be provided with the proper quantity of grease or barrier gas that corresponds to the operational mode. Disregarding this requirement leads to an increased risk of ignition and subsequently to an increased risk of injury to persons and severe property damage.

Barrier gas conduits with pressure reducer and pressure gauges are available on request from the manufacturer.
4. Start-up

4.1 General remarks

Perform a start-up after installation and after each repair. Check for compliance of the finished installation and present operating conditions with the specified data of the fan data sheet (→ chapter 1.2).

The specialist personnel must be authorized by the person who is responsible for the safety of the system to carry out the required works and tasks for the start-up. (see chapter 2, Safety instructions).

4.2 Mechanical check

- Check all external fastening screws for tightness.
- Check impeller for unblocked run (rotate manually once)
  Attention: The impeller must not rub at the inlet.
- Remove possibly existing foreign substances from the fan housing.
- Check all screwed connections of the duct connections for tightness.
- Close the inspection openings properly.
- Remove transport securing devices, if any.
  ATTENTION: If the fan is provided with a transport safety device (e.g. shaft support, etc.), the provisions for transport have to be removed before the fan is start-up. In any case, it must be easy to turn the impeller.

4.2.1 Alignment

Check and document the alignment of the motor to the fan (→ chapter 3.6.4 Mounting and Alignment).
4.3 Electric check

- Check the operating voltage.
- Check for proper condition of earthing connections and equipotential bonding connections.

The electric connections inside the switching cabinet must comply with the regulations of the local power supply company and the valid regulations (e.g. German standard DIN VDE 0105) as well as the instructions of the producers of the drive motor and auxiliary motors.

4.3.1 Monitoring devices / auxiliary equipment

- Check the connections and cabling of the monitoring devices and auxiliary equipment for compliance with the detailed wiring diagram (→ switch cabinet).
- Switch on measuring systems and check connected monitoring devices for functionality.
4.3.2 Check of sense of rotation

- Manually check the impeller for unblocked run.
- Switch on the motor and check the sense of rotation for compliance with the sense of rotation arrow arranged at the back of the fan.
- Motor sense of rotation must be the same as the fan’s sense of rotation (see Figure 20)
- Disconnect the fan.
- The following motor connection results from the sense of rotation:

<table>
<thead>
<tr>
<th>Connection</th>
<th>Sense of rotation facing the drive side (motor shaft journal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>L1, L2, L3</td>
<td>Sense of rotation facing the drive side (motor shaft journal)</td>
</tr>
<tr>
<td>U1 - V1 - W1</td>
<td>clockwise</td>
</tr>
<tr>
<td>W1 - V1 - U1</td>
<td>counterclockwise</td>
</tr>
</tbody>
</table>

When checking the sense of rotation, only the assigned inspector is permitted to be present within the danger area of the fan. Switch on motor and check sense of rotation (observe valid regulations, e.g. DIN VDE 0105).

- Ensure that the motor is switched dead.
- Secure against restart and mark with relevant information sign.
- Check for and ensure dead condition.
- Connect to earth and short-circuit.
- Cover or secure by barrier adjacent alive parts.

4.3.3 Commutating wrong sense of rotation

If two of the existing connecting lines are interchanged, the sense of rotation is altered. In this case the connecting cables must be arranged inside the terminal box in accordance with the terminal connecting plan shown above and the sense of rotation.
4.4 Start-up of fan

4.4.1 General remarks

Check and inspect the following items prior to start-up:

- Is it possible to switch on the fan?
- Has the fan been checked mechanically and electrically and do all results show faultless conditions?
- Are all connections / ductworks installed professionally?
- Are the air intake openings of the motor free and uncovered?
- Has the clearance been checked? (see chapter 3.7.4),
- Are the safety devices in active and correct position?
- Are the power units, switchgears, monitoring devices and the cable cross sections designed and checked by the project engineer / operating company regarding the type of starting, starting time and peak load?
- If the fan is provided with a transport safety device: Has the transport safety device been removed?
- Check the belt tension after the first 50 operating hours (see chapter 7.6 V-belt drive) and re-tension the V-belts if necessary.
- Let the V-belts run several times after they have been installed. The belt pulleys will then set evenly. Check the belt tension every six months. If necessary, re-tension the belt or replace them.

Note on the bearing temperature during the first commissioning phase:

Due to preservation reasons, the grease quantity is far above the quantity that is required for the operation. The bearing temperature, therefore, can even exceed 80°C during the first commissioning. After the excessive amount of grease has leaked out, the bearing temperature must return to normal operating temperature in the range of 60°C to 80°C.
4.4.2 Safety instructions

- The start-up must exclusively be carried out by specialist personnel that is appointed by the person who is responsible for the system.
- Observe the valid safety instructions (e.g. DIN VDE 0105)
- Before switching on the fan:
  - finish all works on the fan,
  - install all covers and safety devices,
  - reverse the protection measures that were carried out for the works on the fan (earthing and short-circuit of the connecting cable, securing against restart, etc).

The screws of safety devices for rotating parts are provided with retentions. The screw retentions ensure that the screws will remain on the safety devices if it is dismantled. Care must be taken when mounting and dismantling the safety devices in order to maintain the serviceability of the screw retentions.
4.4.3 Switching on of the fan

It is only permitted to start-up the fan, if a sufficient acceleration torque is available, covering the complete range of acceleration up to the nominal speed.

Start-up the fan with closed damper.

In case the fan is of gastight design, check the housing, the shaft seal and the connections at inlet and discharge for tightness.

Switch-on fan.

Monitor the following values and document them:

- During start-up
  - current consumption,
  - voltage,
  - vibrations (quiet running),
  - noises.

- After start-up
  - current / voltage,
  - vibrations,
  - noises,
  - bearing temperatures
  - temperature increase at fan housing due to compression of handled gas.

After start-up charge the fan.

Monitor the following values of the fan and document them:

- current consumption / voltage,
- vibrations (quiet running),
- noises,
- bearing temperatures.

The fan must be disconnected, when

- specified values are exceeded
  (see chapter 1.2 Fan data sheet)
- unacceptable vibration values or increased noise levels of the fan occur,
- limit values are exceeded
  (see chapter 9.1.2 Limiting values vibrations)

If the above mentioned malfunctions occur, contact the service specialists of the manufacturer.
4.4.3.1 Direct starting

Direct starting (delta starting) of the motor does not only cause a high starting torque but also a high starting current. During starting the starting current is 6 to 8 times higher than the rated current (depending on the type of rotor). Account for this high consumption of current when selecting the fuses.

4.4.3.2 Star-delta-starting

During star-delta starting the drive motor only provides 1/3 of the acceleration torque when star connected. From a certain speed onwards, the load moment of the fan exceeds the acceleration torque of the motor. The motor stops to accelerate. In this state, the motor must be switched to delta connection. The resulting peak load is significantly lower than that of direct fan starting.

The connecting frequency of the electric motors is limited to maximum six starting processes per hour. For this the instructions of the motor manufacturers must be observed.

4.4.3.3 Prevention of high negative torque impacts during test run

On principle, the fan is only to be restarted after the total standstill of the impeller. This prevents torque impacts which can occur when the rotor is still running (even slightly) at the time of restart. The torque impacts can cause significant damages on components (rotor, bearings and belt pulleys).

4.4.3.4 Fan operation with variable speed control

If the fan has a variable speed control, observe the instructions in 5.6 Automatic operation of fan.
4.4.4 Disconnecting of fan

- Disconnection of fan → open power switch
- Let the fan coast brakeless.

![Warning]

Observe valid regulations, e.g. DIN VDE 0105.

When working on live parts, observe the following:

- Ensure that the fan is switched dead.
- Secure against restart and mark with relevant information sign.
- Check for and ensure dead condition.
- Connect to earth and short-circuit.
- Cover or secure by barrier adjacent alive parts.
5. Operation, Operating

5.1 General remarks

Specialist personnel only is permitted to start and disconnect the fan. The specialist personnel must be appointed by the person who is responsible for the system. Furthermore all instructions concerning the factory and the operation / operating of the operating company must be observed.

5.2 Safety instructions

Read the operating manual of the fan and the motor and observe the instructions and information.

5.3 Operational performance of the fan

During operation the fan must be checked regularly for:
- current consumption and voltage (values → rating plate),
- vibrations and noises (especially for rubbing noises) of the fan, (vibration monitoring → chapter 9.1.2 Limiting values vibrations),
- bearing temperatures by installed measuring device (warning– / disconnecting temperatures → chapter 9.1.3 Limiting values bearing temperatures),
- condition of the shaft sealing.

Check at fan standstill:
- alignment of the belt pulleys (→ chapter 3.6.4.3 Alignment of the belt pulleys)

Disconnect the fan when
- the rated values for current, voltage and temperature are exceeded,
- vibrations or increased noise levels occur on the fan,
- the shaft sealing leaks.
5.4 Disconnecting of fan

Disconnect the fan by opening the power switch
Let the fan coast brakeless.

Observe the valid regulations, e.g. German DIN VDE 0105.

When working on live parts, observe the following:
- Ensure that the fan is switched dead.
- Secure against restart and mark with relevant information sign.
- Check for and ensure dead condition.
- Connect to earth and short-circuit.
- Cover or secure by barrier adjacent live parts.

5.5 Emergency stop of fan

Automatic or semi-automatic operation

If the fan is installed in a ventilation system and is operated by automatic or semi-automatic control, it must be ensured that the fan can safely coast down to a standstill in case of an emergency shut-down. The fan itself is not provided with an emergency stop or power-off switch. The switch-off of the fan in case of emergency must be provided for in the control of the complete system. The operating company of the plant is responsible for the proper setting of the system control.

In case the fan is provided with monitoring devices, the emergency cut-off must be released as soon as the corresponding limit values have been achieved.

Possible parameter for maintenance are:
- bearing temperatures
- bearing vibrations
- condition of anti-friction bearings
- wear and tear of anti-friction bearings
- speed (fan and motor)
- sense of rotation
- temperature of handled gas
We differentiate between the following limit values:

- **prewarning**: further operation subject to constant monitoring
- **main alarm**: the fan must be disconnected immediately!

Unless otherwise prescribed by the motor manufacturer, the limit values for prewarning and disconnection at main alarm, that are indicated in chapter 9.1.2 Grenzwerte Schwingungen und Kapitel 9.1.3 Grenzwerte Lagertemperaturen are to be observed.

Observe the following instructions about the monitoring devices to avoid injury to persons, property damage and environmental harm:

- ensure proper functioning of the readings recorder, of the transmission electronics and of the evaluation unit
- immediately replace damaged or components that are no longer serviceable
- properly connect the maintenance devices to the control panel and carry out a functioning test
- set the measuring value accurateness and – tolerances in accordance with the limit values for pre-warning and disconnection
- select reasonable scaling dimensions adapted to the measuring range within the measuring values transmission chain, to ensure the highest possible resolution and to avoid measuring results falsification
- pre-warning must be shown at the control panel by flash on the display or light or acoustic signal
- main alarm must be shown at the control panel by flash on the display or light or acoustic signal **and** the fan must immediately be disconnected.
Carry out the following measures, when the limit values for prewarning and main alarm are achieved:

- Check the facts and find out the reasons
- Check the readings recorder, the sensor system, the evaluation units, etc.
- Immediately replace faulty sensors, reading recorders, etc.
- Check the impeller for sticking material, wear and tear, deformations, etc. and clean the impeller in case of stickings and replace it in case of wear and tear and deformations
- Check the bearings for oil level (at oil-lubricated bearings) or grease quantity (at grease-lubricated bearings)
- Check the anti-friction bearings for wear and tear and replace them if necessary
- Do not re-set the signal until the cause of the limit exceeding has been clearly identified
  **Attention:**
  Only the person or company responsible for the operation of the plant (operating company) may re-set the main alarm.
- Re-start the fan and check the machine's behaviour
- If the limit values for prewarning or main alarm (disconnection) are again exceed, carry out the described measures anew and immediately inform REITZ.

The monitoring devices serve to detect deviations from normal operation at an early stage and therefore to avoid damage to machine parts (e.g. bearings, impeller, shaft sealing, V-belt drives). Damages can be early determined with proper diagnostic units and replacement of parts can be easily scheduled.
5.6 Automatic operation of fan

5.6.1 Variable speed control with frequency converter

During automatic operation it must be ensured that the speed of the fan shaft does not oscillate around a preset value (periodic control behaviour) in order to avoid probable damage to the power train.

In addition, there must be enough time for the fan
- to start up until the operating or maximum speed is achieved
- to coast down from operating speed to standstill
- to change the operating point and hence the fan speed.

In order to avoid considerable loads, in particular speed accelerations and speed reductions in short periods of time, the variable speed control with frequency converter has to be set as “slow-reacting” as possible, so that symptoms of fatigue of impeller, shaft, etc. will be minimised. The additional alternating load that is generated by the control actions will be almost avoided, if the speed change velocities indicated below are observed (ramp times of the frequency converter).

The following classification applies (recommended values). The ramp time may not fall below the given values.

<table>
<thead>
<tr>
<th>fan speed: [min⁻¹]</th>
<th>ramp time: [s]</th>
</tr>
</thead>
<tbody>
<tr>
<td>750</td>
<td>38</td>
</tr>
<tr>
<td>1000</td>
<td>50</td>
</tr>
<tr>
<td>1200</td>
<td>60</td>
</tr>
<tr>
<td>1500</td>
<td>75</td>
</tr>
<tr>
<td>1800</td>
<td>90</td>
</tr>
<tr>
<td>3000</td>
<td>150</td>
</tr>
<tr>
<td>3600</td>
<td>180</td>
</tr>
</tbody>
</table>

Table: recommended values for ramp times

Irrespective the above, always consider the existing conditions of the individual application case (mass moment inertia of the impeller and the complete rotating unit, start up and acceleration behaviour of the drive, current consumption, process-friendly control behaviour, etc.)
5.6.2 Natural frequency of the impeller

Resonances cannot be excluded since each fan component, in particular the impeller, has a natural frequency that can be excited at certain fan speeds.

We design and construct our fans so that resonances generally do not occur in operation at constant rated speed.

If the fan is variable speed controlled, each change in speed (frequency) can result in an excitation. Additional excitations through the frequency converter control are also possible. If natural frequencies of the components lie within the speed range of the fan, these must be skipped when the variable speed control is parameterised.

5.6.3 Parameterising the variable speed control

If the fan including the variable speed control has been delivered by Reitz, the factory-provided parameterisation has to be kept. Any changes of the originally supplied parameterisation will invalidate any claim on our warranty. Changes in or improper parameterisation may lead to
- operation behaviour that is not free-from-vibration as per DIN IS 10816-3
- fatigue failure of impeller
- resonance vibrations on various components
- damage of components of the power train because the fan is started-up and decelerated too quickly or due to too frequent changes in operating points.

5.6.4 Speed control range

We recommend not falling below a speed control range of 1:10 in order to maintain proper greasing of the bearing. In particular, torsional vibrations of the power train may arise in the range of 5 Hz output frequency of the variable speed control. This range is therefore to be provided.

We recommend having the parameterisation and commissioning done by a REITZ service technician.
5.7 Separate ventilation

If the fan is provided with a separate cooling fan, observe the following:

- If the fan is switched-on, the cooling fan must be in uninterrupted operation.
- Connect the ventilation fan to the electric power supply in accordance with the separate instructions of the manufacturer → observe the indications for voltage supply and current consumption. If the instructions of the manufacturer are not available, request them from REITZ immediately.
- If the ventilation air fan fails, immediately switch off the main fan.

It is not permitted to operate the fan without the simultaneous operation of the ventilation air fan. Irrespective of the operation condition and speed of the fan, the ventilation air fan has to continuously provide sufficient cooling air. Insufficient cooling might lead to excessive warming of the fan shaft and subsequently to bearing damage. This in turn may result in fan failure and breakdown of the overall system.

Figure 21 → exemplary representation of fan with cooling air fan
6. Trouble, Repair

6.1 General remarks

The repair of troubles on the fan must only be carried out by specialist personnel that is appointed by the person who is responsible for the system.

When trouble shooting is carried out, the entire surroundings of the fan (equipment, motor, variable speed control, foundation, kind of installation, switchboard plant, etc.) must be taken into account.

Observe the particular instructions in the operating manuals of the motor and variable speed control producers.

If damages occur during the warranty period, contact the manufacturer.

6.2 Safety instructions

When trouble shooting or repair is carried out, observe the following:

- valid regulations, e.g. German DIN VDE 0105
- regulation for the prevention of accidents, e.g. German regulations BGV A1 and BGV A3

- Ensure that the fan is switched dead.
- Secure against restart and mark with relevant information sign.
- Check for and ensure dead condition.
- Connect to earth and short-circuit the fan.
- Cover or secure by barrier adjacent live parts.
- Ensure that the impeller is at standstill and cannot be set unintentionally into motion.

Attention:
Stack draught or other air draught in the connected duct work may set the impeller in motion.
### 6.3 Troubles

<table>
<thead>
<tr>
<th>Troubles</th>
<th>Possible cause</th>
<th>Remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>unsteady run of fan</td>
<td>material sticking to impeller blades.</td>
<td>clean impeller carefully</td>
</tr>
<tr>
<td></td>
<td>impeller worn out</td>
<td>exchange impeller</td>
</tr>
<tr>
<td></td>
<td>impeller deformed by thermal effect</td>
<td>exchange impeller</td>
</tr>
<tr>
<td></td>
<td>distortion of fan by uneven foundation</td>
<td>loosen foundation fastenings and level foundation, subsequently re-fasten the fan</td>
</tr>
<tr>
<td></td>
<td>improper adjustment of the anti-vibration mounts or of the anti-vibration mounts (spring-type)</td>
<td>correct adjustment</td>
</tr>
<tr>
<td></td>
<td>stress due to incorrect installation of the ductwork</td>
<td>use flexible connections for the ducting</td>
</tr>
<tr>
<td>handled gas leaks from the shaft sealing</td>
<td>seal defective or worn out</td>
<td>exchange sealing</td>
</tr>
<tr>
<td>rubbing noises from the fan</td>
<td>impeller rubs against inlet.</td>
<td>loosen top part of housing and readjust, if required, check ducting and readjust it</td>
</tr>
<tr>
<td></td>
<td>motor noise</td>
<td>check motor for bearing damages, if required, exchange bearings</td>
</tr>
<tr>
<td>the current consumption stated on the motor name plate is exceeded permanently</td>
<td>handled gas volume too high</td>
<td>reduce the flow volume by using a damper until the permitted current consumption is reached</td>
</tr>
<tr>
<td></td>
<td>different speed due to 60 Hz network</td>
<td>check frequency</td>
</tr>
<tr>
<td>fan does not start up</td>
<td>incorrect electric connection of the motor</td>
<td>check electric connection</td>
</tr>
<tr>
<td></td>
<td>trouble with star-delta starting, motor stops acceleration during star connection</td>
<td>reduce change-over time from star to delta</td>
</tr>
<tr>
<td></td>
<td>start-up against too low system resistance</td>
<td>close dampers or install additional plate shutters</td>
</tr>
<tr>
<td></td>
<td>design of motor protective system insufficient</td>
<td>cable cross section and motor protective system must be designed for the starting current during the complete start-up</td>
</tr>
<tr>
<td></td>
<td>start-up time takes too long</td>
<td>close dampers, check starting torque of the motor $M_{A}/M_{N}$</td>
</tr>
<tr>
<td></td>
<td>drive motor defective</td>
<td>check motor and exchange, if required</td>
</tr>
<tr>
<td></td>
<td>motor too warm due to high connecting frequency</td>
<td>choose permanent operation of the fan and control the flow with dampers or variable speed control</td>
</tr>
<tr>
<td></td>
<td>starting current too high</td>
<td>incorrect voltage provide for star-delta start-up, insufficient local power supply</td>
</tr>
</tbody>
</table>

Table 6
### 6.3.1 Bearing troubles

<table>
<thead>
<tr>
<th>Trouble</th>
<th>Possible cause</th>
<th>Remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>unsteady run</td>
<td>damages on bearing races and rollers / balls, bearing clearance too large</td>
<td>exchange bearings.</td>
</tr>
<tr>
<td></td>
<td>wear caused by dirt or insufficient lubrication</td>
<td>protect bearings against contamination, use clean grease only</td>
</tr>
<tr>
<td>extraordinary running noise</td>
<td></td>
<td></td>
</tr>
<tr>
<td>wailing or whistling noise</td>
<td>bearing clearance too small</td>
<td>use bearings with higher clearance</td>
</tr>
<tr>
<td>rumbling or irregular noise</td>
<td>bearing clearance too high, damages on bearing rolling surfaces, dirt</td>
<td>exchange bearings</td>
</tr>
<tr>
<td></td>
<td>inappropriate lubricant</td>
<td>use appropriate grease only.</td>
</tr>
<tr>
<td>gradual change of running noise</td>
<td>bearing clearance is changed by thermal influences damages on the bearing races (e.g. caused by contamination or material fatigue)</td>
<td>protect bearings against temperature</td>
</tr>
</tbody>
</table>

**Table 7**
## 6.3.2 V-belt drive troubles

<table>
<thead>
<tr>
<th>Trouble</th>
<th>Possible cause</th>
<th>Remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>belt breaks shortly after installation</td>
<td>force applied during installation, tensioning strand is damaged</td>
<td>allow belt to be installed as indicated in the instructions (apply them loosely)</td>
</tr>
<tr>
<td>(torn belt)</td>
<td>foreign matter causes damage during operation</td>
<td>install a guard</td>
</tr>
<tr>
<td></td>
<td>blocked drive</td>
<td>eliminate the cause</td>
</tr>
<tr>
<td>cracks and fractures in the V-belt</td>
<td>excessive heat</td>
<td>eliminate radiant sources, shield off the belt; improve air circulation; shield off the drive</td>
</tr>
<tr>
<td>substructure (embrittlement)</td>
<td>excessive cold</td>
<td>use special type of belt</td>
</tr>
<tr>
<td></td>
<td>increase slipping of belt</td>
<td>tension the belt as per mounting instructions</td>
</tr>
<tr>
<td></td>
<td>chemical attack</td>
<td>use special type of belt</td>
</tr>
<tr>
<td>strong vibrations</td>
<td>insufficient belt tension</td>
<td>check belt tension and increase it if necessary</td>
</tr>
<tr>
<td></td>
<td>pulleys are not aligned</td>
<td>align the belt pulleys</td>
</tr>
<tr>
<td></td>
<td>unbalanced belt pulleys</td>
<td>balance the pulleys</td>
</tr>
<tr>
<td>twisted V-belts</td>
<td>pulleys are not aligned</td>
<td>align the pulleys.</td>
</tr>
<tr>
<td></td>
<td>wrong belt/groove profile</td>
<td>match up belt and groove profile.</td>
</tr>
<tr>
<td></td>
<td>heavily worn out pulley grooves</td>
<td>exchange pulleys</td>
</tr>
<tr>
<td></td>
<td>excessive vibrations</td>
<td>tension the drive</td>
</tr>
<tr>
<td></td>
<td>insufficient tension</td>
<td>check belt tension and increase it if necessary</td>
</tr>
<tr>
<td></td>
<td>foreign matter in the belt grooves</td>
<td>remove foreign matter and shield off the drive</td>
</tr>
</tbody>
</table>
| Continued on next page
### V-belt disorders (continued)

<table>
<thead>
<tr>
<th>Disorder</th>
<th>Possible cause</th>
<th>Remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>unusual wear of belt flanks</td>
<td>wrong groove angle</td>
<td>re-machine or re-place pulleys</td>
</tr>
<tr>
<td></td>
<td>worn out pulley grooves</td>
<td>replace pulleys</td>
</tr>
<tr>
<td></td>
<td>wrong belt/groove profile</td>
<td>match up belt and groove profile</td>
</tr>
<tr>
<td></td>
<td>pulleys are not aligned</td>
<td>align pulleys</td>
</tr>
<tr>
<td></td>
<td>insufficient belt tension</td>
<td>check belt tension and increase it if necessary</td>
</tr>
<tr>
<td></td>
<td>belt rubs or hits against other</td>
<td>remove the interfering components; re-align the drive</td>
</tr>
<tr>
<td></td>
<td>components</td>
<td></td>
</tr>
<tr>
<td>irregular noise</td>
<td>pulleys are not aligned</td>
<td>align pulleys</td>
</tr>
<tr>
<td></td>
<td>insufficient belt tension</td>
<td>check belt tension and increase it if necessary</td>
</tr>
<tr>
<td></td>
<td>drive is overloaded</td>
<td>check drive ratios and adapt it to operating conditions</td>
</tr>
<tr>
<td>belt feels spongy and benzene sticky</td>
<td>belt is affected by oil, grease and chemicals</td>
<td>replace the belts; clean pulleys with naphtha before new belts are installed</td>
</tr>
<tr>
<td>uneven lengthening of the belt</td>
<td>faulty pulley grooves</td>
<td>replace pulleys</td>
</tr>
<tr>
<td></td>
<td>set of belts consists of used and new belts</td>
<td>always replace complete set of belts</td>
</tr>
<tr>
<td></td>
<td>set of belts consists of different belt types</td>
<td>only use one make of belts in a set of types</td>
</tr>
</tbody>
</table>
7. Maintenance

7.1 General remarks

- All maintenance and service works on the fan may only be carried out by specialist personnel that is appointed by the person who is responsible for the plant, see chapter 2.8 Qualified person and chapter 2.9 Personal protective equipment.

- Please observe the maintenance instructions for the electric drive as indicated in the operating manuals of the motor producers.

- Observe specified maintenance intervals and use specified lubricants and lubricant quantities only.

- Collect used oil, used grease and/or cleaning rags contaminated with oil / grease in containers correspondingly marked and take care for proper disposal.

- Check all securing components of the screwed connections and exchange them for the new securing components, if required.
7.2 Safety instructions

- Carry out maintenance works (lubrication works excepted) at standstill of the fan only, maintenance works see chapter 7.10 Maintenance schedule.

- Ensure that the fan is secured against restart and marked by a corresponding information sign.

- Observe the safety instructions and the regulations for prevention of accidents of the relevant manufacturers when oil / lubricants, detergents or spare parts are used.

- Maintenance works on the electric connections of the fan or on electric auxiliary / control connections must exclusively be carried out by professional electricians who have to observe the valid regulations (e.g. German DIN VDE 0105)

- Ensure that the fan is switched dead.

- Secure against restart and mark with corresponding information sign.

- Check for and ensure dead condition.

- Connect to earth and short-circuit.

- Cover or secure by barrier live parts.

- Ensure that the impeller is at standstill and cannot be set unintentionally into motion.

Attention:
Stack draught or other air draught in the connected duct work may set the impeller in motion.
7.3 Bearings

This chapter describes the standard bearing design. If an individual bearing solution applies, the special bearings are described in a separate “supplement to the operating manual” or in an “order-related operating manual.

Depending on the design type, the fan shaft runs
- In two grease-lubricated anti-friction bearings in single bearing housings or
- In two grease-lubricated anti-friction bearings in a multiple bearing block.
7.3.1 Anti-friction bearings

Maintenance of the anti-friction bearings:

- monitoring of the bearing temperature during operation,
- check of the bearings for running noises and vibrations
- lubrication of the anti-friction bearings,
- exchange of bearings.

If increased bearing temperatures (→ chapter 9.1.3 Limiting values bearing temperatures) or running noises and / or vibrations (→ chapter 9.1.2 Limiting values vibrations) occur during operation, disconnect the fan immediately to avoid consequential losses.

Remove bearings and check them for damages.

If the bearing shows dark discoloured, dull, coarse or polished looking parts of the bearing races and / or of the rollers / balls, install a new bearing.

Bearings removal / installation by Reitz-service staff only.

If the removal / installation of the bearings are carried out by the operating company, only the bearings recommended or delivered by the bearing manufacturer must be installed. Furthermore the installation instructions of the manufacturer must be observed.

Only install bearings of the same type and clearance range, for type of bearing see nameplate.

When ordering spare parts, specify fan type and serial number (→ nameplate).

Check and document the bearing temperature and vibration velocity at the bearing regularly, but at least once a week in order to maintain the operational reliability and availability of the fan. If necessary, take measures such as maintenance at bearings, belt drive, motor or impeller.
7.3.1.1 Lubrication instructions
anti-friction bearings in single
bearing housings

The anti-friction bearings are to be lubricated during operation with the indicated quantity and grease type at the lubrication nipples M10x1 at the
- non-driven end and
- driven end.

Lubrication intervals, grease quantity and grease type see plate "Maintenance of the bearings".

The bearing temperature may increase after re-greasing for a few hours. After the grease has reached the operating consistency the values return to normal level.

Used grease must be disposed of in a safe manner consistent with all applicable regulations and in an environmentally compatible way.

Figure 22  anti-friction bearings design single bearing housing
### Table 8 Lubrication intervals of anti-friction bearings in single bearing housings

<table>
<thead>
<tr>
<th>housing</th>
<th>anti-friction bearings</th>
<th>lubricating intervals (operating hours)</th>
<th>grease quantity*</th>
<th>grease quantity for re-lubrication per anti-friction bearing (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>$n_L = 3000 \text{ min}^{-1}$</td>
<td>$n_L = 1500 \text{ min}^{-1}$</td>
<td>$n_L = 1000 \text{ min}^{-1}$</td>
</tr>
<tr>
<td>SNB/SNV</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>type with clamping sleeve – tapered bearing</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>607/080</td>
<td>2307K</td>
<td>4000</td>
<td>4000</td>
<td>4000</td>
</tr>
<tr>
<td>608/090</td>
<td>2308K</td>
<td>3600</td>
<td>4000</td>
<td>4000</td>
</tr>
<tr>
<td>609/100</td>
<td>2309K</td>
<td>3200</td>
<td>4000</td>
<td>4000</td>
</tr>
<tr>
<td>610/110</td>
<td>2310K</td>
<td>2950</td>
<td>4000</td>
<td>4000</td>
</tr>
<tr>
<td>611/120</td>
<td>2311K</td>
<td>2700</td>
<td>4000</td>
<td>4000</td>
</tr>
<tr>
<td>612/130</td>
<td>2312K</td>
<td>2500</td>
<td>4000</td>
<td>4000</td>
</tr>
<tr>
<td>613/140</td>
<td>2313K</td>
<td>2250</td>
<td>4000</td>
<td>4000</td>
</tr>
<tr>
<td>615/160</td>
<td>2315K</td>
<td>2000</td>
<td>3800</td>
<td>4000</td>
</tr>
<tr>
<td>616/170</td>
<td>2316K</td>
<td>1900</td>
<td>3600</td>
<td>4000</td>
</tr>
<tr>
<td>617/180</td>
<td>2317K</td>
<td>1800</td>
<td>3400</td>
<td>4000</td>
</tr>
<tr>
<td>618/190</td>
<td>2318K</td>
<td>1700</td>
<td>3300</td>
<td>4000</td>
</tr>
<tr>
<td>619/200</td>
<td>2319K</td>
<td>1600</td>
<td>3100</td>
<td>4000</td>
</tr>
<tr>
<td>515/130</td>
<td>22215K</td>
<td>-</td>
<td>800</td>
<td>1350</td>
</tr>
<tr>
<td>516/140</td>
<td>22216K</td>
<td>-</td>
<td>750</td>
<td>1250</td>
</tr>
<tr>
<td>517/150</td>
<td>22217K</td>
<td>-</td>
<td>700</td>
<td>1200</td>
</tr>
<tr>
<td>518/160</td>
<td>22218K</td>
<td>-</td>
<td>650</td>
<td>1100</td>
</tr>
<tr>
<td>519/170</td>
<td>22219K</td>
<td>-</td>
<td>580</td>
<td>1000</td>
</tr>
<tr>
<td>520/180</td>
<td>22220K</td>
<td>-</td>
<td>540</td>
<td>950</td>
</tr>
<tr>
<td>522/200</td>
<td>22222K</td>
<td>-</td>
<td>460</td>
<td>850</td>
</tr>
<tr>
<td>524/215</td>
<td>22224K</td>
<td>-</td>
<td>410</td>
<td>750</td>
</tr>
<tr>
<td><strong>type without clamping sleeve – cylindrical bearing</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>315/160</td>
<td>2315</td>
<td>2000</td>
<td>3800</td>
<td>4000</td>
</tr>
<tr>
<td>316/170</td>
<td>2316</td>
<td>1900</td>
<td>3600</td>
<td>4000</td>
</tr>
<tr>
<td>317/180</td>
<td>2317</td>
<td>1800</td>
<td>3400</td>
<td>4000</td>
</tr>
<tr>
<td>318/190</td>
<td>2318</td>
<td>1700</td>
<td>3300</td>
<td>4000</td>
</tr>
<tr>
<td>319/200</td>
<td>2319</td>
<td>1600</td>
<td>3100</td>
<td>4000</td>
</tr>
<tr>
<td>218/160</td>
<td>22218</td>
<td>-</td>
<td>650</td>
<td>1100</td>
</tr>
<tr>
<td>220/180</td>
<td>22220</td>
<td>-</td>
<td>540</td>
<td>1100</td>
</tr>
<tr>
<td>222/200</td>
<td>22222</td>
<td>-</td>
<td>460</td>
<td>850</td>
</tr>
<tr>
<td>224/215</td>
<td>22224</td>
<td>-</td>
<td>410</td>
<td>750</td>
</tr>
<tr>
<td>226/230</td>
<td>22226</td>
<td>-</td>
<td>380</td>
<td>680</td>
</tr>
<tr>
<td>228</td>
<td>22228</td>
<td>-</td>
<td>350</td>
<td>600</td>
</tr>
</tbody>
</table>

* grease quantity for first or new filling per bearing

The quantity listed in the table must be re-greased in order to ensure that all parts of the bearing are provided with new grease during re-grease process.
7.3.1.2 Lubrication instructions
anti-friction bearings in a multiple bearing block

The anti-friction bearings are to be lubricated during operation with the indicated quantity and grease type at the lubrication nipples M10x1 at the
- non-driven end and
- driven end.

Lubrication intervals, grease quantity and grease type see plate “Maintenance of the bearings”.

The bearing temperature may increase after re-greasing for a few hours. After the grease has reached the operating consistency the values return to normal level.

Replacement of lubricant

Grease quantity control devices govern the quantity of grease in the anti-friction bearings. They provide the bearings with the proper quantity of grease. Spare grease remains in the bearing housings. After the bearings were re-greased approximately ten times with the quantity that is indicated for the respective bearing type in the table “Lubrication intervals and quantity”, the used grease must be removed from the bearing completely and the bearing must be re-filled with new grease (see table “Lubrication intervals and quantities” on page 7.4).

When re-greasing, it has to be ensured that the grease quantity indicated in the said table is applied (weighing).

Used grease must be disposed of in a safe manner consistent with all applicable regulations and in an environmentally compatible way.

Figure 23 ➔ anti-friction bearings design multiple bearing block
Table 9 Lubrication intervals and quantities multiple bearing blocks

multiple bearing block AA und AK

The exact designation of the multiple bearing block is indicated in the fan data sheet (→ chapter 1.2).

<table>
<thead>
<tr>
<th>Housing</th>
<th>Non-locating bearing</th>
<th>Locating bearing</th>
<th>Lubrication intervals (operating hours) ( n_L ) [min(^{-1})]</th>
<th>① first filling or re-filling</th>
<th>re-lubrication quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZLG</td>
<td></td>
<td></td>
<td>( \leq 3600 )</td>
<td>( &gt; 3000 )</td>
<td>( \leq 1800 )</td>
</tr>
<tr>
<td>306</td>
<td>6306</td>
<td>6306</td>
<td>5080</td>
<td>6760</td>
<td>10150</td>
</tr>
<tr>
<td>307</td>
<td>6307</td>
<td>6307</td>
<td>4500</td>
<td>6000</td>
<td>9000</td>
</tr>
<tr>
<td>308</td>
<td>6308</td>
<td>6308</td>
<td>3980</td>
<td>5300</td>
<td>7950</td>
</tr>
<tr>
<td>309</td>
<td>6309</td>
<td>6309</td>
<td>3570</td>
<td>4760</td>
<td>7150</td>
</tr>
<tr>
<td>310</td>
<td>6310</td>
<td>6310</td>
<td>3230</td>
<td>4300</td>
<td>6450</td>
</tr>
<tr>
<td>311</td>
<td>6311</td>
<td>6311</td>
<td>2960</td>
<td>3940</td>
<td>5900</td>
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<tr>
<td>312</td>
<td>6312</td>
<td>6312</td>
<td>2720</td>
<td>3630</td>
<td>5450</td>
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<tr>
<td>313</td>
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<td>6313</td>
<td>2520</td>
<td>3360</td>
<td>5050</td>
</tr>
<tr>
<td>314</td>
<td>6314</td>
<td>6314</td>
<td>2350</td>
<td>3130</td>
<td>4700</td>
</tr>
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<td>6315</td>
<td>6315</td>
<td>2200</td>
<td>2940</td>
<td>4400</td>
</tr>
<tr>
<td>316</td>
<td>6316</td>
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<td>2760</td>
<td>4150</td>
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<td>317</td>
<td>6317</td>
<td>6317</td>
<td>--</td>
<td>2600</td>
<td>3900</td>
</tr>
<tr>
<td>318</td>
<td>6318</td>
<td>6318</td>
<td>--</td>
<td>2460</td>
<td>3700</td>
</tr>
<tr>
<td>319</td>
<td>6319</td>
<td>6319</td>
<td>--</td>
<td>2340</td>
<td>3500</td>
</tr>
<tr>
<td>320</td>
<td>6320</td>
<td>6320</td>
<td>--</td>
<td>2190</td>
<td>3300</td>
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<tr>
<td>322</td>
<td>6322</td>
<td>6322</td>
<td>--</td>
<td>1950</td>
<td>3100</td>
</tr>
<tr>
<td>324</td>
<td>6322</td>
<td>6324</td>
<td>--</td>
<td>1800</td>
<td>2880</td>
</tr>
</tbody>
</table>

multiple bearing block design AC

The exact designation of the multiple bearing block is indicated in the fan data sheet. (→ chapter 1.2).

<table>
<thead>
<tr>
<th>Housing</th>
<th>Non-locating bearing</th>
<th>Locating bearing</th>
<th>Lubrication intervals (operating hours) ②</th>
<th>① first filling or re-filling</th>
<th>re-lubrication quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZLG</td>
<td></td>
<td></td>
<td>( \leq 3600 )</td>
<td>( &gt; 3000 )</td>
<td>( \leq 1800 )</td>
</tr>
<tr>
<td>315</td>
<td>NJ 315</td>
<td>6315</td>
<td>--</td>
<td>1700</td>
<td>2600</td>
</tr>
<tr>
<td>316</td>
<td>NJ 316</td>
<td>6316</td>
<td>--</td>
<td>1600</td>
<td>2500</td>
</tr>
<tr>
<td>317</td>
<td>NJ 317</td>
<td>6317</td>
<td>--</td>
<td>1500</td>
<td>2350</td>
</tr>
<tr>
<td>318</td>
<td>NJ 318</td>
<td>6318</td>
<td>--</td>
<td>1300</td>
<td>2100</td>
</tr>
<tr>
<td>319</td>
<td>NJ 319</td>
<td>6319</td>
<td>--</td>
<td>1220</td>
<td>1860</td>
</tr>
<tr>
<td>320</td>
<td>NJ 320</td>
<td>6320</td>
<td>--</td>
<td>1100</td>
<td>1750</td>
</tr>
<tr>
<td>322</td>
<td>NJ 322</td>
<td>6322</td>
<td>--</td>
<td>1000</td>
<td>1600</td>
</tr>
<tr>
<td>324</td>
<td>NJ 324</td>
<td>6324</td>
<td>--</td>
<td>930</td>
<td>1470</td>
</tr>
</tbody>
</table>

① basic grease quantity for the anti-friction bearing, not to be supplied by re-greasing
② refers to the cylindrical roller bearing
7.3.1.3 Remarks on lubrication intervals

<table>
<thead>
<tr>
<th>lubrication intervals for other temperatures</th>
</tr>
</thead>
<tbody>
<tr>
<td>temperature bearing housing</td>
</tr>
<tr>
<td>75° C</td>
</tr>
<tr>
<td>80° C</td>
</tr>
<tr>
<td>85° C</td>
</tr>
<tr>
<td>90° C</td>
</tr>
<tr>
<td>95° C</td>
</tr>
<tr>
<td>100° C</td>
</tr>
</tbody>
</table>

Table 10

7.3.2 Information on lubrication grease

The bearings are filled with proper operational grease quantities and ready for operation. Standard lubricants are shown in the following list. In case other lubricants are used, these are stipulated in the "supplements to the operating manual" or in an individual order-related operating manual. Take the type of grease from the plate „Maintenance of the bearings“ Grease type in accordance with Table 11 Other types of grease are not permitted.

Table 11

Lubricants must be disposed of in a safe manner consistent with all applicable regulations and in an environmentally compatible way.
7.4 Shaft seal

Depending on the individual requirements the fan can be equipped with different seal systems.
If heightened temperatures or running noises occur at the shaft sealing during operation, immediately switch down the fan to prevent subsequent damage.

7.4.1 Standard seal

Shaft seal with soft fibre ring (eg UNITEC 300) for a temperature range up to +180°C

Figure 24 → presentation of shaft seal

7.4.2 Shaft seal with graphite ring

Shaft seal with cramped graphite-ring in sheet metal housing
The seal with cramped graphite ring must be re-lubricated monthly. Apply a small quantity of lubrication oil into the clearance between the seal and shaft by oil can.

Figure 25 → presentation of shaft seal
7.4.3 Seal with special rings

The shaft seal can be provided with one or two graphite rings. This type of seal is also called labyrinth seal.

Lubrication of this sealing type is not possible.

Figure 26 → Presentation of shaft seal with one graphite ring

7.4.4 Shaft seal with grease barrier

For improving the leak tightness a grease barrier can be used. The grease barrier reduces the gas penetration through the shaft seal.

Usage of the lubricator enables a maintenance-fee operation of approximately 3 months.

Figure 27 → Presentation of shaft seal

7.4.5 Shaft seal with barrier gas

If barrier gas is used, it must be ensured that the pressure of the barrier gas is always higher than the pressure at the shaft seal that is created by the fan operation. Vacuum operation means higher barrier gas pressure than the maximum static pressure increase, pressure operation means higher barrier gas pressure than the total pressure increase.

It is obligatory to observe the instructions of the seal manufacturer.

Please note: Request technical data regarding minimum and maximum barrier gas pressure from the manufacturer.

Equal or lower barrier gas pressure would enable the penetration of solid matters into the sealing system and therewith an increased wear or, in the worst case, a total breakdown of the seal could be caused.

Monitor the barrier gas consumption or the leakage continuously. A significant increase of the values points out wear of the sealing rings and / or repair.

While carrying out inspection works, the shaft seal must be checked for damages (e.g. corrosion) and must be cleaned.

If sealing components are damaged (scratches, cracks, dents) the complete seal set must be renewed.

Figure 28 → presentation of shaft seal
7.4.6 Shaft seal of type REW6 (Ø 40 to Ø 120)

The shaft seal of type REW6 can be used up to a seal diameter of 120mm. It is suitable for dry running and do not require any lubrication.

The sealing rings are radially cut into several sections and held together by means of a surrounding hose spring.

If it is necessary to replace the sealing rings, please observe the separate mounting instruction of the manufacturer.

Further mounting remarks:

Seal the housing halves with non-adhesive sealing compound (e.g. Epple Stukarit 203 or sealing grease E600N). The radial shaft centre offset of the shaft may not exceed ± 1.5 mm

7.4.7 Shaft seal of type REW6 (Ø 140 to Ø 240)

The shaft seal of type REW6 can be used up to a seal diameter of 120mm. It is suitable for dry running and do not require any lubrication.

The sealing rings are radially cut into several sections and held together by means of a surrounding hose spring.

If it is necessary to replace the sealing rings, please observe the separate mounting instruction of the manufacturer.
7.5 Shaft earthing

If the fan is provided with a shaft earthing, check the correct functioning regularly. There must be no gap between sliding contact (e.g. carbon brush) and shaft. Choose the revision intervals based on the operation conditions. We recommend function checks every quarter of the year. Spare parts like carbon brush, holders, etc. can be ordered from REITZ (indicate serial fan number).

If a protection device covers the shaft earthing, please mark the guard with a corresponding sign.

Figure 31: exemplary representations of shaft earthings

Proper setting of shaft earthing:

Set the holder of the carbon brush so that there is a minimum gap of 2mm between holder and shaft when the carbon brush is removed from the holder (see Figure 32). This ensures that the holder cannot get in contact with the shaft and hence excludes possible spark formation.

Adjust the holder so that the overall sliding contact of the carbon brush is centrically to the shaft. The centre line of the carbon brush must run through the shaft centre.

Pull back the holder and insert the carbon brush. The spring tension force is at maximum with a new carbon brush and will decrease with the increasing wear of the carbon brush.

Replacement of carbon brush (Adhere to minimum size):

The carbon brush has to be replaced when its minimum size is less than 3mm; that is to say that a minimum thickness of 3mm must project from the holder at all points of the brush.
7.6 V-belt drive

7.6.1 General remarks

Switch off the fan prior to any maintenance and general servicing works and secure the fan against re-start.

Inspect the V-belt drive in regular intervals.

Always replace the complete set of belts if one or more drive belts of a multiple-belt drive system fail.

Do not use different makes of drive belts in one set of belts. Do not use belt wax or belt spray.

Remove all deposits from the pulley rim.

7.6.2 Belt tension

Check the belt tension at standstill of fan only and observe the safety instructions.

Remove the V-belt protection box for checking the belt tension. Use a standard tension measuring instrument to determine the deflection $E_a$. Compare the measured value with the table (see page 7.15).

Refer to the presentation on the left as example of the measuring method and device.

Increase the tension of the belt if it can be pushed in or pulled out too far.

Install the V-belt protection box before re-starting the fan.

Figure 33 → example of a measuring method
Guide values for belt tension

Guide values for the deflection of V-belts as a function of the applied testing force and the distance between pulley centres (simplified method).

<table>
<thead>
<tr>
<th>Profile</th>
<th>Testing force per V-belt f (N)</th>
<th>Diameter of small pulley dK (mm)</th>
<th>Deflection of belt 'Ea' in mm with a distance between centres 'A' in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>500 630 800 1000 1250 1600 2000 2500 3150</td>
</tr>
<tr>
<td>SPZ</td>
<td>25</td>
<td>&gt;100 ≤ 125</td>
<td>14 17 22 28 34 44 55 - -</td>
</tr>
<tr>
<td></td>
<td></td>
<td>&gt;140 ≤ 160</td>
<td>13 16 20 25 31 40 50 63 - -</td>
</tr>
<tr>
<td></td>
<td></td>
<td>&gt;180 ≤ 200</td>
<td>11 14 18 22 28 36 45 56 71</td>
</tr>
<tr>
<td>SPA</td>
<td>50</td>
<td>&gt;180 ≤ 200</td>
<td>15 19 24 30 38 48 60 75 95</td>
</tr>
<tr>
<td></td>
<td></td>
<td>&gt;224 ≤ 250</td>
<td>13 16 20 25 31 40 50 63 79</td>
</tr>
<tr>
<td>SPB</td>
<td>75</td>
<td>&gt;224 ≤ 250</td>
<td>15 19 24 30 38 48 60 75 95</td>
</tr>
<tr>
<td></td>
<td></td>
<td>&gt;280 ≤ 355</td>
<td>15 19 24 30 38 48 60 75 95</td>
</tr>
<tr>
<td>SPC</td>
<td>125</td>
<td>&gt;315 ≤ 355</td>
<td>15 19 24 30 38 48 60 75 95</td>
</tr>
<tr>
<td></td>
<td></td>
<td>400</td>
<td>14 17 22 28 34 44 55 69 87</td>
</tr>
<tr>
<td></td>
<td></td>
<td>450</td>
<td>13 16 20 25 31 40 50 63 79</td>
</tr>
<tr>
<td></td>
<td></td>
<td>500</td>
<td>11 14 18 22 28 36 45 56 71</td>
</tr>
</tbody>
</table>

Figure 34

A = distance between pulley centres in mm
f = testing force per V-belt in N
E = deflection per 100 mm distance between centres in mm
Ea = deflection of the belt strand

\[ E_a \approx \frac{E \cdot A}{100} \text{ [mm]} \]

Figure 34 → Belt tension
7.7 Marking, information sign

The marking / information signs must be:

- cleaned with a rag,
- checked for tight fastening and legibility.

Legend:
1 name plate  
2 sense of rotation arrow  
3 warning notice inspection opening (optional)  
4 sign “Maintenance of the bearings”  
5 motor nameplate  
6 earthing clamps (optional)  
7 sign “danger symbols with explanations”  
8 sign “Read operation manual”  
9 sign “Attention – do not weld”

Figure 35 → Example for markings

The fan can be designed for use in potentially explosive atmosphere. An individual nameplate then indicates the equipment group and category as per directive 94/9/EC (ATEX)

Figure 36 → example of an ATEX individual nameplate
7.8 Waste disposal

Collect used oil, used grease or cleaning rags / wool contaminated with oil / grease in containers correspondingly marked and dispose of them in a safe manner consistent with all applicable regulations and in an environmentally compatible way.

7.9 Revision

The required examinations and maintenance of fans that are designed in accordance with directive 94/9/EC may only be carried out by qualified personnel.

In general, half-yearly up to yearly revision intervals should be sufficient under the conditions that:

- all checks in the course of the commissioning / start-up and the maintenance works were carried out properly and in due time, and
- each serious constitutional change that were recognized by the continuous operation monitoring has been systematically investigated and repaired.
# 7.10 Maintenance schedule

<table>
<thead>
<tr>
<th>Structural component</th>
<th>Daily</th>
<th>Weekly</th>
<th>Quarterly</th>
<th>Yearly</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Impeller</strong></td>
<td>An inspection of the impeller must be carried out immediately, if</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>- the permissible limiting values (see chapter 9.1.2 Limiting values vibrations) are exceeded,</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>- changed impeller noises occur.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Examine the impeller every 5,000 operating hours and check it for alteration (cracks, geometric alterations, balancing condition, wear and sticking material), but at least once a year.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Check the impeller e.g. by non-destructive crack testing.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Fans that are subject to high dynamical stresses are to be checked in accordance with the additional agreement (maintenance schedule) within the prescribed intervals.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Bearings</strong></td>
<td>An inspection of the bearings must be carried out immediately, if</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>- the permissible limiting values (see chapter 9.1.2 Limiting values vibrations and 9.1.3 Limiting values bearing temperatures) are exceeded,</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>- changed running noises occur</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>- unusual alterations of the lubricant occur</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>- check the fixation of the bearing foot and re-tighten the screws if necessary</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Re-lubrication intervals acc. to plate “Maintenance of the bearings” (see chapter 7.3.1.3 Remarks on lubrication intervals)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Shaft Seal</strong></td>
<td>The shaft sealing rings have to be checked and exchanged if the barrier gas consumption or leakage increases. Exchange the shaft seal ring when the rings are worn or damaged. If the seal ring consists of more than one part, replace the full seal ring set.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Shaft Earthing</strong></td>
<td>Check the correct functioning of the shaft earthing regularly and in dependence of the operating conditions and replace it, if required. Check the function monthly.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Condensate Drain</strong></td>
<td>Drain the accumulated condense water in regular intervals or when required in a suitable drain receptacle and dispose of it in an environmentally compatible way.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>V-Belt Drive</strong></td>
<td>Check the belt tension after the first 50 operating hours (see chapter 7.6 V-belt drive) and re-tension the V-belts if necessary.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>If noise levels change abruptly and / or vibrations occur abruptly, the belt drive must be checked and if required, it must be re-aligned or exchanged.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>check the alignment and fastening</td>
<td>check the alignment and fastening, exchange the drive belt, if necessary</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Motor</strong></td>
<td>pay attention to running noises and quiet running, remove sticking material (e.g. dust), if required</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>re-tighten screws, check bearings</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Earthing Motor Terminal Box</strong></td>
<td>clean inside, tighten screws</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>check motor, if required, exchange bearings, observe maintenance instructions of motor manufacturer, check the motor feet fixation</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Connections for Monitoring Devices and Auxiliary Equipment</strong></td>
<td>collect measuring values and analyse them</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>check for functionality</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>check for functionality</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>check for functionality</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
### Table 12

<table>
<thead>
<tr>
<th>Structural component</th>
<th>Daily</th>
<th>Weekly</th>
<th>Quarterly</th>
<th>Yearly</th>
</tr>
</thead>
<tbody>
<tr>
<td>flexible connections and chutes</td>
<td>check at regular intervals and – if required – after change of the processes.</td>
<td>check, if required, retighten screws and if worn-out, exchange flexible connections</td>
<td>check, if required, retighten screws and, if worn out, exchange flexible connections</td>
<td>check, if required, retighten screws and, if worn out, exchange flexible connections</td>
</tr>
<tr>
<td>total fan</td>
<td>pay attention to operational noises and quiet running, remove sticking material (dust) on the fan, in particular in the area of the shaft sealing and on the bearing housing</td>
<td>pay attention to operational noises and quiet running, check all screwed connections for tightness and retighten if necessary</td>
<td>check impeller, fan bearings and motor bearings, shaft seal, belt drive and flexible connections for wear and, if required, repair or exchange them</td>
<td>check impeller, fan bearings and motor bearings, shaft seal, belt drive and flexible connections for wear and, if required, repair or exchange them</td>
</tr>
</tbody>
</table>

The checks and controls in accordance with the maintenance schedule mainly contribute to the unrestricted continuous functioning of the fan and hence to the complete system and are regarded as being part of the operational company's requisite obligations.
8. Repair work

8.1 General remarks

Authorized personnel only is entitled to repair fans that are designed in accordance to the directive 94/9/EC (ATEX).

- Prior to removal / installation of spare parts, as:
  - impeller,
  - anti-friction bearings,
  - sealing rings,
  - V-belts,
  - motor,

prepare everything to ensure smooth and faultless working processes.

- Use appropriate removal / installation devices, tools and heating devices for the anti-friction bearings.

- The working place for the removal of the parts must be kept clean.

- Install only spare parts recommended and/or delivered by the manufacturer. The special installation instructions must be observed. These instructions are not part of this operating manual and are to be requested from REITZ as separate documents.
8.2 Fans in accordance with directive 94/9/EC ATEX

Maintenance of fans that were designed in accordance with directive 94/9/EC may only be carried out by qualified personnel (see chapter 2.8 Qualified person), see also chapter 2.4 Safety regulations.

Example for the stages of the maintenance:

<table>
<thead>
<tr>
<th>stage</th>
<th>activity</th>
<th>instructions</th>
<th>responsible</th>
</tr>
</thead>
<tbody>
<tr>
<td>maintenance</td>
<td>e.g. re-grease bearings</td>
<td>observe lubrication instructions</td>
<td>operating company</td>
</tr>
<tr>
<td>inspection</td>
<td>e.g. check impeller for wear and tear</td>
<td>observe the instructions of the operating manual</td>
<td>operating company</td>
</tr>
<tr>
<td>repair</td>
<td>e.g. replace impeller</td>
<td>observe the instructions of the operating manual</td>
<td>operating company</td>
</tr>
</tbody>
</table>

Table 13 Example for the stages of the maintenance

8.3 Safety instructions

Repair work that has been carried out during the warranty without our prior written agreement of the manufacturer, leads to the extinction of all warranty rights.

Recommendation:

If repair works are required, request the service specialists of the manufacturer:

Carry out maintenance works at standstill of the fan only.

Ensure that the fan is secured against restart and marked by a corresponding information sign.

Observe the safety instructions and the regulations for prevention of accidents.
8.4 Spare parts

When ordering spare parts, specify

- the exact name of the structural components
- the type of machine and
- the serial number.

The spare parts list (see enclosure) is a document separately attached to this operating manual. The clearly arranged list comprises all main spare parts for the fan with exact description of the parts.

Type of machine and serial number are shown on the name plate.

If required, send the manufacturer a sample of the part to be exchanged.
9. Annex

9.1 Additional technical information

9.1.1 Tightening moments for fastening screws

Unless otherwise stated, use the following tightening moments for connections with fastening screws and fastening nuts: Data in Newton metre (Nm).

When installing the fan, reduce the tightening moments by 10% so that the screw is not tightened to its yield point.

Values for set screws with metric coarse pitch thread bases upon German Standard VDI2230 with a coefficient of frictions are

$$\mu_{ges} = \mu_K = \mu_G = 0.12.$$  

The tightening moments refer to slightly oiled screws and nuts.

<table>
<thead>
<tr>
<th>Screws property class</th>
<th>Screws property class</th>
</tr>
</thead>
<tbody>
<tr>
<td>8.8</td>
<td>10 14</td>
</tr>
<tr>
<td>10.9</td>
<td>25 35</td>
</tr>
<tr>
<td>M6</td>
<td>49 69</td>
</tr>
<tr>
<td>M8</td>
<td>86 120</td>
</tr>
<tr>
<td>M10</td>
<td>210 295</td>
</tr>
<tr>
<td>M12</td>
<td>410 580</td>
</tr>
<tr>
<td>M16</td>
<td>710 1000</td>
</tr>
<tr>
<td>M20</td>
<td>1050 1500</td>
</tr>
<tr>
<td>M24</td>
<td>1450 2000</td>
</tr>
<tr>
<td>M27</td>
<td>2400 3555</td>
</tr>
<tr>
<td>M30</td>
<td>2400 3555</td>
</tr>
<tr>
<td>M36</td>
<td>2400 3555</td>
</tr>
</tbody>
</table>
9.1.2 Limiting values vibrations

Table of limiting values for fans:

<table>
<thead>
<tr>
<th>Machinery Class</th>
<th>Motor Power in kW</th>
<th>Substructure or System of Installation</th>
<th>Evaluation Zones</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>A New State</td>
</tr>
<tr>
<td>2 *)</td>
<td>&gt; 15 ≤ 300</td>
<td>rigid</td>
<td>≤ 1,4</td>
</tr>
<tr>
<td></td>
<td></td>
<td>flexible</td>
<td>≤ 2,3</td>
</tr>
<tr>
<td>1</td>
<td>&gt; 300</td>
<td>rigid</td>
<td>≤ 2,3</td>
</tr>
<tr>
<td></td>
<td></td>
<td>flexible</td>
<td>≤ 3,5</td>
</tr>
</tbody>
</table>

*) Motors smaller than 15kW are not treated separately in the DIN ISO 10816-3 and are therefore assigned to group 2.

The values assigned to the rating zones are not intended to serve as acceptance values. The acceptance values have to be specified between the machine manufacturer and the customer. The values should serve as guidelines to avoid major errors or unrealistic requirements.

The above shown warning and disconnecting values regarding the working temperature are maximum values. They are related to an ambient temperature of 40°C and an altitude of installation of up to 1000 m asl. Under special circumstances these values can be exceeded, if the preceding agreement of the manufacturer is obtained.

Evaluation criteria regarding vibrations according to German standard DIN ISO 10816/3.

If the vibration values level out between warning and disconnecting and if the fan is carefully observed, the operating of the fan can be continued until a proper point of time is defined, so the process can be shut down in a controlled way.

Possible damages of the fan can not be excluded → if required, inform REITZ.
9.1.3 Limiting values bearing temperatures

Warning at 80 °C
Disconnection at 100 °C

Temperature is a long-time indicator for the machine load. Excessive bearing load results in an increase in temperature of the bearing. Provided that the anti-friction bearing is used properly in accordance with the advised design instructions, a nearly constant working temperature of the bearing will turn up at constant working conditions after the initial operation phase. If the temperature changes without alteration of the speed or the load or without addition or reduction of warmth, this is an indication for a disturbed lubrication condition. Load changes due to malfunction of the non-located bearing can be recognised by the temperature course of the bearing. Bearing damages due to interruptions of the lubrication film or malfunction of the bearing can be recognized early by using a temperature monitoring device for the bearing. Running period damages due to fatigue and ageing can not be detected by a temperature monitoring device for the bearing.

The bearing temperature is measured by an electric temperature probe directly on the outer ring of the bearing.

**Permissible bearing temperatures**

![Temperature Chart](chart.png)

- **Disconnection** at 100 °C
- **Pre-warning** at 80 °C
- **Working temperature** range
- **Max. permissible temperature** at 120 °C
9.2 Requests regarding field service staff

For any queries or to require service specialists or spare parts, we ask you to specify the following data:

- Serial number of the fan, (6-digit number, see fan data sheet or name plate).
- Exact address of the operating company.
- Name of the person in charge who is to be contacted by our service specialist.
- Describe the trouble and your observations as exact as possible. The more exact the information, the easier for us to support you efficiently and quickly. Please inform us in detail by fax or e-mail.

See chapter 14 of this operating manual for detailed addresses of all companies of the REITZ Group.
10. Fan shutdown

10.1 General remarks

The definition – fan shutdown—means standstill of the fan for a longer period of time. It is necessary to weather-proof the fan.

In case the fans are intermediately stored for more than 3 months observe the instructions of the separate “Instructions for Storage and Corrosion Protection”. If necessary, request them from REITZ.

10.2 Safety instructions

Works required for putting the fan out of action must exclusively be carried out by specialist personnel, that due to professional training, experiences and instructions has sufficient knowledge about:

- Safety regulations,
- Regulations for prevention of accidents,
- Directives and accepted engineering standards (e.g. German VDE-directives, DIN EN Standards).

- The specialist personnel must:
  - be able to assess the works allocated to them, to recognize possible dangers and to avoid them.
  - be authorized by the person who is responsible for the safety of the plant to carry out the required works and tasks.

Works on electric systems, like disconnecting the fan from the electric supply, must exclusively be carried out by professional electricians.

- Disconnect fan from the power supply.
- If a future re-commissioning is intended, protect all structural components against corrosion.
- Cover machine parts.

Dispose properly of all lubricants, oils and any other materials dispose of them in a safe manner consistent with all applicable regulations and in an environmentally compatible way.
10.3 Measures in case of extended shutdown

When the fan is put out of operation for more than three months the following steps must be taken:

- **Drive motors and actuators**
  If there are drains, please open them, drain the accumulated water and re-close the openings. Check the terminal box connections for tight screwing.

- **Protect all bright parts (especially fan shaft) from corrosion.**

- **for single-bearing housings (fan shaft bearings)**
  press in grease until fresh grease leaks out from the discharge bore and turn the shaft manually several times

- **for multiple-bearing block (fan shaft bearings)**
  fill the space between housing covers and anti-friction bearings with grease and turn the shaft manually several times.

The values in Table 14 should serve as reference values:

<table>
<thead>
<tr>
<th>bearing type</th>
<th>relubrication quantity (in grams)</th>
</tr>
</thead>
<tbody>
<tr>
<td>ZLG306</td>
<td>20</td>
</tr>
<tr>
<td>ZLG307</td>
<td>26</td>
</tr>
<tr>
<td>ZLG308</td>
<td>36</td>
</tr>
<tr>
<td>ZLG309</td>
<td>50</td>
</tr>
<tr>
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Table 14

The grease type that was filled in and the relubrication grease type are indicated on the bearing plate (“Maintenance of bearings”).

Do not use another grease type.

**Note on the time period of the fan shutdown:**

If the fan is taken out of operation for a period of more than twelve months, check the grease for de-oiling or contamination (if condensate water intrudes in the grease, it will change its consistency). The grease has to be exchanged if it is de-oiled or contaminated.
10.4 Measures in case of recommissioning

Carry out the following steps:

- Check the bearings and shaft seals for tightness
- Check whether the operating materials like oil or grease have been filled in properly, re-fill or re-grease if necessary or exchange the consumables
- Check the V-belts for damage, ruptures, cracks or embrittlement
- Check drives and actuators for condensate water in the terminal box and housing, if necessary, drain the water and dry the interior.
- Remove the anti-corrosion coating from all bright parts which could affect the functioning (e.g. shaft seal, shaft earthing)

It is not permitted to employ damaged or corroded parts or such parts that are unfit for operation.

Prior to a new start-up, chapter 4 Start-up must be observed.
11. Dismantling

11.1 General remarks
The definition “Dismantling” means the removal of the fan and the subsequent re-mounting at a new location or the scrapping of the fan.

Prior to a new start-up especially the chapters 1 to 5 of this operating manual must be observed.

It is recommended to request the field service staff of the manufacturer to carry out the professional dismantling of the fan.

11.2 Safety instructions
Works required for dismantling the fan may exclusively be carried out by specialist personnel, that due to professional training, experiences and instructions has sufficient knowledge about:

- safety regulations,
- regulations for prevention of accidents,
- directives and accepted engineering standards (e. g. German VDE-directives, DIN EN-standards).

The specialist personnel must:

- be able to assess the works allocated to them, to recognize possible dangers and to avoid them.
- be authorized by the person who is responsible for the safety of the plant to carry out the required works and tasks.

Works on electric systems, like disconnecting the fan from the electric supply, must exclusively be carried out by professional electricians.

The dismantling must not start before all works that are required for putting the fan out of action are finished and not before the start of the dismantling works are permitted by an authorized assigned supervisor.

- Initially all accessory parts like flexible connections and louvre dampers must be removed.
- Subsequently remove the monitoring devices and the safety hoods.

Overturning or dropping components can cause most serious injuries or even death.

Secure all components to avoid sliding and dropping of these parts during dismantling works and transport.

Staying below suspended loads means danger to live and therefore must be refrained from in any circumstance.
12. Safety data sheets

The safety data sheets on bearing greases or oils can be submitted on demand from REITZ.
13. Expiry of service life, disposal

Dismantle and dispose of properly and in accordance with the national and international laws and regulations of those fan components and parts, whose service life has expired due to wear and tear, corrosion, mechanical load, fatigue and/or other effects that could not be directly discerned. The same applies to the auxiliary materials used like oil, grease or the like.

Deliberate or unintentional further application of used parts, e.g. impellers, bearings, V-belts etc. may endanger persons, harm the environment and/or damage the machine or the complex system. The corresponding local regulations of the operating company are to be observed and applied.
14. Addresses of the REITZ group

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