



Empowering you to work smarter

DuoDrive Vacuum Pump Operating Manual



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Failure to follow warnings could
result in death or serious injury.

**SAVE THIS MANUAL
FOR FUTURE REFERENCE**

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1. Use Information

Thanks for choosing NAVAC vacuum pump of high reliability (Hereinafter referred to as “the pump”). Please check carefully whether the product received is the same as you ordered and the accessories, spare parts & operating manual are attached as well. Please also check if there’s any damage occurred during transportation. If needed, contact the local distributor or our sales team. In order to maintain a stable performance level of the pump, read this operating manual carefully to fully understand the safety instructions, technical data as well as operating procedures before installation, operation, repair and maintenance of the pump.

 **Warning**

Failure to observe the terms could result in serious personal injury.

 **Notice**

Failure to observe the terms could result in damage to the pump.



This warning label indicates risk of electrical shock. Disconnect the pump from the power supply before beginning with connections, repair and maintenance. Make sure the cover of junction box is properly installed before running.



This warning label indicates high temperature hazard. Do not touch the pump when the pump is in operation.

 **Notice**

Read the operating manual carefully and follow the operating procedures. We reserve the right to modify the design and technical data of the pump without notice which may have discrepancies in the manual. Add vacuum oil as requested before starting the new pump.

2. Attention

In order to ensure the personal safety, read the operating manual carefully before installation, operation, repair and maintenance.

 **Warning**

- 1). According to the technical guidelines and wiring regulations for electrical equipment, the power supply must match with the information shown on the pump nameplate and the electrical connections must be performed by a skilled electrician.
- 2). To prevent electrical hazards and sudden start-up hazard which may result in personal injury, disconnect the power supply before checking or repairing the pump.
- 3). Before starting the pump, the motor must be effectively grounded and properly connected with a rated motor protection switch.
- 4). The pump is strictly prohibited to pump dusty, active toxic, corrosive, flammable and explosive gases.

- 5). Do not place obstacles which may affect the ventilation of the motor and cause burn hazard and fire by abnormal temperature rise.
- 6). The exhaust passage must be unimpeded before operating. Make sure that the gas flow from the exhaust port is not blocked or restricted in any way.

! Notice

- 1). The pump must be operated at ambient temperature between 10-40°C.
- 2). Check the oil level before running. Do not operate the pump without oil or short of oil. Otherwise it will result in pump failure.
- 3). Check oil leakage of the pump to prevent slip hazard caused by spilled oil.
- 4). Running without oil lubrication or wrong rotation direction of the motor may cause pump failure.
- 5). Handling of used oil and other parts must be in compliance with local relevant environmental laws and regulations.
- 6). To pump condensable gases, only use the pump installed with gas ballast.
- 7). While pumping a small amount of dust and condensable gases, an installation of corresponding filters is required. Otherwise it will cause pump failure or sharp drop of performance.

3. Description

DD series vacuum pump is a high speed, motor direct drive dual-stage oil sealed rotary vane pump. It is an basic equipment to obtain vacuum and can be used to pump inactive gas within the scope of low vacuum and a small amount of non-condensable gas.

The pump is specially suitable for coating, refrigeration, freeze drying, sterilization, instruments analysis, leak detection equipment, heat treatment metallurgy, etc. It can be used as a backing pump for roots pumps as well.

The pump has a reasonable structure design (Refer to Fig. 1) for long failure-free operation. It features high reliability, high flow rate, low ultimate pressure and low noise level. The pump has no oil spray, no leak and easy to maintain.

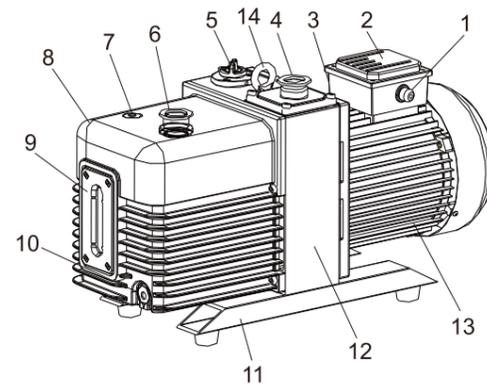


Fig. 1 Outside view

1. Power Outlet
2. Junction box cover
3. Junction box
4. Intake port
5. Gas ballast
6. Exhaust port
7. Oil fill plug
8. Oil housing sump
9. Sight glass
10. Oil drain plug
11. Pump feet
12. Support
13. Motor
14. Lifting eye

3.1 Principle of Operation

Refer to Fig. 2, the rotor mounted eccentrically in the pump cylinder, has two vanes which divide the pump chamber into three changeable compartments. When the rotor rotates clockwise, gas is sucked into chamber 1 gradually, transferred by chamber 2, and compressed and exhausted by chamber 3. The working cycle is repeated to achieve the vacuum of the system. The exhausted gas from the first stage goes into the second stage (low-vacuum stage) through air channel, and is compressed again before discharging into atmosphere to achieve a lower ultimate vacuum pressure.

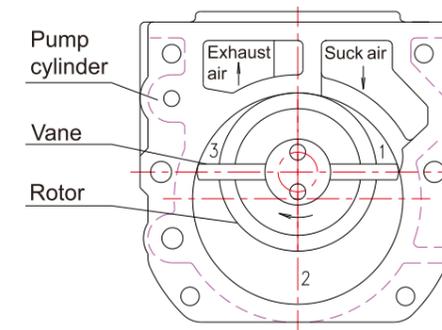


Fig. 2 Functional diagram

3.2 Principle of Gas Ballast

The controllable gas (generally dry air at room temperature) is admitted into the pump chamber. It is mixed with pumped vapor during the gas compression process.

This increases the percentage of non-condensable gas such that the partial pressure of the vapor being pumped is below its saturated vapor pressure when the exhaust valve opens. The vapor is then discharged from the pump without liquefaction. The more vapor contained in the pumped gas, the more dry air is required (See Fig. 7 Gas ballast valve).

4. Technical Parameters

Model			DD48	DD65	DD90
Displacement speed	50Hz	m³/h(CFM)	48 (28)	65 (38)	85
	60Hz		56 (33)	78 (46)	102
Ultimate pressure	Without gas ballast	mbar (Torr)	$2 \times 10^{-3} (1.5 \times 10^{-3})$	$2 \times 10^{-3} (1.5 \times 10^{-3})$	$2 \times 10^{-3} (1.5 \times 10^{-3})$
	With gas ballast I	mbar (Torr)	$3 \times 10^{-2} (2.3 \times 10^{-2})$	$3 \times 10^{-2} (2.3 \times 10^{-2})$	$3 \times 10^{-2} (2.3 \times 10^{-2})$
	With gas ballast II	mbar (Torr)	$6 \times 10^{-2} (4.6 \times 10^{-2})$	$6 \times 10^{-2} (4.6 \times 10^{-2})$	$6 \times 10^{-2} (4.6 \times 10^{-2})$
Power supply			220-230VAC-Δ/460VAC-Y 60Hz; 380-415VAC-Y 50Hz		
Rated Current	A		7.1-Δ / 4-Y	7.8-Δ / 4.5-Y	9.7-Δ / 5.5-Y
Power rating	kW		1.5	2.2	3
Intake and exhaust DN			KF40	KF40	KF40
Oil capacity	L		4	4	4
Motor speed	50/60Hz	rpm	1440/1720	1440/1720	1440/1720
Ambient temperature	°C		10 ~ 40	10 ~ 40	10 ~ 40
Noise level	dB		≤62/68	≤65/73	≤65/72
Net weight	lbs		136	143	143

Table 1

Pumping speed characteristics

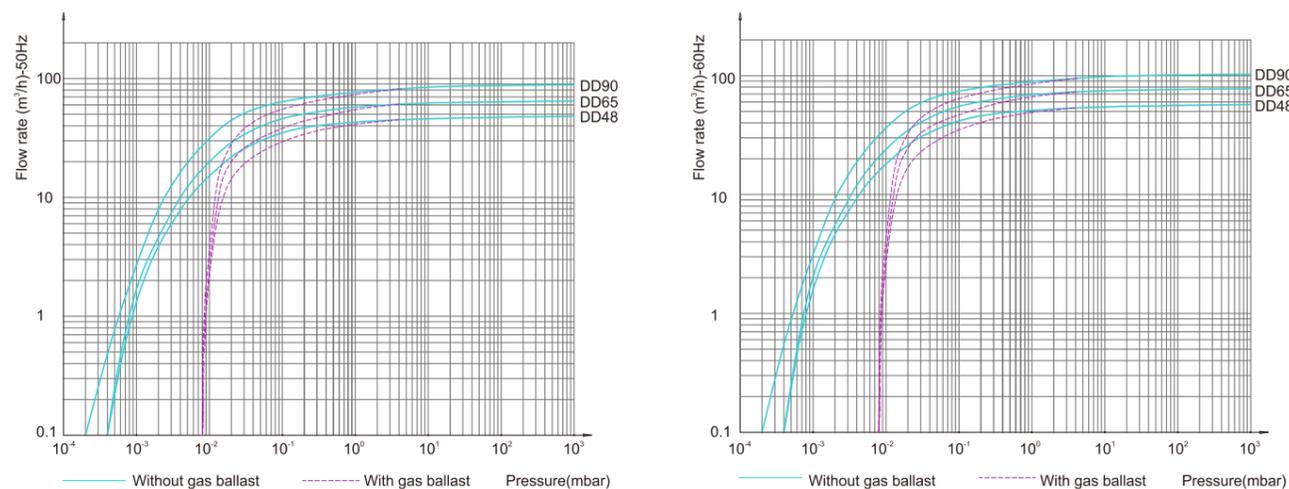


Fig. 3

5. Transport and Storage

Warning

- 1). Do not move the pump unless it's switched off and the power supply is disconnected.
- 2). Make sure that the lifting eye is tightened before lifting the pump.

Notice

- 1). Check carefully if there's any packaging damage during transportation.
- 2). Move the pump with care. Any negligence will cause pump damage during transportation. In order to avoid oil spilling, move the pump in horizontal direction.
- 3). Handling of used packing material must be in compliance with local environmental laws and regulations.
- 4). For long term storage, clean the pump and empty the oil inside. Store the pump in a dry place at room temperature.

6. Installation and Connection

6.1 Installation Dimensions

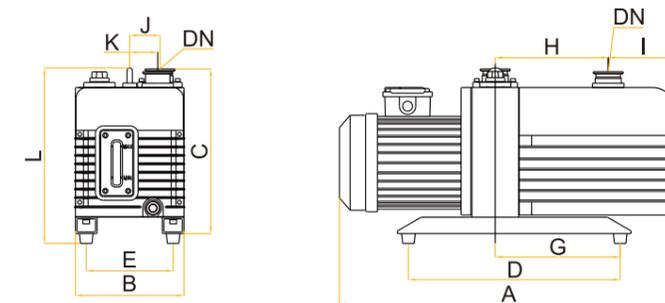


Fig. 4

Unit: inch

Model	A	B	C	D	E	G	H	I	J	K	L	DN
DD48	28.7	9.2	14.1	15.6	7.5	7.9	8.8	6.2	2.7	2.2	15.4	KF40
DD65	28.7	9.2	14.1	15.6	7.5	7.9	8.8	6.2	2.7	2.2	15.4	KF40
DD90	28.7	9.2	14.1	15.6	7.5	7.9	8.8	6.2	2.7	2.2	15.4	KF40

Table 2

6.2 Connection to System

Warning

- 1). The pump is strictly forbidden to operate in areas with risk of fire and explosion.
- 2). Make sure the gas flow at the exhaust port is not blocked or restricted in any way. Check to ensure the exhaust line is not obstructed by deposits before start-up.

! Notice

- 1). Take the following into account to choose the pump installation site: convenient for installation, maintenance, disassembly and electrical connections as well as good ventilation.
- 2). Place the pump feet horizontally or fix the feet with bolts while connecting the pump to vacuum system.
- 3). Uneveled installation may result in pump's vibration, loud noise or even damage. The pump shall be set up on a flat and firm surface.
- 4). The length of hose between pump and vacuum system shall be as short as possible. The diameter of the hose shall be the same as that of intake port.
- 5). Both the vacuum hose and regular vacuum pipe can be clamped to the intake port. Make sure not to pull the hose or pipe, as this might cause vibration, leading to damage to the intake port.
- 6). The exhaust line should be laid so that it slopes down so as to prevent condensate from backstreaming into the pump and contaminating the oil. Drain the oil in the exhaust line periodically to avoid block of exhaust line. If the exhaust line slopes up, the installation of a condensate trap is necessary. Check leak of the connection between pipe and flange. Vacuum tightness is essential for the achievement of ultimate pressure of the pump.

6.3 Grounding instructions

! Warning

This product must be connected to a grounded, metallic, permanent wiring system, or an equipment-grounding terminal or lead on the product.

6.4 Power Supply and Motor Rotation Direction

! Warning

Make sure the power supply is correct. The electrical connections must be performed by a skilled electrician according to the technical guidelines and wiring regulations for electrical equipment. For 3-phase motor, open the junction box cover and make the connections according to the wiring diagram refer to Fig. 5. No components are supplied for electrical connections. RECOMMENDED CABLE, MINIMUM CIRCUIT AMPACITY OF CONDUCTOR, MAXIMUM BRANCH CIRCUIT FUSE are shown in table 2:

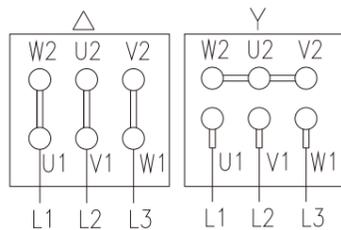


Fig.5

	DD48	DD65	DD90
Recommended cable	SJT, 4*16AWG		
Maximum branch circuit fuse	15A		
Minimum circuit ampacity of conductor	15A		

Table 2

! Caution

MOTOR NOT PROTECTED — EXTERNAL OVERHEAT PROTECTION IN ACCORDANCE WITH CE CODE, PART I, SHALL BE PROVIDED.

How to check rotation direction of 3-phase motor:

Check whether the motor rotation direction is the same as the indicated arrow on the motor. In case that an incorrect direction is found, cut off the power immediately and interchange any 2 wires of L1, L2 and L3.

7. Initial Start and Operation

7.1 Start-up

! Warning

- 1). Make sure the gas flow at the exhaust port is not blocked or restricted in any way. Do not start the pump if the exhaust port is blocked.
- 2). The oil level shall be kept between position MAX and MIN of oil sight glass. Excessive or insufficient oil will decrease the pump performance or even cause malfunction. The pump must be stopped before adding oil.
- 3). Make sure the gas flow at the exhaust port is not blocked or restricted in anyway. Do not start the pump if the exhaust port is blocked.

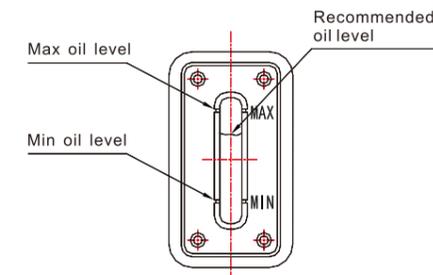


Fig. 6

! Notice

The operating ambient temperature is 10 - 40°C and humidity should be less than 85%.

7.2 Operation

! Notice

High temperature hazard! Do not touch the surface! The surface of the pump could be very hot during operation and after shutdown within one hour.

Pumping non-condensable gases

Close the gas ballast to pump non-condensable gases (Set the gas ballast to position C, refer to Fig. 7). The ultimate pressure will rise (loss of vacuum) with gas ballast opened.

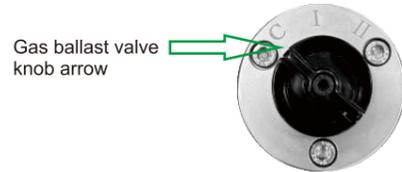


Fig. 7 Gas Ballast Valve

Pumping condensable gases and vapor

If the vacuum system contains a small amount of condensable gas, open the gas ballast valve (Set the gas ballast to position I or II, refer to Fig. 7) and keep the pump running for at least 30 minutes to pump the condensable gas effectively. Close the gas ballast valve when the vacuum system pressure is reduced to a certain value. If the pump operates at low temperature, condensable gas may be dissolved in the pump oil. The oil may be emulsified or deteriorated which will affect the pump performance, even cause corrosion of the pump body.

The rise of oil level during pump operation is a sign of condensable gas contained in the vacuum system. Do not switch off the pump immediately when the process is finished. Keep the pump running with gas ballast open and intake port closed until all gases dissolved in the oil are removed.

8. Inspection and Maintenance

! Warning

- 1). All checks and maintenance must be performed by trained personnel in accordance with local safety rules and regulations.
- 2). In case of presence of hazardous substances due to oil decomposition or media sucked into the pump, it's necessary to define the hazard and take all necessary safety precautions.
- 3). In the presence of hazardous substances, determine the hazard in the first time and follow all appropriate safety procedures. If the potential hazard still exists, the pump must be decontaminated before any maintenance.

8.1 Routine inspection

Content	Operation	Interval	Remarks
Oil level	Visual inspection	Every three days	8.2.1
Oil color	Visual inspection	Every three days	8.2.1
Pump noise	Acoustic inspection	Every three days	8.2.2
Pump vibration	Visual inspection	Every three days	Check the pump feet or feet bolts in case of abnormal vibration.
Pump temperature	Temperature meter	Every one week	Check and clean fan of the pump and motor for deposits.
Seal & O-ring	Visual inspection	Every one month	Replace it if necessary
Dirt trap	Visual inspection	Every one month	Check and clean the foreign matter. Dry it by compressed air.

Table 3

8.2 Maintenance

8.2.1 Checking oil level

- 1) The oil level shall be always kept between position MAX and MIN of oil sight glass during operation (refer to Fig. 6). Add oil when the oil level is lower than position MIN and discharge oil by removing the oil drain plug (refer to Fig. 1) when the oil level is above position MAX.
- 2) Check the oil color. Replace the oil if the color is other than clear and transparent.

8.2.2 Checking pump's noise

The pump noise shall be continuous and stable during operation. If any abnormal noise is found, refer to Table 4 Troubleshooting.

8.2.3 Changing oil

- 1) Change the oil when the pump is switched off and cooled down.
- 2) Remove the oil drain plug (Fig. 1) and drain the used oil into a suitable receptacle. When the flow of oil stops, screw on the oil drain plug and start the pump shortly (10 seconds). Switch off the pump, remove the plug again and drain the residual oil. Screw on the oil drain plug (Check O-ring, replace it if necessary). Remove the oil fill plug (Fig. 1) and fill in fresh pump oil which is specified or provided by the manufacturer.
- 3) After oil changing, handle the used oil stored in an assigned container according to local relevant environmental laws and regulations.

8.2.4 Regularly checking intake filter and anti-siphon valve

Regularly take down the intake port and clean the filter by compressed air. Check the seal position of anti-siphon valve for cleanness, damage, hardening and height.

8.2.5 Regularly checking fan cover and motor fan

Regularly remove the clean the fan cover and motor fan. Clean them by compressed air and reinstall them properly before pump operation.

9. Troubleshooting

Fault	Possible Reason	Remedy
Pump cannot start	1. Wiring is malfunctioning.	1. Check and repair wiring.
	2. Operation voltage is abnormal.	2. Make sure the voltage is within rated voltage's tolerance of $\pm 10\%$.
	3. Motor is malfunctioning.	3. Replace the motor.
	4. Overload protector is active.	4. Check the ambient temperature or pumped gases temperature.
	5. Oil temperature is below 10°C	5. Increase the ambient temperature.
	6. Pump is jammed.	6. Repair the pump.
	7. Out of operating for long.	7. Repair the pump.
	8. Oil is too viscous.	8. Change the oil.
	9. Exhaust filter or exhaust line is clogged.	9. Replace the filter or clean the exhaust line.
	10. Pump inner parts are damaged.	10. Repair the pump.
Pump cannot reach ultimate pressure.	1. Vacuum system configuration is unreasonable.	1. Choose a suitable pump.
	2. Vacuum system leak.	2. Check the system.
	3. Measuring technique or gauge is unsuitable.	3. Use correct measuring technique and gauge. Measure the pressure directly at pump's intake port.
	4. Poor lubrication.	
	4.1 Oil filter is obstructed.	4.1 Change the oil filter.
	4.2 Oil is unsuitable.	4.2 Change the oil.
	4.3 Oil channel is obstructed.	4.3 Clean the channel.
	4.4 Oil is insufficient.	4.4 Add the oil to the level as requested.
Pumping speed is too low.	5. Anti-suckback oil valve is malfunctioning.	5. Repair anti-suckback oil valve.
	6. Intake line is dirty.	6. Clean vacuum lines.
	7. Floating ball components return oil valve is malfunctioning.	7. Repair floating ball components return oil valve.
	1. Intake port line is clogged.	1. Clean the intake port line.
	2. Connecting lines are too narrow or too long.	2. Use adequately wide and short connecting lines.
	3. Exhaust line is clogged.	3. Keep exhaust port line unobstructed.
	4. Oil mist filter is clogged.	4. Change the oil mist filter.
Noise is abnormal.	5. Anti-suckback oil valve is malfunctioning.	5. Repair anti-suckback oil valve.
	1. Operation voltage is abnormal.	1.1 Check the power supply, switches and wiring connection. 1.2 Make sure the voltage is within rated voltage's tolerance of $\pm 10\%$.
	2. Foreign matters entering into the pump.	2. Repair the pump.
	3. The oil level of the pump is too low.	3. Add the oil to the level as requested.
	4. The pump inner parts are damaged.	4. Disassembly and replace the parts.

Fault	Possible Reason	Remedy
Pump get shotted than usually observed.	1. Poor ventilation.	1. Improve ventilation environment.
	2. The fan is damaged.	2. Change the fan.
	3. Pumped gas temperature is too high.	3. Add cold trap at intake port.
	4. Poor lubrication.	
	4.1 The oil filter or exhaust line is clogged.	4.1 Replace oil filter or clean the exhaust line.
	4.2 Oil is unsuitable.	4.2 Change the oil.
	4.3 Oil channel is obstructed.	4.3 Clean the channel.
	4.4 Oil is insufficient.	4.4 Add the oil to the level as requested.
	5. The condensator is dirty.	5. Clean the condensator.
	6. Ambient temperature is too high.	10. Repair the pump.
Oil in the intake line or in vacuum vessel.	1. Oil comes from the vacuum system.	1. Check the vacuum system.
	2. Anti-suckback valve spring is obstructed.	2. Replace anti-suckback valve spring.
	3. Anti-suckback valve plate is obstructed.	3. Replace anti-suckback valve plate.
	4. Oil level is high.	4. Drain the excess oil.
Vacuum pressure in system rises too fast when pump stops.	1. Vacuum system leak.	1. Check the system.
	2. Anti-suckback valve is malfunctioning.	2. Repair anti-suckback valve.
Too much oil in the exhaust port.	1. Too much oil in the pump.	1. Drain some oil.
	2. Continuous operation under high pressure in the intake port	2. Shorten exhaust time.
	3. Oil mist filter is obstructed.	3. Replace oil mist filter.
Sealing surface leak	1. The seal is damaged.	1. Replace the seal.
	2. Seal ring is damaged.	2. Replace the seal ring.

Table.4

10. Warranty

DD series vacuum pumps have one year guarantee from the date of purchase. Spare parts will be provided free of charge within the period of guarantee in condition that the pump is operated according to the operating manual. The following failures will be charged for repair:

- (1) Malfunction caused by nature disasters or artificial factors.
- (2) Malfunction caused by special operating environment.
- (3) Damage of wear parts.
- (4) Malfunction caused by abnormal operation or incorrect use identified by our engineers. Before the pump is delivered to our company for maintenance, it is required to acquire the information if the pump is contaminated (and which kind of pollutants) or hazardous substances exist inside the pump. Without receiving this statement in advance, the pump will be returned to the address of the sender.

11. Accessories

11.1 DD48/65/90 Exploded View

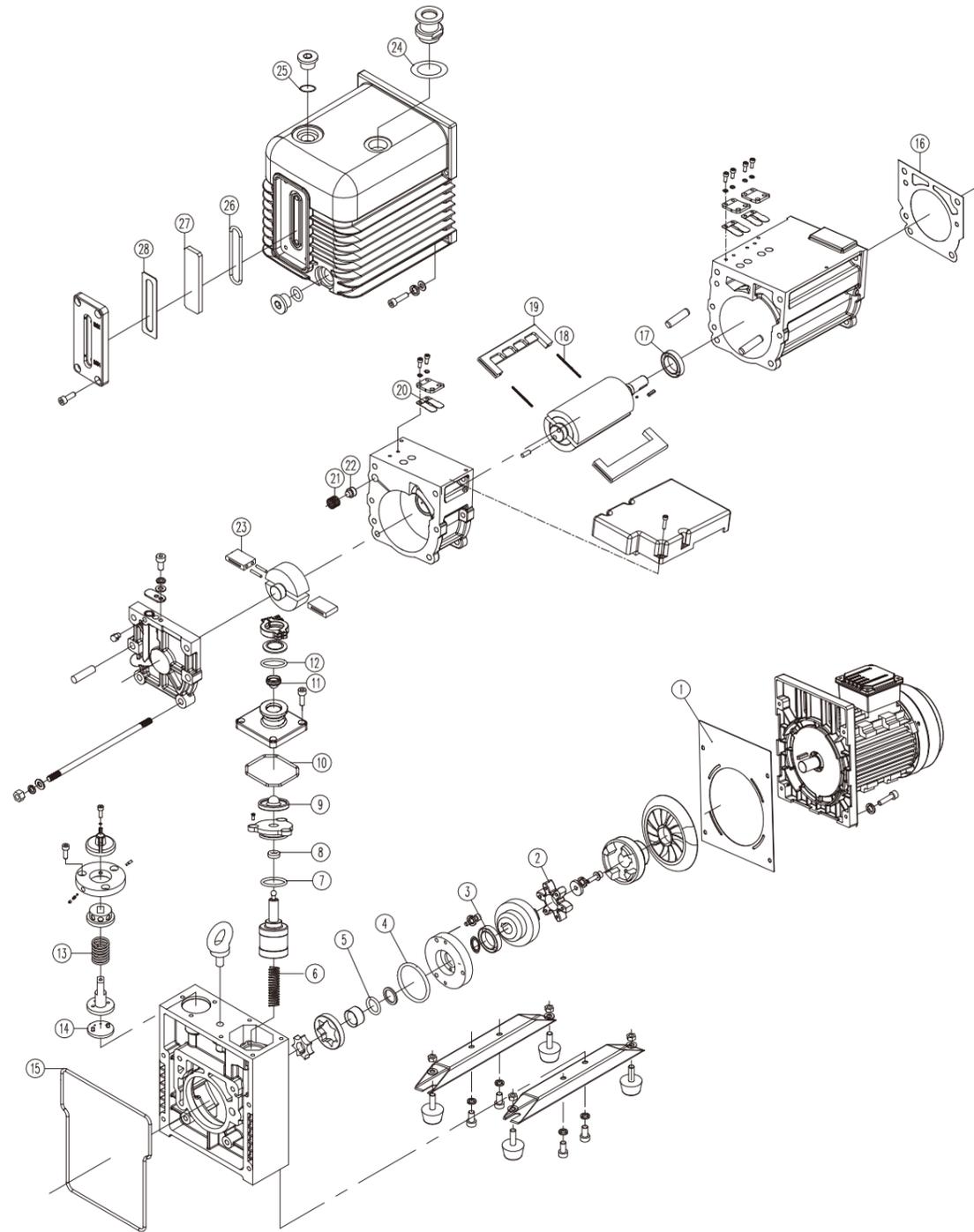


Fig. 8

11.2 DD48/65/90 Spare Parts List

Item No.	Description	Quantity (PCS)
1	Washer	1
2	Spider	1
3	Seal	1
4	O ring	1
5	O ring	1
6	Spring	1
7	O ring	1
8	Seal	1
9	Valve	1
10	O ring	1
11	Filter	1
12	O ring	2
13	Spring	1
14	Washer	1
15	O ring	1
16	Gasket	1
17	Seal	1
18	Spring	5
19	Vane	2
20	Valve	1
21	Spring	1
22	Valve	1
23	Vane	2
24	Washer	1
25	O ring	2
26	O ring	1
27	Oil sight	1
28	Washer	1

Table 5

REMARK: 1) To ensure the stability of the pump, it is recommended to use genuine spare parts and accessories provided by the manufacturer. If you need further assistance, please contact us.
 2) Please refer to the exploding drawing for the relationships of each spare part.
 3) We reserve the right to modify the design and specified data in this operating manual without notice.
 4) The following optional accessories may be selected based on specific application requirements: intake/exhaust port (if not the standard one supplied) and dust filter.