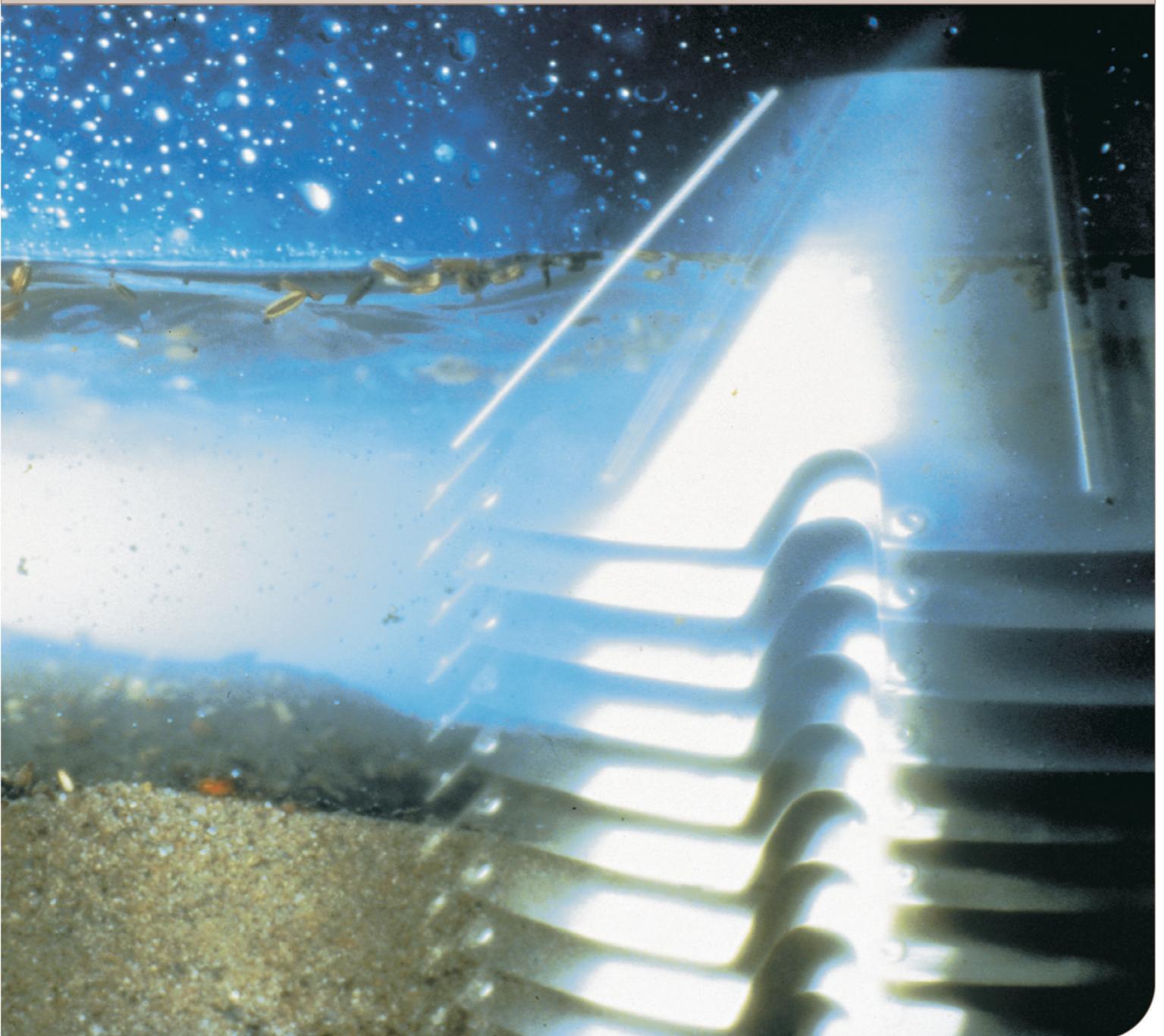


Separator Manual  
High Speed Separator

**MSPX 303TGP-61**



**Published By:**

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**Read and understand instruction manuals  
and observe the warnings before installation,  
operation, service and maintenance.**

**Not following the instructions can result in  
serious accidents.**

In order to make the information clear only foreseeable conditions have been considered. No warnings are given, therefore, for situations arising from the unintended usage of the machine and its tools.



---

# 1 *Read this first*

---

This manual is designed for operators and service engineers working with the Alfa Laval separator MSPX 303TGP-61.

For information concerning the function of the separator, see chapter “[3 Separator Basics](#)” on [page 17](#), and chapter “[8 Technical Reference](#)” on [page 139](#).

If the separator has been delivered and installed by Alfa Laval as part of a processing system, this manual is a part of the system documentation. In this case, study carefully all the instructions in the system documentation.

In addition to this separator manual a *Spare Parts Catalogue*, SPC is supplied.

This separator manual consists of:

## **Safety Instructions**

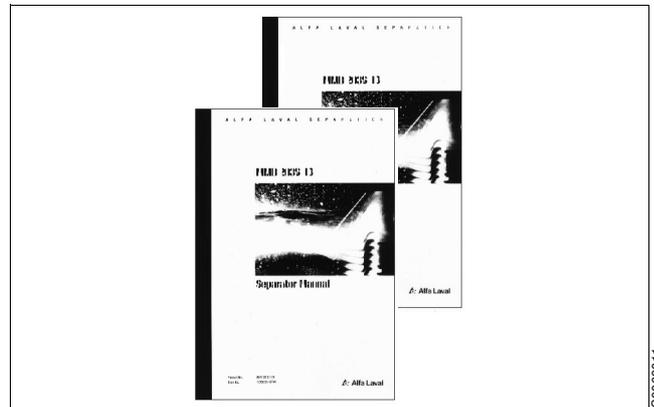
Pay special attention to the safety instructions for the separator. Not following the safety instructions can cause accidents resulting in damage to equipment and serious injury to personnel.

## **Separator Basics**

Read this chapter if you are not familiar with this type of separator. This chapter contains the technical description and function description.

## **Operating Instructions**

This chapter contains operating instructions for the separator only.



*Separator Manual and Spare Parts Catalogue*

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## **Service Instructions**

This chapter gives instructions for daily checks, cleaning, oil changes, servicing and check points.

## **Dismantling / Assembly**

This chapter contains step-by-step instructions for dismantling and assembly of the separator for service and repair.

## **Trouble-tracing**

Refer to this chapter if the separator functions abnormally.

If the separator has been installed as part of a processing system always refer to the trouble-tracing part of the system documentation first.

## **Technical Reference**

This chapter contains technical data and drawings concerning the separator.

## **Index**

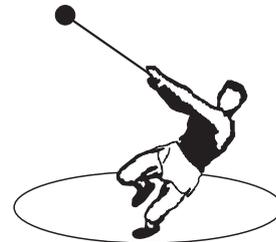
This chapter contains an alphabetical list of subjects, with page references.

## 2 Safety instructions



The centrifuge includes parts that rotate at high speed. This means that:

- Kinetic energy is high
- Great forces are generated
- Stopping time is long



Manufacturing tolerances are extremely fine. Rotating parts are carefully balanced to reduce undesired vibrations that can cause a breakdown. Material properties have been considered carefully during design to withstand stress and fatigue.

The separator is designed and supplied for a specific separation duty (type of liquid, rotational speed, temperature, density etc.) and must not be used for any other purpose.

Incorrect operation and maintenance can result in unbalance due to build-up of sediment, reduction of material strength, etc., that subsequently could lead to serious damage and/or injury.

The following basic safety instructions therefore apply:

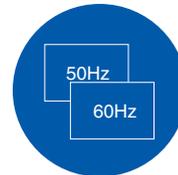
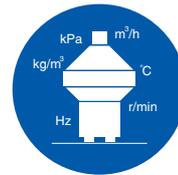
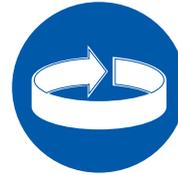
- **Use the separator only for the purpose and parameter range specified by Alfa Laval.**
- **Strictly follow the instructions for installation, operation and maintenance.**
- **Ensure that personnel are competent and have sufficient knowledge of maintenance and operation, especially concerning emergency stopping procedures.**
- **Use only Alfa Laval genuine spare parts and the special tools supplied.**





## Disintegration hazards

- When power cables are connected, always check direction of motor rotation. If incorrect, vital rotating parts could unscrew.
- If excessive vibration occurs, **stop** separator and **keep bowl filled** with liquid during rundown.
- Use the separator only for the purpose and parameter range specified by Alfa Laval.
- Check that the gear ratio is correct for power frequency used. If incorrect, subsequent overspeed may result in a serious break down.
- Welding or heating of parts that rotate can seriously affect material strength.
- Wear on the large lock ring thread must not exceed safety limit.  $\phi$ -mark on lock ring must not pass opposite  $\phi$ -mark by more than specified distance.
- Inspect regularly for **corrosion** and **erosion** damage. Inspect frequently if process liquid is corrosive or erosive.



S01512F1

S01512N1

S01512P1

S01512L1

S0151241

S01512G1

S01512H1



### Entrapment hazards

- Do NOT stand on the separator or parts of.



### Entrapment hazards

- Make sure that rotating parts have come to a **complete standstill** before starting **any** dismantling work.

If there is no braking function the run down time can exceed two hours.

- To avoid accidental start, switch off and lock power supply before starting **any** dismantling work.

Assemble the machine **completely** before start. **All** covers and guards must be in place.



### Electrical hazard

- Follow local regulations for electrical installation and earthing (grounding).
- To avoid accidental start, switch off and lock power supply before starting **any** dismantling work.



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S0151271



### Crush hazards

- Use correct lifting tools and follow lifting instructions.

Do **not** work under a hanging load.



S01512M1

S01512Y1



### Noise hazards

- Use ear protection in noisy environments.



S0151291



### Burn hazards

- Lubrication oil, machine parts and various machine surfaces can be hot and cause burns. Wear protective gloves.



S01512A1



### Skin irritation hazards

- When using chemical cleaning agents, make sure you follow the general rules and suppliers recommendation regarding ventilation, personnel protection etc.
- Use of lubricants in various situations.



S01512D1



### Cut hazards

- Sharp edges, especially on bowl discs and threads can cause cuts. Wear protective gloves.



S01512B1



### Flying objects

- Risk for accidental release of snap rings and springs when dismantling and assembly. Wear safety goggles.

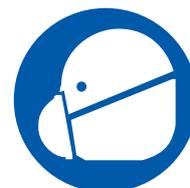


S01512C1



### Health hazard

- Risk for unhealthy dust when handling friction blocks/pads. Use a dust mask to make sure not to inhale any dust.



S01512V1



## 2.1 Warning signs in text

Pay attention to the safety instructions in this manual. Below are definitions of the three grades of warning signs used in the text where there is a risk for injury to personnel.



### **DANGER**

Type of hazard

**DANGER** indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



### **WARNING**

Type of hazard

**WARNING** indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



### **CAUTION**

Type of hazard

**CAUTION** indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

### **NOTE**

**NOTE** indicates a potentially hazardous situation which, if not avoided, may result in property damage.



## 2.2 Recycling Information

### Unpacking

Packing material consists of wood, plastics, cardboard boxes and in some cases metal straps.

- Wood and cardboard boxes can be reused, recycled or used for energy recovery.
- Plastics should be recycled or burnt at a licensed waste incineration plant.
- Metal straps should be sent for material recycling.

### Maintenance

During maintenance oil and wear parts in the machine are replaced.

- Oil must be taken care of in agreement with local regulations.
- Rubber and plastics should be burnt at a licensed waste incineration plant. If not available they should be disposed to a suitable licensed land fill site.
- Bearings and other metal parts should be sent to a licensed handler for material recycling.
- Seal rings and friction linings should be disposed to a licensed land fill site. Check your local regulations.
- Worn out or defected electronic parts should be sent to a licensed handler for material recycling.

### Scrapping

At the end of use, the equipment must be recycled according to relevant local regulations.

Besides the equipment itself, any hazardous residues from the process liquid must be taken into consideration and dealt with in a proper manner. When in doubt, or in the absence of local regulations, please contact your local Alfa Laval sales company.



## 2.3 Requirements of personnel

Only **skilled** or **instructed** persons are allowed to operate the machine, e.g. operating and maintenance staff.

- **Skilled person:** A person with technical knowledge or sufficient experience to enable him or her to perceive risks and to avoid hazards which electricity/mechanics can create.
- **Instructed person:** A person adequately advised or supervised by a skilled person to enable him or her to perceive risks and to avoid hazards which electricity/mechanics can create.

In some cases special skilled personnel may need to be hired, like electricians and others. In some of these cases the personnel has to be certified according to local regulations with experience of similar types of work.

## 2.4 Remote start

If the separator is operated from a remote position, from where it can neither be seen nor heard, the power isolation device shall be equipped with an interlocking device. This is to prevent a remote start command which could result in some liquid being fed to the separator when it is shut down for service.

The first start after the separator has been taken apart or has been standing still for a long time shall always be locally manually supervised.

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# 3 *Separator Basics*

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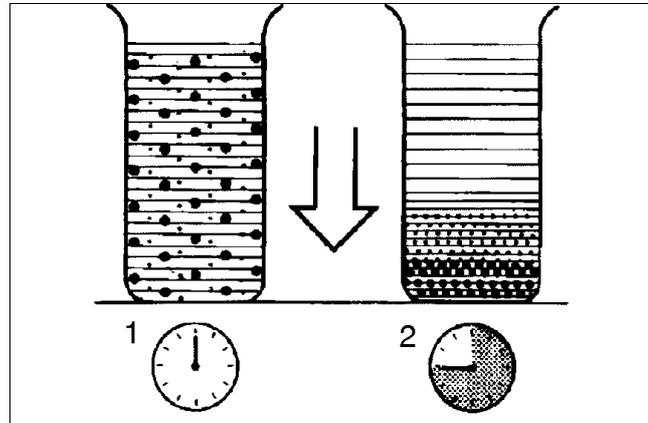
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## 3.1 Basic principles of separation

The purpose of separation can be:

- to free a liquid of solid particles,
- to separate two mutually insoluble liquids with different densities while removing any solids presents at the same time,
- to separate and concentrate solid particles from a liquid.



*Sedimentation by gravity*

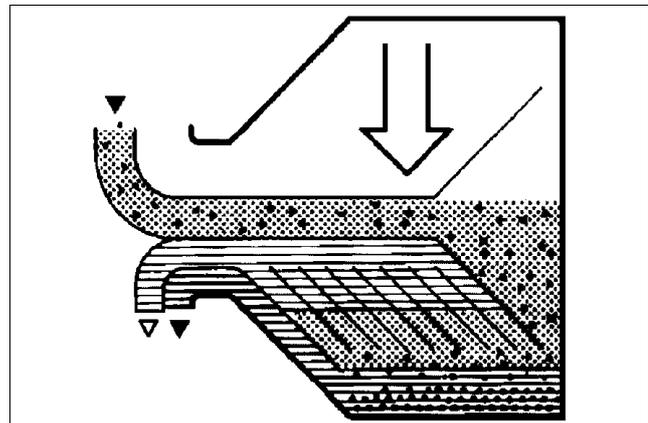
### Separation by gravity

A liquid mixture in a stationary bowl will clear slowly as the heavy particles in the liquid mixture sink to the bottom under the influence of gravity.

A lighter liquid rises while a heavier liquid and solids sink.

Continuous separation and sedimentation can be achieved in a settling tank having outlets arranged according to the difference in density of the liquids.

Heavier particles in the liquid mixture will settle and form a sediment layer on the tank bottom.



*Sedimentation in a settling tank, with outlets making it possible to separate the lighter liquid parts from the heavier*

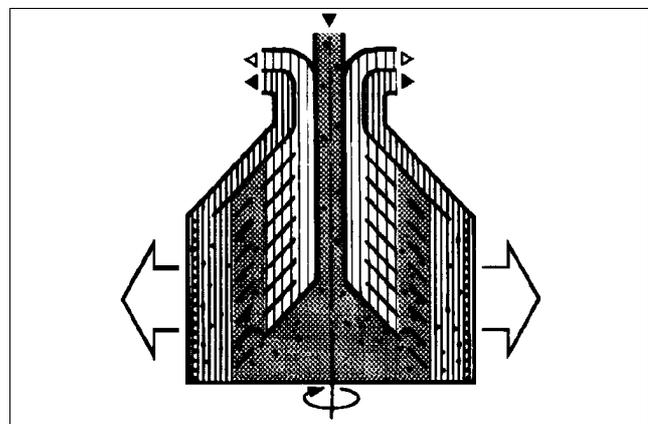
### Centrifugal separation

In a rapidly rotating bowl, the force of gravity is replaced by centrifugal force, which can be thousands of times greater.

Separation and sedimentation is continuous and takes place quickly.

The centrifugal force in the separator bowl can achieve in a few seconds what takes many hours in a tank under influence of gravity.

The separation efficiency is influenced by changes in the viscosity (separating temperature) and in the throughput.

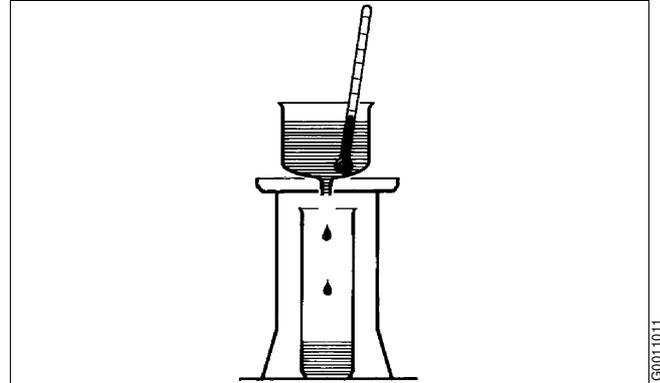


*The centrifugal solution*

### 3.1.1 Factors influencing the separation result

#### Separating temperatures

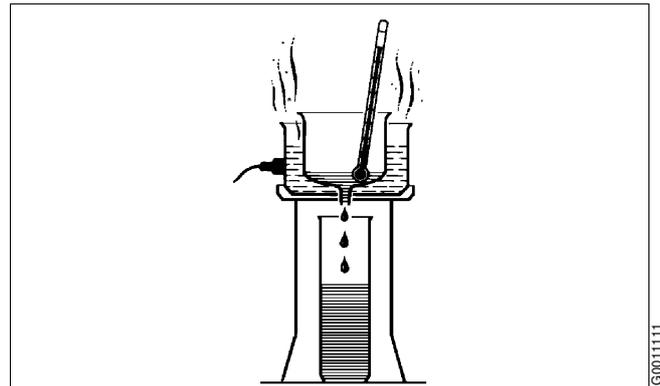
For some types of process liquids (e.g. mineral oils) a high separating temperature will normally increase the separation capacity. The temperature influences oil viscosity and density and should be kept constant throughout the separation.



*High viscosity (with low temperature)*

#### Viscosity

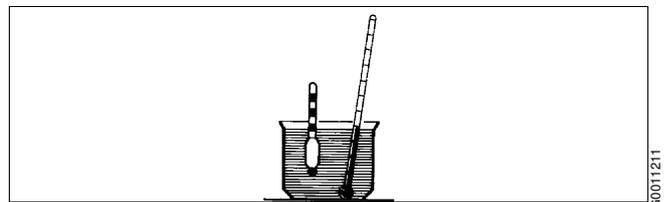
Low viscosity facilitates separation. Viscosity can be reduced by heating.



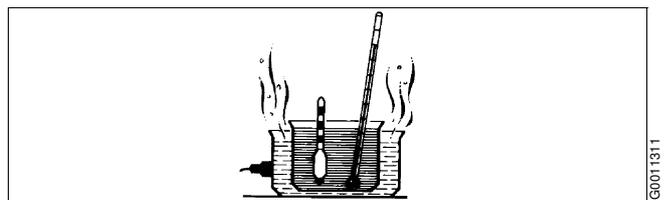
*Low viscosity (with high temperature)*

#### Density difference

The greater the density difference between the two liquids, the easier the separation. The density difference can be increased by heating.



*High density (with low temperature)*



*Low density (with high temperature)*

### Phase proportions

An increased quantity of water in a oil will influence the separating result through the optimum transporting capacity of the disc stack. An increased water content in the oil can be compensated for by reducing the throughput in order to restore the optimum separating efficiency.

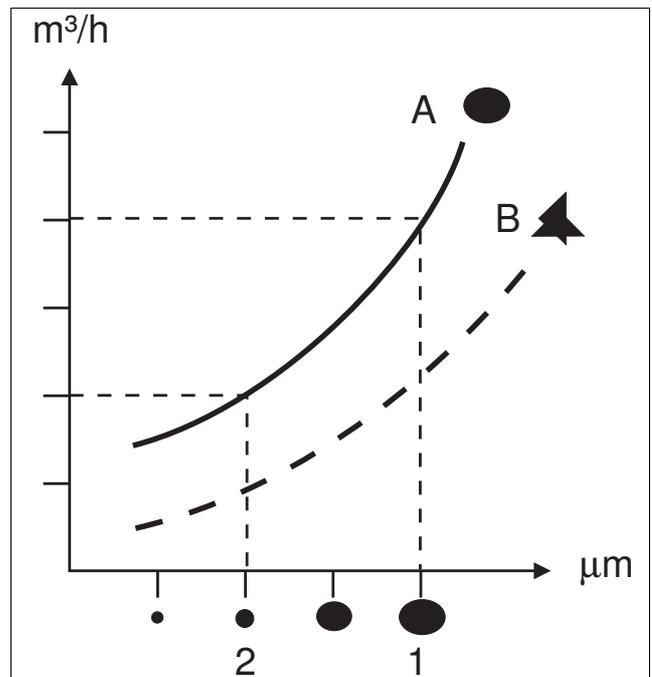
### Size and shape of particles

The round and smooth particle (A) is more easily separated out than the irregular one (B).

Rough treatment, for instance in pumps, may cause a splitting of the particles resulting in slower separation. Larger particles (1) are more easily separated than smaller ones (2) even if they have the same density.

### The throughput

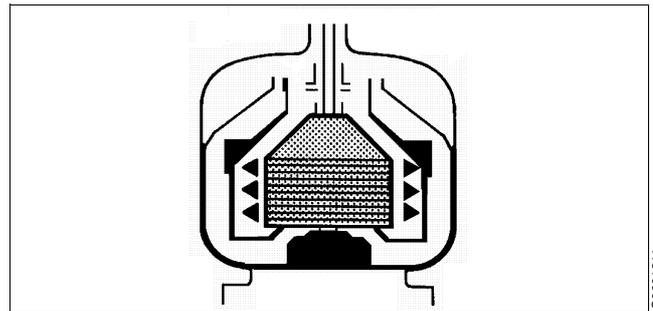
The throughput sets the time allowed for the separation of water and sediment from the oil. A better separation result can often be achieved by reducing the throughput, i.e. by increasing the settling time.



*Influence of size and shape*

### Sludge space - sludge content

The sediment accumulates along the bowl wall. If the sludge is allowed to fill up the space outside the discs the flow in the bowl is influenced, and the separating efficiency is reduced. In such cases the time between discharge of sediment should be reduced to prevent this effect.



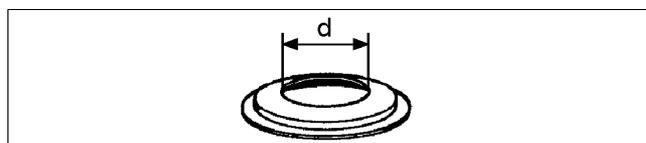
*Sludge accumulation*

### Disc stack

A neglected disc stack containing deformed discs or discs coated with deposits will impair the separating result.

### Gravity disc

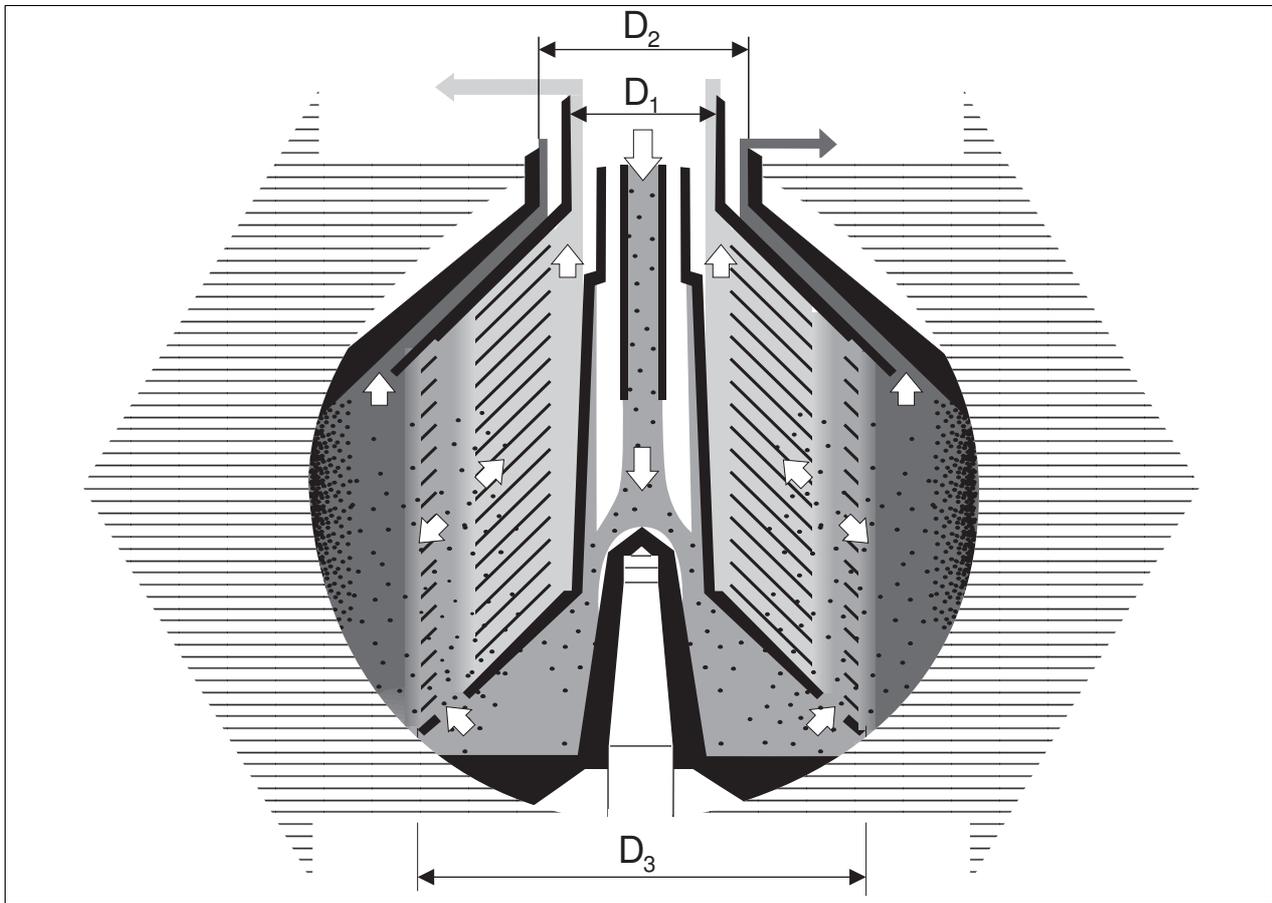
The position of the interface is adjusted by altering the outlet diameter of the heavy liquid phase, that is by exchanging the gravity disc.



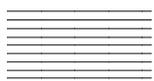
*Gravity disc diameter sets the oil/water interface*



3.1.2 Purification



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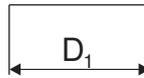
Centrifugal force



Bowl parts



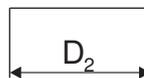
Process liquid



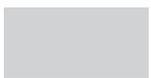
$D_1$  Diameter of inner outlet



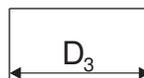
Heavy liquid phase



$D_2$  Hole diameter of gravity disc



Light liquid phase



$D_3$  Diameter of interface



Sediment (solids)

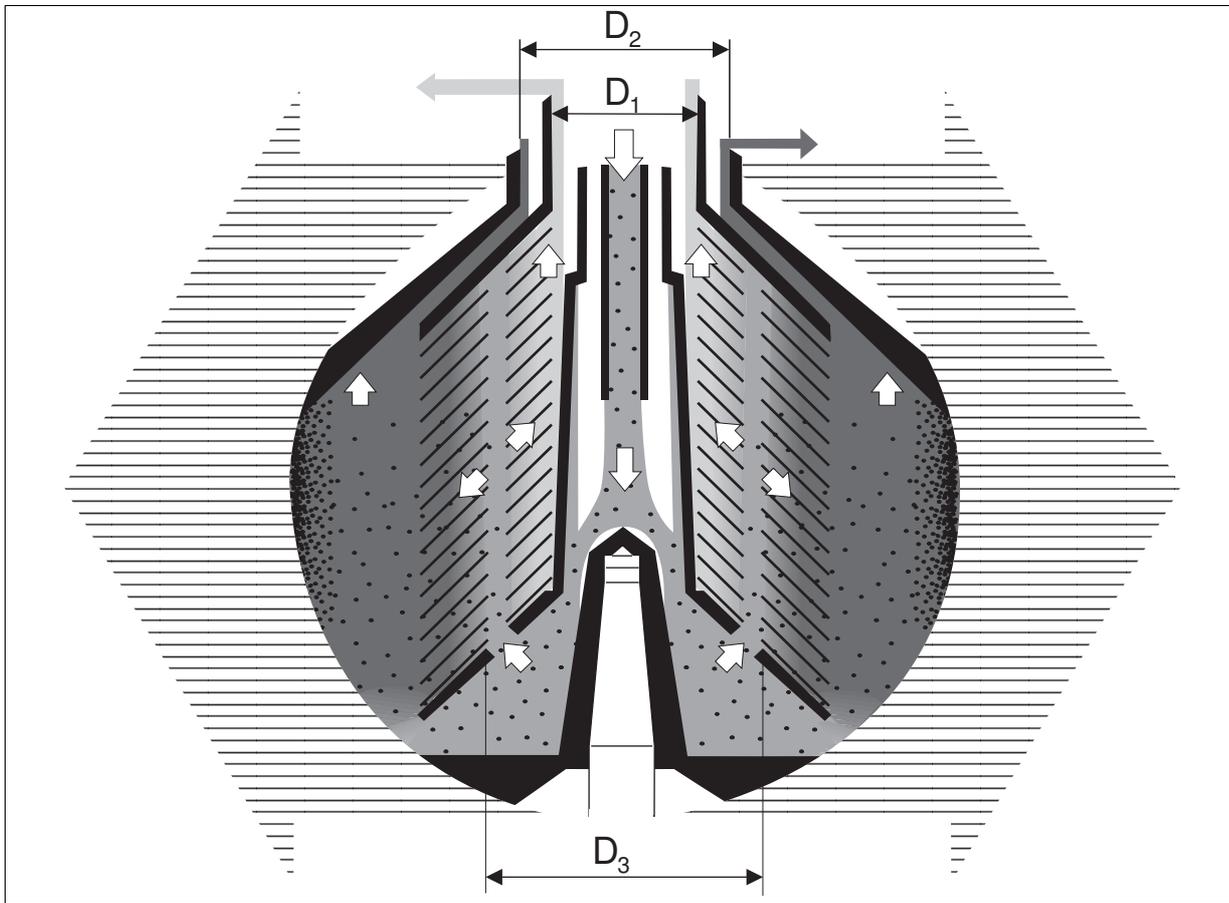
This bowl has two liquid outlets. The process liquid flows into the bowl through the centre and into the space under the distributor.

The liquid flows up through slots in the distributor and distribution holes in the bowl discs and is divided among the interspaces between the discs, where the liquid phases are separated from each other by action of the centrifugal force.

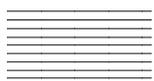
The heavy phase and any sediment move along the underside of the bowl discs towards the periphery of the bowl, where the sediment accumulates. The heavy phase proceeds along the upper side of the top disc towards the neck of the bowl hood and leaves the bowl via the gravity disc - *the outer way* (dark coloured in illustration).

The light phase moves along the upper side of the bowl discs towards the bowl centre and leaves the bowl via the oil paring disc - *the inner way* (light coloured in illustration).

3.1.3 Concentration



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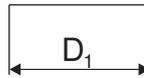
Centrifugal force



Bowl parts



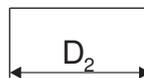
Process liquid



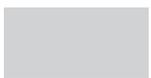
$D_1$  Diameter of inner outlet



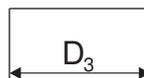
Heavy liquid phase



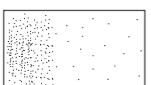
$D_2$  Hole diameter of gravity disc



Light liquid phase



$D_3$  Diameter of interface



Sediment (solids)

This bowl has two liquid outlets. The process liquid flows into the bowl through the centre and into the space under the distributor.

The liquid flows up through slots in the distributor and distribution holes in the bowl discs and is divided among the interspaces between the discs, where the liquid phases are separated from each other by action of the centrifugal force. As the process starts an interface area forms between the heavy phase and the light phase.

The heavy phase and any sediment move along the underside of the bowl discs towards the periphery of the bowl, where the sediment settles on the bowl wall. The heavy phase proceeds outside the top disc towards the neck of the bowl hood and leaves the bowl via the gravity disc - *the outer way* (dark coloured in illustration).

The light phase moves along the upper sides of the bowl discs towards the bowl centre and leaves the bowl via the oil paring disc- *the inner way* (light coloured in illustration).

### 3.1.4 Position of interface

The bowl is adjusted for separation of liquid mixtures having various densities by altering the diameter ( $D_2$ ) of the outlet for the heavy phase. This in turn influences the diameter of the interface ( $D_3$ ).

For this purpose two gravity discs with various hole diameters is delivered with the separator.

Where to locate the interface between light phase and heavy phase depends on which phase should be cleaned the most, and on the proportions between the two phases as well, see below [“3.1.5 Selection of gravity disc” on page 26](#).

### 3.1.5 Selection of gravity disc

The gravity disc is located inside the bowl hood. A gravity disc with a larger hole will move the interface towards the bowl periphery, whereas a disc with a smaller hole will place it closer to the bowl centre.

In a concentrator bowl the interface should be located near the middle of the discs, not too close to the distribution holes.

Where to locate the interface depends on which phase should be delivered pure, and on the proportions between the amounts of the two phases as well. Guidelines are also that the heavier or more viscous the light phase and the larger the liquid feed the smaller the diameter should be.

- If the light phase is wanted more free from the heavy one, the interface should be located nearer the bowl periphery. However, if the gravity disc is too big the interface may form outside the edge of the top disc, and the liquid seal is broken.
- When the heavy phase is wanted more free from the light one, the interface should be located nearer the bowl centre. However, if the gravity disc is too small the interface will form within the range of the distribution holes of the discs, and untreated liquid may be discharged through the light phase outlet.

When optimizing the separation process, keep the following directions in mind:

- If light phase is present in the heavy phase outlet before the desired throughput has been obtained, the gravity disc selected is too large. Fit the gravity disc with the smaller hole.
- If the heavy phase is present in the light phase outlet before the desired throughput has been obtained, the gravity disc selected is too small. Fit the gravity disc with the larger hole.

## 3.2 Design and function

### 3.2.1 Application

The MSPX 303TGP-61 is a high-speed centrifugal separator intended for marine and land applications. It is specifically designed for cleaning sludge from oil treatment systems in diesel engine installations.

The sludge consists of a mixture of water, oil and solids and is separated into its main parts; the oil and water are discharged continuously, while the solid particles are discharged at intervals.

The separator can be operated either as a purifier or as a concentrator depending on the amounts of oil/water/solid particles in the sludge.

The separator has to be installed together with devices for control of its operation.

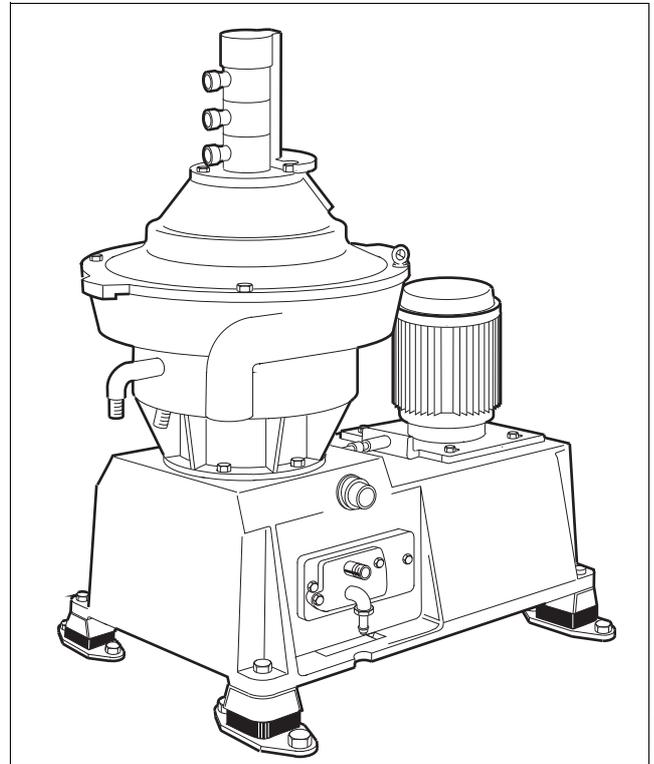


#### **WARNING**

#### **Disintegration hazards**

Use the separator only for the purpose and parameters (type of liquid, rotational speed, temperature, density etc.) specified in chapter “8 Technical Reference” on page 139 and in the Purchase Order documents.

Consult your Alfa Laval representative before any changes outside these parameters are made.



*The MSPX 303TGP-61 separator*

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### 3.2.2 Design

The MSPX 303TGP-61 separator comprises a frame consisting of a frame with a lower part, an intermediate part and a top part with frame hood.

The separator bowl (2) is driven by an electric motor (4) via a flat-belt power transmission (6) and a bowl spindle (3). The motor drive is equipped with a friction coupling to prevent overload.

The bowl is of disc type and hydraulically operated at sludge discharges. The hollow bowl spindle features an impeller which pumps closing water from a built-in tank to the operating system for sludge discharge.

The main inlets and outlets are shown with their connection numbers in the illustration. The connections are listed in chapter “8 Technical Reference” on page 139, where also the basic size drawing can be found.

### 3.2.3 Outline of function

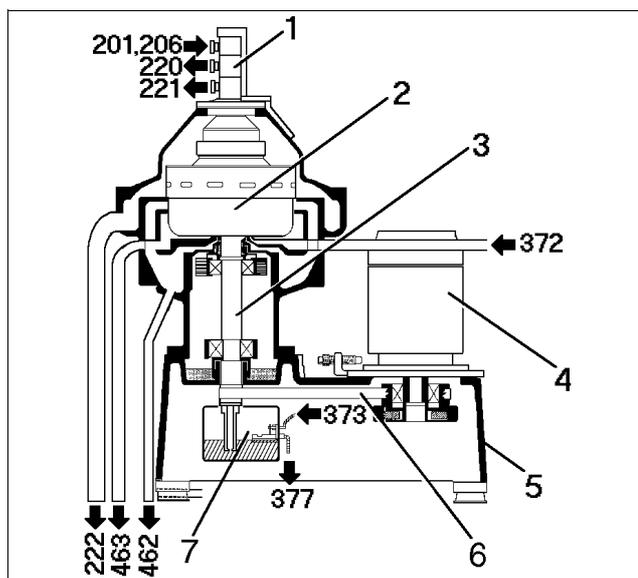
The separation process takes place in the rotating bowl. Unseparated sludge is fed into the bowl through the feed inlet (201). The separated oil leaves the separator through the outlet (220) via a paring disc. The separated water leaves through outlet 221 via a paring disc.

The solid particles which are heavier than the water are collected as concentrated sludge in the sludge space at the bowl periphery and removed automatically at regular intervals.

Permissible pressures and operating conditions are specified in chapter “8 Technical Reference” on page 139.

The processing parts of the separator are shown in the illustration on next page.

There are no contacting surfaces between process rotating parts (the bowl) and stationary parts (inlet, outlet, feed devices), and the interfacing surfaces are not sealed. As the separation process is carefully balanced regarding pressures and fluid levels, any leakages will not occur as long as the correct running conditions are maintained.



Sectional view  
Main parts, inlets and outlets

1. Inlet and outlet device
  2. Bowl
  3. Bowl spindle
  4. Electric motor
  5. Frame lower part
  6. Flat belt
  7. Closing water tank
- 
201. Feed inlet
  206. Sealing water
  220. Oil outlet
  221. Water outlet
  222. Concentrated sludge outlet
  372. Opening water inlet
  373. Bowl closing water inlet
  377. Operating liquid outlet
  462. Drain of frame top part (lower)
  463. Drain of frame top part (upper)

### 3.2.4 Separating function

#### Liquid flow

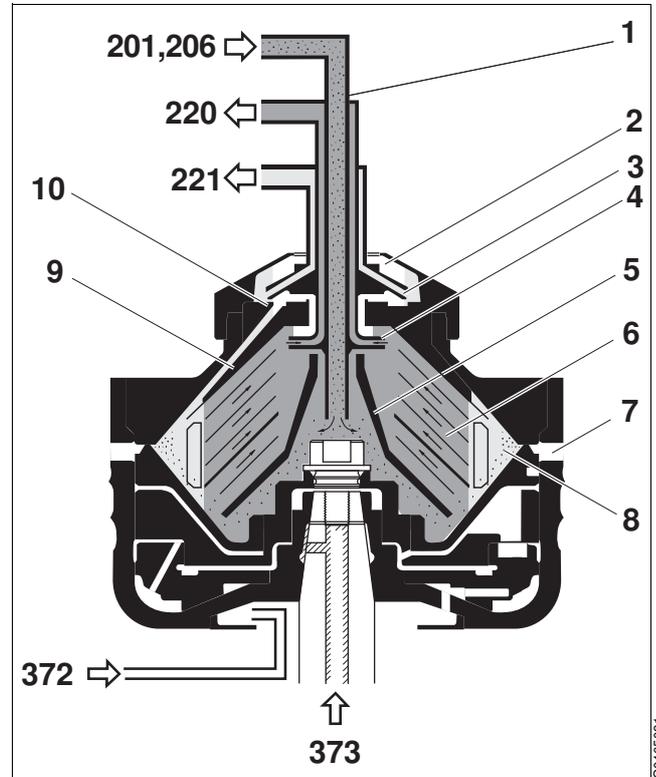
Separation takes place in the separator bowl to which sludge is fed through the inlet pipe (1). The sludge is led by the distributor (5) towards the periphery of the bowl.

When the sludge reaches the slots of the distributor, it will rise through the channels formed by the disc stack (6) where it is evenly distributed.

In the disc stack oil and water are continuously separated from the sludge. The oil flows towards the center of the bowl and when it leaves the disc stack rises upwards to the oil paring disc (4). From there it is pumped by the paring disc and leaves the separator through the oil outlet (220).

Separated sludge and water will move towards the bowl periphery. Separated water rises along the outside of the disc stack, passes through the top disc channels over the gravity disc (10) and enters the water paring chamber. From here it is pumped by the water paring disc (3) and leaves the separator through the water outlet (221).

Concentrated sludge are collected in the sludge space (8) outside the disc stack and are discharged at intervals through the sludge ports (7).



1. Inlet pipe
2. Water paring chamber
3. Water paring disc
4. Oil paring disc
5. Distributor
6. Disc stack
7. Sludge ports
8. Sludge space
9. Top disc
10. Gravity disc

201. Feed inlet
206. Sealing water inlet
220. Oil outlet
221. Water outlet
372. Opening water inlet
373. Bowl closing water

### Water seal

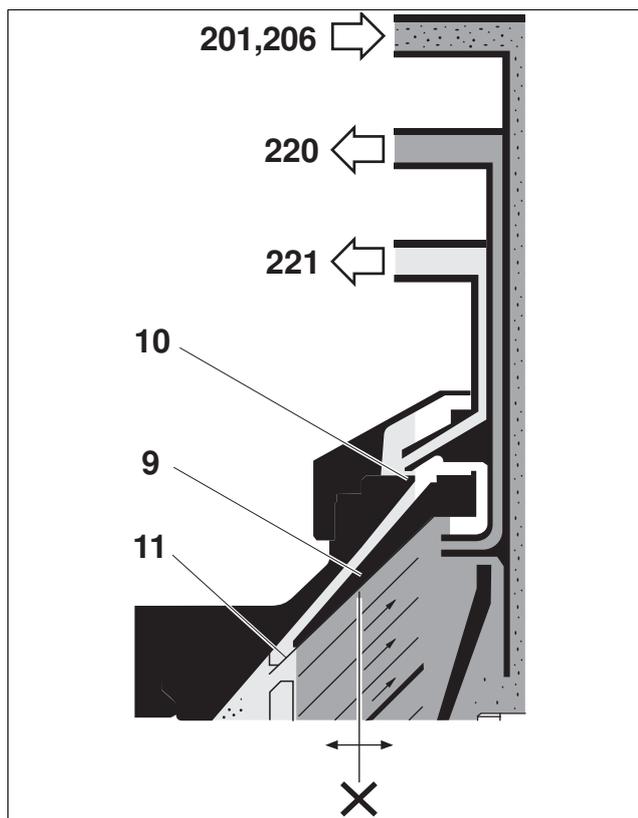
To prevent oil from passing the outer edge of the top disc (9) and escaping through the water outlet (221), a water seal must be provided in the bowl. This is done by filling the bowl with water through the water inlet (206), before unseparated sludge is supplied. The water will then be forced towards the bowl periphery and an interface (X) will form between the water and the sludge. The position of the interface is determined by the density and viscosity of the unseparated sludge.

### Covering disc

When cleaning sludge with high content of water and /or solid particles the sludge space may be filled up very quickly with solid particles which prevents water to leave the bowl.

If shortening the time between sludge discharges (see [“3.2.5 Sludge discharge function” on page 31](#)) does not help the covering disc can be removed instead.

Removing the covering disc enlarges the sludge space and make it easier for the water to leave the bowl.



*Principle of liquid seal*

- 9. Top disc
- 10. Gravity disc
- 11. Covering disc
- X. Normal interface position

- 201. Feed inlet
- 206. Sealing water
- 220. Oil outlet
- 221. Water outlet

### 3.2.5 Sludge discharge function

Sludge is discharged through a number of ports (7) in the bowl wall. Between discharges these ports are covered by the sliding bowl bottom (12), which forms an internal bottom in the separating space of the bowl. The sliding bowl bottom is pressed upwards against a sealing ring (11) by force of the closing water underneath.

The sliding bowl bottom is operated hydraulically by means of operating water supplied to the discharge mechanism from an external freshwater line. Opening water is supplied directly to the operating system in the bowl while closing water is supplied to the built-in closing water tank, and pumped to the operating system through the bowl spindle.

The opening and closing only takes a fraction of a second, therefore the discharge volume is limited to a certain percentage of the bowl volume.

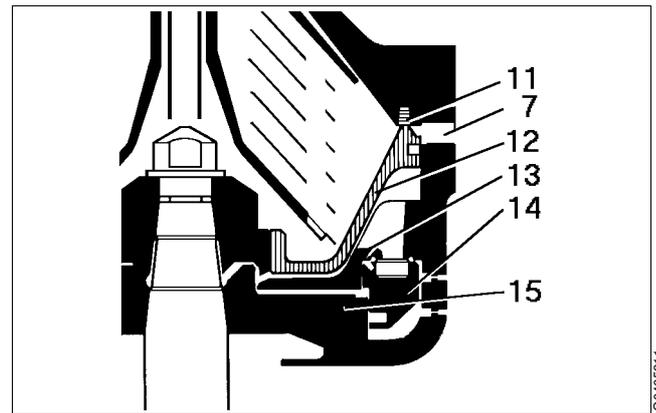
This action is achieved by the closing water filling space above the upper distributing ring (13) and pushing the sliding bowl bottom upwards. Simultaneously, the water in the chamber below the operating slide is drained off through the nozzles in the bowl body.

#### Bowl opening

The key event to start a sludge discharge is the downward movement of the operating slide. This is accomplished by supply of opening water (372) to the discharge mechanism. Water is drained off through nozzles (16) in the bowl body. The sliding bowl bottom is rapidly pressed downwards by the force from the liquid in the bowl, opening the sludge ports.

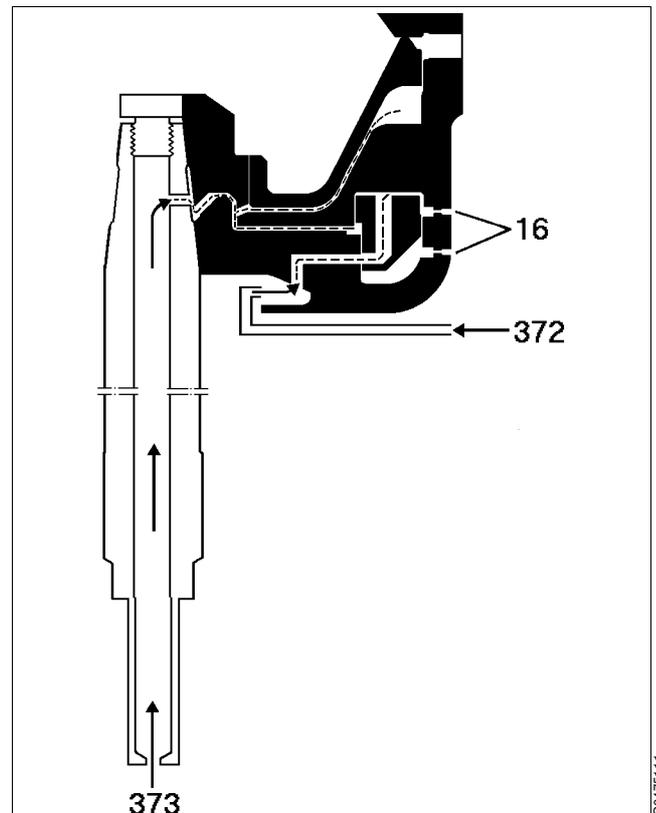
#### Bowl closing

After the sludge is discharged the sliding bowl bottom is immediately pressed up and the sludge ports in the bowl wall are closed.



*Sludge discharge mechanism*

- 7. Sludge ports
- 11. Sealing ring
- 12. Sliding bowl bottom
- 13. Upper distributing ring
- 14. Operating slide
- 15. Lower distributing ring



*Supply of opening water and closing water*

- 16. Nozzles
- 372. Opening water
- 373. Closing and make-up water through bowl spindle

### 3.2.6 Power transmission

#### Bowl spindle

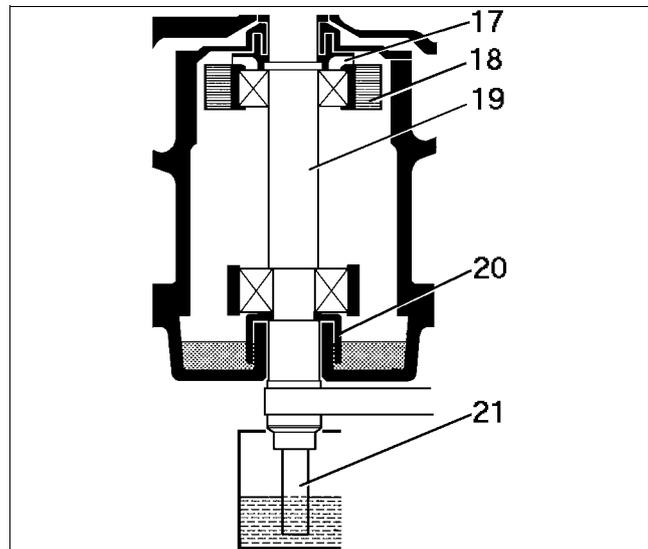
In addition to its primary role in the power transmission system, the bowl spindle also serves as:

- pump for the closing water
- supply pipe for the closing water
- lubricator for spindle ball bearings.

Closing water is pumped through the hollow spindle (19) to the discharge mechanism in the bowl. For this purpose a pump sleeve (21) is fitted in the lower end.

The two spindle bearings are lubricated with oil mist. An oil pump (20) creates the oil mist, which is sucked through the upper ball bearing by a fan (17). Oil is supplied via an oil filling device, which also serves as a level indicator.

Two identical ring-shaped rubber buffers (18) support the top bearing housing. The buffers are held in place by a buffer holder and form channels through which the recirculated oil passes.



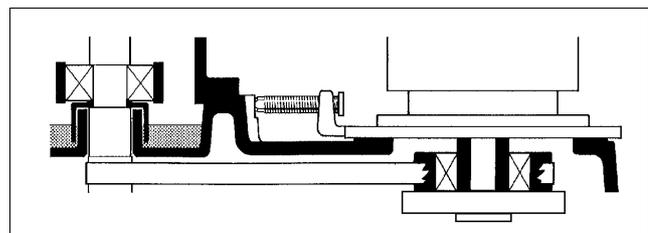
*Bowl spindle assembly*

- 17. Fan
- 18. Buffers
- 19. Bowl spindle
- 20. Oil pump
- 21. Pump sleeve

#### Belt drive

The bowl spindle is driven by a flat belt. Adaptation to 50 or 60 Hz power supply is made by selecting the motor belt pulley with the appropriate diameter. A longer belt is needed for the pulley for 50 Hz.

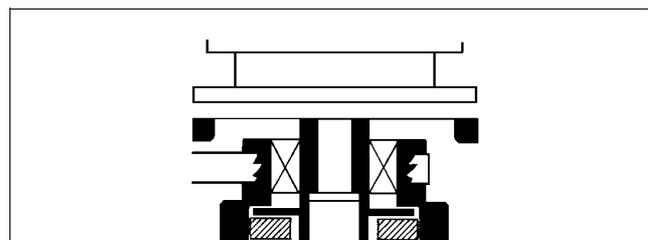
Procedure for change of belt will secure a fixed distance between spindle and motor belt pulley.



*Belt drive*

#### Friction coupling

The friction coupling on the motor pulley ensures gentle start-up and prevents overload of the electric motor. Centrifugal force creates a torque that acts on the pulley through the friction elements.



*Friction coupling*

### **3.2.7 Sensors and indicators**

#### **Sight glass**

The sight glass shows the oil level in the oil sump.

## 3.3 Definitions

<b>Back pressure</b>	Pressure in the separator outlet.
<b>Concentration</b>	Liquid/liquid/solids separation with the intention of separating two intermixed and mutually insoluble liquid phases of different densities. Solids having a higher density than the liquids can be removed at the same time. The heavier liquid phase (water), which is the major part of the mixture, shall be purified as far as possible. The lighter phase must be concentrated.
<b>Counter pressure</b>	See Back pressure.
<b>Density</b>	Mass per volume unit. Expressed in kg/m <sup>3</sup> at a specified temperature, normally at 15 °C.
<b>Gravity disc</b>	Disc in the bowl hood for positioning the interface between the disc stack and the outer edge of the top disc. This disc is only used in purifier mode.
<b>Interface</b>	Boundary layer between the heavy phase (water) and the light phase (oil) in a separator bowl.
<b>Intermediate Service (IS)</b>	Overhaul of separator bowl and inlet/outlet. Renewal of seals in bowl and inlet/outlet.
<b>Major Service (MS)</b>	Overhaul of the complete separator, including bottom part (and activities included in an Intermediate Service). Renewal of seals and bearings in bottom part.
<b>Phase</b>	Light phase: the lighter liquid separated, e.g. oil. Heavy phase: the heavier liquid separated, e.g. water.
<b>Purification</b>	Liquid/liquid/solids separation with the intention of separating two intermixed and mutually insoluble liquid phases of different densities. Solids having a higher density than the liquids can be removed at the same time. The <b>lighter</b> liquid phase, which is the major part of the mixture, shall be purified as far as possible.
<b>Sediment (sludge)</b>	Solids separated from a liquid.
<b>Sludge discharge</b>	Ejection of sludge from the separator bowl.
<b>Throughput</b>	The feed of process liquid to the separator per time unit. Expressed in m <sup>3</sup> /hour or litres/hour.
<b>Viscosity</b>	Fluid resistance against movement. Normally expressed in centistoke (cSt = mm <sup>2</sup> /s), at a specified temperature.
<b>Water seal</b>	Water in the solids space of the separator bowl to prevent the light phase (oil) from leaving the bowl through the heavy phase (water) outlet, in purifier mode.

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# 4 *Operating Instructions*

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## Contents

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## 4.1 Operating routine

These operating instructions describe routine procedures to follow before and during the start, running and stopping sequences of the separator.

If system documentation is available always follow the operating instructions of this. If there is no system documentation the instructions below are to be followed.

### 4.1.1 Before first start

Technical demands for connections and logical limitations for the separator are listed in chapter [“8 Technical Reference” on page 139](#):

- Technical data
- Connection list
- Interface description
- Basic size drawing
- Foundation drawing.

Before first start the following shall be checked:

1. Ensure the machine is installed correctly and that feed lines and drains have been flushed clean.
2. Fill oil in the oil sump. Fill up to the middle of the sight glass. For grade and quality of oil see [“8.6.3 Recommended lubricating oils” on page 160](#).

### 4.1.2 Selection of gravity disc

The separator is delivered with two gravity discs with different diameters. The hole diameter of the gravity disc sets the position of the oil/water interface in the separator, see [“3.1.4 Position of interface” on page 25](#). The separation efficiency can be optimized by selection of the correct diameter for each oil quality.

The best separated water quality is obtained by using the gravity disc with the small hole diameter. The best separated oil quality is obtained by using the gravity disc with the large hoile diameter

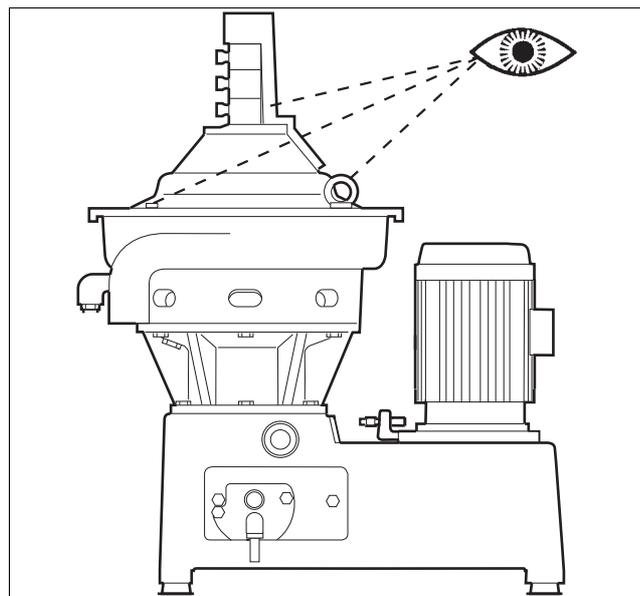
### 4.1.3 Start after a service

Pay special attention to unusual conditions when starting the separator after a service. Different fault symptoms are listed in chapter “7 Troubleshooting” on page 127.

### 4.1.4 Before normal start

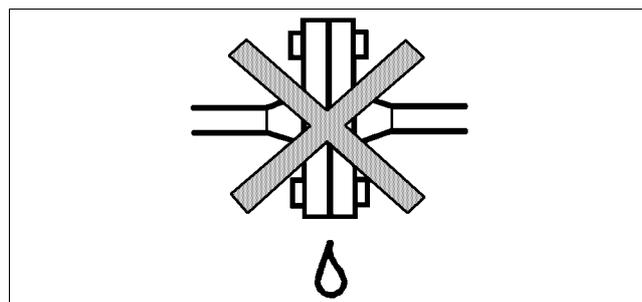
Check these points before every start.

1. Decide if the covering disc should be fitted or not. It depends on the amounts of oil/water/solid particles in the sludge.
2. Make sure that the bowl is clean and that the separator is properly assembled.
3. Make sure that the bolts of the outlet cover and the frame hood are fully tightened.



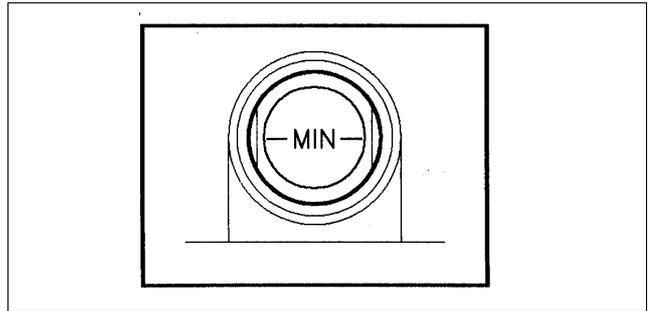
Check assembly and tightenings

4. Make sure that all couplings and connections are securely tightened to prevent leakage.
5. Make sure that the inlet pipe is tightened.



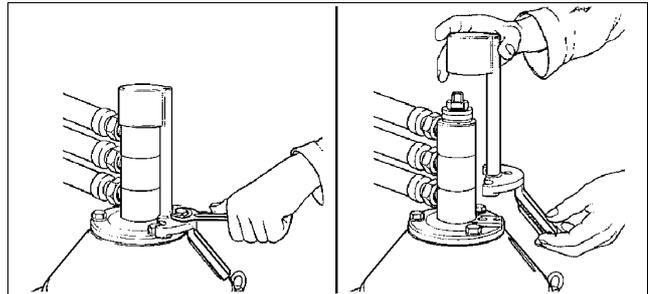
Check for leakages (not admitted)

6. Read the oil level. The line in the middle of the sight glass shows the **minimum** level. Refill if necessary.  
 For grade and quality of oil see [“8.6.3 Recommended lubricating oils”](#) on page 160.



Check the oil level

7. Make sure the direction of rotation of the motor and bowl corresponds to the sign on the frame.  
 Remove the safety device, see illustration. Look through the slot in the frame hood and make a quick start and stop. Correct rotational direction is **clockwise**.

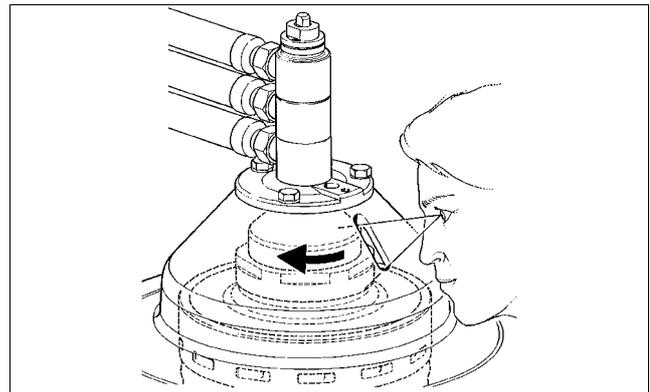




**WARNING**

**Disintegration hazards**

If the direction of rotation is wrong, vital parts could unscrew.





**WARNING**

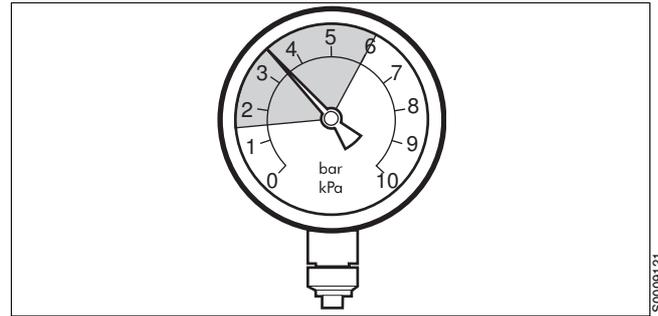
**Disintegration hazards**

After change of feed the sludge discharge interval must be adjusted.

Too long intervals between discharges can result in breakdown.

### 4.1.5 Starting and running-up procedure

1. Open the water supply valve(s). Make sure that the water supply is on 150-600 kPa (1,5-6 bar).
2. Start the separator.
3. Be alert for unusual noises and conditions.
4. Note the normal occurrence of critical speed periods. Some vibrations occur for short periods during the starting cycle, when the separator passes through its critical speeds. This is normal and passes over without danger. Try to learn the vibration characteristics of the critical speed pattern.



Water supply



#### WARNING

##### Disintegration hazards

When excessive vibration occurs, **keep bowl filled** and **stop** separator.

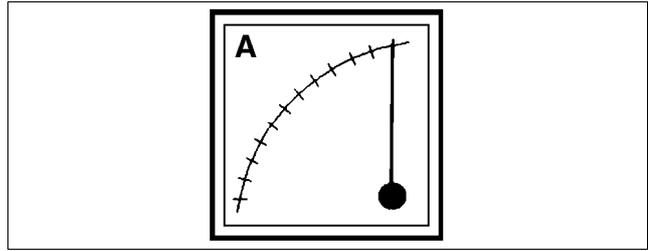
The cause of the vibration must be identified and rectified before the separator is restarted.

Excessive vibration may be due to incorrect assembly or insufficient cleaning of the bowl.

5. Check the current to the separator motor to ensure that the separator has reached full speed:

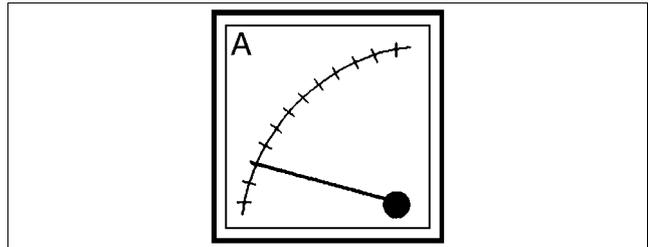
During start, the current reaches a peak and then slowly drops to a low and stable value.

For normal length of the start-up period see [“8.2 Technical data” on page 142.](#)



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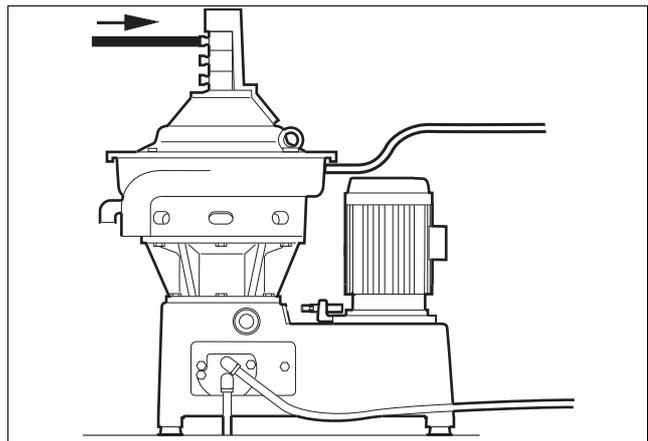
*Current increases during start...*



S0009631

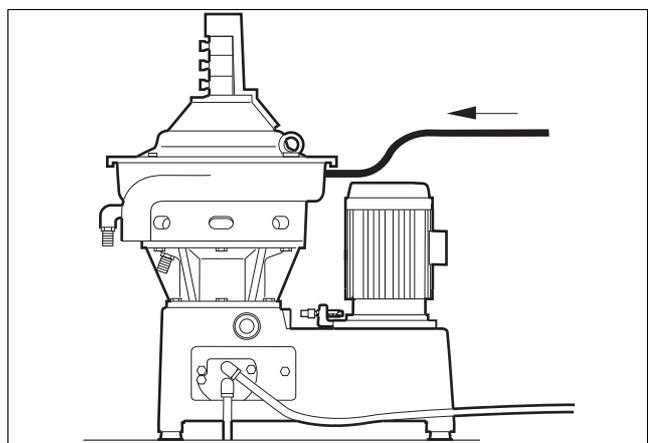
*... to decrease to a stable value when full speed has been reached*

6. Supply water to form the water-seal. The water should have the same temperature as the process liquid and be supplied quickly.



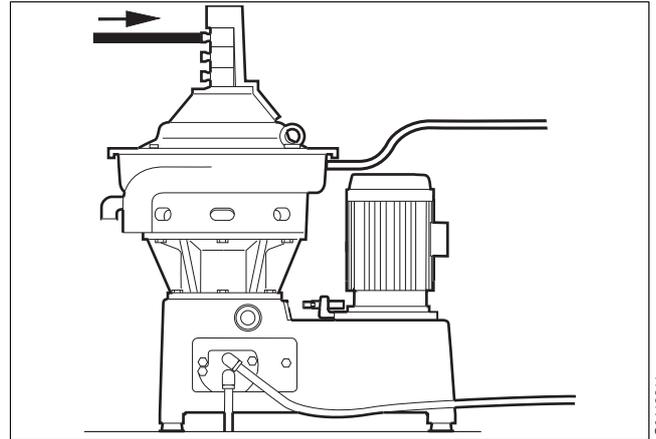
G0412311

7. Initiate a couple of discharges to see that the separator is working properly.



G0465811

8. Feed the unseparated liquid to the separator. Start the feed slowly to avoid breaking the water seal. Then fill the bowl as quickly as possible.
9. Check the separator inlet and outlet pressures. See recommended values in your system documentation.
10. Adjust to desired throughput.



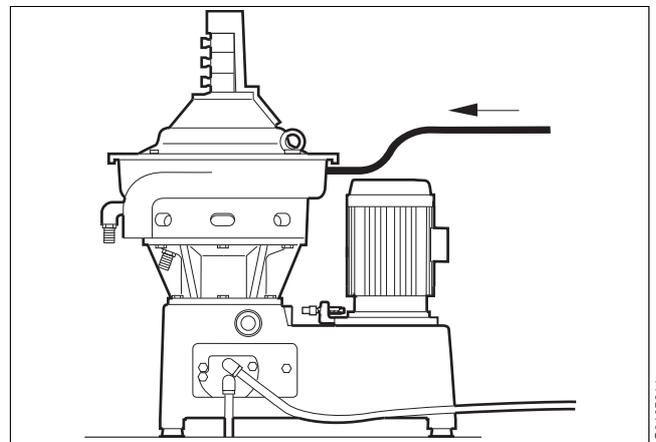
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### 4.1.6 Separation

Initiate a discharge every 5 minutes.

Do regular checks on:

- oil inlet temperature (if applicable)
- water collecting tank level (if applicable)
- sound/vibration of the separator
- back pressure
- motor current.



G0465811

### 4.1.7 Stopping procedure

1. Turn off the feed to the separator.
2. Initiate a discharge.
3. Feed water to the separator.
4. Stop the separator.
5. Wait until the separator has come to a complete standstill (13-17 minutes).

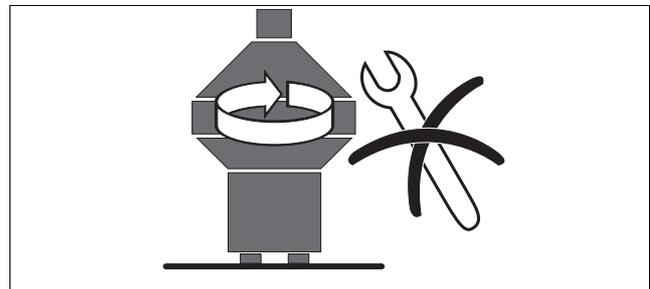
Remove the safety device and look through the slot in the frame hood to see the movement of the bowl.



#### WARNING

#### Entrapment hazards

Make sure that rotating parts have come to a **complete standstill** before starting **any** dismantling work.



*The separator must not be dismantled before standstill*

### 4.1.8 Safety stop

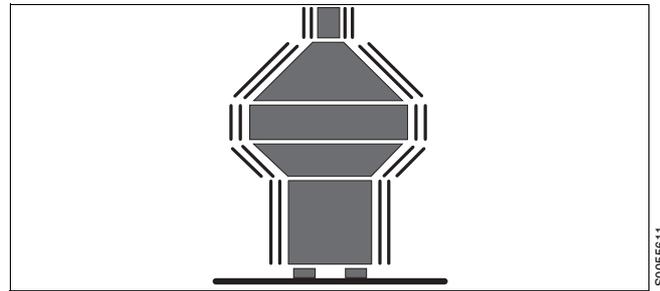
If the separator begins to **vibrate** excessively during operation, stop it immediately by pushing the **safety stop**. The separator motor is switched off.

- Keep the **bowl filled** during the run-down to minimize the excessive vibration.

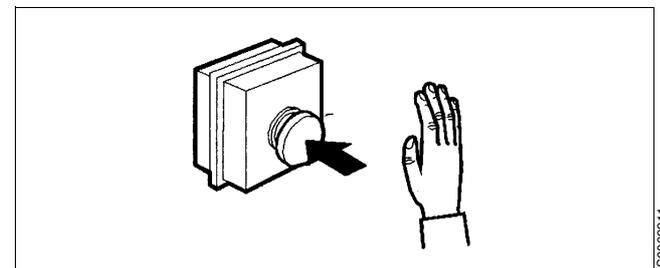
**Evacuate the room.** The separator may be hazardous when passing its critical speeds during the run-down.

	<b>WARNING</b>
	<b>Disintegration hazards</b>
Never discharge a vibrating separator.	

	<b>CAUTION</b>
	<b>Disintegration hazards</b>
After a safety stop the cause of the fault must be identified.	
If all parts have been checked and the cause remains unclear, contact Alfa Laval for advice.	



*Hazard!*



*Push the safety stop!*

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# 5 *Service Instructions*

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## 5.1 Periodic maintenance

### 5.1.1 Introduction

Periodic, preventive maintenance reduces the risk of unexpected stoppages and breakdowns. Maintenance logs are shown on the following pages in order to facilitate periodic maintenance.

	<p><b>WARNING</b></p> <p><b>Disintegration hazards</b></p> <p>Separator parts that are worn beyond their safe limits or incorrectly assembled may cause severe damage or fatal injury.</p>
---	--

### 5.1.2 Maintenance intervals

The following directions for periodic maintenance give a brief description of which parts to clean, check and renew at different maintenance intervals.

The service logs for each maintenance interval later in this chapter give detailed enumeration of the checks that must be done.

**Daily checks** consist of simple check points to carry out for detecting abnormal operating conditions.

**Oil change** interval is 1500 hours. If the total number of operating hours is less than 1500 hours change oil at least once every year.

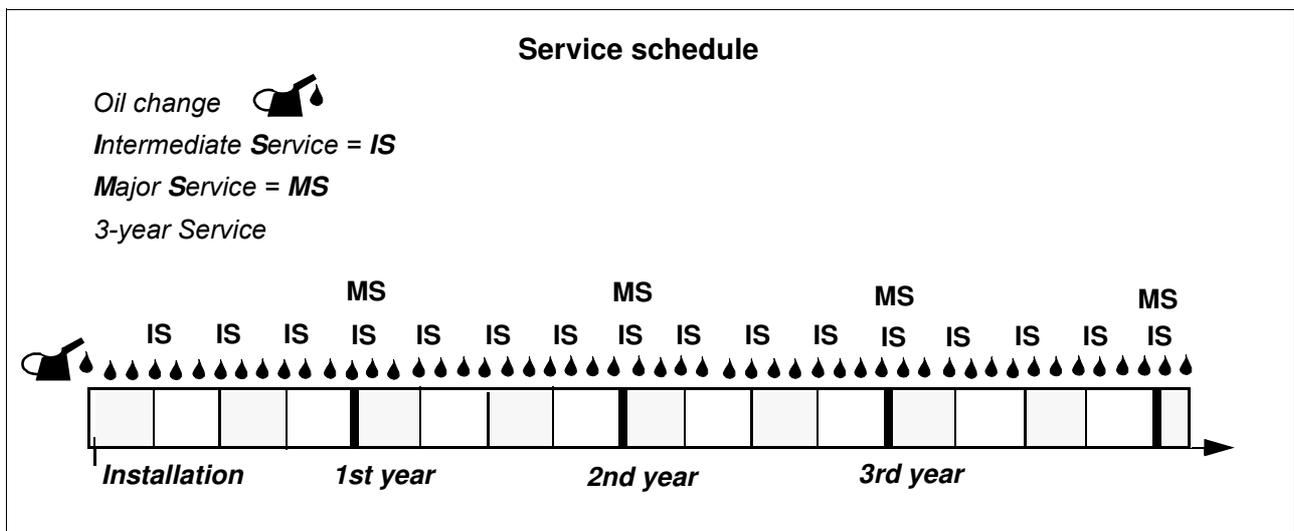
Time of operation between oil changes can be extended from the normal 1500 hours to 2000 hours if a synthetic oil of group D is used.

In seasonal operation change the oil before a new period.

**IS - Intermediate Service** consists of an overhaul of the separator bowl, inlet and outlet every 3 months or 2000 operating hours. Seals in bowl and gaskets in the inlet/outlet device and operating device are renewed.

**MS - Major Service** consists of an overhaul of the complete separator every 12 months or 8000 operating hours. An Intermediate Service is performed, and the flat belt, friction elements, seals and bearings in the bottom part are renewed.

**3S - 3-year service** consists of service of the coupling bearings, service of frame intermediate part and renewal of frame feet. The rubber feet get harder with increased use and age. Interval: Every 3 years independent of number of operating hours.



### Other

Check and prelubricate spindle bearings of separators which have been out of service for 6 months or longer. See also [“5.10.2 Before shut-downs” on page 81](#).

### NOTE

#### Do not interchange bowl parts!

To prevent mixing of parts, e.g. in an installation comprising several machines of the same type, the major bowl parts carry the machine manufacturing number or its last three digits.

### 5.1.3 Maintenance procedure

At each intermediate and major service, take a copy of the service log and use it for notations during the service.

An intermediate and major service should be carried out in the following manner:

1. Dismantle the parts as mentioned in the service log and described in chapter “6 Dismantling/Assembly” on page 83.  
Place the separator parts on clean, soft surfaces such as pallets.
2. Inspect and clean the dismantled separator parts according to the service log.
3. Fit all the parts delivered in the service kit while assembling the separator as described in chapter “6 Dismantling/Assembly” on page 83. The assembly instructions have references to check points which should be carried out during the assembly.

### 5.1.4 Service kits

Special service kits are available for Intermediate Service (IS), Major Service (MS) and 3-year service (3S).

For other services the spare parts have to be ordered separately.

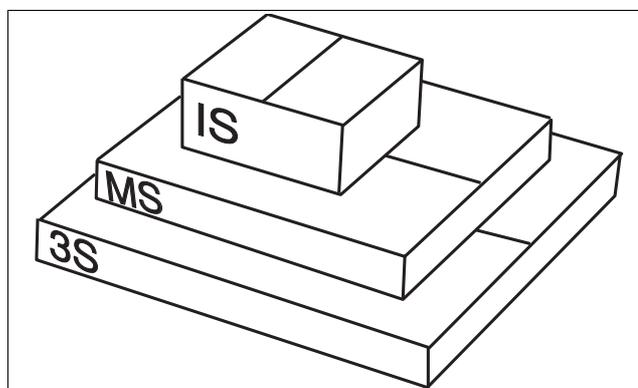
Note that the parts for IS are **not** included in the MS kit.

The contents of the service kits are described in the *Spare Parts Catalogue*.

#### NOTE

Always use Alfa Laval genuine parts as otherwise the warranty will become invalid.

Alfa Laval takes no responsibility for the safe operation of the equipment if non-genuine spare parts are used.



*Spare parts kits are available for Intermediate Service, Major Service and 3-year Service*

## 5.2 Maintenance Logs

### 5.2.1 Daily checks

The following steps should be carried out daily.

Main component and activity	Part	Page	Notes
<b>Inlet and outlet</b> Check for leakage	Connecting housing	37	
<b>Separator bowl</b> Check for vibration and noise		39	
<b>Belt transmission</b> Check for vibration and noise		39	
<b>Oil sump</b> Check	Oil level	38	
<b>Electrical motor</b> Check for heat, vibration and noise See manufacturer's instructions			

### 5.2.2 Oil change - monthly

The oil change and check of belt transmission should be carried out every 1500 hours of operation.

When using a group D oil, time of operation between oil changes can be extended from the normal 1500 hours to 2000 hours.

When the separator is run for short periods, the lubricating oil must be changed every 12 months even if the total number of operating hours is less than 1500 hours (less than 2000 hours if a group D oil is used).

See chapter [“8.6 Lubricants” on page 155](#) for further information on oil brands etc.

Main component and activity	Part	Page	Notes
<b>Bowl spindle and transmission</b>			
Check	Belt tension	<a href="#">119</a>	
Change	Oil in oil sump	<a href="#">75</a>	

### 5.2.3 IS - Intermediate Service

Name of plant: \_\_\_\_\_ Local identification: \_\_\_\_\_  
 Separator: MSPX 303TGP-61 Manufacture No./Year: \_\_\_\_\_  
 Total running hours: \_\_\_\_\_ Product No.: 881099-02-06  
 Date: \_\_\_\_\_ Signature: \_\_\_\_\_

Renew all parts included in the Intermediate Service kit (IS) and do the following activities.

Main component and activity	Part	Page	Notes	
<b>Inlet and outlet, frame</b>  Clean and inspect	Threads of inlet pipe	64		
	Paring disc	64		
	Housings and frame hood	-		
<b>Separator bowl</b>  Clean and inspect	Bowl hood	65		
	Top disc	74		
	Bowl discs	74		
	Distributor	-		
	Nozzles in bowl body	60		
	Sliding bowl bottom	61		
	Discharge mechanism	60		
	Threads on bowl hood and bowl body	65		
	Bowl spindle cone and bowl body nave	63		
	Check	Disc stack pressure	67	
		Galling of guide surface	65	
Corrosion, erosion, cracks		56 - 58		
<b>Power transmission</b>				
	Check	Belt and belt tension	119	
Change	Oil in oil sump	75		

<b>Main component and activity</b>	<b>Part</b>	<b>Page</b>	<b>Notes</b>
<b>Electrical motor</b> Lubrication (if nipples are fitted)	See sign on motor	-	
<b>Signs and labels on separator</b> Check attachment and legibility	Safety label on hood Other plates and labels	171 171	

### 5.2.4 MS - Major Service

Name of plant: \_\_\_\_\_ Local identification: \_\_\_\_\_  
 Separator: MSPX 303TGP-61 Manufacture No./Year: \_\_\_\_\_  
 Total running hours: \_\_\_\_\_ Product No.: 881099-02-06  
 Date: \_\_\_\_\_ Signature: \_\_\_\_\_

Renew all parts included in the Intermediate and Major Service kits and do the following activities.

Main component and activity	Part	Page	Notes	
<b>Inlet and outlet, frame</b> Clean and inspect	Threads of inlet pipe	64		
	Paring disc	64		
	Housings and frame hood	-		
<b>Separator bowl</b> Clean and inspect	Bowl hood	65		
	Top disc	74		
	Bowl discs	74		
	Distributor	-		
	Nozzles in bowl body	60		
	Sliding bowl bottom	61		
	Discharge mechanism	60		
	Threads on bowl hood and bowl body	65		
	Bowl spindle cone and bowl body nave	63		
	Check	Height of paring disc	68	
		Disc stack pressure	67	
		Galling of guide surface	65	
Corrosion, erosion, cracks		56 - 58		

Main component and activity	Part	Page	Notes
<b>Vertical driving device</b>			
Clean and inspect	Oil mist fan	111	
	Oil pump	111	
	Water tank	125	
	Pump sleeve		
	Bowl spindle	99	
	Ball bearing housing indentations	99	
Check	Radial wobble of bowl spindle	69	
<b>Oil sump</b>			
Clean	Oil sump	75	
Change	Oil	75	
Clean and inspect	Oil filling device	124	
<b>Friction coupling</b>			
Clean and inspect	Friction coupling	113	
<b>Electrical motor</b>			
Replace	Bearings <sup>1)</sup>		
<b>Signs and labels on separator</b>			
Check attachment and legibility	Safety label on hood	171	
	Other signs and labels	171	

<sup>1)</sup> See manufacturer's instructions.

## 5.3 3-year service

Additional to a major service do the following:

### Exchange of frame feet

See [“6.7.1 Mounting of new frame feet”](#) on page 126.

### Friction coupling

Exchange of ball bearings, see [“6.3 Friction coupling”](#) on page 113.

### Frame intermediate part

Replace O-ring and gasket, see [“6.2.2 Bowl spindle and frame – assembly”](#) on page 106.

### Frame hood

Replace seal ring.

## 5.4 Check points at Intermediate Service

### 5.4.1 Corrosion

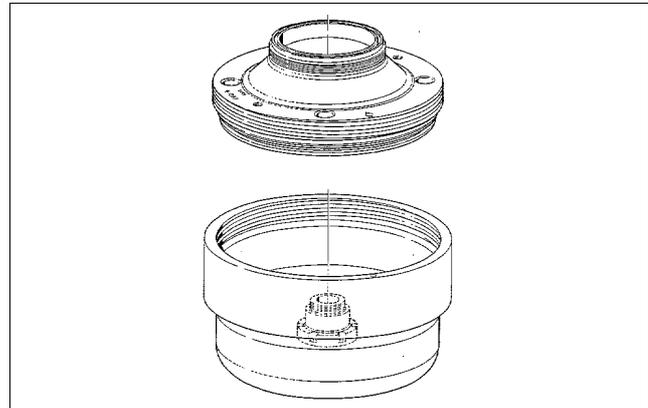
Evidence of corrosion attacks should be looked for and rectified each time the separator is dismantled. Main bowl parts such as the bowl body and hood must be inspected with particular care for corrosion damage.



#### WARNING

#### Disintegration hazard

Inspect regularly for corrosion damage.  
Inspect frequently if the process liquid is corrosive.



Main bowl parts to check for corrosion

G017211

Always contact your Alfa Laval representative if you suspect that the largest depth of a corrosion damage exceeds 1,0 mm or if cracks have been found. Do not continue to use the separator until it has been inspected and given clearance for operation by Alfa Laval.

Cracks or damage forming a line should be considered as being particularly hazardous.

#### Non-stainless steel and cast iron parts

Corrosion (rusting) can occur on unprotected surfaces of non-stainless steel and cast iron. Frame parts can corrode when exposed to an aggressive environment.

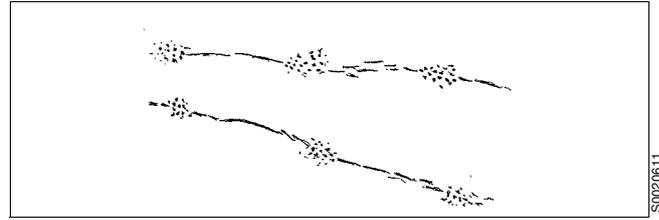
### Stainless steel

Stainless steel parts corrode when in contact with either chlorides or acidic solutions. Acidic solutions cause a general corrosion. The chloride corrosion is characterised by local damage such as pitting, grooves or cracks. The risk of chloride corrosion is higher if the surface is

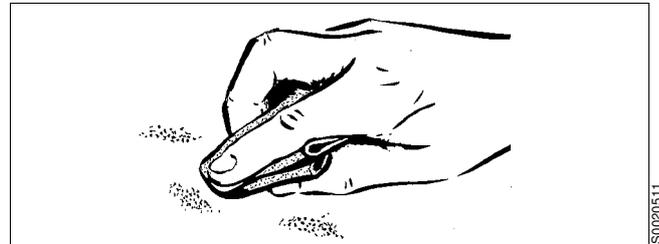
- exposed to a stationary solution,
- in a crevice,
- covered by deposits,
- exposed to a solution that has a low pH value.

A corrosion damage caused by chlorides on stainless steel begins as small dark spots that can be difficult to detect.

- Inspect closely for all types of damage by corrosion and record these observations carefully.
- Polish dark-coloured spots and other corrosion marks with a fine grain emery cloth. This may prevent further damage.



*Example of chloride corrosion in stainless steel*



*Polish corrosion marks to prevent further damage*



#### **WARNING**

#### **Disintegration hazard**

Pits and spots forming a line may indicate cracks beneath the surface.

All forms of cracks are a potential danger and are totally unacceptable.

Replace the part if corrosion can be suspected of affecting its strength or function.

### Other metal parts

Separator parts made of materials other than steel, such as brass or other copper alloys, can also be damaged by corrosion when exposed to an aggressive environment. Possible corrosion damage can be in the form of pits and/or cracks.

### 5.4.2 Erosion

Erosion can occur when particles suspended in the process liquid slide along or strike against a surface. Erosion can become intensified locally by flows of higher velocity.



**WARNING**

**Disintegration hazard**

Inspect regularly for erosion damage. Inspect frequently if the process liquid is erosive.

Always contact your Alfa Laval representative if the largest depth of any erosion damage exceeds 1,0 mm. Valuable information as to the nature of the damage can be recorded using photographs, plaster impressions or hammered-in lead.

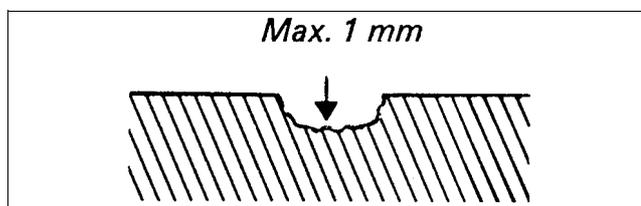
Erosion is characterised by:

- Burnished traces in the material.
- Dents and pits having a granular and shiny surface.

Parts of the bowl particularly subjected to erosion are:

- The paring disc.
- The top disc.
- The underside of the distributor in the vicinity of the distribution holes and wings.
- The sludge ports.
- The seal ring in the bowl hood.

Look carefully for any signs of erosion damage. Erosion damage can deepen rapidly and consequently weaken parts by reducing the thickness of the metal.



*Maximum permitted erosion*

G020521

### 5.4.3 Cracks

Cracks can initiate on the machine after a period of operation and propagate with time.

- Cracks often initiate in areas exposed to high cyclic material stresses. These cracks are called fatigue cracks.
- Cracks can also initiate due to corrosion in an aggressive environment.
- Although very unlikely, cracks may also occur due to the low temperature embrittlement of certain materials.

The combination of an aggressive environment and cyclic stresses will speed-up the formation of cracks. Keeping the machine and its parts clean and free from deposits will help to prevent corrosion attacks.

	<b>WARNING</b>
	<b>Disintegration hazard</b>
All forms of cracks are potentially dangerous as they reduce the strength and functional ability of components.	
Always replace a part if cracks are present.	

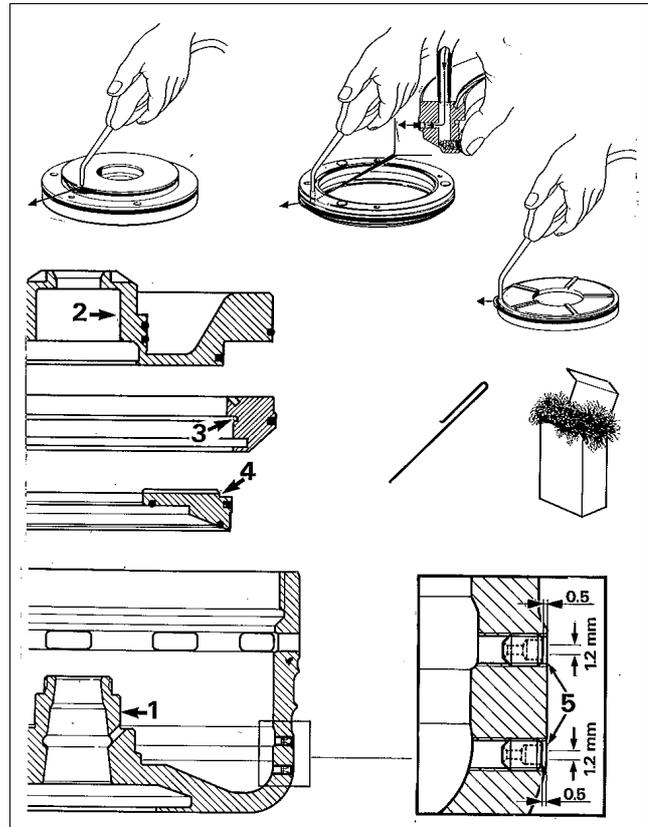
It is particularly important to inspect for cracks in rotating parts.

Always contact your Alfa Laval representative if you suspect that the largest depth of the damage exceeds 1,0 mm. Do not continue to use the separator until it has been inspected and cleared for operation by Alfa Laval.

### 5.4.4 Discharge mechanism

Dirt and lime deposits in the sludge discharge mechanism can cause discharge malfunction or no discharge.

- Thoroughly clean and inspect the parts. Pay special attention to important surfaces (1, 2, 3 and 4). If necessary, polish with steel wool.
- Clean nozzles (5) using soft iron wire or similar. Note that lime deposits can with advantage be dissolved in a 10% acetic acid solution.
- Use Loctite 242 on the threads if the nozzles have been removed or replaced.



### 5.4.5 Bowl hood and sliding bowl bottom

Poor sealing between the bowl hood seal ring and the edge of the sliding bowl bottom will cause a leakage of process liquid from the bowl.

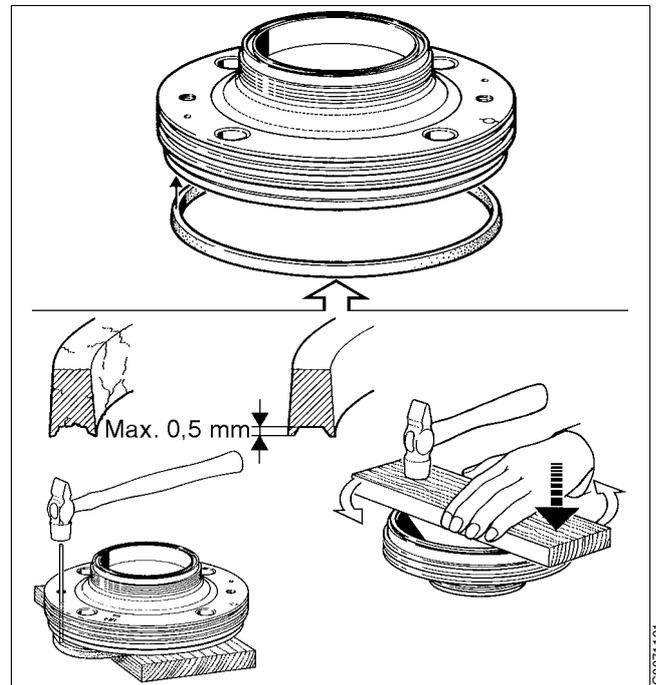
Fit a new bowl hood seal ring at each Intermediate Service (IS) if the old ring is damaged or indented more than **0,5 mm**.

Fit a new ring as follows:  
Press the ring into the groove with a straight board (1" x 4"), placed across the ring.

#### NOTE

If a new ring is too narrow, put it into hot water, 70 - 80 °C for about 5 minutes.

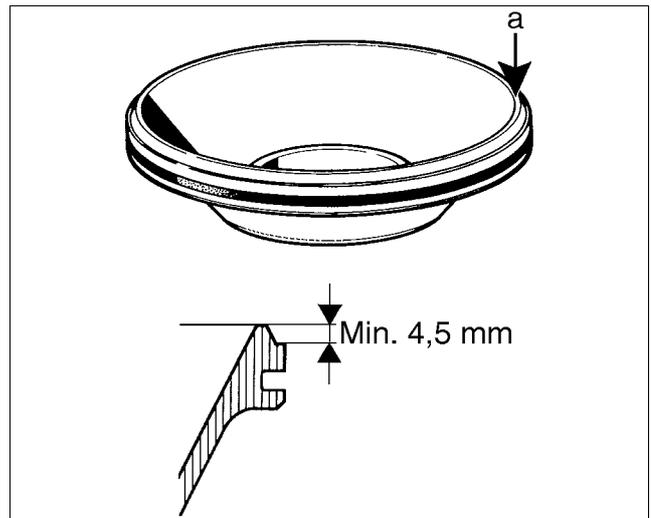
If it is too wide it will recover after drying at 80 - 90 °C for about 24 hours.



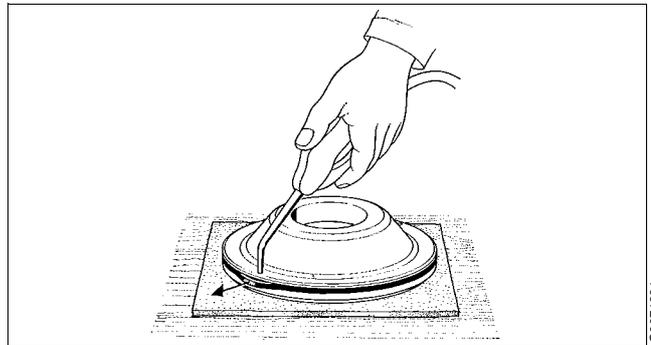
Exchange of seal ring in bowl hood

Check the sealing edge (a) of the sliding bowl bottom.

If damaged by corrosion or erosion or in other ways it can be rectified by turning in a lathe. Minimum permissible height of sealing edge: **4,5 mm**.



a. Sealing edge on sliding bowl bottom



Removal of seal ring on sliding bowl bottom

### 5.4.6 Spindle top cone and bowl body nave

Impact marks on the spindle cone or in the bowl body nave may cause the separator to vibrate while running.

Corrosion may cause the bowl to stick firmly to the spindle cone and cause difficulties during the next dismantling.

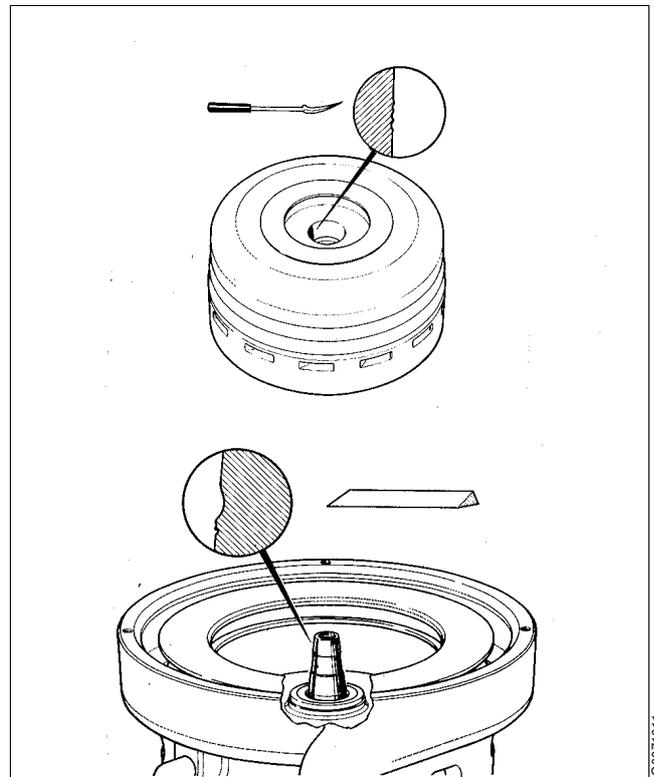
- Remove any impact marks using a scraper and/or a whetstone.

Rust can be removed by using a fine-grain emery cloth (e.g. No. 320).

Finish with polishing paper (e.g. No. 600).

#### NOTE

Always use a scraper with great care. The conicity must not be marred.

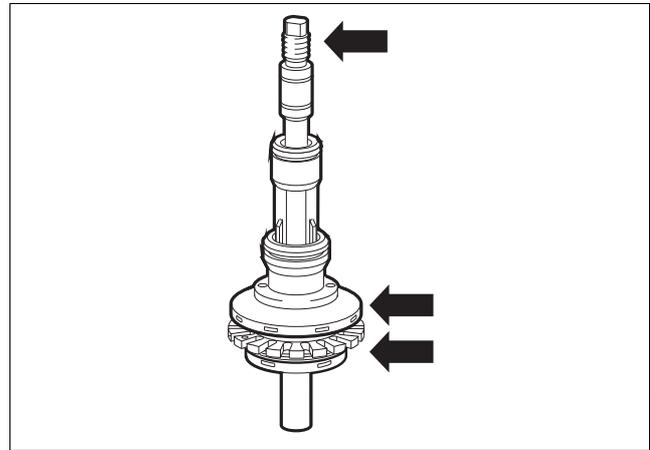


*Use whetstone or scraper with great care*

### 5.4.7 Threads of inlet pipe, paring disc

Damage to threads or a broken paring disc can prevent correct tightening of the inlet pipe and cause the paring disc to scrape against the top disc, even though the height adjustment of the paring disc has been made correctly.

1. Examine the threads for damage and rectify if required.
2. Examine the paring disc for damage and to see if the disc walls have parted. If they have, the inlet pipe has to be replaced with a new one.



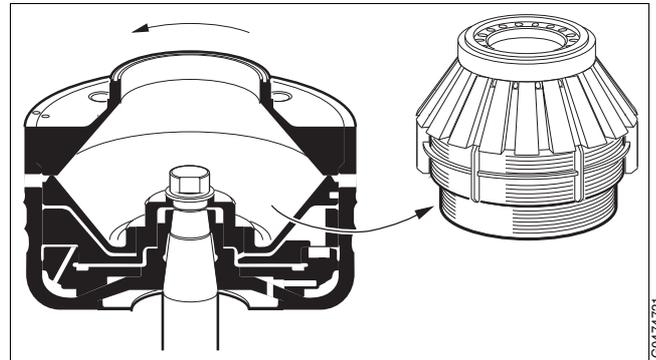
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### 5.4.8 Threads on bowl hood and bowl body

Excessive wear or impact marks on threads and guide surfaces of the bowl hood or bowl body can cause seizure damage.

Examine the thread condition by tightening the bowl hood after removing the disc stack and top disc from the bowl.

When the bowl is new the alignment marks on the bowl hood and the bowl body should be aligned. If not, contact an Alfa Laval representative.



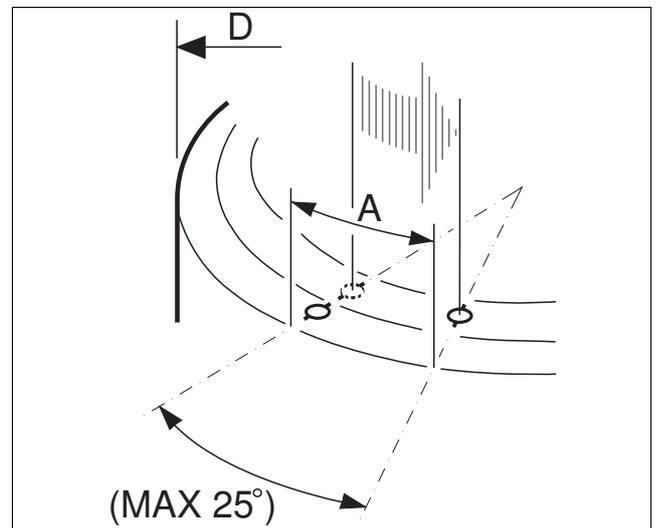
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#### Wear

If thread wear is observed, mark the bowl body at the new position by punching a new alignment mark. If the mark on the bowl hood passes the mark on the bowl body by more than  $25^\circ$ , (A in the illustration) an Alfa Laval representative should be contacted immediately.

The measure A in millimetres (mm) is obtained by calculating bowl outside diameter D times 0,2.

If the marks are illegible, an Alfa Laval representative should be contacted for determination and punching of new alignment marks.



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#### WARNING

#### Disintegration hazards

**Wear** on threads must not exceed safety limit.  $\phi$  mark on bowl hood must not pass  $\phi$  mark on bowl body by more than  $25^\circ$ .

**Damage**

The position of threads, contact and guide surfaces are indicated by arrows in the illustration.

Examine for burrs and protrusions caused by impact.

Clean the threads, contact and guide surfaces with a suitable degreasing agent.



**CAUTION**

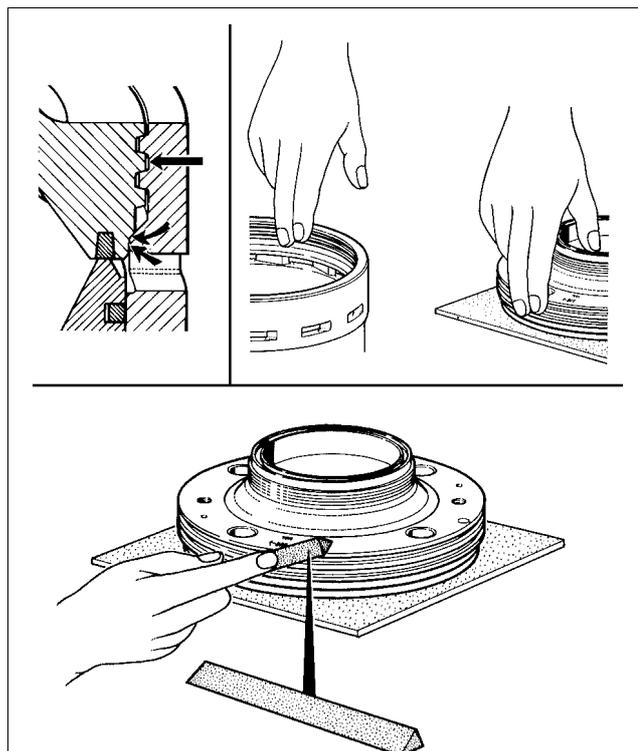
**Cut hazard**

The threads have sharp edges which can cause cuts.

If damage is found, rectify by using a whetstone or fine emery cloth. Recommended grain size: 240.

If the damage is bad, use a fine single-cut file, followed by a whetstone.

After rectifying, the threads have to be primed with Molykote 1000.



*Contact surfaces to inspect on the bowl*

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### 5.4.9 Disc stack pressure

The bowl hood exerts a pressure on the disc stack clamping it in place.

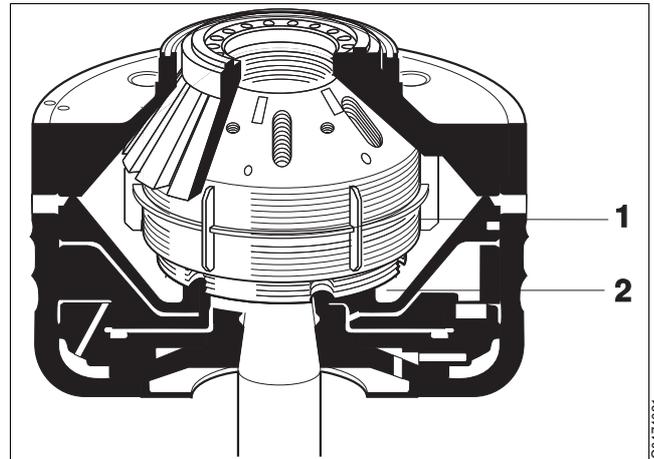
#### NOTE

Insufficient pressure in the disc stack may affect the bowl balance, which in turn will cause abnormal vibration of the separator and shorten the life of ball bearings.

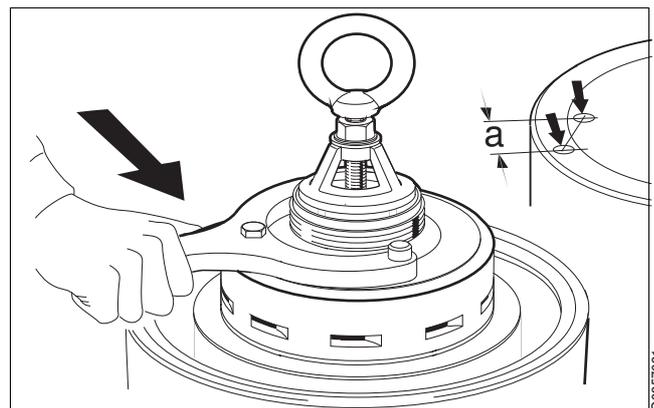
1. Place the bowl hood on the top of the disc stack and tighten it by hand.  
The assembly mark on the bowl hood should now be positioned at the angle  $a$  (see illustration),  $30^\circ - 60^\circ$  ahead of the corresponding mark on the bowl body.
2. If the bowl hood can be tightened by hand without resistance until the marks are in line with each other, an extra disc must be added to the top of the disc stack beneath the top disc.
3. If one or more discs have been added re-check the disc stack pressure by repeating the procedure above.

#### NOTE

The top disc can stick inside the bowl hood and fall when the hood is lifted.



1. *Bowl discs, large size:*  
At least 26 in number
2. *Bowl discs, small size:*  
12 in number



- a. *Angle  $30^\circ - 60^\circ$  between assembly marks before final tightening*

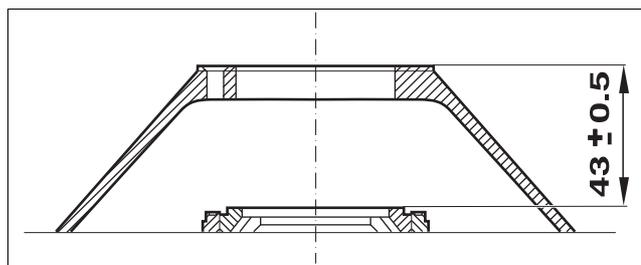
## 5.5 Check points at Major Service

### 5.5.1 Paring disc height adjustment

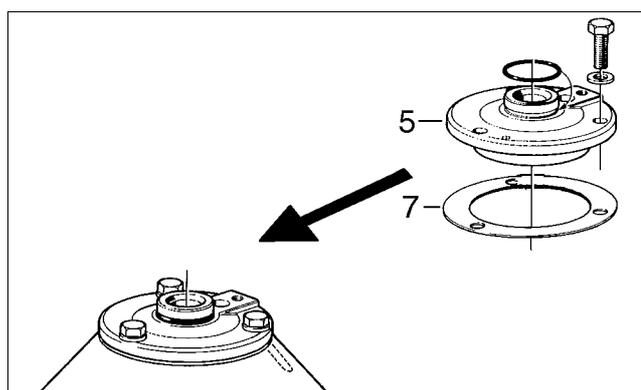
The height between the top disc and the frame hood must be measured if the bowl spindle has been dismantled or if the bowl has been replaced with a new one.

#### NOTE

Incorrect height position can cause the paring disc to scrape against the paring chamber cover. Pay attention to scraping noise at start-up after service.



1. Remove safety device and inlet and outlet housings from the frame hood if not already done. Remove the connecting housing.
2. Lift off frame hood.
3. Remove paring chamber cover, discharge pipe and gravity disc from the bowl.
4. Lift on frame hood.
5. Measure the distance according to the illustration above. Adjust the distance by adding or removing height adjusting rings.
6. Reassemble the connecting housing and lift off the frame hood.
7. Fit gravity disc, discharge pipe and paring chamber cover.
8. Lift on the frame hood and mount inlet/outlet housing and safety device.
9. With inlet and outlet parts mounted:
10. Rotate the bowl spindle by hand by means of the flat belt. If it does not rotate freely or if a scraping noise is heard, incorrect height adjustment or incorrect fitting of the inlet pipe can be the cause. Remove the parts and readjust.
11. Finally, fit the safety device.



### 5.5.2 Radial wobble of bowl spindle

The bowl spindle wobble must be measured if the bowl spindle has been dismantled or if rough bowl run (vibration) occurs.

#### NOTE

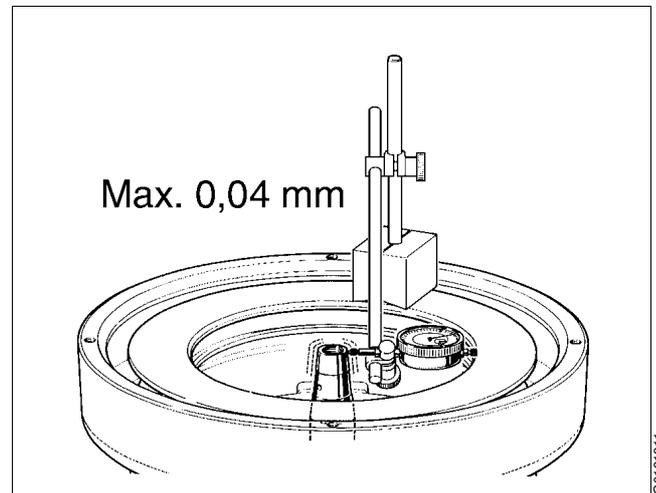
Spindle wobble will cause rough bowl run. This leads to vibration and reduces lifetime of ball bearings.

Check the wobble **before** removing the bowl spindle.

If the bowl spindle has been dismantled check the wobble before installing the bowl.

1. Fit a dial indicator in a support and fasten it in position as illustrated.
2. Remove the water tank from the frame bottom part for access to the flat belt. Use the flat belt to turn the spindle.
3. Permissible radial wobble: max. **0,04 mm**.  
If the spindle wobble is more than the maximum permitted value, contact Alfa Laval representatives.
4. Finally fit the water tank to the frame bottom part.

Incorrect belt tension causes displacement of the vertical line of the spindle centre, but does not affect the wobble of the spindle.



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## 5.6 Lifting instructions

1. Remove the inlet/outlet housings, the frame hood and the bowl according to the instructions in chapter "6.1.2 Inlet/outlet and bowl – dismantling" on page 86.

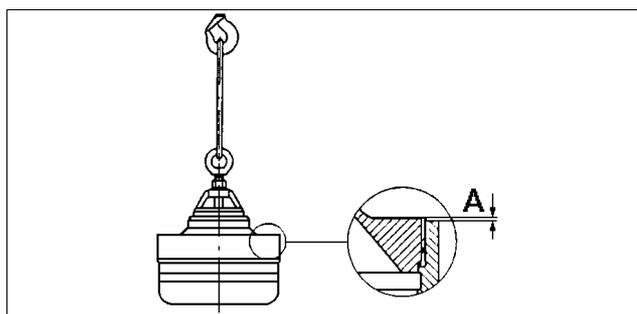
### NOTE

Make sure to remove the cap nut fixing the bowl to the bowl spindle.

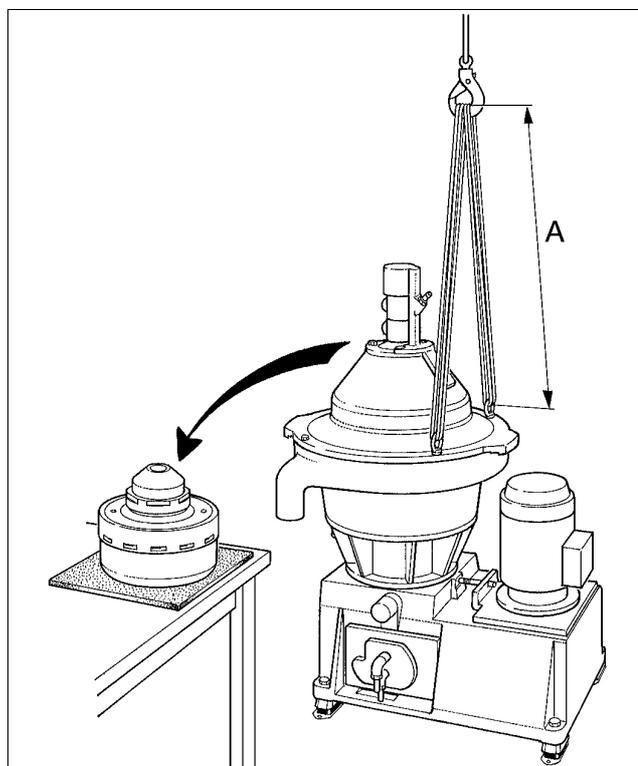
Before lifting the bowl, check that the bowl hood has been screwed home into the bowl body. Less than **2 mm** (A) of bowl hood threading must remain above the bowl body edge. See illustration.

When lifting the bowl, use the compression tool fastened on the distributor.

2. Disconnect the motor cables.
  3. Tighten the frame hood.
  4. Fit the lifting eyes. The two eyebolts must be fitted in the holes nearest to the electric motor.
  5. Use two endless slings to lift the separator. Length of each sling: minimum **1,5 metres**. Thread the slings through the lifting eyes and fit them to the hook of the hoist.
  6. Unscrew the foundation bolts.
  7. When lifting and moving the separator, obey normal safety precautions for lifting large heavy objects.
- Do not** lift the separator unless the bowl has been removed.



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- A. Minimum 750 mm distance between lifting eye and hook. Use a lifting hook with catch.

8. Remove the lifting eyes afterwards.



### WARNING

#### Crush hazards

Use only the two **special lifting eyes** (M12) for lifting the machine. They are to be screwed into the special threaded holes.

Other holes are **not** dimensioned for lifting the machine.

A falling separator can cause accidents resulting in serious injury and damage.

### NOTE

Separator without bowl: Use lifting slings for WLL 300 kg.

Bowl: Use lifting slings for WLL 100 kg.

## 5.7 Cleaning

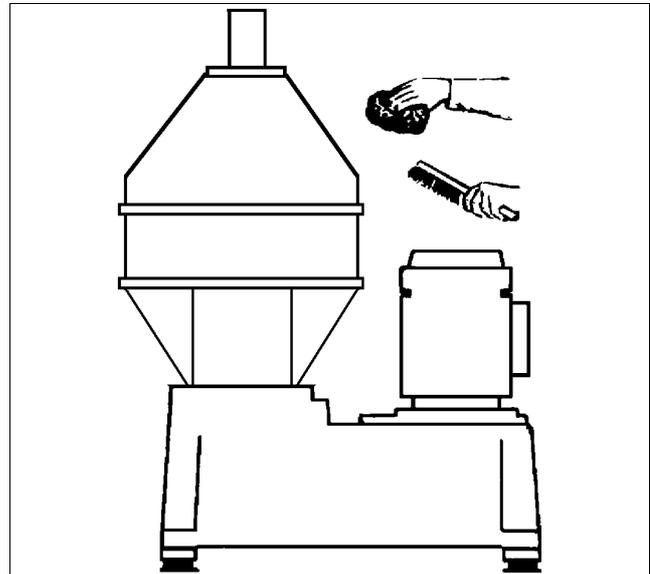
### External cleaning

The external cleaning of frame and motor should be restricted to brushing, sponging or wiping while the motor is running or is still hot.

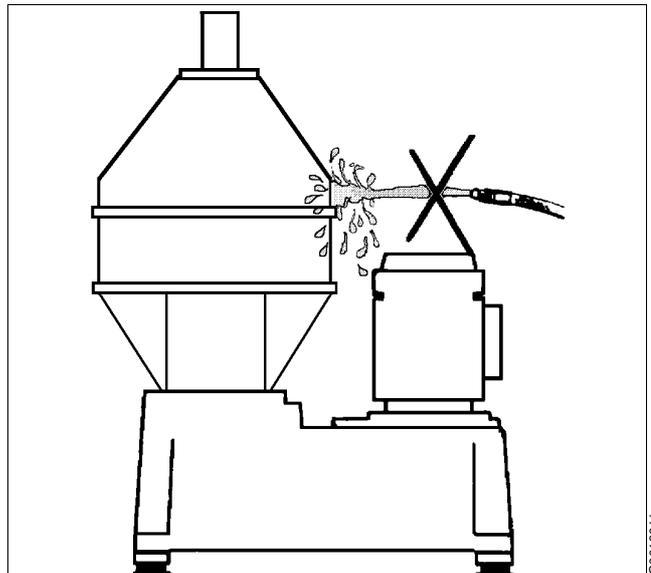
Never wash down a separator with a direct water stream. Totally enclosed motors can be damaged by direct hosing to the same extent as open motors and even more than those, because:

- Many operators believe that these motors are sealed, and normally they are not.
- A water jet played on these motors will produce an internal vacuum, which will suck the water between the metal-to-metal contact surfaces into the windings, and this water cannot escape.
- Water directed on a hot motor may cause condensation resulting in short-circuiting and internal corrosion.

Be careful even when the motor is equipped with a protecting hood. Never play a water jet on the ventilation grill of the hood.



*Use a brush and a sponge or cloth when cleaning*



*Never wash down a separator with a direct water stream or spray*

### 5.7.1 Cleaning agents

When using chemical cleaning agents, make sure you follow the general rules and suppliers' recommendations regarding ventilation, protection of personnel, etc.

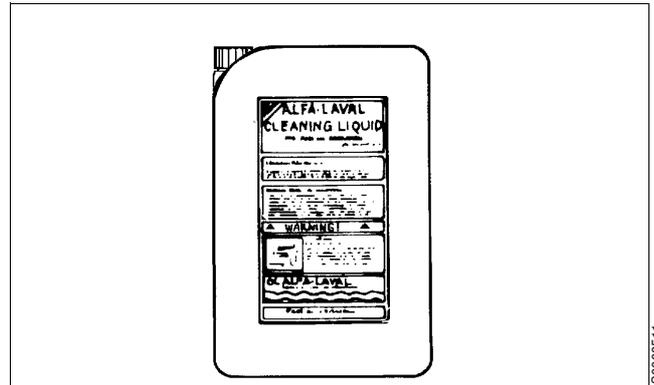
#### For separator bowl, inlet and outlet

A chemical cleaning agent must dissolve the deposits quickly without attacking the material of the separator parts.

- For cleaning of **lube oil** separators the most important function of the cleaning agent is to be a good solvent for the gypsum in the sludge. It should also act as a dispersant and emulsifier for oil. It is recommended to use **Alfa Laval cleaning liquid for lube oil separators** which has the above mentioned qualities. Note that carbon steel parts can be damaged by the cleaning agent if submerged for a long time.
- **Fuel oil** sludge mainly consists of complex organic substances such as asphaltenes. The most important property of a cleaning liquid for the removal of fuel oil sludge is the ability to dissolve these asphaltenes.

**Alfa Laval cleaning liquid for fuel oil separators** has been developed for this purpose. The liquid is water soluble, non-flammable and does not cause corrosion of brass and steel. It is also gentle to rubber and nylon gaskets in the separator bowl.

Before use, dilute the liquid with water to a concentration of 3-5%. Recommended cleaning temperature is 50-70 °C.



*Alfa Laval cleaning liquid for lube oil and fuel oil separators is available in 25-litre plastic containers.*



#### CAUTION

##### Skin irritation hazard

Read the instructions on the label of the plastic container before using the cleaning liquid.

Always wear safety goggles, gloves and protective clothing as the liquid is alkaline and dangerous to skin and eyes.

### For parts of the driving devices

Use white spirit, cleaning-grade kerosene or diesel oil.

### Oiling (protect surfaces against corrosion)

Protect cleaned carbon steel parts against corrosion by oiling. Separator parts that are not assembled after cleaning must be wiped and coated with a thin layer of clean oil and protected from dust and dirt.

## 5.7.2 Cleaning of bowl discs

### Bowl discs

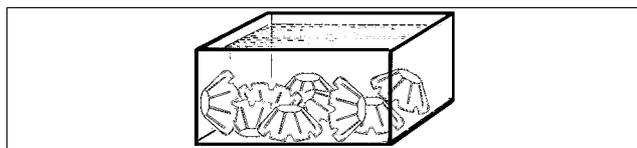
Handle the bowl discs carefully so as to avoid damage to the surfaces during cleaning.

#### NOTE

Mechanical cleaning is likely to scratch the disc surfaces causing deposits to form quicker and adhere more firmly.

A mild chemical cleaning is therefore preferable to mechanical cleaning.

1. Remove the bowl discs from the distributor and lay them down, **one by one**, in the cleaning agent.
2. Let the discs remain in the cleaning agent until the deposits have been dissolved. This will normally take between two and four hours.
3. Finally clean the discs with a **soft** brush.



*Put the discs one by one into the cleaning agent*



*Clean the discs with a soft brush*

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#### WARNING

**Cut hazards**

The discs have sharp edges that can cause cuts.

## 5.8 Oil change

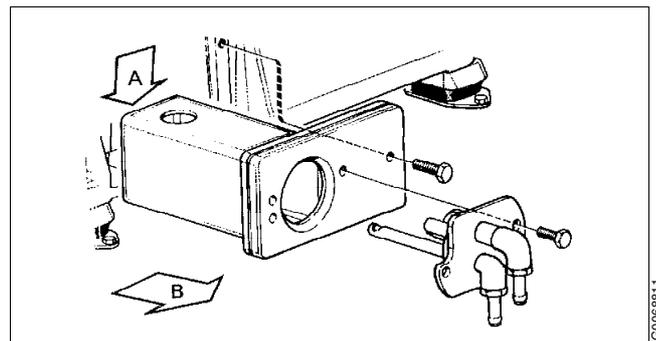
### 5.8.1 Oil change procedure

#### NOTE

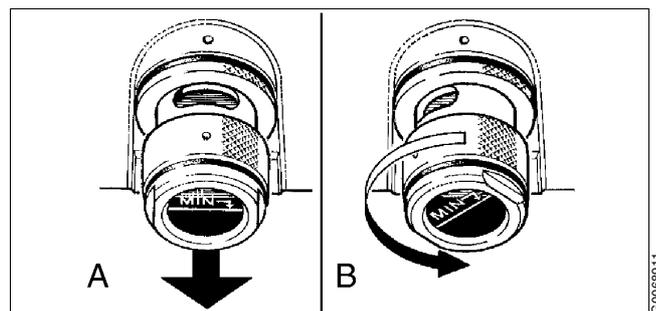
Before adding or renewing lubricating oil in the oil sump, the information concerning different oil groups, handling of oils, oil change intervals etc. given in chapter "8.6 Lubricants" on page 155 must be well known.

The separator should be level and at standstill when oil is filled or the oil level is checked. The MIN-line on the sight glass refers to the oil level at standstill.

1. Remove the cover and the water tank.  
Note that the tank must be lowered past spindle end (A) before it can be withdrawn (B).



2. Place a collecting vessel under the drain hole.
3. Pull out (A) the oil filling device and turn it half a turn (B).



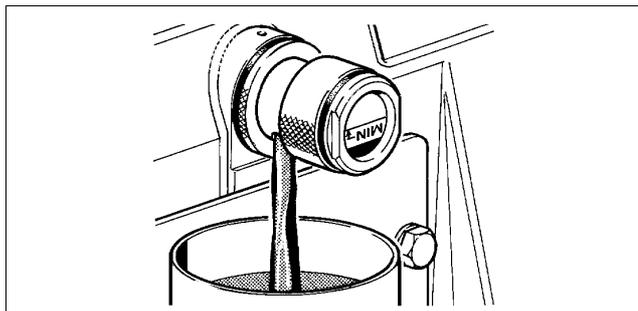
4. Collect the oil in the vessel



**CAUTION**

**Burn hazards**

The lubricating oil and various machine surfaces can be sufficiently hot to cause burns.

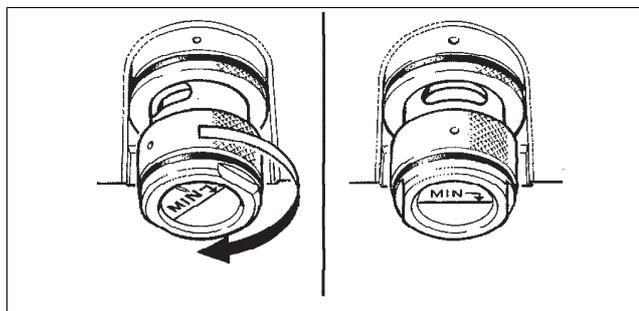


G0173811

5. Turn the oil filling device back to its normal position (A), the drain hole pointing upwards.

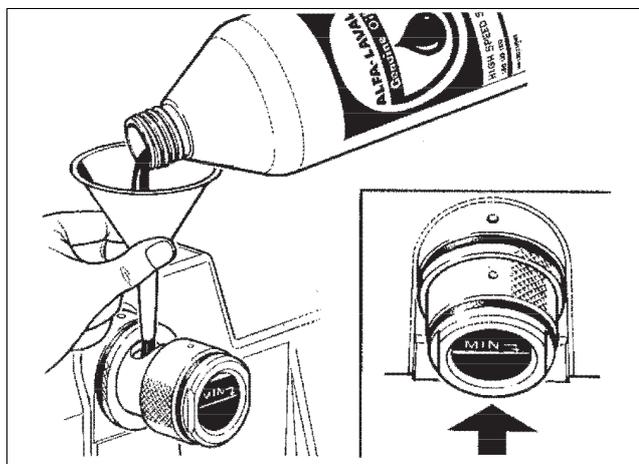
**NOTE**

When changing from one group of oil to another, the frame housing and the spindle parts must be thoroughly cleaned before the new oil is filled.



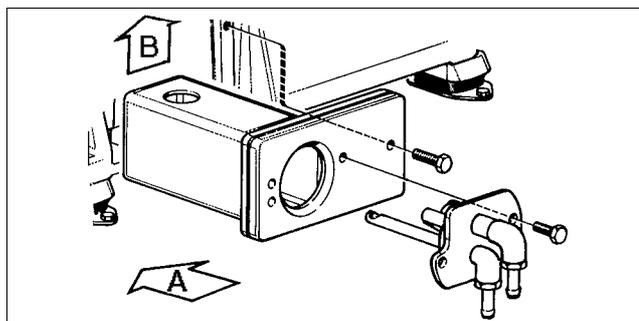
G0069111

6. Fill the oil sump in the frame housing with new oil. The oil level should be slightly above middle of the sight glass. Information on volume see "8.2 Technical data" on page 142.
7. Push in the oil filling device.



G0069211

8. Fit the water tank and the cover.



G0069321

## 5.9 Vibration

### 5.9.1 Vibration analysis

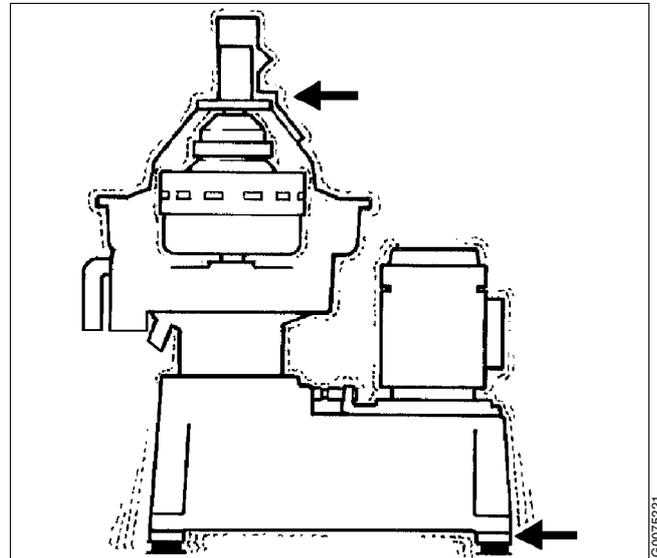
A separator normally vibrates and produces a different sound when passing through its critical speeds during run-up and run-down.

It also vibrates and sounds to some extent when running. It is good practice to be acquainted with these normal conditions.

Excessive vibrations and noise indicate that something is wrong. Stop the separator and identify the cause.

Use vibration analysis equipment to periodically check and record the level of vibration.

The level of vibration of the separator should not exceed **9 mm/s**.



*Measuring points for vibration analysis*



#### **WARNING**

#### **Disintegration hazards**

When excessive vibration occurs, **keep bowl filled** and **stop** separator.

The cause of the vibration must be identified and corrected before the separator is restarted. Excessive vibration can be due to incorrect assembly or poor cleaning of the bowl.

## 5.10 General directions

### 5.10.1 Ball and roller bearings

#### Specially designed bearings for the bowl spindle

The bearings used for the bowl spindle are special to withstand the speed, vibration, temperature and load characteristics of high-speed separators.

Only Alfa Laval genuine spare parts should be used.

A bearing that in appearance looks equivalent to the correct may be considerably different in various respects: inside clearances, design and tolerances of the cage and races as well as material and heat treatment.

#### NOTE

Using an incorrect bearing can cause a serious breakdown with injury to personnel and damage to equipment as a result.

Do not re-fit a used bearing. Always replace it with a new one.



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1. *Outer race*
2. *Ball/roller*
3. *Inner race*
4. *Cage*

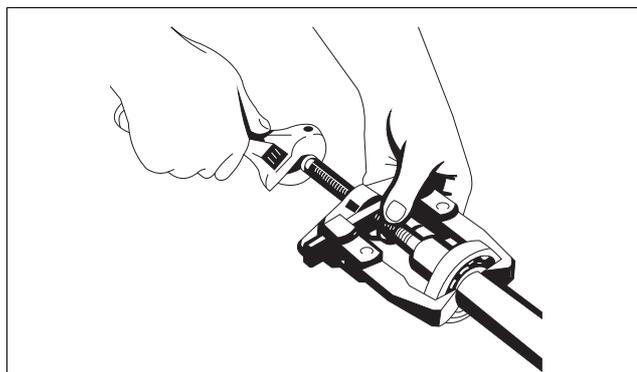
#### Dismantling

Remove the bearing from its seat by using a puller. If possible, let the puller engage the inner ring, then remove the bearing with a steady force until the bearing bore completely clears the entire length of the cylindrical seat.

The puller should be accurately centered during dismantling; otherwise it is easy to damage the seating.

#### NOTE

Do not hit with a hammer directly on the bearing.



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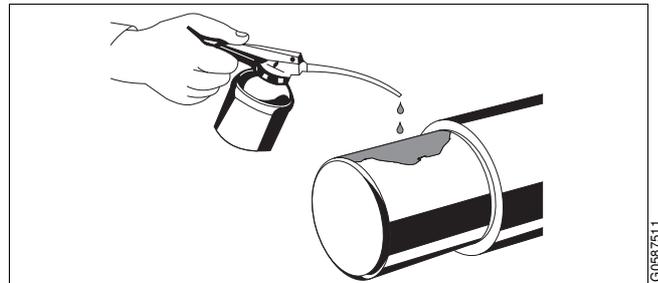
*For bearings where no driving-off sleeve is included in the tool kit, use a puller when removing bearings*

### Cleaning and inspection

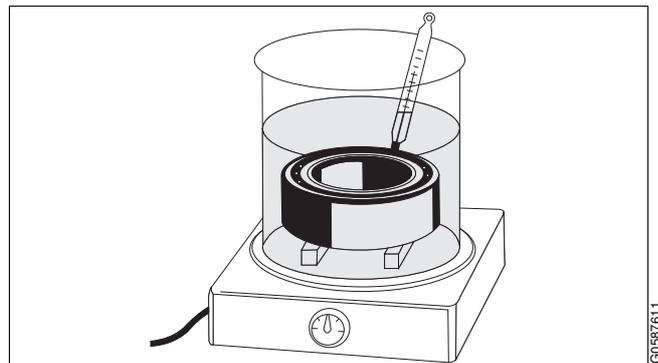
Check shaft (spindle) end and/or bearing seat in the housing for damage indicating that the bearing has rotated on the shaft (spindle) and/or in the housing respectively. Replace the damaged part, if the faults cannot be remedied by polishing or in some other way.

### Assembly

- Leave new bearings in original wrapping until ready to fit. The anti-rust agent protecting a new bearing should not be removed before use.
  - Use the greatest cleanliness when handling the bearings.
  - To facilitate assembly and also reduce the risk of damage, first clean and then lightly smear the bearing seating on shaft (spindle) or alternatively in housing, with a thin oil.
- 
- When assembling ball bearings, the bearings must be heated in oil to maximum 125 °C.



*Clean and smear the bearing seating before assembly*



*The bearing must not be in direct contact with the container*

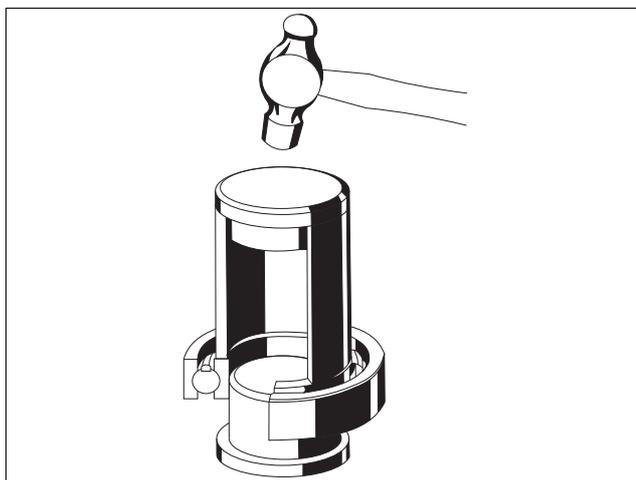
**NOTE**

Heat the bearing in a clean container with a cover.

Use only clean oil with a flash point above 250 °C.

The bearing must be well covered by the oil and not be in direct contact with the sides or the bottom of the container. Place the bearing on some kind of support or suspended in the oil bath.

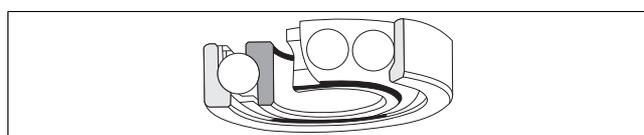
- There are several basic rules for assembling cylindrical bore bearings:
  - Never directly strike a bearing's rings, cage or rolling elements while assembling. A ring may crack or metal fragments break off.
  - Never apply pressure to one ring in order to assemble the other.
  - Use an ordinary hammer. Hammers with soft metal heads are unsuitable as fragments of the metal may break off and enter the bearing.
  - Make sure the bearing is assembled at a right angle to the shaft (spindle).
- If necessary use a driving-on sleeve that abuts the ring which is to be assembled with an interference fit, otherwise there is a risk that the rolling elements and raceways may be damaged and premature failure may follow.



Use a driving-on sleeve for bearings that are not heated

**Angular contact ball bearings**

Always fit single-row angular contact ball bearings with the wide shoulder of the inner race facing the axial load (upwards on a bowl spindle).



The wide shoulder of the inner race must face the axial load

### 5.10.2 Before shut-downs

Before the separator is shut-down for a period of time, the following must be carried out:

- Remove the bowl, according to instructions in chapter “6 Dismantling/Assembly” on page 83.
- Protect parts in contact with process liquid from corrosion by applying a thin layer of oil.
- Remove the O-rings.
- Protect cleaned carbon steel parts against corrosion by oiling. Separator parts that are not assembled after cleaning must be wiped and protected against dust and dirt.

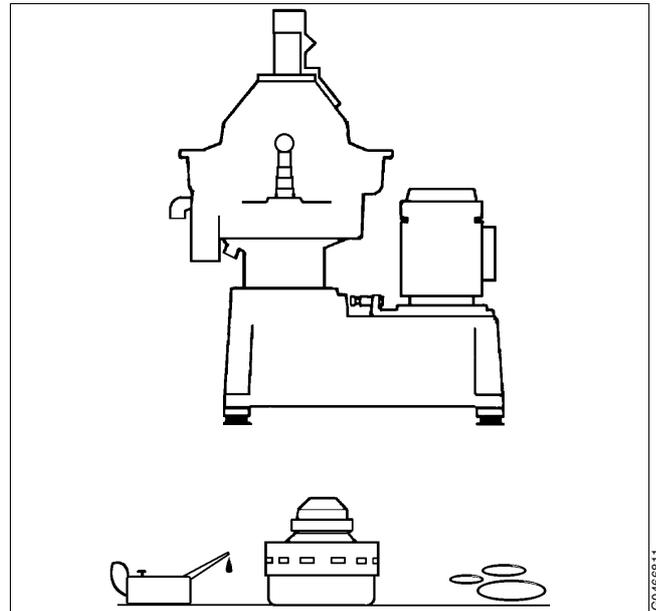
#### NOTE

The bowl must not be left on the spindle during standstill for more than one week.

Vibration in foundations can be transmitted to the bowl and produce one-sided loading of the bearings. The resultant indentations in the ball bearing races can cause premature bearing failure.

If the separator has been shut-down for more than 3 months but less than 12 months, an Intermediate Service (IS) has to be made before the separator is put into operation again.

If the shut-down period has been longer than 12 months, a Major Service (MS) should be carried out.



*Remove the bowl if the separator is left at standstill for more than one week*



---

# 6 *Dismantling/Assembly*

---

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## References to check-points

In the text you will find references to the check point instructions in chapter 5. The references appear in the text as in the following example:

### ✓ Check point

“5.4.9 Disc stack pressure” on page 67.

In this example, look up check point **Disc stack pressure** in chapter 5 for further instructions.

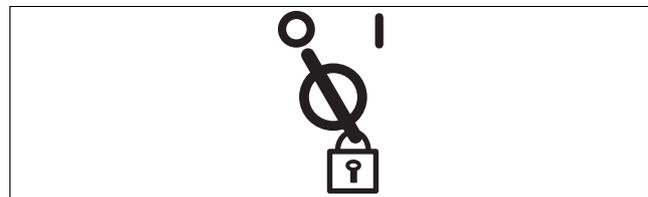
## Tools

Special tools from the tool kit must be used for dismantling and assembly. The special tools are specified in the *Spare Parts Catalogue*.

## Other

Do not use the exploded views when dismantling and assembling the separator. The parts are not always shown in proper order for this purpose. Follow the dismantling/assembly instructions.

	<b>WARNING</b> <b>Entrapment hazard</b>
To avoid accidental start, switch off and lock power supply before starting <b>any</b> dismantling work.	



Switch off and lock power supply before starting **any** dismantling work

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## 6.1 Inlet/outlet, bowl

### 6.1.1 Exploded views

#### Inlet, outlet and frame hood

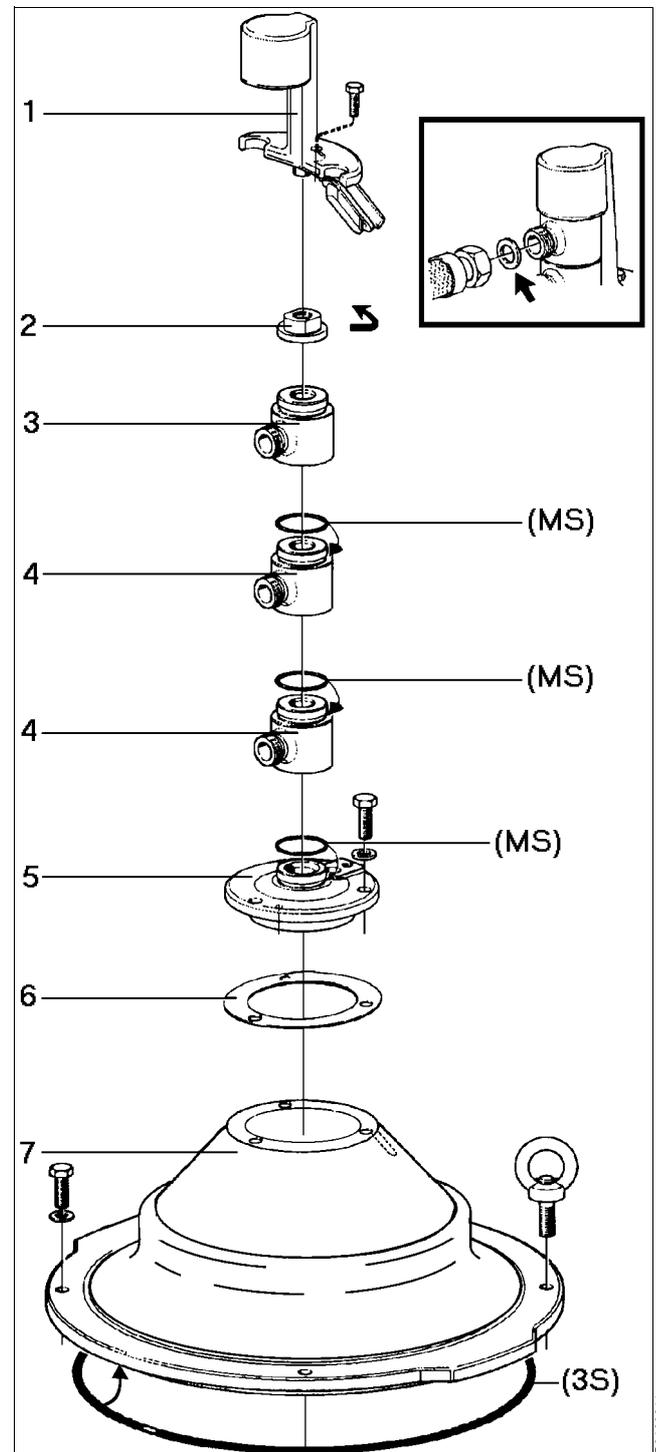
1. Safety device
2. Nut
3. Inlet housing
4. Outlet housing
5. Connecting housing\*
6. Height adjusting ring
7. Frame hood

\*The connecting housing is removed from the frame hood top at paring disc adjustment (Major Service).

↶ Left-hand thread

MS Major service kit

3S 3-year service kit



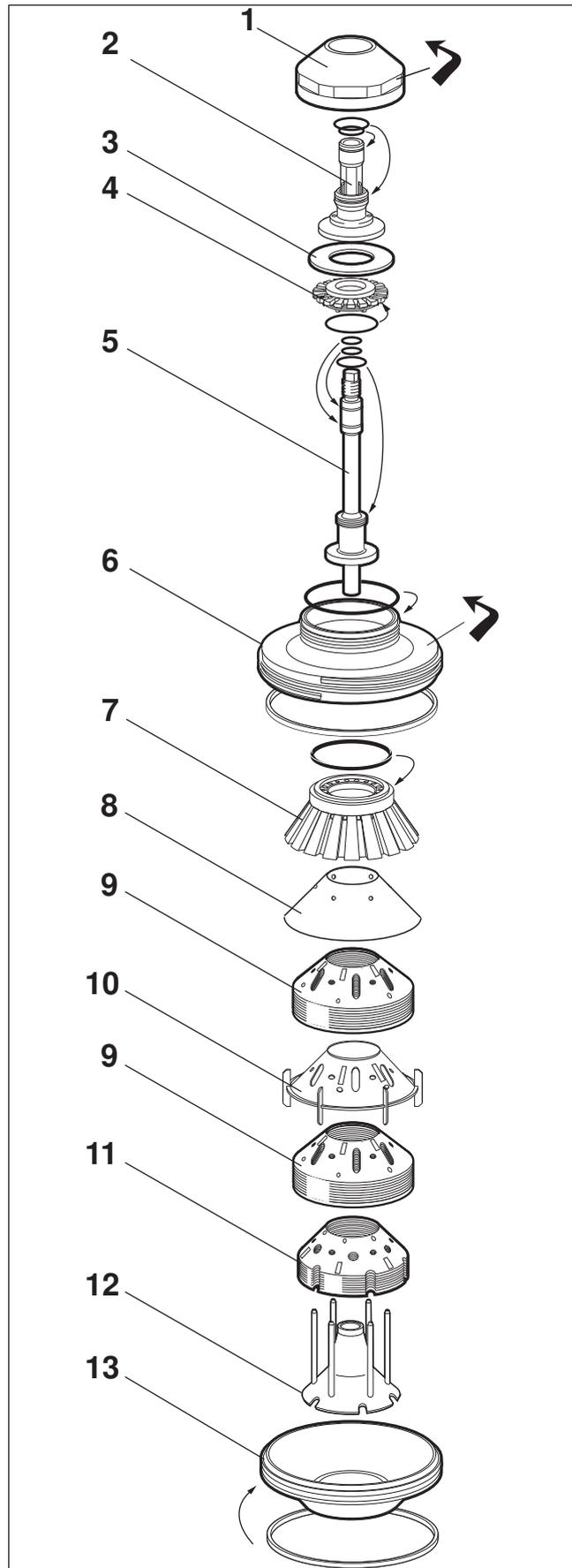
**Paring chamber, bowl hood and bowl discs**

- 1. Paring chamber cover
- 2. Discharge pipe with paring disc
- 3. Gravity disc
- 4. Cover
- 5. Inlet pipe
- 6. Bowl hood
- 7. Top disc
- 8. Cover disc
- 9. Bowl discs
- 10. Wing insert
- 11. Bowl discs
- 12. Distributor
- 13. Sliding bowl bottom

➤ Left-hand thread

IS Intermediate service kit

MS Major service kit



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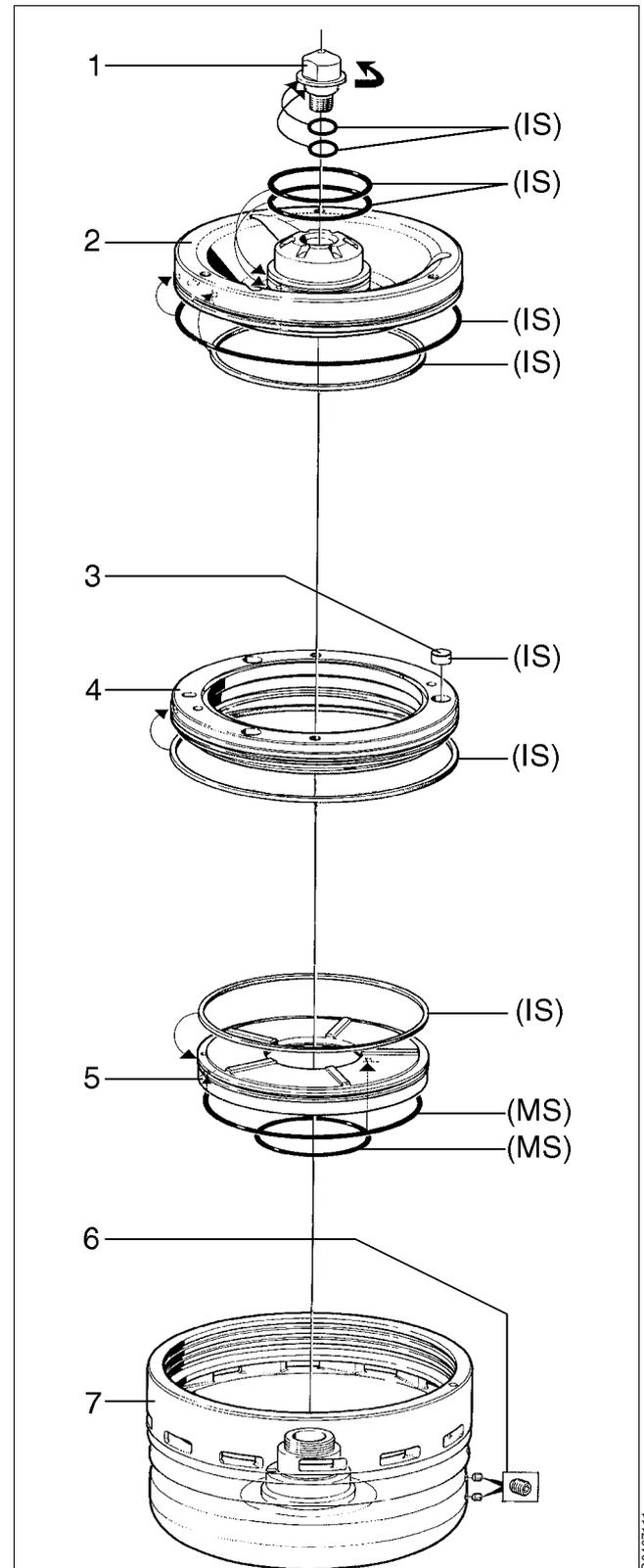
**Bowl body and discharge mechanism**

- 1. Cap nut
- 2. Upper distributing ring
- 3. Valve plug
- 4. Operating slide
- 5. Lower distributing ring
- 6. Nozzle
- 7. Bowl body

↻ Left-hand thread

IS Intermediate service kit

MS Major service kit



G046711

### 6.1.2 Inlet/outlet and bowl – dismantling

The frame hood and the heavy bowl parts must be lifted by means of a hoist. Position the hoist exactly above the bowl centre. Use an endless sling and a lifting hook with catch.

The parts must be handled carefully. Don't place parts directly on the floor, but on a clean rubber mat, fibreboard or a suitable pallet.

1. Remove safety device and look through the slot in the frame hood to see if the bowl still rotates.

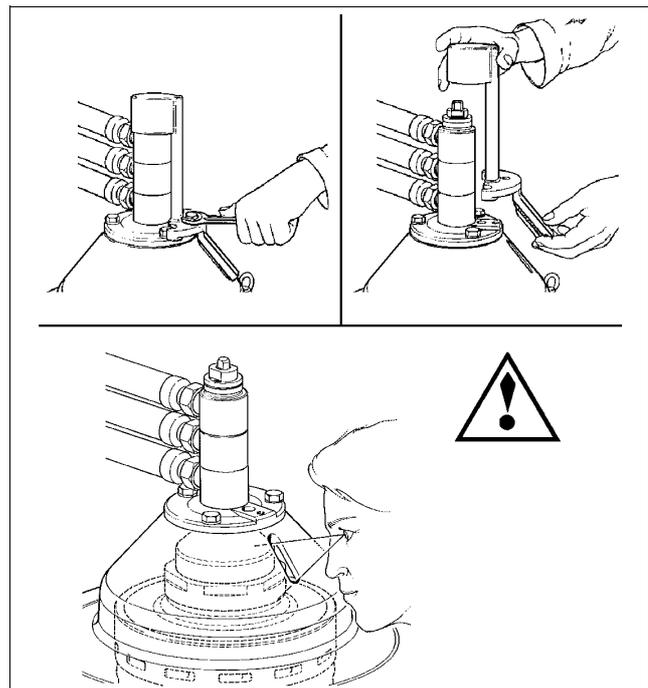


**WARNING**

**Entrapment hazards**

Make sure that rotating parts have come to a **complete standstill** before starting **any** dismantling work.

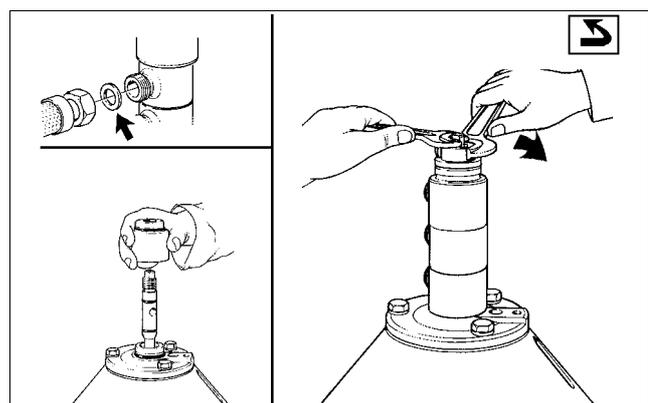
The bowl parts can remain very hot for a considerable time after the bowl has come to a standstill.



G0467/311

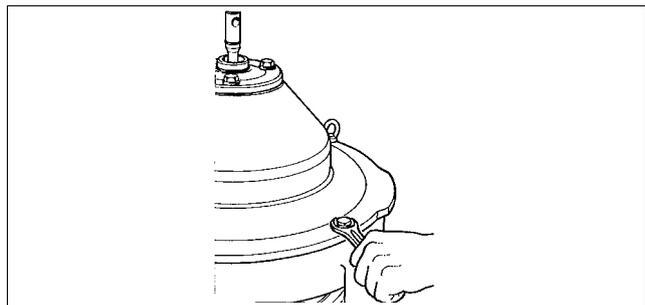
2. Unscrew the nut clockwise and lift off the inlet and outlet housings together with the connecting hoses. When removing the connecting hoses, do not drop the washer.

**Left-hand thread!**



G0467/411

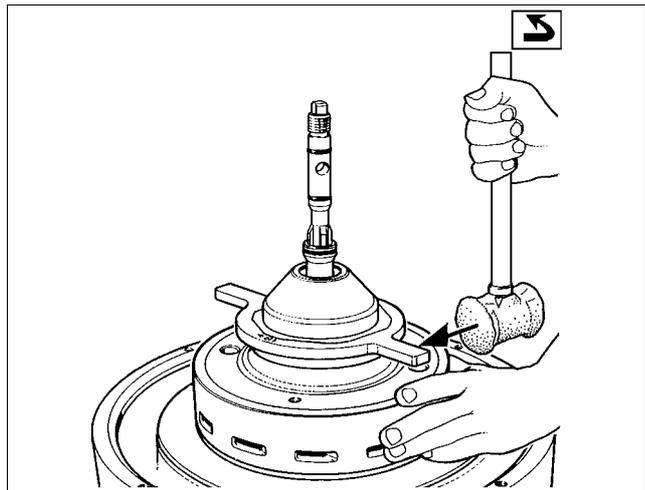
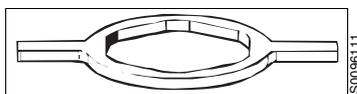
3. Remove the bolts and lift off the frame hood.



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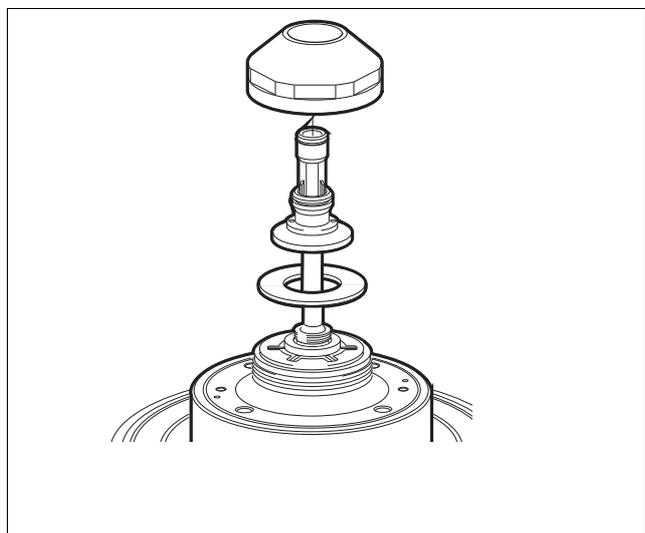
4. Unscrew the paring chamber cover clockwise by using the special tool; spanner for paring chamber cover.

**Left-hand thread!**



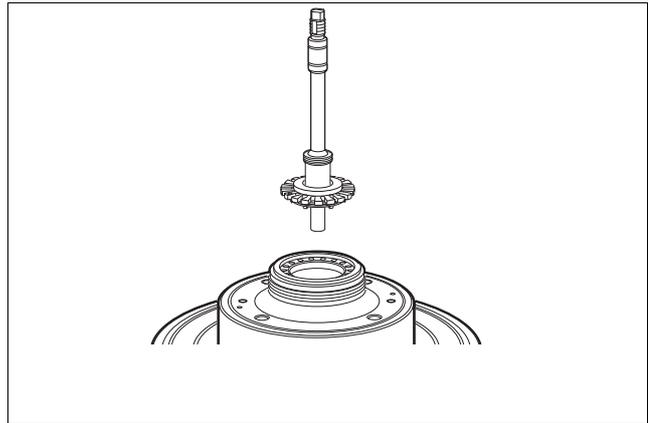
G0467511

5. Lift off the paring chamber cover, the discharge pipe and the gravity disc.



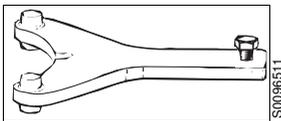
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6. Carefully lift out the inlet pipe and the cover together.

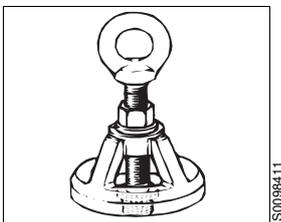


7. Preparations for unscrewing of the bowl hood:

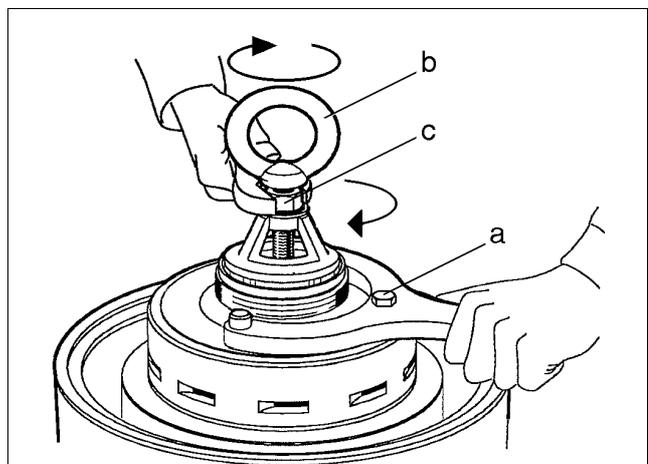
- Fit the spanner to the bowl hood and secure it with the bolt (a).



- Fit the compression tool and screw down the central screw (b) until it stops.



- Compress the disc stack by tightening the nut (c) firmly.



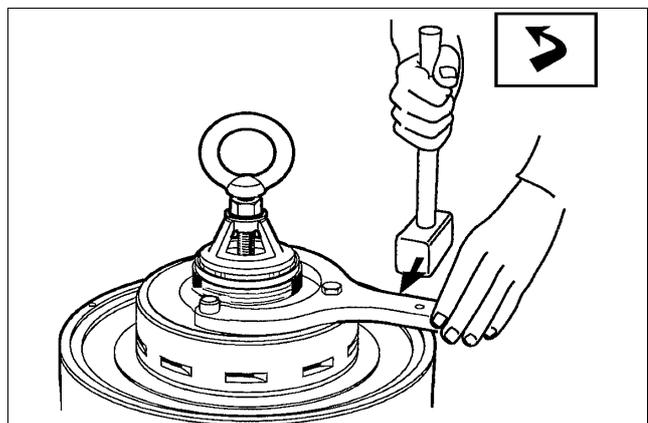
**NOTE**

Use the compression tool as instructed.  
Use of substitute tools can damage the equipment.

8. Unscrew the bowl hood clockwise by using a tin hammer.

**Left-hand thread!**

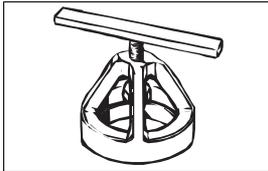
9. Lift off the bowl hood with the spanner still attached.



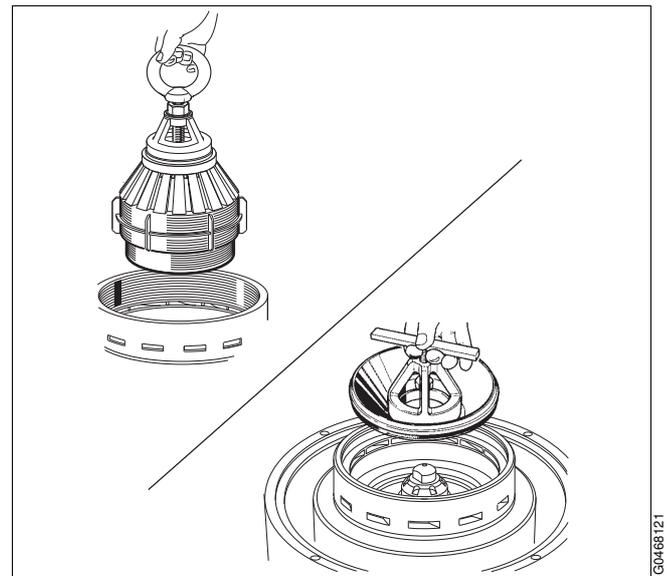
10. Lift out the top disc, wing insert, bowl discs and distributor.

Screw the nut of the compression tool up against the eye bolt, turn the unit with the tool still attached upside down and hit it against a firm base. This will facilitate loosening of the top disc.

11. Lift out sliding bowl bottom by using the special tool.



Ease the sliding bowl bottom off with the central screw of the tool. If necessary, knock on the handle.



### Dismantling of bowl body and discharge mechanism

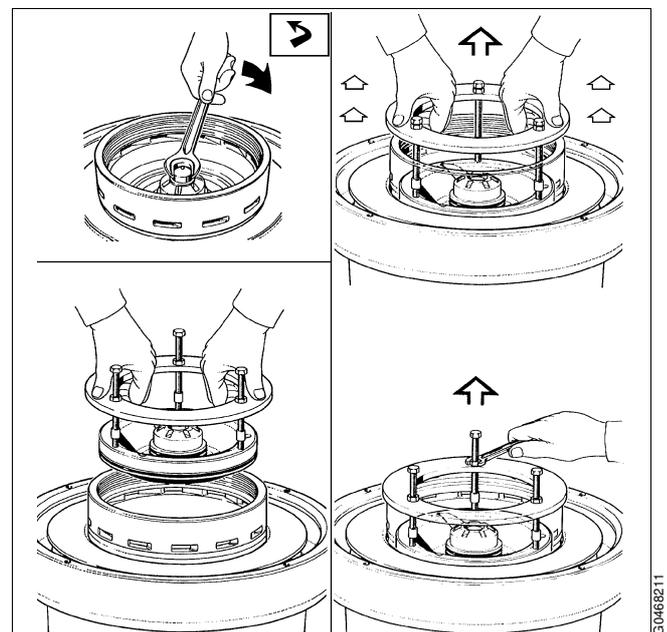
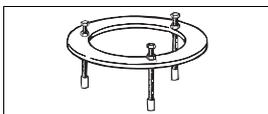
1. Unscrew the cap nut clockwise.

➤ **Left-hand thread**

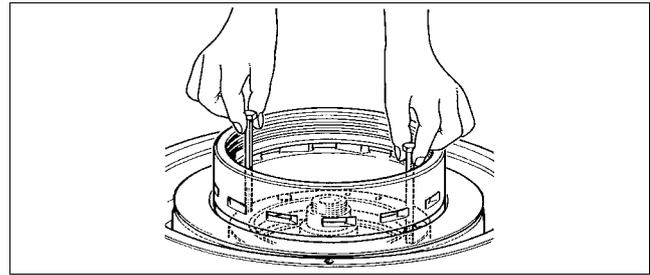
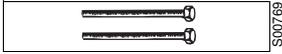
2. Remove the upper distributing ring using the special tool.

Detach the distributing ring either:

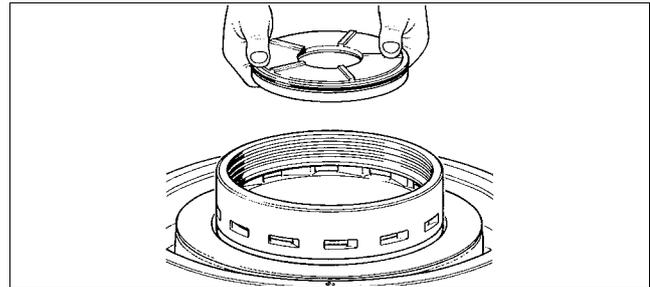
- by jerking, or
- by tightening the nuts equally.



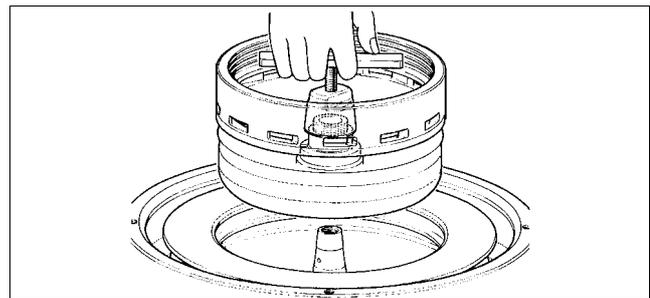
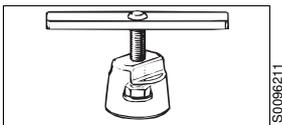
3. Lift out the operating slide by using the special tool: lifting bolts for operating slide.



4. Lift out the lower distributing ring.



5. Lift out the bowl body using the special tool.



6. Ease the bowl body off with the central screw of the tool. If necessary, knock on the handle.
7. Soak and clean all parts thoroughly in suitable cleaning agent, see [“5.7.1 Cleaning agents” on page 73](#).
8. Clean the nozzles in the bowl body using soft iron wire of maximum 1,2 mm diameter, see [“5.4.4 Discharge mechanism” on page 60](#).

## NOTE

Dirt and lime deposits in the sludge discharge mechanism can cause discharge malfunction or failing discharge.

- Remove O-rings and replace them with spares from the intermediate service kit (IS).

### 6.1.3 Inlet/outlet and bowl – assembly

Make sure that the following check points are carried out before assembling the separator bowl.

- Corrosion, see “5.4.1 Corrosion” on page 56.
- Erosion, see “5.4.2 Erosion” on page 58.
- Cracks, see “5.4.3 Cracks” on page 59
- Discharge mechanism, see “5.4.4 Discharge mechanism” on page 60.

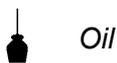
Check points preferably carried out during assembly are indicated in the assembly instructions below.

#### NOTE

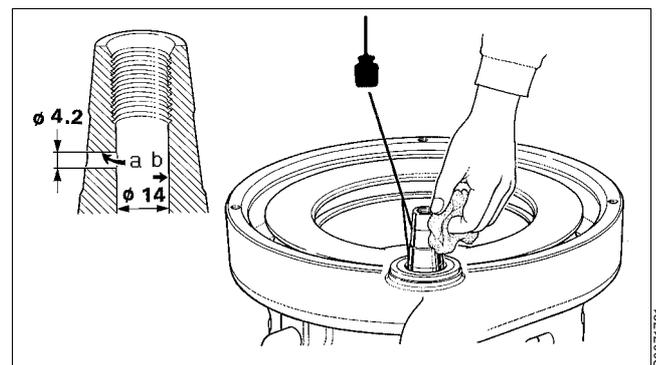
Be sure bowl parts are not interchanged.  
Out of balance vibration will reduce ball bearing life.

#### Assembly of bowl body and discharge mechanism

- Clean the hollow part (b) of the spindle top and the radial hole (a). Wipe clean the spindle top and nave bore in the bowl body. Apply oil to the tapered end of the spindle, smear the oil over the surface and wipe off surplus with a clean cloth.



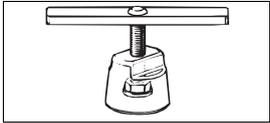
- ✓ **Check point**  
“5.4.6 Spindle top cone and bowl body nave” on page 63.
- Clean the nozzles in the bowl body, see “5.4.4 Discharge mechanism” on page 60.



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3. Fit the bowl body on the spindle. Avoid damaging the spindle cone.

- Attach the special lifting tool to the bowl body nave.



- Screw down the central screw of the tool, then lower the bowl body until the screw rests on the spindle top.
- Screw up the central screw and the bowl body will sink down on the spindle cone.

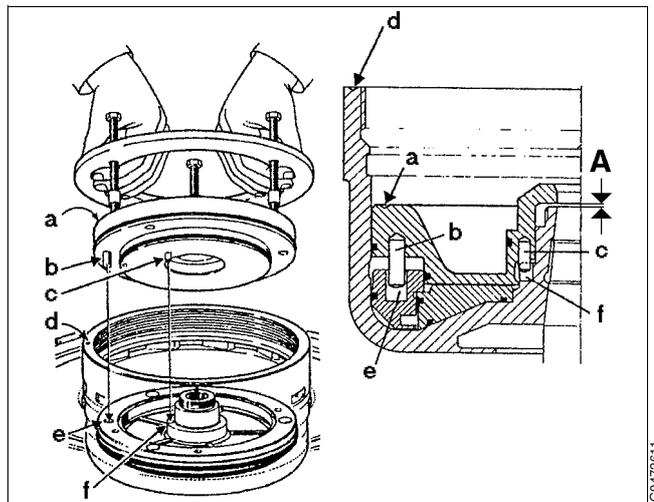
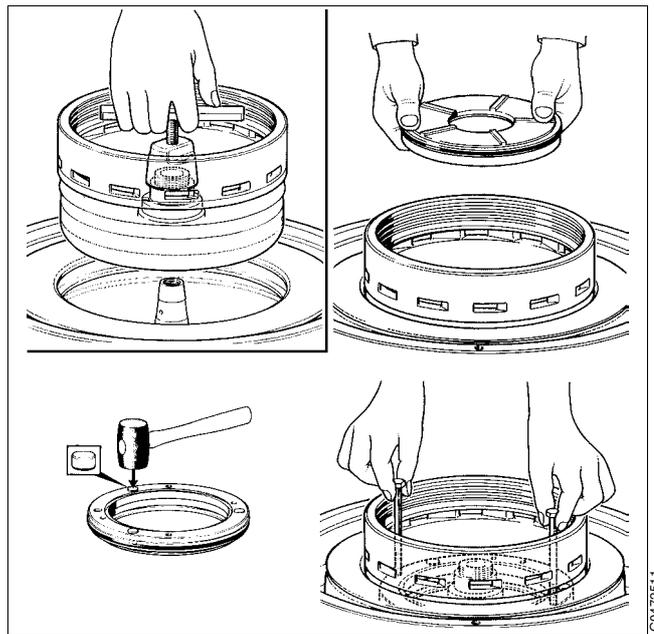
4. Using the lifting bolts place the lower distributing ring and the operating slide in the bowl body.

Make sure that all O-rings lie concentrically in their grooves.

If replacing valve plugs, use a rubber mallet.

5. Before fitting the upper distributing ring into the bowl body, turn the operating slide so that the hole (e) is in line with drill mark (d) and notch (f).

6. Fit the upper distributing ring so that drill mark (a) is in line with drill mark (d) on bowl body. When the distributing ring is in correct position the guide pins (b) and (c) will enter hole (e) and groove (f) respectively.



- |               |                |
|---------------|----------------|
| a. Drill mark | d. Drill mark  |
| b. Guide pin  | e. Guide hole  |
| c. Guide pin  | f. Guide notch |

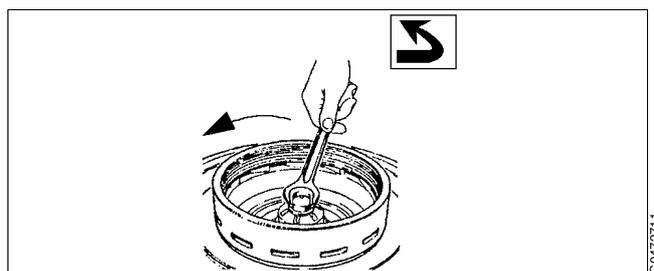
**NOTE**

The two guide pins (b, c) in the distributing ring have to be fitted properly.

Check the distance "A". If the play is larger than 2 mm the guide pins have not entered the hole and notch properly.

7. Screw the cap nut counter-clockwise onto the spindle. Tighten firmly.

**Left-hand thread!**



**Assembly of bowl discs**

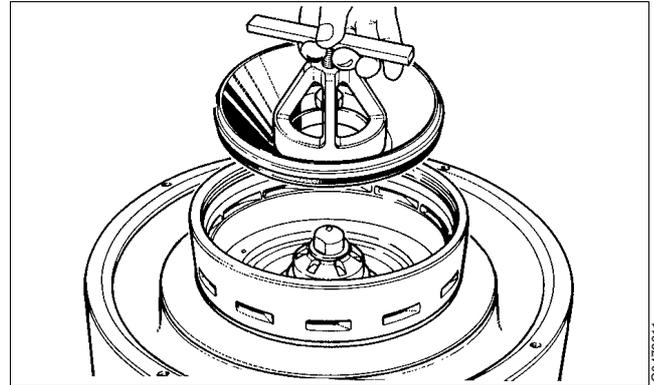
1. Fit the sliding bowl bottom.

Make sure that the square seal ring lies concentrically in its groove.

Press the sliding bowl bottom down on the upper distributing ring.

✓ **Check point**

Before assembling the bowl discs, check the threads of the bowl hood and bowl body, see [“5.4.8 Threads on bowl hood and bowl body”](#) on page 65.

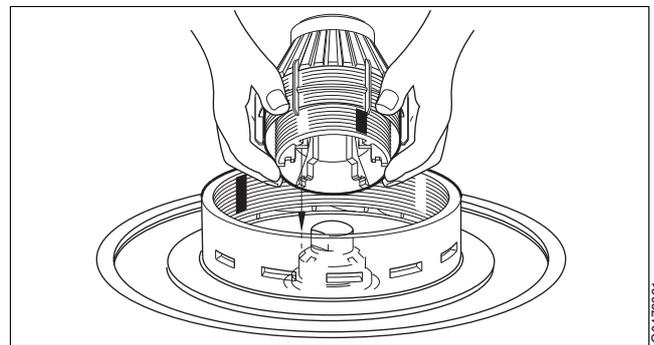


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2. Assemble the covering disc (if applicable), wing insert and bowl discs with top disc and distributor. Note the angular positioning (six options).

Ensure that the pins in the distributor fit properly into the holes of the top disc.

3. Fit the disc stack assembly into the bowl body. Make sure that the cuts in the wings on the underside of the distributor fit properly in the corresponding lugs of the bowl.

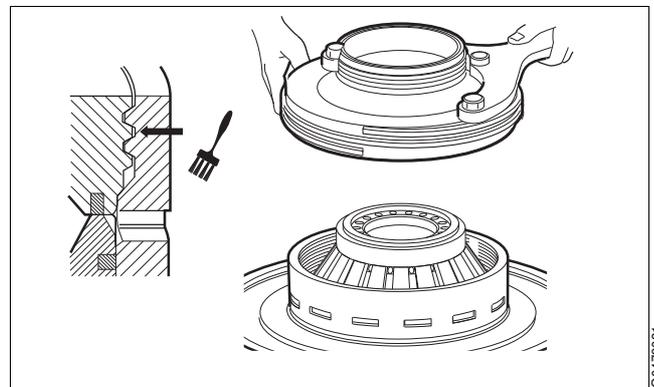


G0472821

4. Fit the bowl hood:

- Apply a thin layer of Molykote Paste 1000 to threads and on contact and locating surfaces.
- Fit the spanner for the bowl hood and secure it with the bolt.
- Screw on the bowl hood by hand.

**Left-hand thread!**

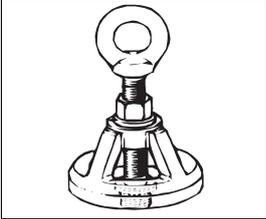


G0473021



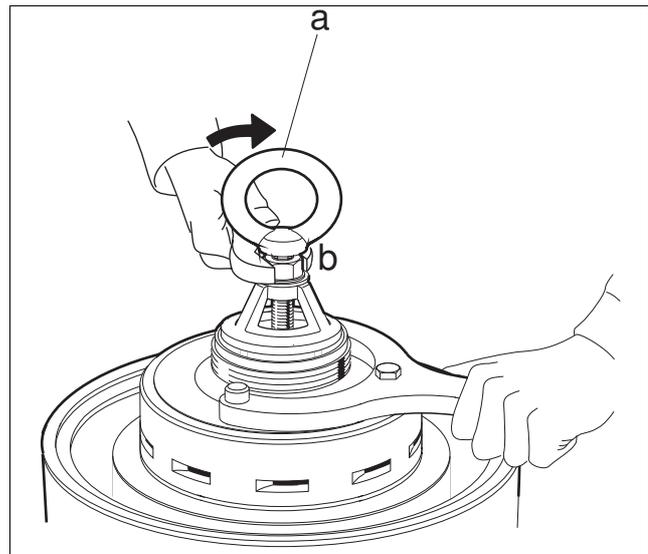
*Molykote 1000 Paste*  
(thin layer to be rubbed into surface)

5. Fit the compressing tool and screw down the central screw (a) until it stops.  
Compress the disc stack by tightening the nut (b) firmly.



### NOTE

Use the compression tool as instructed.  
Use of substitute tools can damage the equipment.



### ✓ Check point

“5.4.9 Disc stack pressure” on page 67.

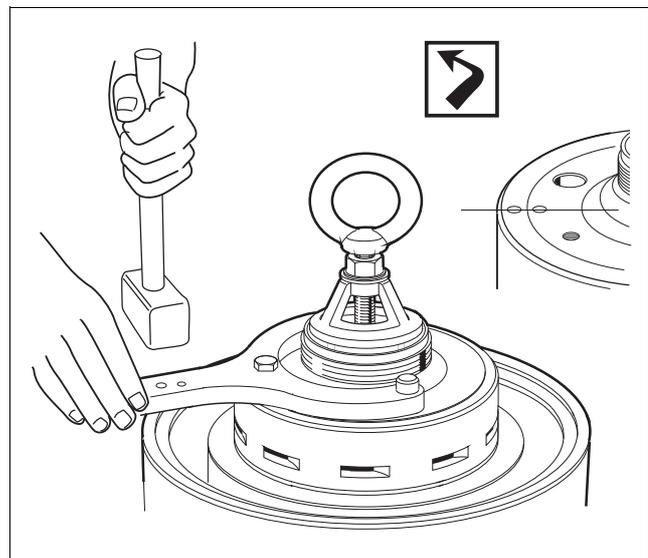
6. Tighten the bowl hood by using a tin hammer.  
Strike the spanner handle until the bowl hood lies tightly against the bowl body. In a new bowl, the assembly marks now will be in line with each other.



### WARNING

#### Disintegration hazard

The assembly mark on the bowl hood must never pass the mark on the bowl body by more than 25°.



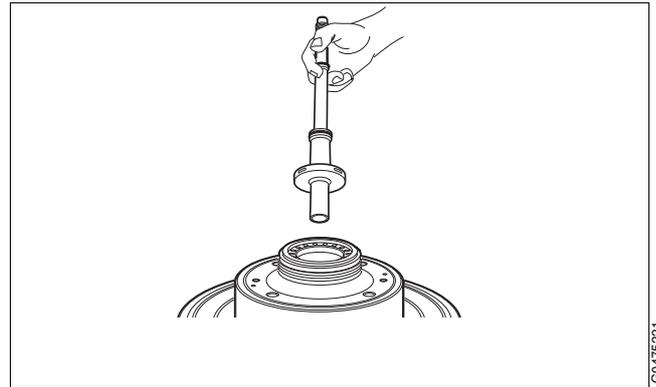
See also “5.4.8 Threads on bowl hood and bowl body” on page 65.

7. Remove the compressing tool by unscrewing the nut against the central screw. Then loosen the central screw.  
8. Remove the spanner for bowl hood.

9. Place the inlet pipe in the bowl.

✓ **Check point**

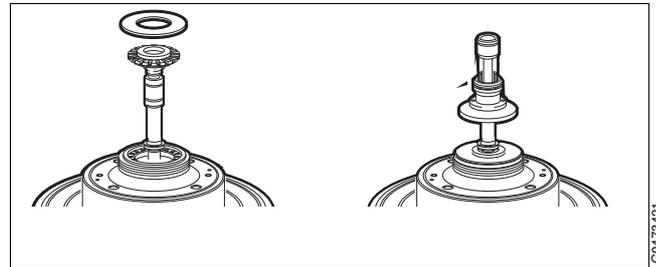
“5.4.7 Threads of inlet pipe, paring disc” on page 64.



G0475221

10. Fit the cover and the gravity disc. Press the cover down gently.

11. Fit the discharge pipe.



G0473421

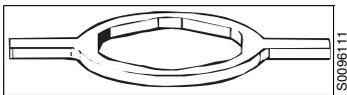
12. Fit the paring chamber cover:

Apply a thin layer of Molykote Paste 1000 to the threads and on contact and locating surfaces.

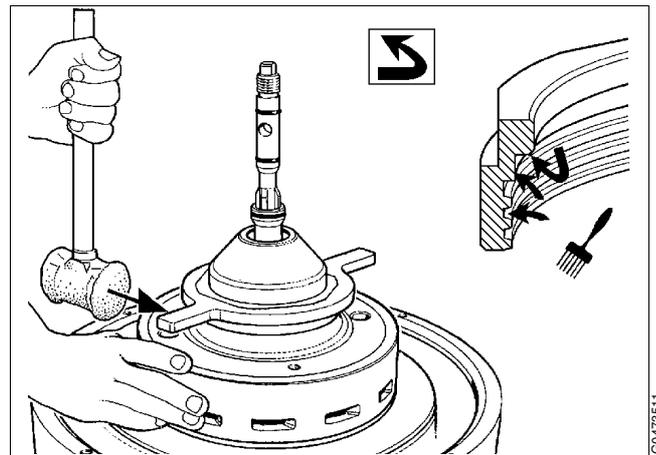
**Left-hand thread!**



*Molykote 1000 Paste  
(thin layer to be rubbed into surface)*

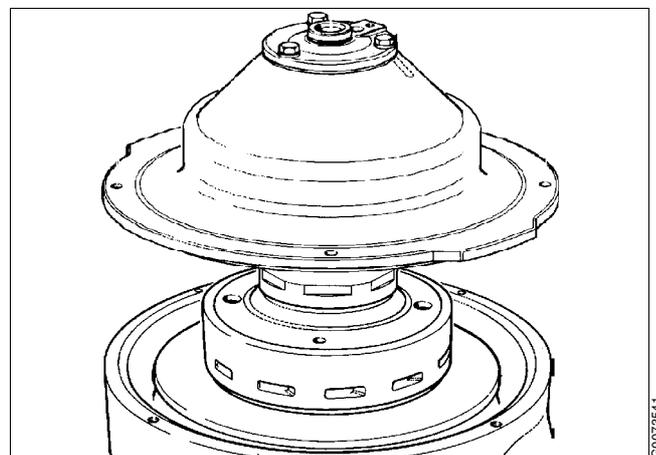


S0096111



G0473511

13. Fit the frame hood. The two eye-bolts must be fitted in the holes nearest to the electric motor.

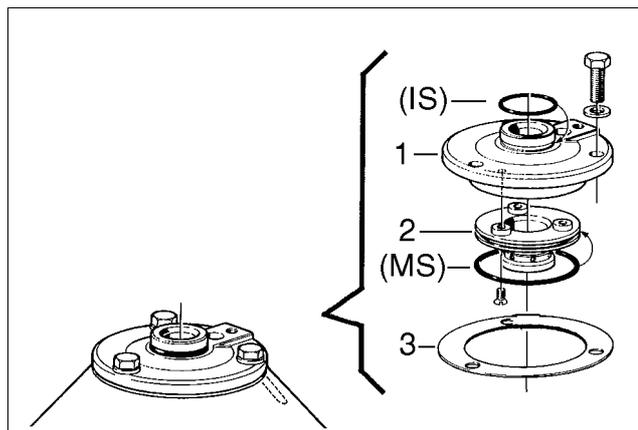


G0073541

14. In case of Major Service remove the connecting housing and fit a new O-ring on the insert.

✓ **Check point**

“5.5.1 Paring disc height adjustment” on page 68. To be performed at Major Service and if the bowl spindle has been dismantled.



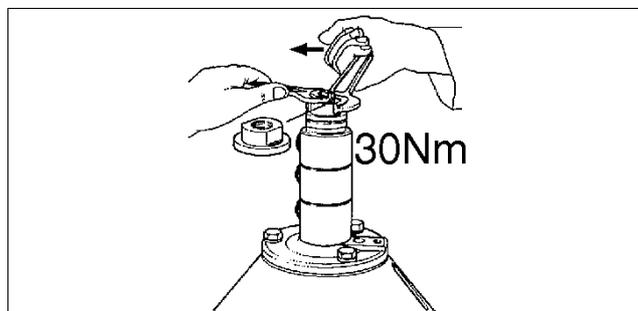
1. Connecting housing
2. Insert
3. Height adjusting ring(s)

15. Fit the inlet/outlet housings and tighten the nut.

**Left-hand thread!**

**NOTE**

To avoid damage on the inlet pipe the tightening torque must not exceed 30 Nm.



Then rotate the bowl by means of the flat belt.

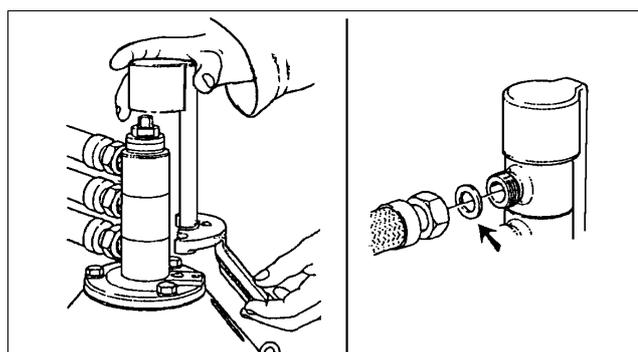
If the bowl does not rotate freely or a scraping noise is heard, incorrect bowl assembly or incorrect height adjustment of the paring disc can be the cause.

16. Make sure that the gasket on the safety device is in position. If not, glue with Loctite 407.

Fit and secure the safety device.

17. Fit the connecting hoses if they have been removed. Make sure to fit their gasket rings.

18. Fit the water tank on the frame bottom part if it has been removed.



## 6.2 Bowl spindle and frame

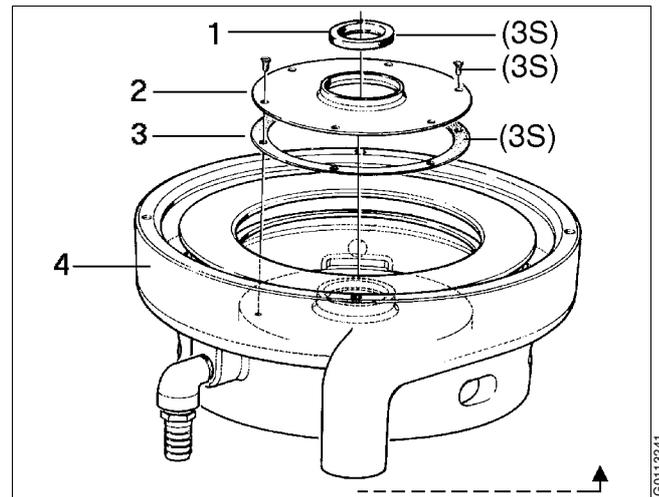
### 6.2.1 Bowl spindle and frame – dismantling

Before dismantling the bowl spindle, the inlet and outlet housings, frame hood and bowl as well as the flat belt must be removed.

Before dismantling, in the case of Major Service, or if the separator vibrates while running, see

#### ✓ Check point

“5.5.2 Radial wobble of bowl spindle” on page 69.



1. Lip seal ring
2. Screen
3. Gasket
4. Frame, top part

3S Parts to be renewed at 3-year service

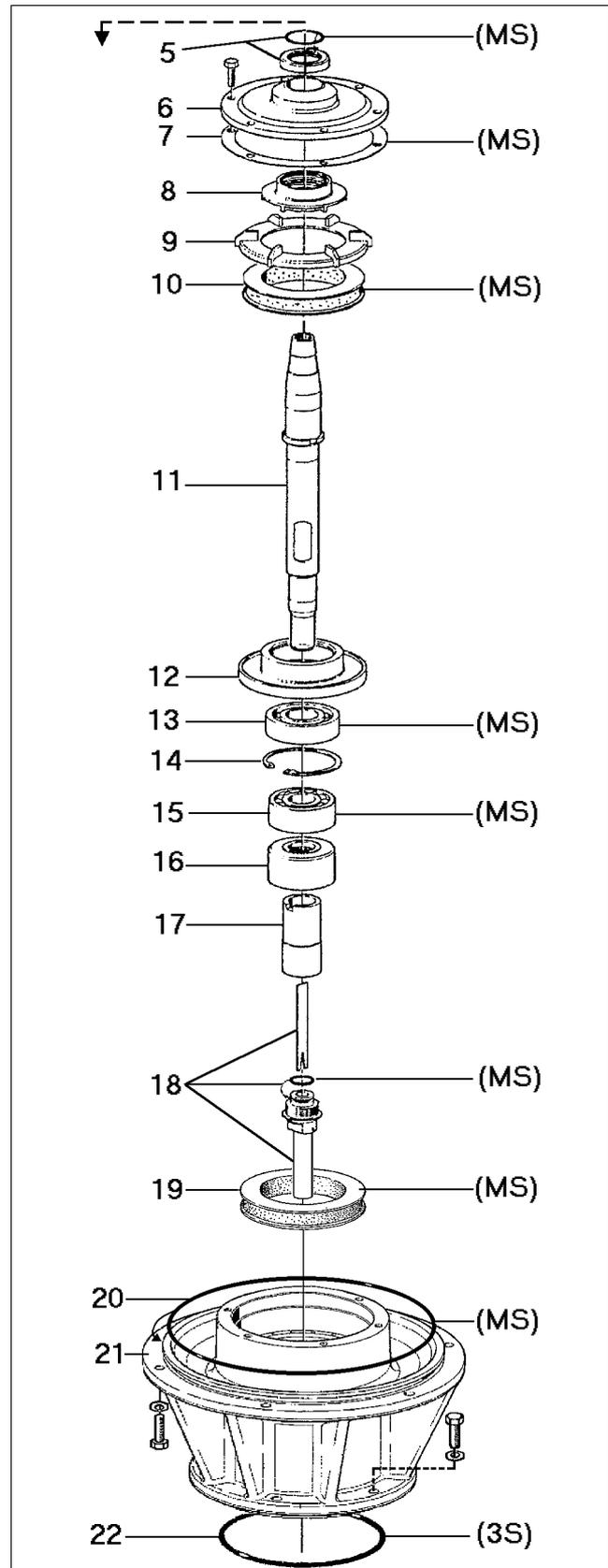
Continues on next page

continued:

- 5. Deflector ring
- 6. Top bearing cover
- 7. Gasket
- 8. Fan
- 9. Buffer holder
- 10. Rubber buffer
- 11. Bowl spindle
- 12. Ball bearing holder
- 13. Ball bearing
- 14. Snap ring
- 15. Ball bearing
- 16. Oil pump
- 17. Belt pulley
- 18. Pump sleeve
- 19. Rubber buffer
- 20. O-ring
- 21. Frame, intermediate
- 22. O-ring

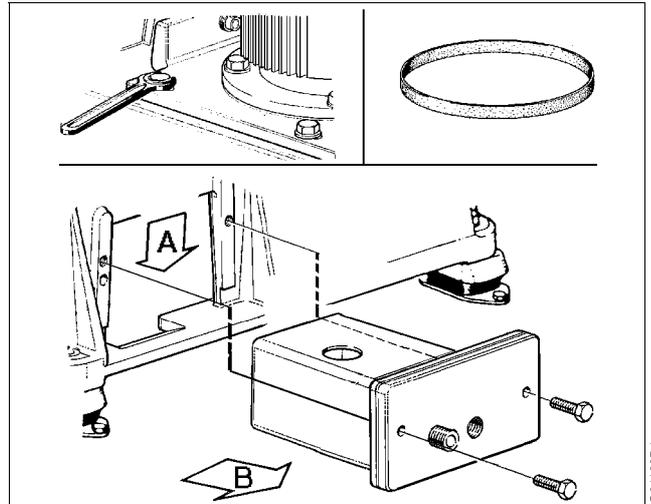
MS Parts to be renewed at Major Service

3S Parts to be renewed at 3-year service



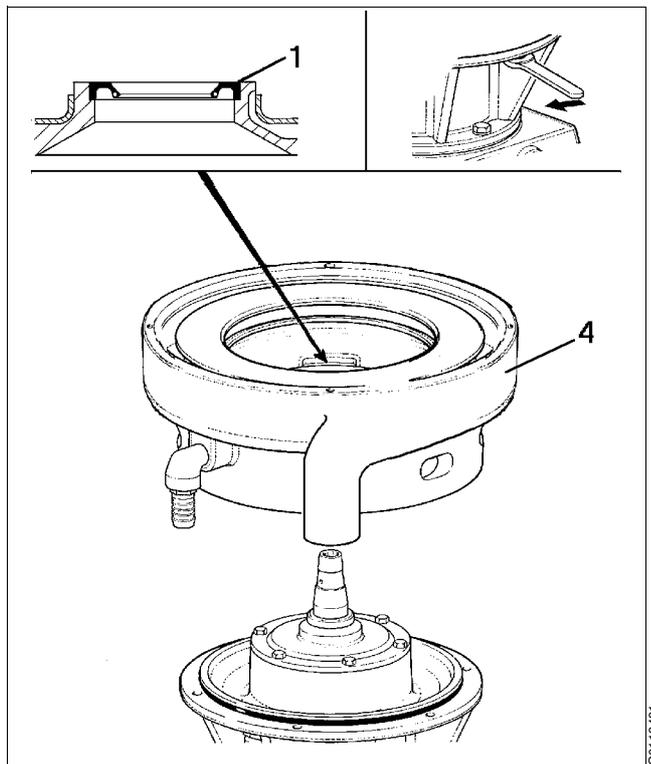
G0113161

1. Loosen but do not remove the motor adapter screws.
2. Remove the water tank.  
**Note** that the tank must be lowered past spindle end (A) before it can be withdrawn (B).
3. Remove the flat belt.



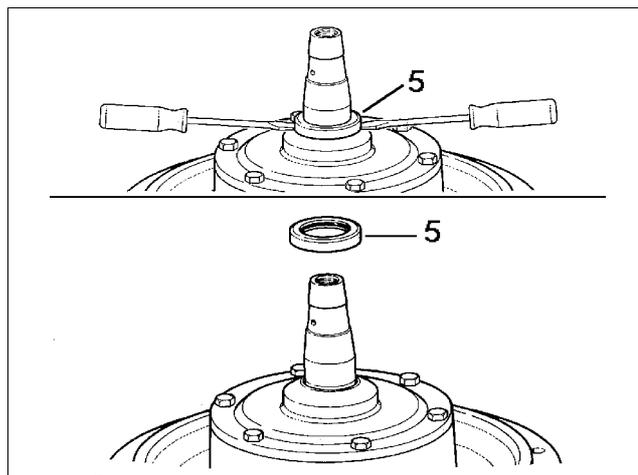
G0113301

4. Remove the screws and lift off frame top part (4). The lip seal ring (1) must be removed in the case of Major Service, or if found damaged.



G0113431

5. Clean the bowl spindle cone in place and remove deflector ring (5).



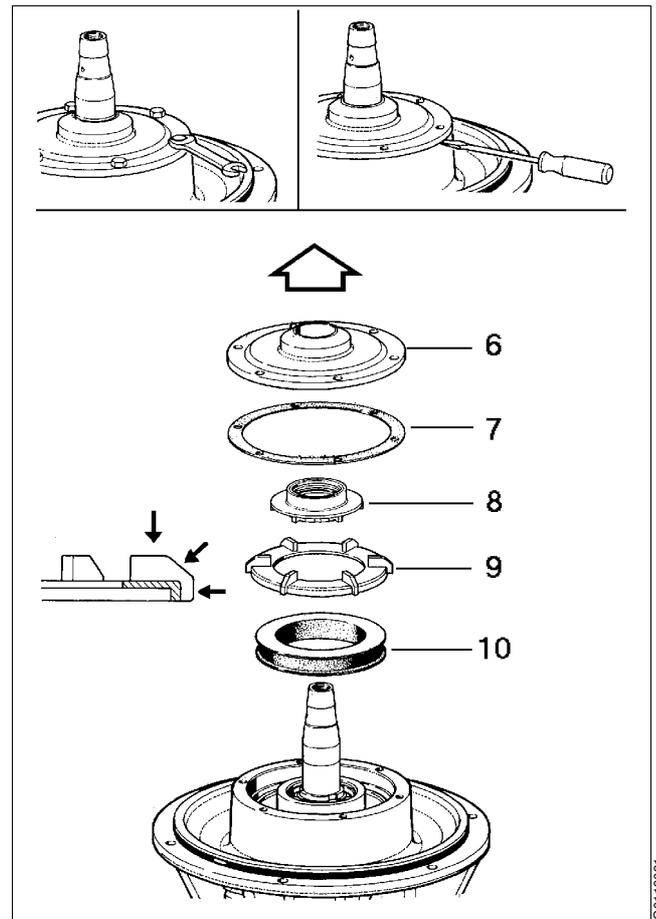
G0113521

6. Remove, in the following sequence:

- Top bearing cover (6)
- Gasket (7)
- Fan (8)
- Buffer holder (9)
- Rubber buffer (10).

### NOTE

Be very careful not to damage the wings of the buffer holder.

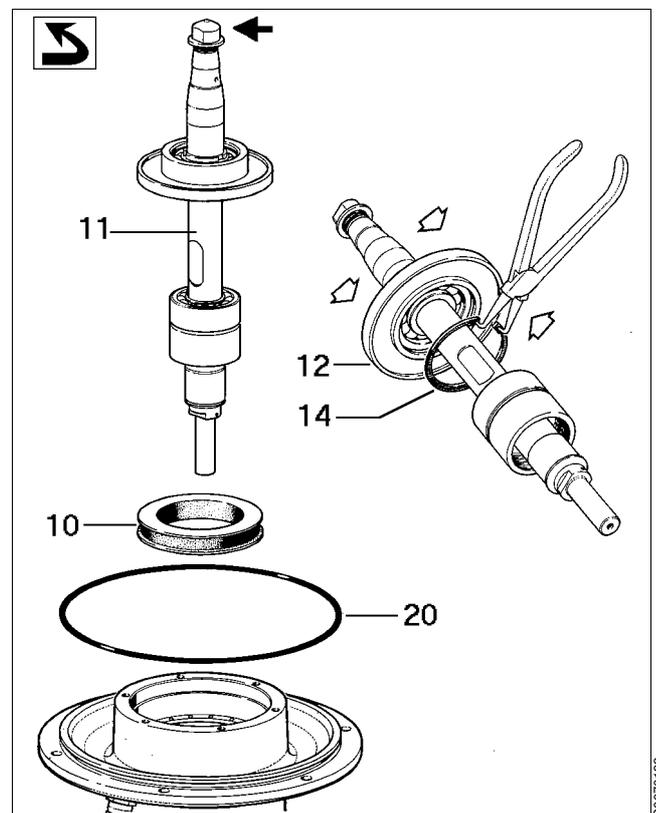


G0113621

7. Screw the cap nut counter-clockwise (left-hand thread) onto the spindle top to protect the top and bore.

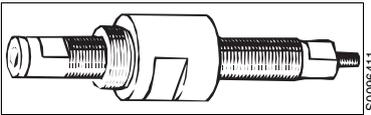
Lift out spindle assembly (11), rubber buffer (10) and O-ring (20).

Remove snap ring (14) by using a pair of pliers and pull off ball bearing holder (12).



G0076132

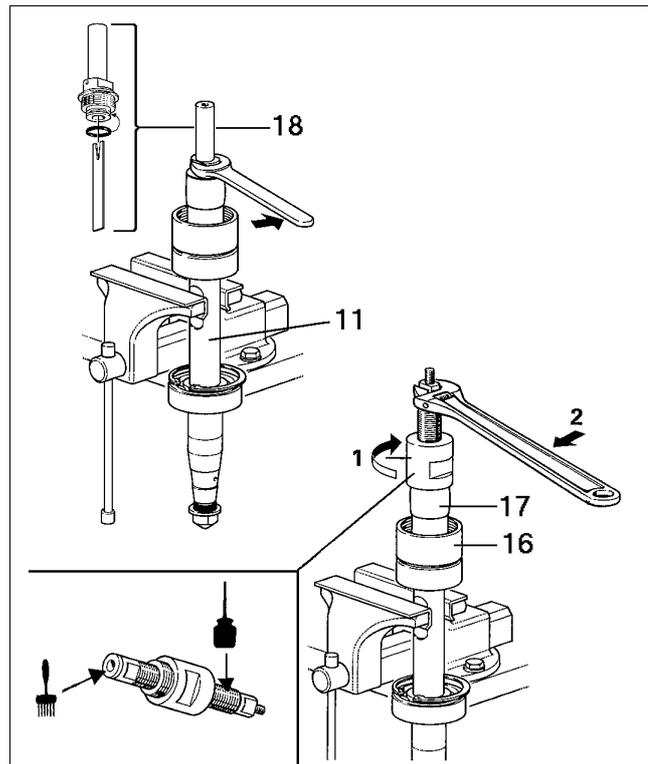
8. Clamp the bowl spindle (11) in a screw vice. Remove the pump sleeve (18). When turning the spindle upside down there is a risk that the vane in the pump sleeve can slide down partly or entirely into the spindle. Therefore, after unscrewing the sleeve, check that the vane has not been damaged.
9. Remove the belt pulley (17):
10. Lubricate the mounting/dismantling tool.



Fit the mounting/dismantling tool and screw it down as far as it will go (1).

Use a long spanner (450 - 650 mm) to press the belt pulley off the spindle (2).

Remove the oil pump (16) by hand.



*Molykote 1000 Paste (thin layer to be rubbed into surface)*



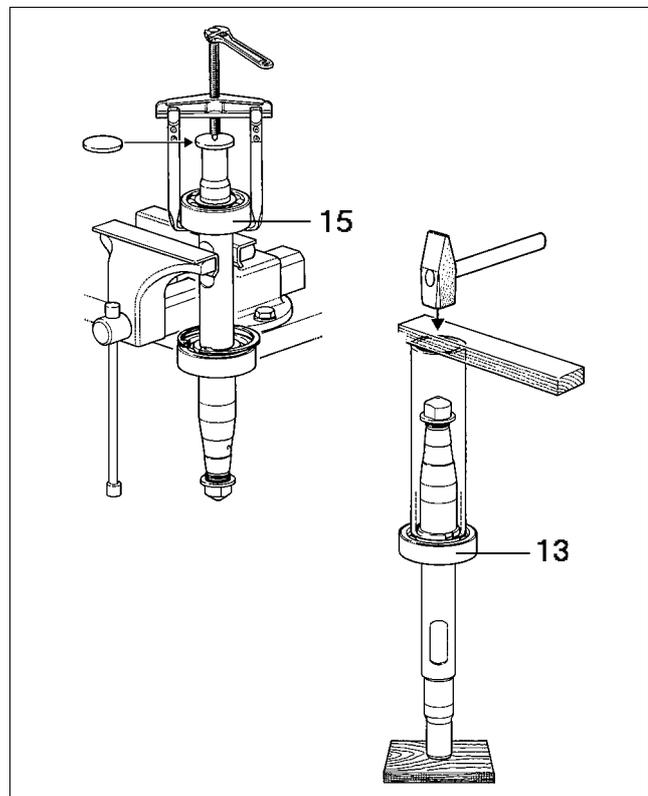
*Oil*

11. Pull off ball bearing (15) using a puller and thrust washer. Pull off bearing (13) using the drive off tool and a hammer.



**NOTE**

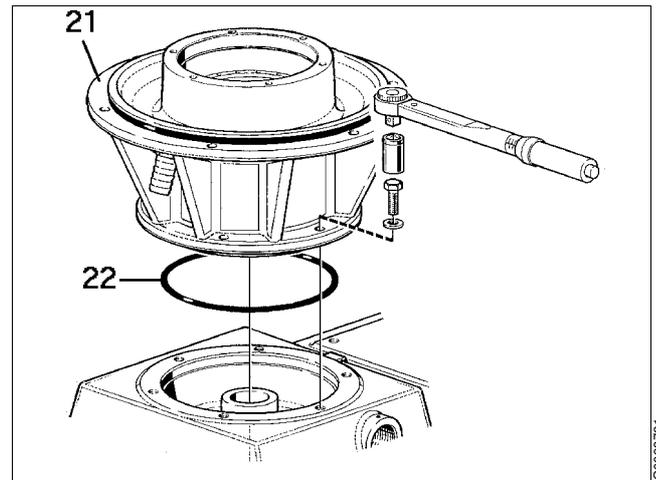
Always discard a used bearing.



**In case of 3-year-service**

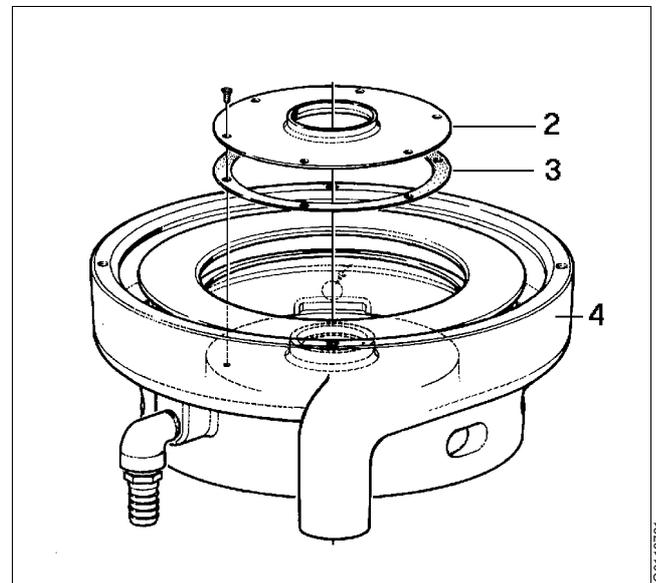
12. Loosen the screws and lift off the frame intermediate part (21).

13. Discard the O-ring (22).



14. Remove the screen (2) from the frame top part (4).

Discard the gasket (3).



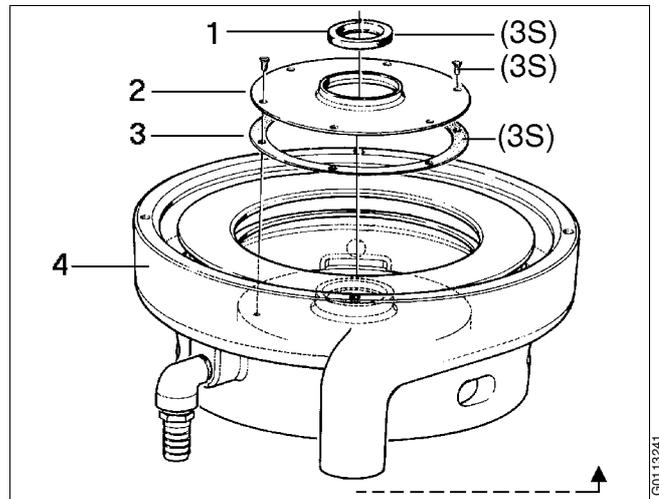
15. Clean the oil sump.

16. Clean all dismantled parts thoroughly in a degreasing agent and inspect for damage and corrosion.

Replace all parts supplied in the spare parts kits.

### 6.2.2 Bowl spindle and frame – assembly

The bowl spindle and frame is assembled in reverse sequence to dismantling.



1. Lip seal ring
  2. Screen
  3. Gasket
  4. Frame, top part
- continues on next page

3S 3-year service kit

continued:

- 5. Deflector ring
- 6. Top bearing cover
- 7. Gasket
- 8. Fan
- 9. Buffer holder
- 10. Rubber buffer
- 11. Bowl spindle
- 12. Ball bearing holder
- 13. Ball bearing
- 14. Snap ring
- 15. Ball bearing
- 16. Oil pump
- 17. Belt pulley
- 18. Pump sleeve
- 19. Rubber buffer
- 20. O-ring
- 21. Frame, intermediate
- 22. O-ring

MS Major service kit  
 3S 3-year service kit



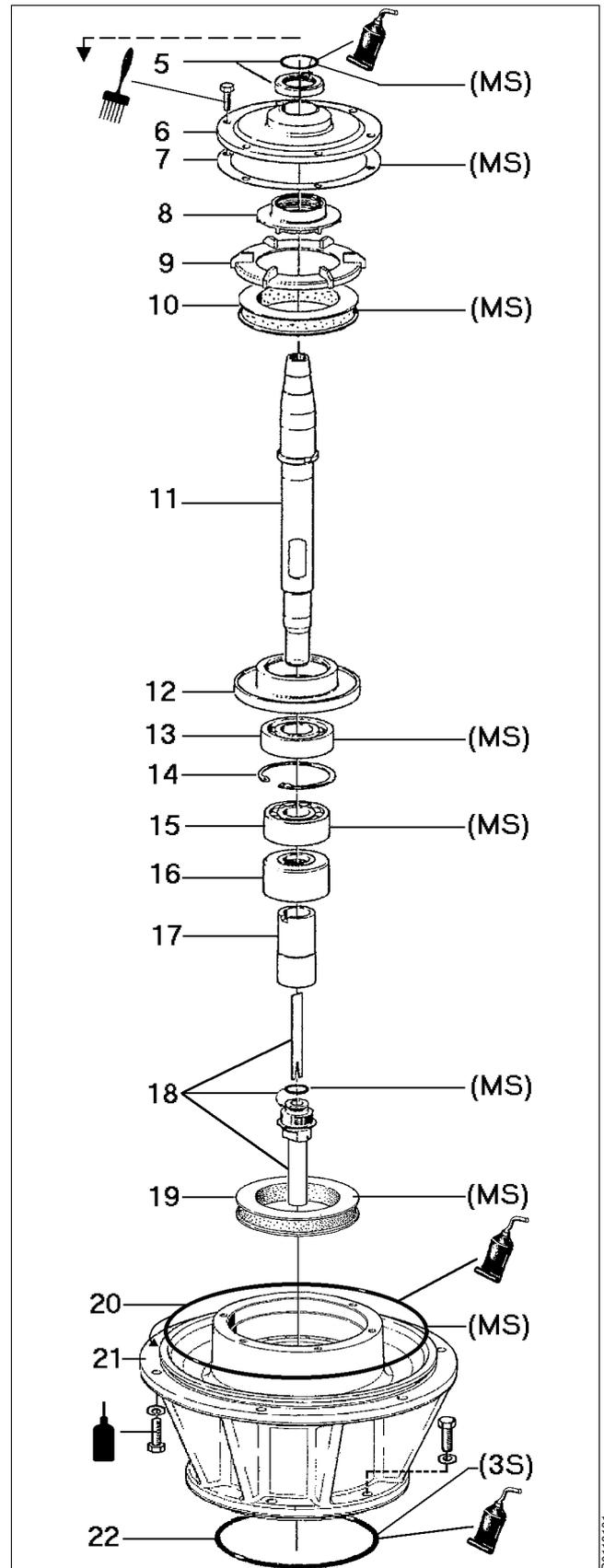
Loctite 242



Silicone grease (thin layer)



Molykote 1000 Paste  
 (thin layer to be rubbed into surface)



G0113181

**In case of 3-year-service**

1. Fit a new O-ring (22) and assemble the frame intermediate part (21).

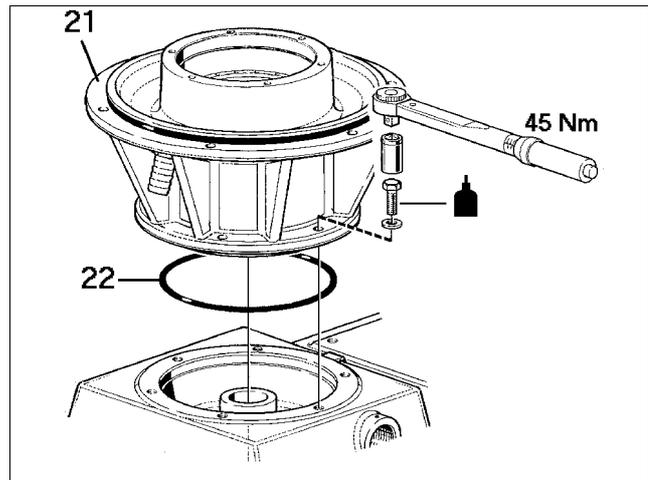
Use a torque wrench (width across flats 16 mm).

Tighten the screws lightly crosswise at first. Then tighten all around to **45 Nm**.

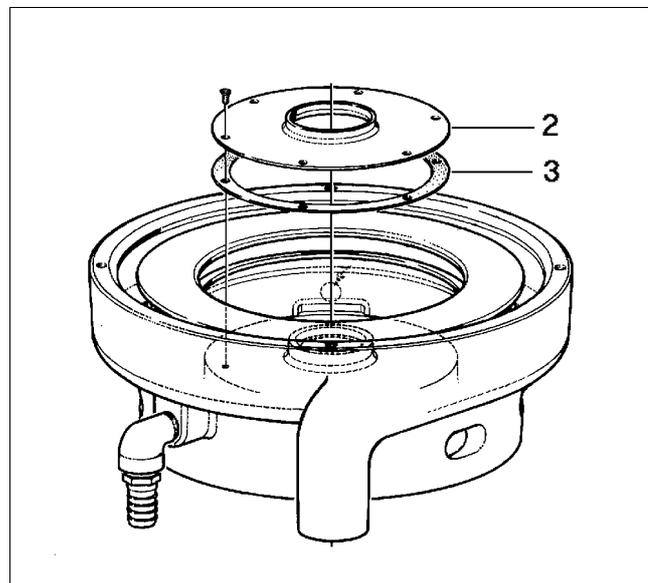
Secure the screws with Loctite 242.



Loctite 242



2. Fit a new gasket (3) and fit the screen (2) on the frame top part.



3. Inspect the tapered end and the hollow part of the bowl spindle for wear and clean if necessary. Assemble ball bearings (13 and 15).

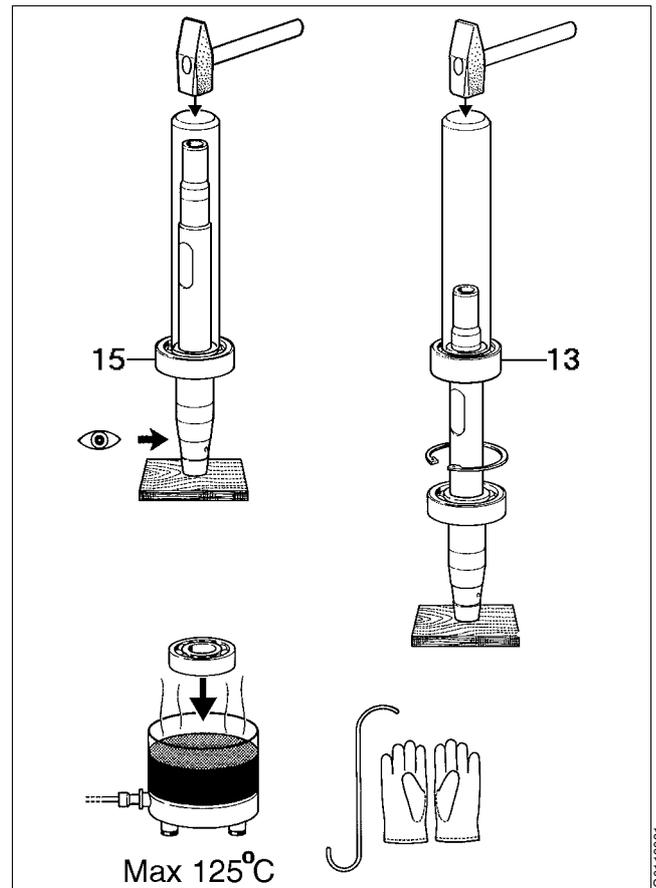
Heat the new ball bearings in oil to maximum 125 °C. Use the special mounting tool from the tool kit.



### NOTE

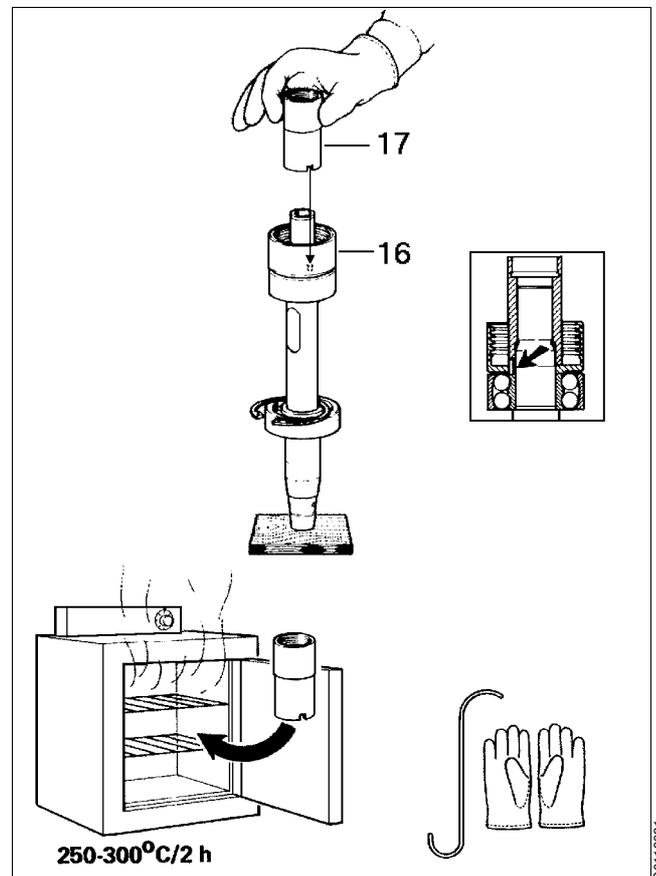
Always fit **new** bearings.

If in doubt how to install roller bearings in a correct way, please see the detailed description in [“5.10.1 Ball and roller bearings”](#) on page 78.



4. Fit oil pump (16) and belt pulley (17). Make sure that the recess in the belt pulley fits over the guide pin in the oil pump.

Heat the belt pulley in a heating cabinet to 250-300 °C for at least 2 hours before fitting.



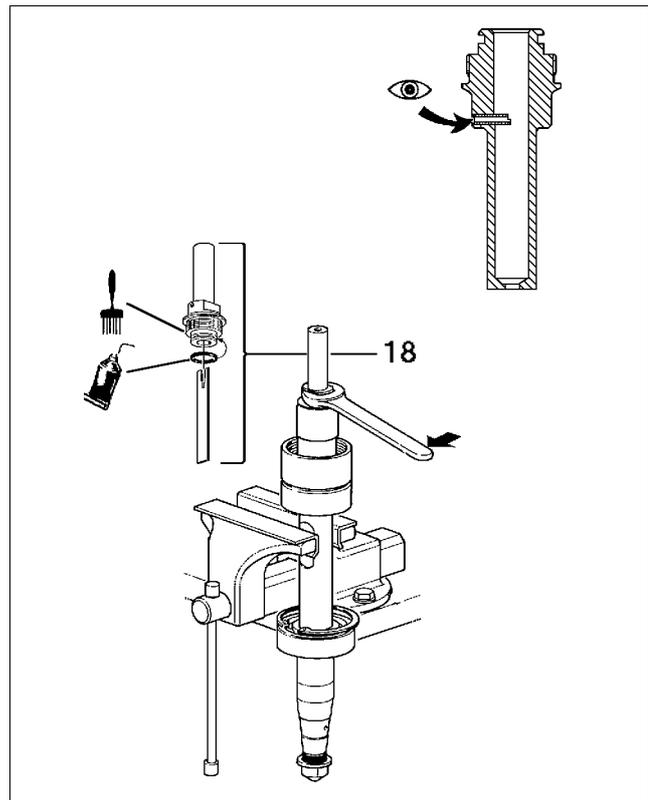
5. Check that the radial hole ( $\phi$  1 mm) in the pump sleeve (18) is clean, and fit the pump.

### NOTE

Do not fit the pump sleeve until the belt pulley has cooled down

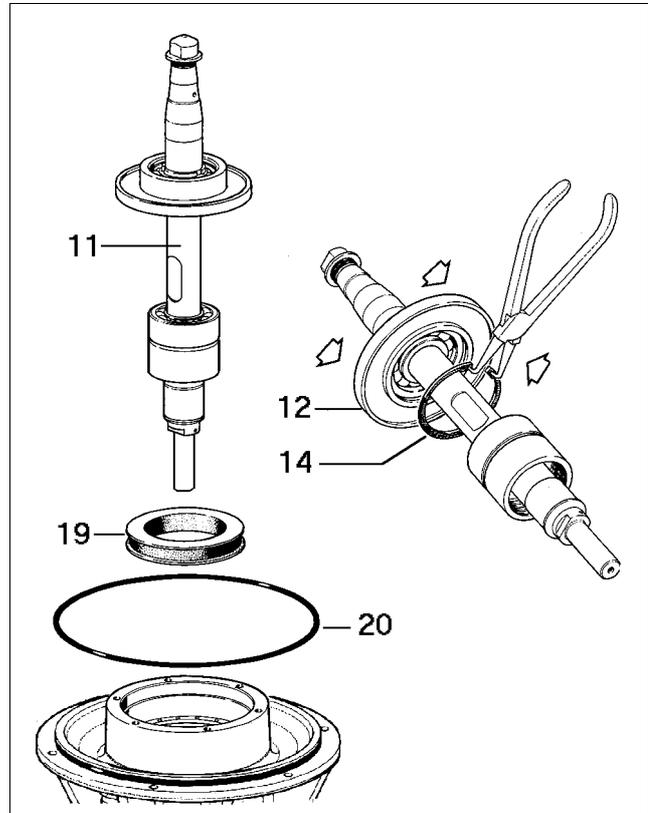
 *Molykote 1000 Paste*  
(thin layer to be rubbed into surface).

 *Silicone grease*  
(thin layer)



G0114321

6. Fit ball bearing holder (12) and secure it with snap ring (14).  
Fit O-ring (20) and rubber buffer (19).  
Lower spindle assembly (11) carefully into the separator intermediate frame.



G0076122

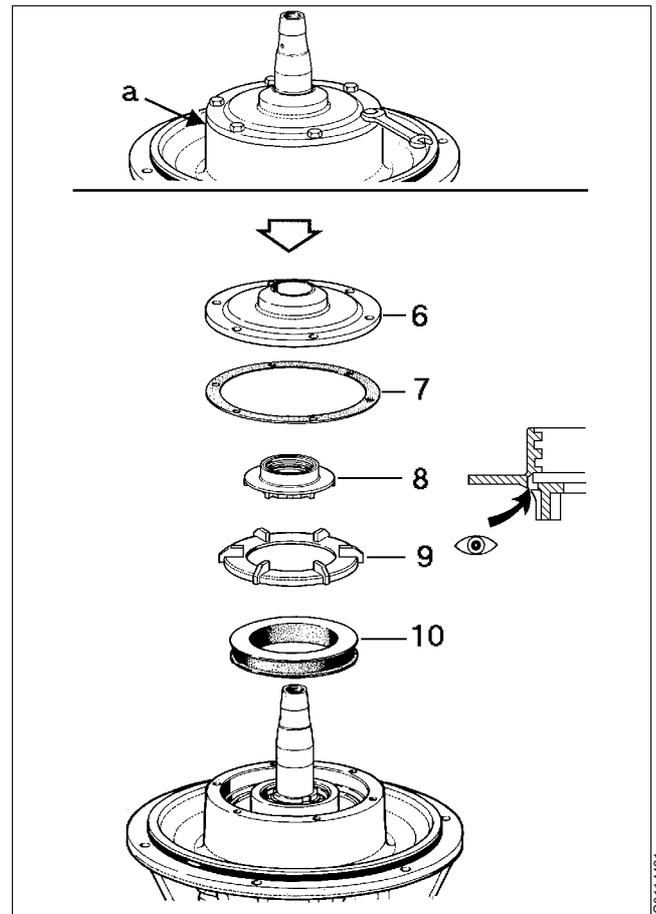
7. Assemble, in the following sequence:

- Rubber buffer (10)
- Buffer holder (9)
- Fan (8)
- Gasket (7)
- Top bearing cover (6)

Make sure that the  $\phi$  3 mm hole in fan (8) is clean and the lugs in the fan enter the recesses in the bowl spindle.

Before tightening, make sure that there is some play (a) between top bearing cover (6) and the frame. The play will disappear when the screws are tightened.

Tighten the screws sequentially (not crosswise) in order to successively compress the rubber buffers.

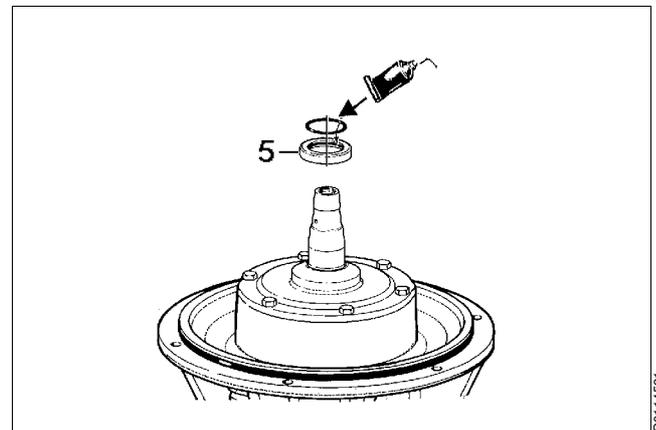


G0114421

8. Push down deflector ring (5) till it stops.



*Silicone grease (thin layer)*



G0114521

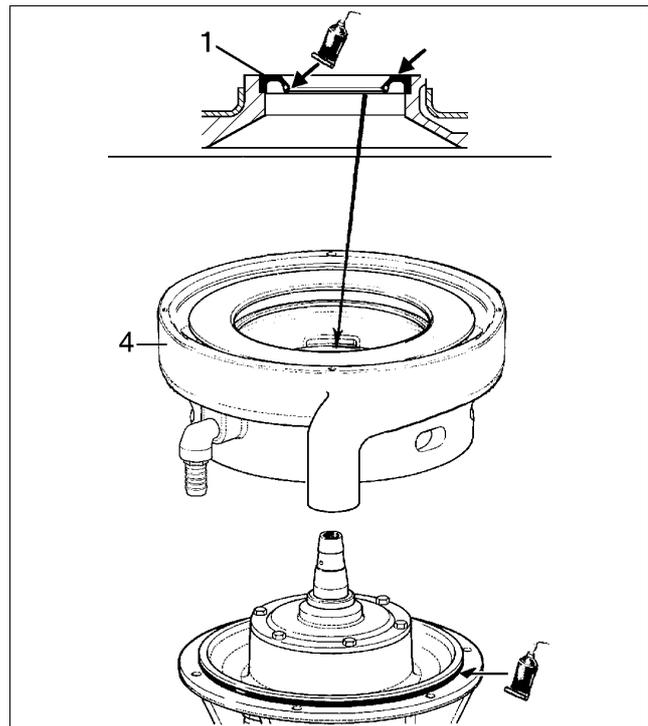
9. Assemble frame top part (4). If lip seal ring (1) has been removed, fit a new one **before** the frame top part is put in place.

Make sure the lip seal is turned the correct way. See illustration.

When frame top part (2) is assembled there shall be a small gap between the bowl spindle and the lip seal (1).



*Silicone grease (thin layer)*

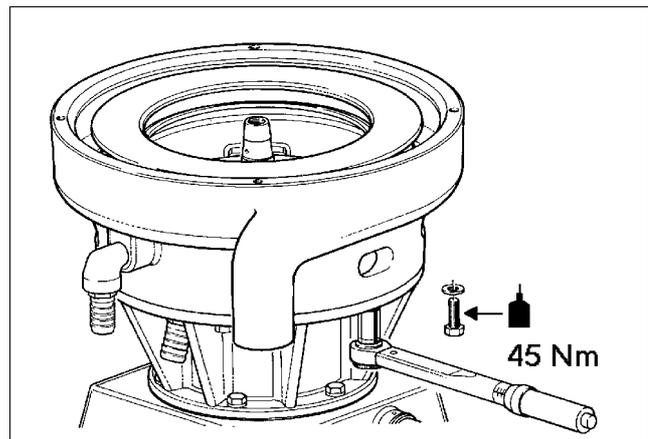


G0114631

10. Tighten the screws of the top frame using a torque wrench (width across flats 16 mm). Tighten the screws slightly crosswise at first. Then tighten all around to **45 Nm**. Secure the screws with Loctite 242.



*Loctite 242*



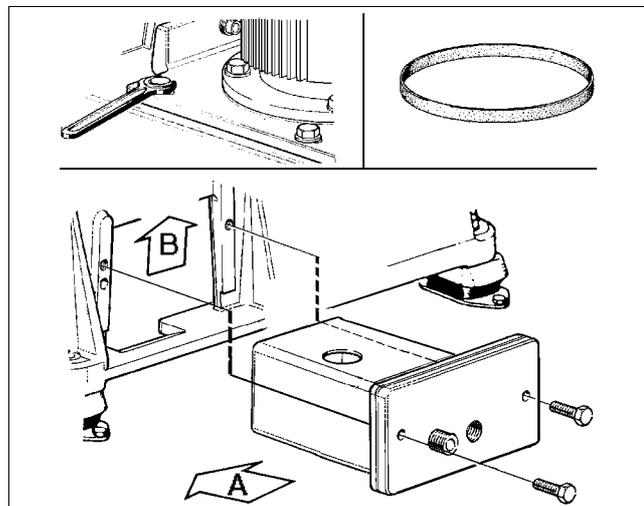
G0114721

11. Fit and adjust the flat belt, see [“6.4.1 Change of belt”](#) on page 119.

✓ **Check point**

[“5.5.2 Radial wobble of bowl spindle”](#) on page 62.

12. Fit the water tank. Push in the water tank (A). Raise the tank (B) and tighten the screws.



G01133C1

## 6.3 Friction coupling

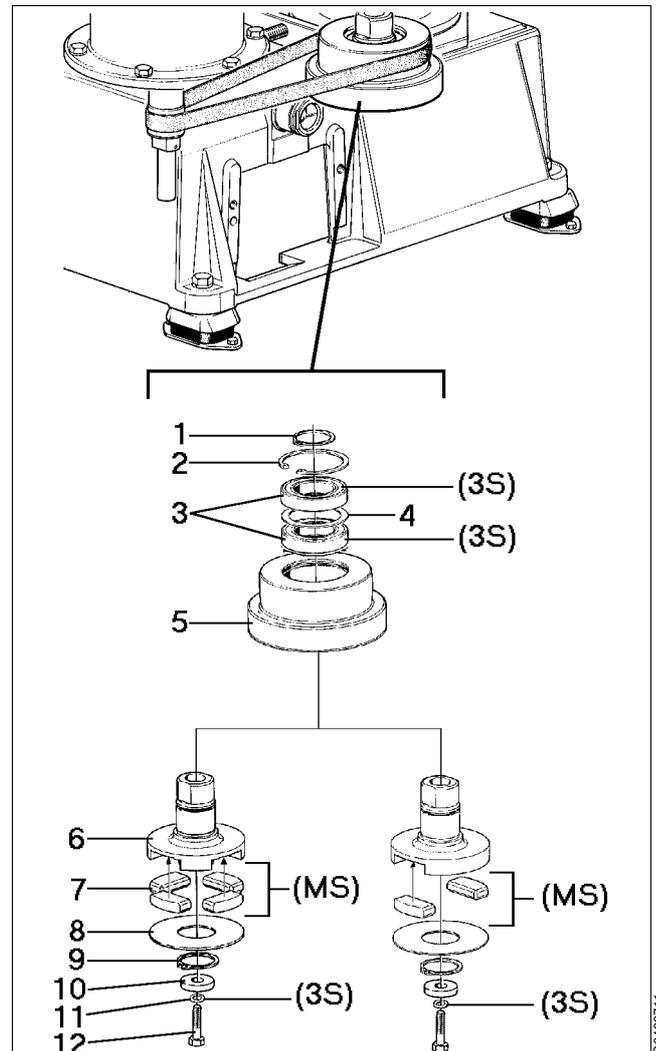
If the separator does not attain full speed within about 2 minutes, the friction elements or the coupling may be worn or greasy. The friction elements must then be replaced with new ones or be thoroughly cleaned from grease.



### WARNING

#### Entrapment hazards

Make sure that rotating parts have come to a **complete standstill** before starting **any** dismantling work.



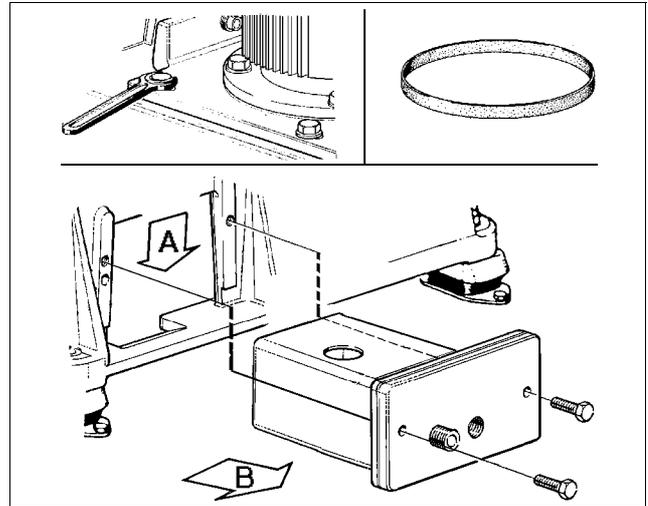
1. Snap ring
2. Snap ring
3. Ball bearings
4. Washer
5. Belt pulley
6. Coupling hub
7. Friction element
8. Cover
9. Snap ring
10. Washer
11. Spring washer
12. Screw

(MS) = Set of friction elements included in the Major Service Kit for 50 Hz (left) or 60 Hz (right)

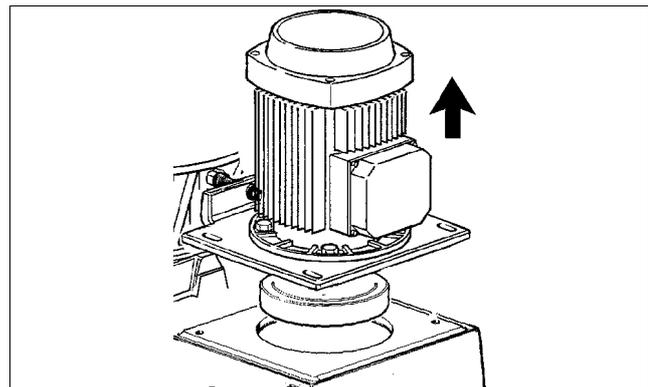
(3S) = Parts included in the 3-year service kit

### 6.3.1 Friction coupling – dismantling

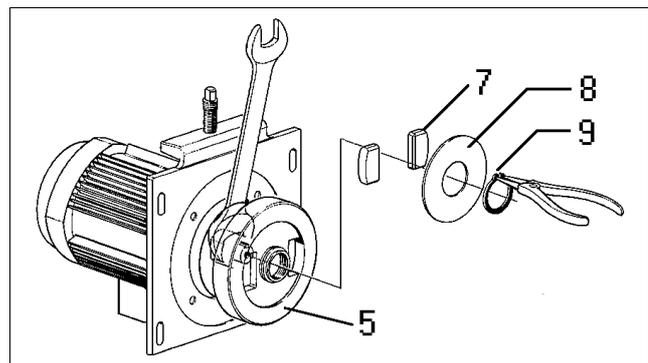
1. Check that the belt tightener is in backward position.
2. Remove the motor adapter screws.
3. Remove the water tank and the flat belt.  
Note that the tank must be lowered past spindle end (A) before it can be withdrawn (B).
4. Remove the flat belt.



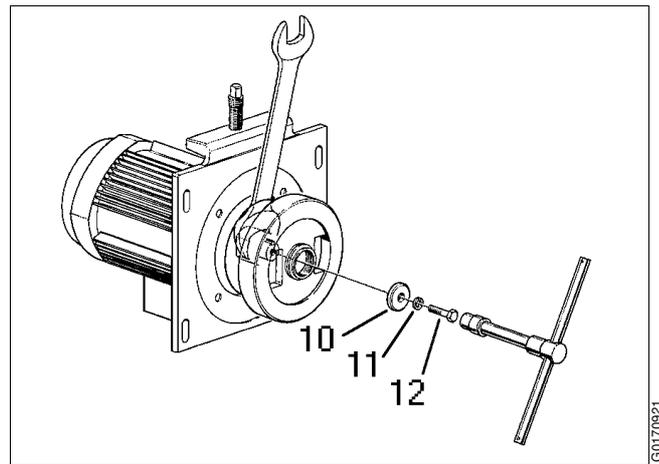
5. Remove the electric motor complete with the friction coupling and motor adapter.  
Weight of motor including adapter and friction coupling is not more than 20 kg.



6. Remove snap ring (9), cover (8) and friction elements (7).  
If the friction elements are worn, fit new ones.  
**Replace all friction elements even if only one is worn.**  
If the friction elements are only greasy:  
Clean the friction elements and the inside of belt pulley (5) with a degreasing agent.

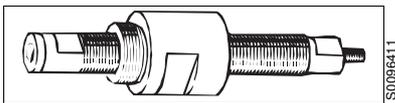


- Remove the screw (12), spring washer (11) and washer (10) from the friction coupling.



**Complete dismantling of the friction coupling**

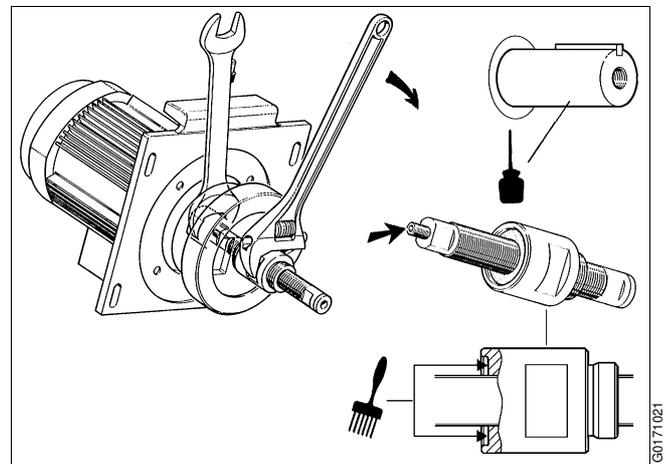
- Lubricate and fit the special mounting and dismantling tool. Ease off the coupling.



*Molykote 1000 Paste*  
(thin layer to be rubbed into surface)

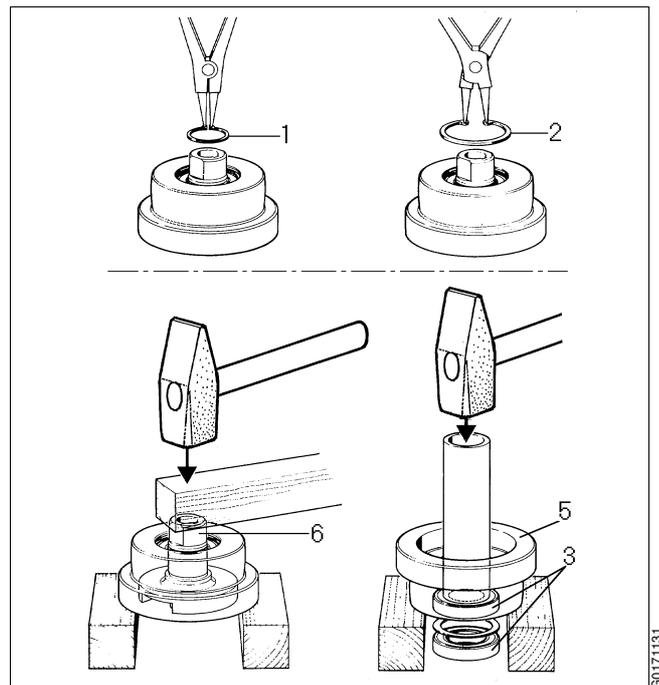


Oil



- Remove snap rings (1 and 2) and drive off coupling hub (6). Turn the coupling, i.e. belt pulley (5) with bearings (3), the other way round and drive off the ball bearings and washer by using a tube.
- Clean all parts in a degreasing agent and replace parts supplied in the spare parts kits.

**NOTE**  
Always discard a used bearing.



### 6.3.2 Friction coupling – assembly

Before the friction coupling is assembled, examine all parts thoroughly for wear and corrosion.

1. Assemble the new ball bearings in belt pulley (5) by using a tube and a hammer.

Apply Loctite 641 on the outer surfaces of ball bearings (3).

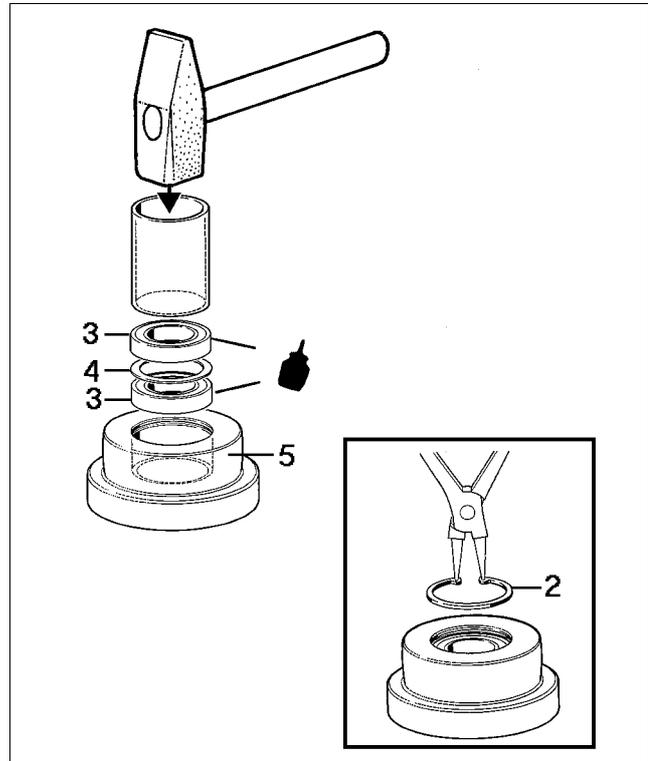
Knock down the bearings carefully (do not forget washer 4) by using the tube which must rest on the outer race of the bearing.

The new bearings must **not be heated** as they are packed with grease and sealed with plastic membranes.

After the assembly of the bearings, fit snap ring (2).



Loctite 641



G0171231

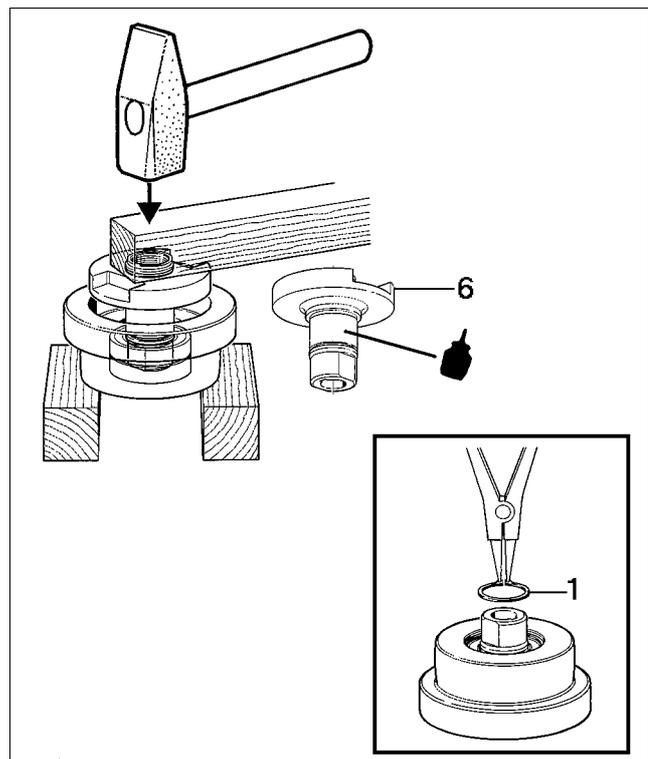
#### NOTE

Do not refit used bearings.

2. Apply Loctite 641 on the coupling hub (6) and knock it down into the belt pulley by using a hammer.
3. Fit snap ring (1).

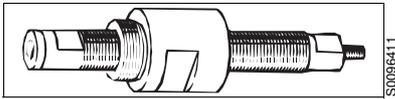


Loctite 641



G0171321

4. Wipe clean the motor shaft and apply a thin oil film on it. Fit the special mounting and dismantling tool to the motor shaft (by means of the small screw on one end of the tool) and press the friction coupling onto the shaft.

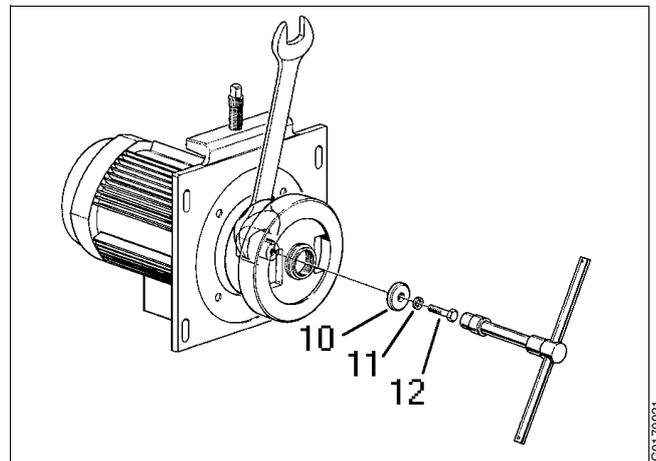
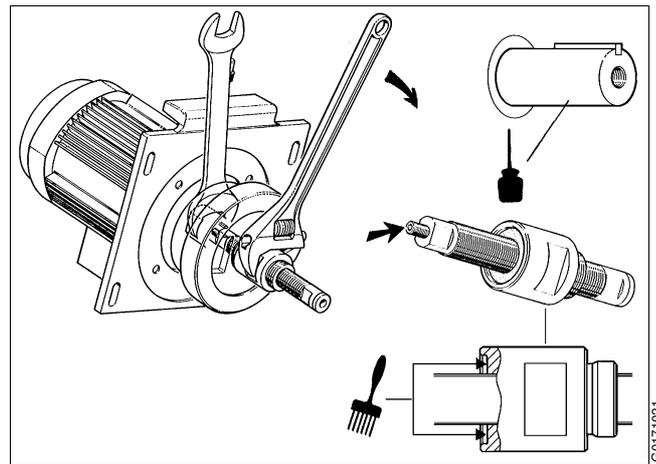


*Molykote 1000 Paste*  
(thin layer to be rubbed into surface)



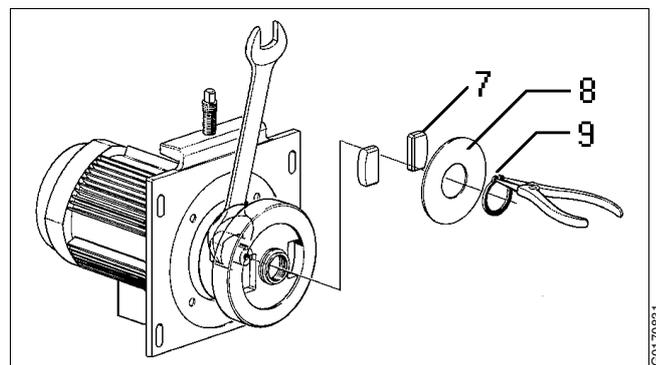
*Oil*

5. Fit the screw (12) with the washer (11) and spring washer (10) to secure the friction coupling.



### Assembly of friction elements

6. Fit new friction elements (7), cover (8) and snap ring (9).
- A coupling with two friction elements is used for 60 Hz installations.
  - A coupling with four friction elements is used for 50 Hz installations.

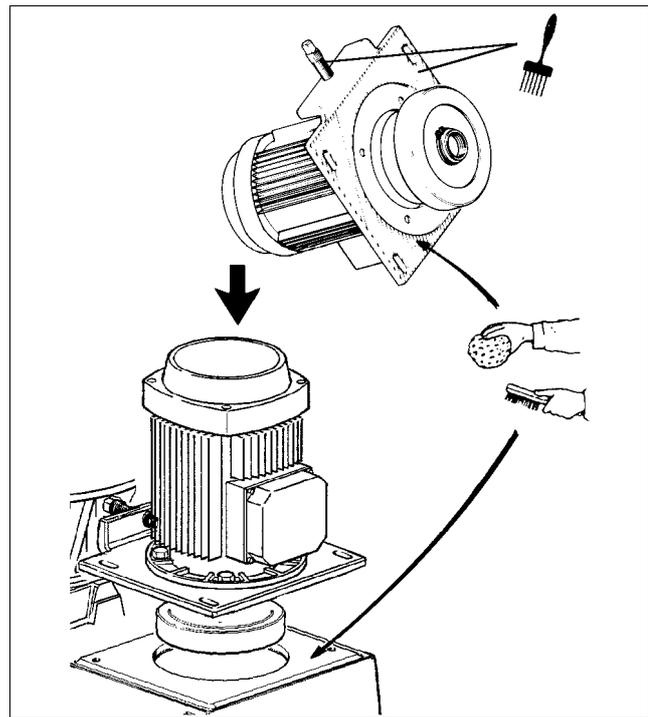


7. Degrease and clean the contact surfaces of frame and motor adapter. Lubricate the contact surfaces with Molykote 1000 paste. Then fit the electric motor with adapter and friction coupling in position.



*Molykote 1000 Paste*  
(thin layer to be rubbed into surface)

Also lubricate the threads of the belt tightener with Molykote 1000 paste or similar.



8. Fit and tighten the flat belt, see [“6.4.1 Change of belt” on page 119](#).
9. Install the water tank and the cover.

## NOTE

The belt must be re-tightened before starting the separator, see next page.

## 6.4 Flat belt and tightener

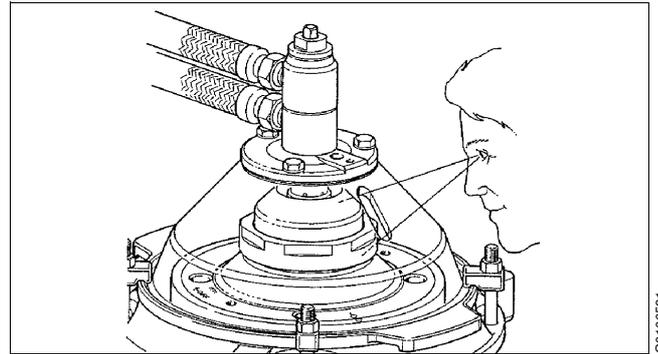


### WARNING

#### Entrapment hazards

Make sure that rotating parts have come to a **complete standstill** before starting **any** dismantling work.

Look into the slot in the frame hood to see if separator parts are rotating or not.



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### 6.4.1 Change of belt

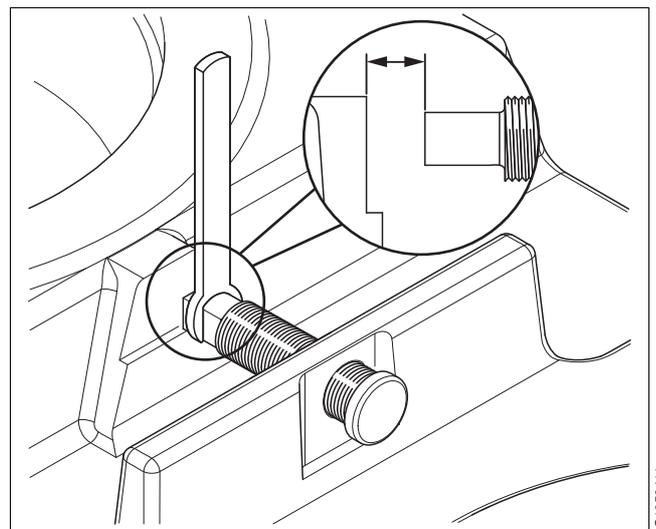
Alfa Laval ref. 9007861, rev. 2

#### Remove water tank and brake

1. Remove the water tank by lowering the back end of the tank and then pulling it out of the frame.  
For separators without water tank: Remove the cover.
2. Remove the brake.

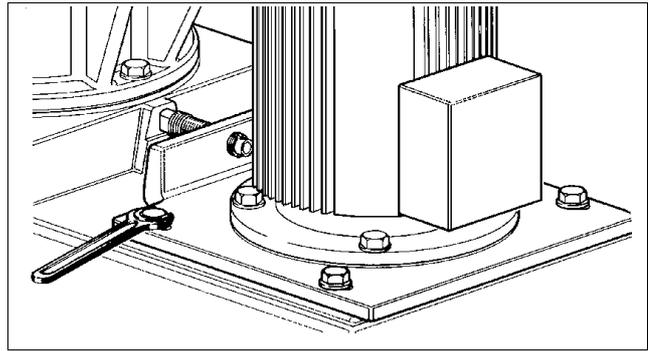
#### Remove belt

1. Adjust the belt tightener to make sure there is a gap between frame pad and belt tightener.



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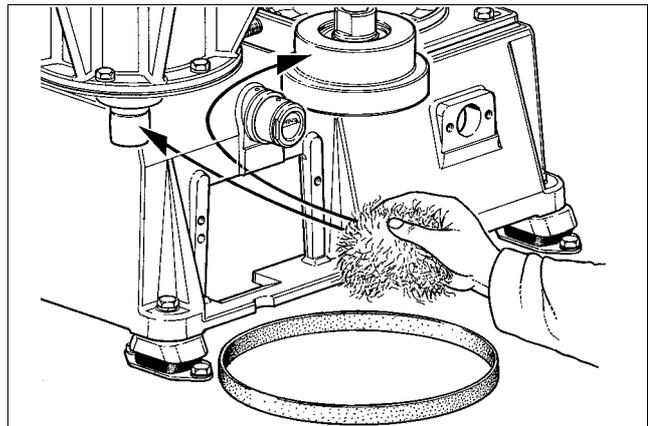
2. Loosen but do not remove the motor adapter screws.



3. Remove the belt.
4. Clean the raceways of the bowl spindle and the friction coupling by using a degreasing agent. Wipe the raceways with a clean rag after cleaning.

**NOTE**

Make sure there is no dirt, oil or grease on the raceways.



5. Remove the motor adapter screws.
6. Remove the friction coupling.

Lift the motor together with adapter and friction coupling.

### NOTE

The capacity of the lifting equipment should be at least 50 kg.

7. Lubricate the adapter and the frame surface.

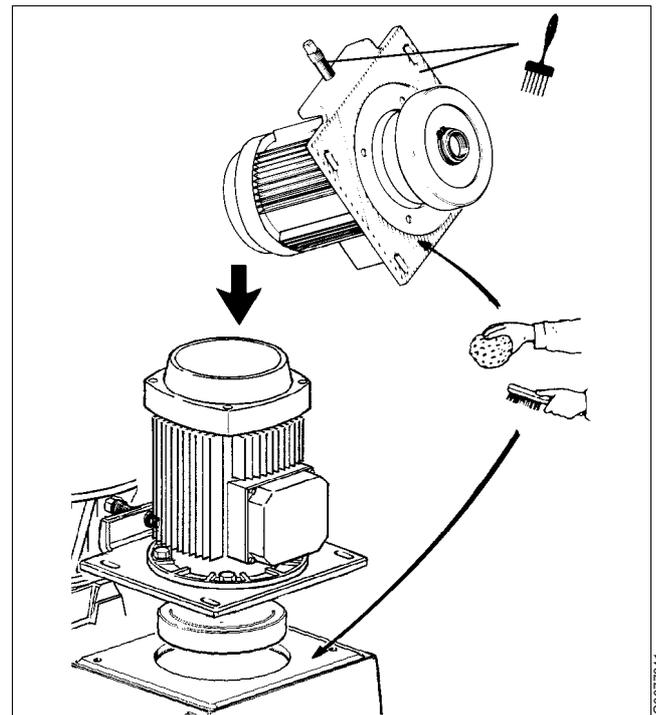
Make sure there is a sufficient film of lubricating paste between the adapter and the frame surface.

For more information regarding lubricants refer to the lubrication instructions for the product.

8. Install motor and friction coupling.
9. Fit the motor adapter screws but do not tighten them.
10. Lubricate the threads of the belt tightener.

Make sure there is a sufficient film of lubricating paste on the threads of the belt tightener.

For more information regarding lubricants refer to the lubrication instructions for the product.

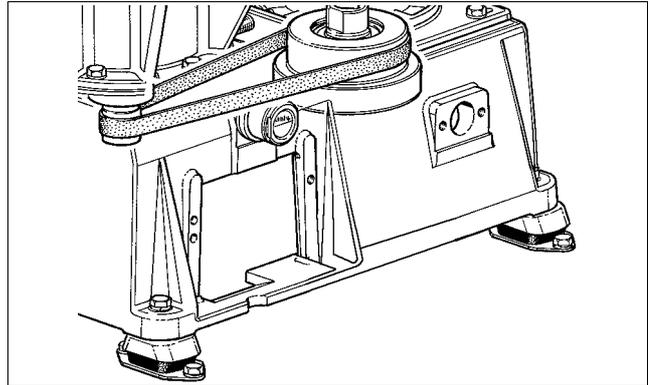


**Install belt**

1. Assemble the belt on the motor side first and then on to the spindle.

Tighten the belt by moving the motor backwards by hand.

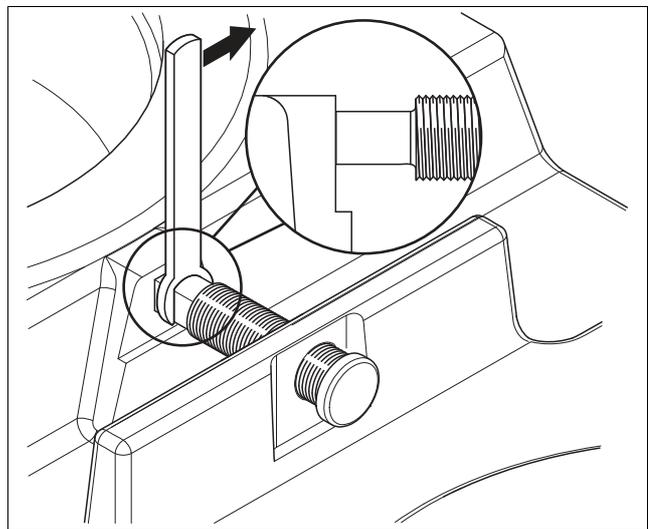
Pull the belt around a few turns by hand.



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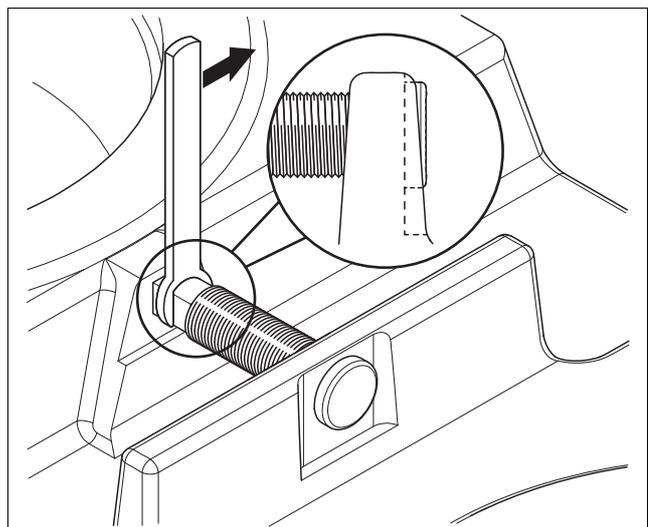
2. Tighten belt.

Rotate the belt tightener until it makes contact with the frame pad.



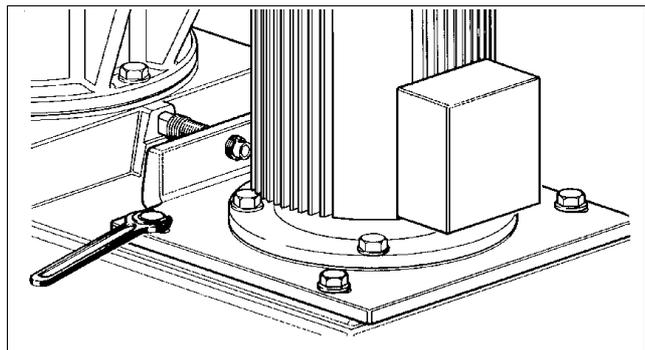
G1058611

Tighten the belt by rotating the belt tightener until the end lug of the screw is in contact with the motor adapter.

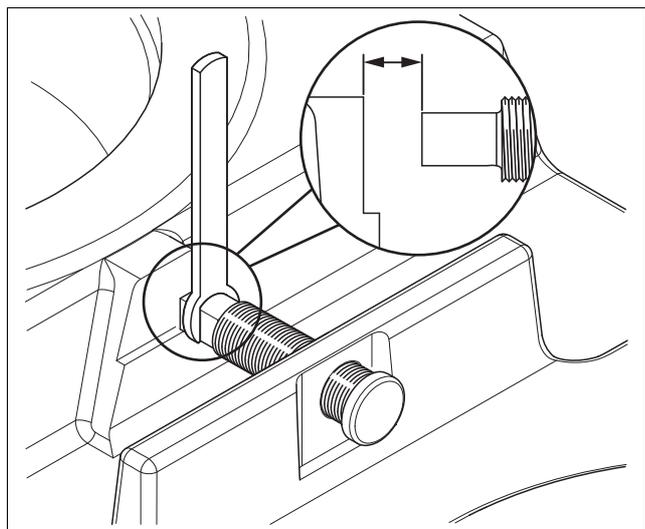


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3. Tighten the motor adapter screws.



4. Loosen the belt tightener.



#### **Install water tank, or cover, and brake**

1. For separators with water tank: Install the water tank.  
For separators without water tank: Install the cover.
2. Install the brake.

#### **Before starting the separator**

3. Wait at least 30 minutes before starting the separator.

## 6.5 Oil filling device

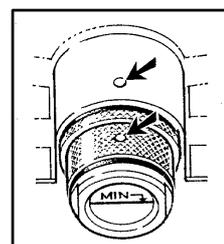
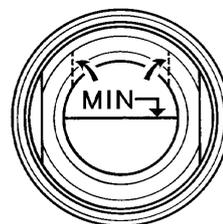
### 6.5.1 Dismantling/assembly

Drain off the oil, see “5.8 Oil change” on page 75.

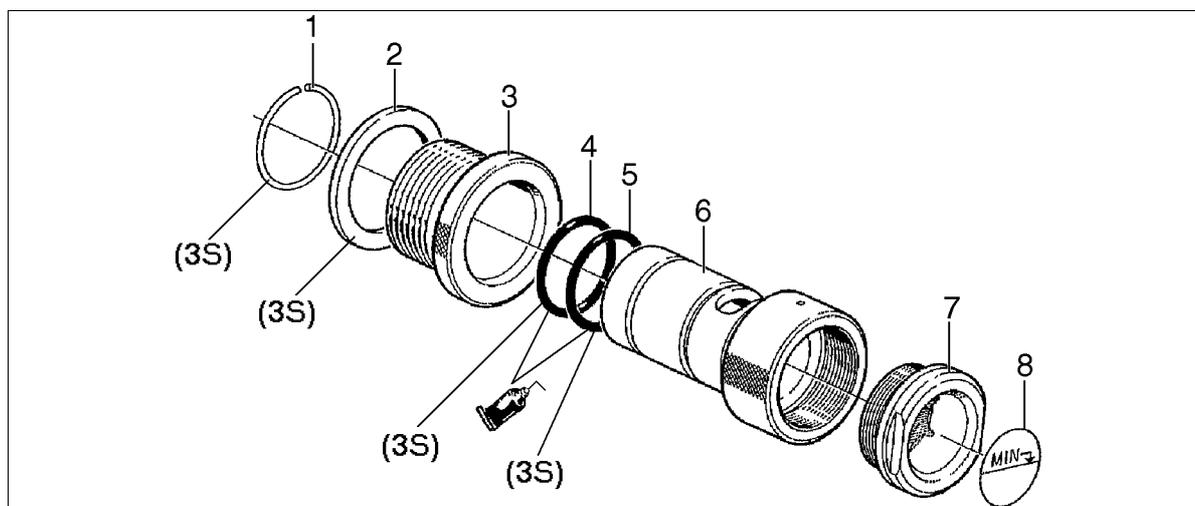
Unscrew nipple (3) and pull off the oil filling device. Then unbend and pull off the round safety wire (1).

1. If plate (8) is to be replaced, wipe the sight glass (7) with a degreasing agent.
2. Fit the new plate on the outside of the sight glass. The plate is self-adhesive.
3. Mark the position of the plate relative to the recess in sleeve (6).

Assemble the oil filling device and fit it into the frame. Note that the mark on sleeve (6) must be positioned opposite the mark on the frame. Fill the sump with new oil.



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- |                      |                           |
|----------------------|---------------------------|
| 1. Round safety wire | 5. O-ring                 |
| 2. Sealing ring      | 6. Sleeve for oil filling |
| 3. Nipple            | 7. Sight glass            |
| 4. O-ring            | 8. Plate                  |

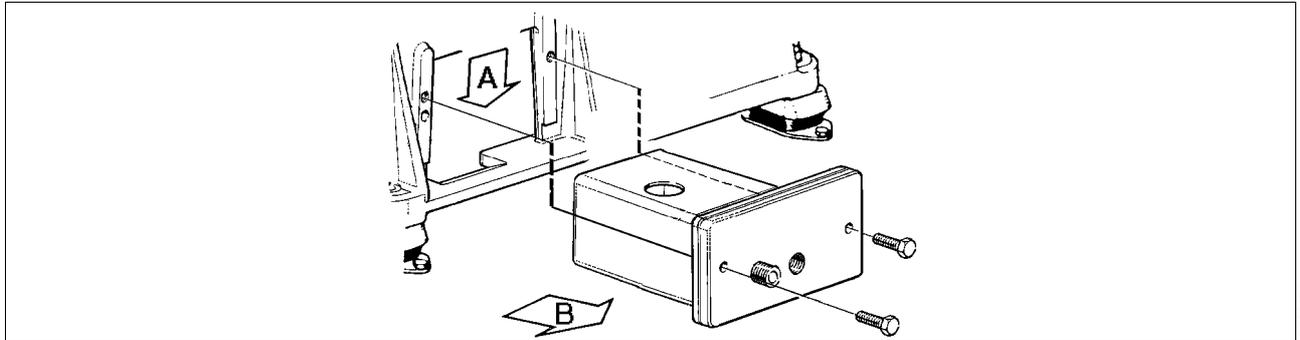
(3S) = Parts included in the 3-year service kit



Silicone grease (thin layer)

## 6.6 Water tank

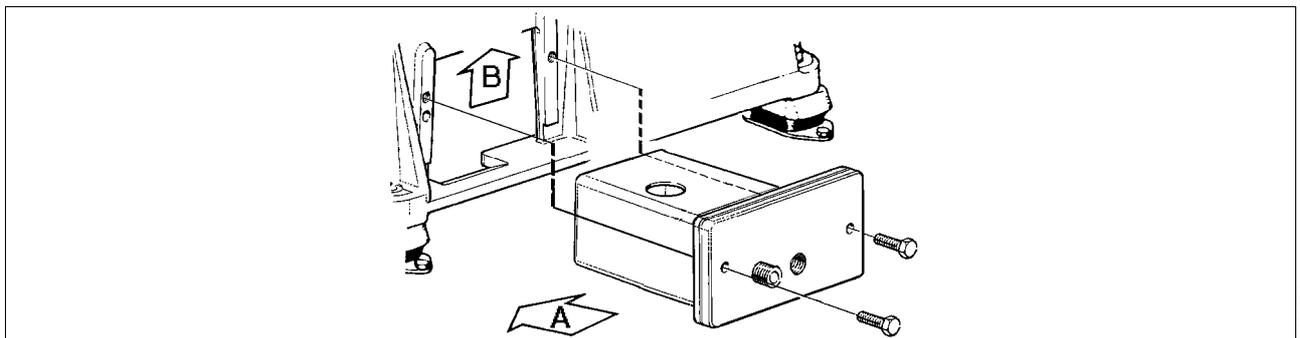
### 6.6.1 Exploded view



### 6.6.2 Dismantling

1. Remove the tank. Note that the tank must be lowered past the spindle end (A) before it can be withdrawn (B).
2. Check the tank interior and clean out if necessary.

### 6.6.3 Assembly



Fit the water tank. Push in the water tank (A).  
Raise the tank (B) and tighten the screws.

## 6.7 Frame feet

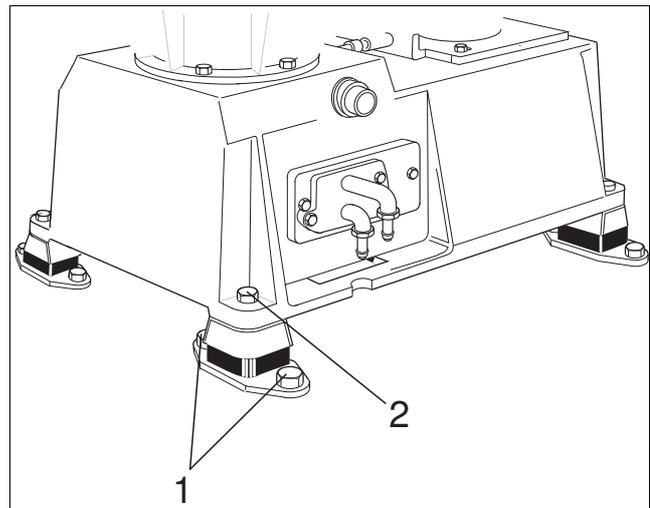
### 6.7.1 Mounting of new frame feet

When replacing the frame feet, the separator must be lifted.

Remove the bowl before lifting the separator.

Follow [“5.6 Lifting instructions”](#) on page 70.

1. Loosen the foundation bolts and lift the separator.
2. Remove the existing frame feet.
3. Mount the new feet.
4. Place the separator in its original position and fasten the foundation bolts.
5. Remove the two lifting eye bolts.
6. Assemble the separator bowl, see [“6.1.3 Inlet/outlet and bowl – assembly”](#) on page 93.



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# 7 *Trouble-tracing*

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## Contents

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## 7.1 Trouble-tracing procedure

This chapter applies to trouble-tracing concerning functions of the separator only. It does not include the other equipment in your processing system.

Always start with trouble-tracing instructions in the system documentation, and if required, continue with the instructions below. If the problem still is not solved, contact your Alfa Laval representative.

## 7.2 Mechanical function

### 7.2.1 The separator does not start

Possible cause	Action
No power supply to motor.	Check power supply.

### 7.2.2 Start-up time too long

Possible cause	Action
Friction elements worn or oily.	Fit new friction elements or clean the old ones if they are oily.
Belt tension too loose.	Tighten the belt.
Motor failure.	Repair.
Incorrect power supply (50 Hz instead of 60 Hz).	Use applicable 60 Hz power supply.
Bearing damaged or worn.	Install new bearings.

### 7.2.3 Starting power too low

See [“7.2.2 Start-up time too long”](#).

### 7.2.4 Starting power too high

Possible cause	Action
Motor failure.	Repair the motor.
50 Hz pulley running on 60 Hz power supply.	After immediate stop, install correct pulley.
Height position of paring disc incorrect.	Check and adjust.
Bearing damaged or worn.	Install new bearings.

### 7.2.5 Separator vibrates during starting sequence

#### NOTE

Some vibration is normal during starting sequence when the separator passes through its critical speeds.

Possible cause	Action
Bowl out of balance due to: <ul style="list-style-type: none"> <li>– poor cleaning</li> <li>– incorrect assembly</li> <li>– too few discs</li> <li>– insufficiently tightened bowl hood</li> <li>– bowl assembled with parts from other separators.</li> </ul>	After safety stop, identify and rectify cause.   <b>Incorrectly tightened bowl hood involves fatal danger.</b>
Height adjustment of paring disc is incorrect.	Check and adjust.
Vibration dampers in frame feet worn out.	Fit new frame feet.
Bowl spindle bent (max. 0,04 mm).	Fit a new bowl spindle.
Top and/or bottom bearing overheated, damaged or worn.	Fit new bearings.
Spindle top bearing rubber buffer defective.	Fit new rubber buffers.

### 7.2.6 Separator vibrates during normal running

	<p><b>WARNING</b></p> <p><b>Disintegration hazards</b></p> <p>Never discharge a vibrating separator.</p>
---	--

Possible cause	Action
Uneven sludge deposits in sludge space.	Clean the bowl.
Bearing damaged or worn.	Fit new bearings.
Vibration dampers in frame feet worn out.	Fit new frame feet.
Spindle top bearing rubber buffer defective.	Fit new rubber buffers.

**7.2.7 Smell**

Possible cause	Action
Normal occurrence during start as the friction elements slip.	None.
Belt slips.	Tighten the belt. Check for oily pulleys.
Top and/or bottom bearing overheated.	Fit new bearings.

**7.2.8 Noise**

Possible cause	Action
Oil level in oil sump is too low.	Read oil level and add oil if necessary.
Height adjustment of paring disc is incorrect.	Check and adjust.
Top and/or bottom bearing damaged or worn.	Fit new bearings.

**7.2.9 Speed too high**

Possible cause	Action
Incorrect transmission (50 Hz pulley running on 60 Hz power supply).	After immediate stop, install correct transmission.
	 <p>In the event of overspeed, examine bowl for possible deformation. The separator must not be started without correcting the effects of the fault. Contact your Alfa Laval representative.</p>
Frequency of power supply (50/60 Hz).	Check.

**7.2.10 Speed too low**

Possible cause	Action
Bowl not closed or leaking.	Dismantle and check.
Friction elements worn or oily.	Fit new friction elements or clean the old ones if they are oily.
Belt tension too loose.	Tighten the belt.
Motor failure/motor bearings.	Repair the motor.
Bearing overheated/damaged or worn.	Fit new bearings.
Incorrect transmission (60 Hz pulley running on 50 Hz power supply).	Make sure that the pulley is intended for 50 Hz power supply.

**7.2.11 Water in oil sump**

Possible cause	Action
Bowl casing drain obstructed.	Clean. Change oil in oil sump.
Leakage at top bearing.	Fit a new seal ring and change oil in oil sump.
Condensation.	Clean the oil sump. Change oil in oil sump.

## 7.3 Separating function

### 7.3.1 Liquid flows through bowl casing drain and/or sludge outlet

Possible cause	Action
Sludge discharge or water draining in progress.	None (normal).
Broken water seal.	See <a href="#">“7.3.7 Oil discharge through water outlet = broken water seal”</a> on page 137.
Displacement water volume too large.	Adjust.
The supply of operating water is not sufficient due to clogged strainer, kinked hose or low water pressure.	Straighten the hose. Clean the strainer. Check the water pressure.
Seal ring on bowl hood/paring chamber cover defective.	Fit a new seal ring.
Seal ring in sliding bowl bottom defective.	Install a new seal ring.
Bowl hood seal ring defective or sealing surface of sliding bowl bottom damaged.	Install a new seal ring. Polish the surface on sliding bowl bottom or install a new one.
Valve plugs defective.	Install new valve plugs.
Sludge deposits on operating slide.	Clean the operating slide.
Seal rings in paring disc device defective.	Fit new seal rings.
Bowl speed too low.	Make sure current is on. Retighten the flat belt or inspect motor and power transmission.

### 7.3.2 Bowl opens unintentionally during operation

Cause	Remedy
Nozzles in bowl body clogged.	Clean the nozzles,
Seal ring in sliding bowl bottom or upper or lower distributing ring defective.	Install a new seal ring or install a new upper or lower distributing ring.
Lime scale deposits in hollow spindle.	Clean the hollow spindle after removing the pump sleeve.
Valve plugs defective.	Install new valve plugs.
Sludge deposits on operating slide.	Clean the operating slide.
Valve for operating water not closing properly. Can result in repeated discharges.	Open and clean the valve.

### 7.3.3 Bowl fails to open for sludge discharge

Cause	Remedy
The supply of operating water is not sufficient due to clogged strainer, kinked hose or low water pressure.	Straighten the hose. Clean the strainer. Check the water pressure.
Seal ring in operating slide defective.	Install a new seal ring.
Valve for operating water not opening.	Examine the electrical system and correct the fault (open circuit, low voltage, dirt, high voltage).

### 7.3.4 Unsatisfactory sludge discharge

Cause	Remedy
Sludge deposits in operating system.	Clean the operating system.

### 7.3.5 Unsatisfactory separation result

Possible cause	Action
Gravity disc size wrong.	Select another gravity disc.
Incorrect separating temperature.	Adjust temperature.
Throughput too high.	Reduce throughput.
Sludge space in bowl is filled with sludge.	Clean the bowl and shorten time between discharges.  Remove the covering disc if the first measure does not help.
Disc stack clogged.	Clean the bowl discs.
Inlet clogged.	Clean.
Bowl speed too low.	See <a href="#">“7.2.10 Speed too low” on page 133</a> .

### 7.3.6 Outgoing water contains oil

Possible cause	Action
Gravity disc hole too large.	Use a gravity disc with a smaller hole.
The supply of operating water is not sufficient due to clogged strainer, kinked hose or low water pressure.	Straighten the hose. Clean the strainer. Check the water pressure.

### 7.3.7 Oil discharge through water outlet = broken water seal

Possible cause	Action
Gravity disc too large.	Use a gravity disc with a smaller hole.
Separation temperature too low.	Increase temperature.
Throughput too high.	Reduce throughput.
The supply of operating water is not sufficient due to clogged strainer, kinked hose or low water pressure.	Straighten the hose. Clean the strainer. Check the water pressure (200-600 kPa).
Valve(s) in oil outlet line closed.	Open the valve(s) and adjust the back pressure to normal value.
Sealing water volume too small.	Check supply of sealing water.
Disc stack clogged.	Clean the bowl discs.
Seal ring in sliding bowl bottom or upper or lower distribution ring defective.	Install a new seal ring.
Bowl hood seal ring defective or sealing surface of sliding bowl bottom damaged.	Install a new seal ring. Polish the surface on sliding bowl bottom or install a new one.
Valve plugs defective.	Install new valve plugs on operating slide.
Bowl speed too low.	See <a href="#">“7.2.10 Speed too low” on page 133</a> .
Bowl incorrectly assembled.	Examine and make correct.



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# 8 *Technical Reference*

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## 8.1 Product description

Alfa Laval ref. 558482, rev. 5

<b>Product number</b>	881099-02-06/4
<b>Separator type designation:</b>	MSPX 303TGP-61
<b>Application</b>	For marine and power oil sludge
<b>Technical design</b>	<p>Purifier / Concentrator with rough separation part disc stack and partial discharge.</p> <p>Machine bottom part for belt drive.</p> <p>Intended for marine- and land applications.</p> <p>Sealings in Nitrile/Viton</p>
<b>Restrictions</b>	<p>Discharge interval: 2-60 minutes</p> <p>Feed temperature: 0 °C to +100 °C.</p> <p>Ambient temperature: +5 to +55 °C.</p> <p>Not to be used for liquids with flashpoint below 60 °C.</p> <p>Maximum allowed density of operating liquid: 1000 kg/m<sup>3</sup>.</p> <p>Risk for corrosion and erosion has to be investigated in each case by the application centre.</p>

### 8.1.1 Directives & standards

*Alfa Laval ref. 591985, rev. 4*

#### Declaration of Incorporation of Partly Completed Machinery

The machinery complies with the relevant, essential health and safety requirements of:

2006/42/EC Machinery Directive

To meet the requirements the following standards have been applied:

EN 60204-1 Electrical equipment of machines, part 1: General requirements

EN ISO 12100 Safety of machinery - General principles for design - Risk assessment and risk reduction

ISO 3744 Acoustics - Determination of sound power levels of noise sources using sound pressure

#### Declaration of Conformity

The machinery complies with the following Directives:

2004/108/EC Electromagnetic Compatibility

To meet the requirements the following standards have been applied:

EN 60204-1 Safety of machinery - Electrical equipment of machines. Part 1: General requirements

EN 61000-6-2 Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments

EN 61000-6-4 Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments

EN ISO 12100 Safety of machinery - General principles for design - Risk assessment and risk reduction

This machinery is to be incorporated into other equipment and must not be put into service until it has been completed with starting/stopping equipment, control equipment, auxiliary equipment. e.g. valves, according to the instructions in the technical documentation, and after the completed machinery has been declared in conformity with the directives mentioned above, in order to fulfil the EU-requirements.

## 8.2 Technical data

Alfa Laval ref. 558483, rev. 2

### NOTE

The separator is a component operating in an integrated system including a monitoring system. If the technical data in the system description does not agree with the technical data in this instruction manual, the data in the system description is the valid one.

### Speed

The prescribed speed of the bowl spindle is stamped on the name plate of the machine. The speed must not be exceeded.

Gear ratio (pulleys): 130:41 (50 Hz), 106:41 (60 Hz)

Maximum speed of rotation, rpm	50 Hz	60 Hz
Motor shaft	3000	3600
Bowl	9510	9305

<b>Hydraulic capacity</b>	0,3	m <sup>3</sup> /h
<b>Nom. discharge volume</b>	0,9 / 1,1	Litres, fixed discharge volume
<b>Max. density</b>	feed / sediment	1100/2138 kg/m <sup>3</sup>
<b>Feed temperature</b>	Min. / Max.:	0 / +100 °C
<b>Operating liquid</b>	Max. density:	1000 kg/m <sup>3</sup>
	Max. pressure:	150 kPa
<b>Weight of separator</b>	210	kg (without motor)
<b>Motor power</b>	2,2	kW
<b>Jp reduced to motor shaft</b>	2,5 / 1,7	kg/m <sup>2</sup> 50Hz / 60Hz
<b>Power consumption</b>	idling	0,8 kW
	running (at max. capacity)	1,8 kW
	max. power consumption	2,8 kW (at starting-up)
<b>Starting time</b>	1,8 / 2.3	minutes (min. / max.)
<b>Stopping time without brake</b>	13 / 17	minutes (min. / max.)
<b>Lubricating oil volume</b>	0,5	litres
<b>Max. running time</b>	empty bowl / filled bowl	180 minutes
<b>Sound</b>	power / pressure level	8,3 / 69 Bel(A) / dB(A)
<b>Vibration level max.</b>	new separator	5,6 mm/sec
	separator in use	9 mm/sec
<b>Bowl max. inner diameter</b>	200	mm
<b>Bowl volume</b>	1,5	litres
<b>Bowl weight</b>	approx. 35	kg
<b>Bowl body material</b>	AL 111 2377-02	

There are other material than stainless steel in contact with process liquid.

## 8.3 Connection list

Alfa Laval ref. 557558, rev. 2

Connection No.	Description	Requirements/limit
201	Inlet for process liquid Permitted temperatures	Maximum +100 °C minimum 0 °C
206	Inlet for liquid seal and displacement liquid Quality requirements Liquid seal water flow Pressure Liquid seal water period	Fresh water Min. 7 litres/minute 150 kPa 30 s
220	Outlet for light phase (oil) Pressure	Maximum 150 kPa
221	Outlet for heavy phase (water) Pressure	Maximum 150 kPa
222	Outlet for solid phase Discharge volume The outlet must always be arranged with open outlet or guidance of a sludge pump to prevent the sediment deflector from being filled up with sludge.	Approximately 1 litre
372	Inlet for discharge liquid Flow Quality requirements Pressure Time	Min. 18 litres/minute See <a href="#">"8.5 Water quality" on page 154</a> Minimum 150 kPa 1 s
373	Inlet for closing liquid Flow Quality requirements	Min 0,9 litres/minute See <a href="#">"8.5 Water quality" on page 154</a>
377	Outlet for operating liquid	open

Connection No.	Description	Requirements/limit
462	Drain of frame top part, lower	
463	Drain of frame top part, upper	
701	Motor for separator  Allowed deviation from nominal frequency (momentarily during maximum 5 seconds)	Maximum $\pm 5\%$ $\pm 10\%$ )
753	Unbalance sensors, vibration  -Type -Frequency range -Vibration measurement range -internal impedance -Reset coil voltage -Reset coil power -Switch rating, resistive load max.	Mechanical switch < 300 Hz < 4,5 g 4 k $\Omega$ $\pm 5\%$ 48 V DC Max. 14 W 2 A at 24 V DC

Location of connections on the separator, see  
[“8.7.1 Basic size drawing” on page 165](#), and  
[“8.7.2 Dimensions of connections” on page 166](#).

## 8.4 Interface description

Alfa Laval ref. 557469 rev. 2

### 8.4.1 Scope

This document gives information, requirements and recommendations about operational procedures and signal processing for safe and reliable operation of the separator. It is intended to for designing auxiliary equipment and control system for the separator.

### 8.4.2 References

This Interface Description is one complementary document to the separator. Other such documents that contain necessary information and are referred to here are:

- Interconnection Diagram
- Connection List
- Technical Data

Standards referred to are:

- EN 418 Safety of machinery - Emergency stop equipment, functional aspects - Principles of design
- EN 1037 Safety of machinery - Prevention of unexpected start-up

### 8.4.3 Definitions

For the purpose of this document, the following definitions apply:

- Synchronous speed: The speed the machine will attain when it is driven by a three-phase squirrel-cage induction motor and there is no slip in the motor and the drive system.
- Full speed: The synchronous speed minus normal slip.

### 8.4.4 Goal

To eliminate situations that can cause harm, i.e. injury, damage to health or property and unsatisfactory process result are e.g.:

Situation	Effect
Unbalance caused by uneven sediment accumulation in the bowl.	Too high stress on bowl and bearing system which might cause harm.
Too high bowl speed.	Too high stress on bowl which might cause harm.
Access to moving parts.	Can cause injury to person who accidentally touches these parts.
Insufficient cleaning of separator.	Unsatisfactory product quality.
Bowl leakage.	Product losses.

Information and instructions given in this document aim at preventing these situations.

Control and supervision can be more or less comprehensive depending on the type of used control equipment. When a simple control unit is used it would be impossible or too expensive to include many of the functions specified here while these functions could be included at nearly no extra cost when a more advanced control unit is used. For this reasons functions that are indispensable or needed for safety reasons to protect the machine and/or personnel are denoted with shall while other functions are denoted with should.

### 8.4.5 Description of separator modes.

For control purposes the operation of the separator should be divided into different modes.

The normally used modes are described below but other modes might exist.

It is assumed that:

- The separator is correctly assembled.
- All connections are made according to "Connection List", "Interconnection Diagram" and "Interface Description".
- The separator control system is activated.

If above conditions are not fulfilled the separator is unready for operation.

*STAND STILL* means:

- The power to the separator motor is off.
- The bowl is not rotating.

*STARTING* means:

- The power to the separator motor is on.
- The bowl is rotating and accelerating.

*RUNNING* means:

- The power to the separator motor is on.
- The bowl is rotating at full speed.

*RUNNING* is a collective denomination for a number of sub modes which e.g. can be:

- *STAND BY*: Separator is in a waiting mode and not producing.
- *PRODUCTION*: Separator is fed with product and producing.
- *CLEANING*: Separator is fed with cleaning liquids with the intention to clean the separator.

*STOPPING* means:

- The power to the separator motor is off.
- The bowl is rotating and decelerating.

*STOPPING* is a collective denomination for a number of sub modes which e.g. can be:

- **NORMAL STOP:** A manually or automatically initiated stop.
- **SAFETY STOP:** An automatically initiated stop triggered by too high vibrations.
- **EMERGENCY STOP:** A manually initiated stop at emergency situations. This stop will be in effect until it is manually reset.

### 8.4.6 Handling of connection interfaces.

#### Electrical connections.

##### 701 Separator motor.

The separator is equipped with a 3-phase DOL (Direct On Line) started motor.

There shall be an emergency stop circuit designed according to EN 418 and a power isolation device according to EN 1037.

There shall be a start button close to the separator that shall be used for first start after assembly of the separator.

There should be a counter to count number of running hours.

There should be a current transformer to give an analogue signal to the control unit about the motor current.

##### 753 Unbalance sensor.

For indication of any abnormal unbalance and to be able to perform appropriate countermeasures, the separator may be equipped with a vibration initiated mechanical switch on the separator frame.

The vibration monitor shall include a self-check function to be performed at least at initiation of *STARTING*.

If to high vibrations occur the separator shall be stopped the quickest way possible and it shall not be restarted until the reasons for the vibrations have been found and measures to remove them have been taken.

Signal processing in *STARTING*:

- If to high vibrations occur the separator shall be stopped automatically by *SAFETY STOP*.
- If the self-check system triggers, an alarm shall be given and an automatic stop by *NORMAL STOP* shall be initiated.

Signal processing in *RUNNING*:

- If to high vibrations occur the separator shall be stopped automatically by *SAFETY STOP*.
- If the self-check system triggers, an alarm shall be given.

Signal processing in *STOPPING*:

- If the self-check system triggers, an alarm shall be given.

Signal processing in *NORMAL STOP*:

- If to high vibrations occur the system shall turn over automatically to *SAFETY STOP*.

## Fluid connections.

Complementary information is given in the document "Connection List".

### 201 Inlet for process liquids (feed).

Processing in *STAND STILL*:

- Shall be closed.

Processing in *STARTING*:

- Should be closed. Bowl will be open and empty or closed and filled depending on if start is done from *STAND STILL* or *STOPPING*.

Processing in *RUNNING*:

- Could be closed or open.
- Shall be closed before a discharge.
- Processing in *NORMAL STOP* or *EMERGENCY STOP*:
- Could be closed or open but the bowl should be filled unless the stop is initiated in *STARTING*.

Processing in *SAFETY STOP*:

- Could be closed or open but the bowl shall be filled unless the stop is initiated in *STARTING*.

### 206 Inlet to liquid seal.

Processing in *STAND STILL*:

- Shall be closed.

Processing in *STARTING*:

- Shall be closed.

Processing in *RUNNING*:

- Supplying a liquid seal prior to opening the feed.
- Displacing (the interface) before a discharge.

### 220 and 221 Outlets

Processing in *STAND STILL*:

- Could be closed or open.

Processing in other modes:

- Shall be open.

**372 Inlet for discharge liquid.**

Processing in *STAND STILL*:

- Shall be closed.

Processing in *STARTING*:

- Shall be closed.

Processing in *RUNNING*:

- A discharge is initiated.
- After a discharge has been triggered the motor current or bowl speed should be monitored to indicate if there comes a current peak or a sudden drop in speed. The absence of such a signal indicates that the discharge has failed and corrective action should be taken (e.g. trigger a new discharge). Absence of a discharge may result in problems due to solidification of the sediment.  
That the current returns to original value after discharge could also be supervised. If current is much higher after the discharge this might be an indication that the bowl has not closed properly after the discharge.
- For service purposes there should be a counter to count number of discharges.

**373 Inlet for make-up liquid.**

Processing in *STAND STILL*:

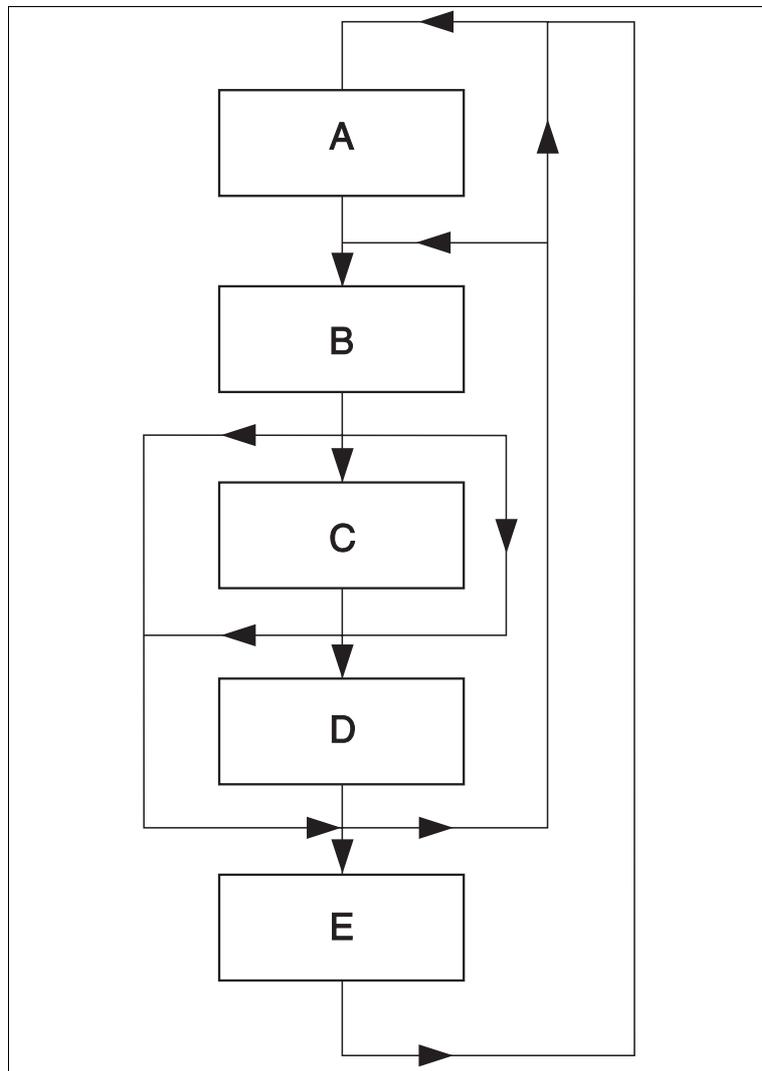
- Shall be closed.

Processing in *STARTING*:

- Shall be closed.

Processing in *RUNNING*:

- The separator bowl is closed.
- The separator bowl is closed in a discharge sequence.

**Function graph and running limitations**

- A. *Stand still*
- B. *Starting mode*
- C. *Running mode*
- D. *Stop mode*
- E. *Safety stop mode*

## 8.5 Water quality

Alfa Laval ref. 553406 rev. 10

Operating water is used in the separator for several different functions: e.g. to operate the discharge mechanism, to lubricate and cool mechanical seals.

Poor quality of the operating water may cause erosion, corrosion and/or operating problem in the separator and must therefore be treated to meet certain demands.

### NOTE

Alfa Laval accepts no liability for consequences arising from unsatisfactorily purified operating water supplied by the customer.

#### The following conditions must be fulfilled:

1. Turbidity free water, solids content <0,001% by volume.  
Deposits must not be allowed to form in certain areas in the separator.
2. A maximum of particle size 50 µm.
3. A total hardness less than 180 mg CaCO<sub>3</sub> per litre, which corresponds to 10°dH or 12.5°E. Hard water may with time form deposits in the operating mechanism. The precipitation rate is accelerated with increased operating temperature and low discharge frequency. These effects become more severe the hardness of the water increase.
4. A chloride content of maximum 100 ppm NaCl (equivalent to 60 mg Cl/l).

A chloride concentration above 60 mg/l is not recommended. Chloride ions contribute to corrosion on the separator surface in contact with the operating water, including the spindle. Corrosion is a process that is accelerated by increased separating temperature, low pH, and high chloride ion concentration.

5. pH>6  
Increased acidity (lower pH) increases the risk for corrosion; this is accelerated by increased temperature and high chloride ion content.

## 8.6 Lubricants

### 8.6.1 Lubrication chart

Alfa Laval ref. 553216-01 rev. 8

Lubricating points	Type of lubricant	Interval
<b>The oil bath:</b> Bowl spindle bearings are lubricated by oil splash from the oil bath.	See <a href="#">Recommended lubricating oils</a> . Volume: see "Technical data".	<b>Oil Change:</b> <ol style="list-style-type: none"> <li>1. Continuous operation: 2000h</li> <li>2. Seasonal operation: Before every operating period</li> <li>3. Short period's operation: 12 months even if total number of operating hours is less than stated above.</li> </ol>
<b>Bowl spindle taper:</b>	Lubricating oil, only a few drops for rust protection.	At assembly.
<b>Bowl:</b> Sliding contact surfaces, thread of lock nut and cap nut.	Pastes as specified in <a href="#">Recommended oil brands</a> .	At assembly.
<b>Rubber seal rings:</b>	Grease as specified in <a href="#">Recommended lubricating oils</a>	At assembly.
<b>Friction coupling ball bearings.</b> <i>Not valid for rigid coupling:</i>	The bearings are packed with grease and sealed and need no extra lubrication.	-
<b>Electric moto:r</b>	Follow manufacturer's instructions.	Follow manufacturer's instructions.
<b>Threads:</b>	Lubricating oil, if not otherwise stated.	At assembly.

#### NOTE!

If not otherwise specified, follow the supplier's instructions about applying, handling and storing of lubricants.



#### CAUTION

Check the oil level before start.  
 Top up when necessary.  
 Do not overfill.

## 8.6.2 Recommended lubricants

Alfa Laval ref. 553217-01 rev. 12

### Lubricant recommendation for hygienic and non-hygienic applications

Lubricants with a Alfa Laval part number are approved and recommended for use.

The data in the below tables is based on supplier information in regards to lubrication properties.

Trade names and designations might vary from country to country. Please contact your local supplier for more information.

### Paste for assembly of metallic parts, non-hygienic applications

Part No	Quantity	Designation	Manufacturer	Remark
537086-02	1000 g	Molykote 1000 Paste	Dow Corning	-
537086-03 537086-06	100 g 50 g	Molykote 1 G-n plus Paste	Dow Corning	-
537086-04		Molykote G-rapid plus Paste	Dow Corning	-
-	-	Gleitmo 705	Fuchs Lubritech	-
-	-	Wolfracoat C Paste	Klüber	-
-	-	Dry Moly Paste	Rocol	-
-	-	MT-LM	Rocol	-

### Bonded coating for assembly of metallic parts, non-hygienic applications

Part No	Quantity	Designation	Manufacturer	Remark
535586-01	375 g	Molykote D321R Spray	Dow Corning	
		Gleitmo 900	Fuchs Lubritech	Varnish or spray

**Paste for assembly of metallic parts, hygienic applications (NSF registered H1 is preferred)**

Part No	Quantity	Designation	Manufacturer	Remark
-	-	Molykote D paste	Dow Corning	-
537086-07	50 g	Molykote P-1900	Dow Corning	NSF Registered H1 (22 Jan 2004)
-	-	Molykote TP 42	Dow Corning	-
561764-01	50 g	Geralyn 2	Fuchs Lubritech	NSF Registered H1 (3 Sep 2004)
-	-	Geralyn F.L.A.	Fuchs Lubritech	NSF Registered H1 (2 April 2007). German § 5 Absatz 1 LMBG approved.
554336-01	55 g	Gleitmo 1809	Fuchs Lubritech	-
-	-	Gleitmo 805	Fuchs Lubritech	DVGW (KTW) approval for drinking water (TZW prüfzeugnis)
		Klüberpaste 46 MR 401	Klüber	White, contains no lead, cadmium, nickel, sulphur nor halogens.
		Klüberpaste UH1 84-201	Klüber	NSF Registered H1 (26 Aug 2005)
		Klüberpaste UH1 96-402	Klüber	NSF Registered H1 (25 Feb 2004)
		252	OKS	NSF Registered H1 (23 July 2004)
		Foodlube Multi Paste	Rocol	NSF Registered H1 (13 April 2001)

**Silicone grease/oil for rubber rings, hygienic and non-hygienic applications**

Part No	Quantity	Designation	Manufacturer	Remark
-	-	No-Tox Food Grade Silicone grease	Bel-Ray	NSF Registered H1 (16 December 2011)
		Dow Corning 360 Medical Fluid	Dow Corning	Tested according to and complies with all National Formulary (NF) requirements for Dimethicone and European Pharmacopeia (EP) requirements for Dimeticone or Silicone Oil Used as a Lubricant, depending on viscosity.
539474-02 539474-03	100 g 25 g	Molykote 111 Compound	Dow Corning	Molykote® 111Compound meets several global standards for water contact, including NSF 51, NSF 61, FDA 21 CFR 175.300, Water Regulations Advisory Scheme Approval BS9260 (England), IPL Certificate of Conformity (France) and DIN-DVGW Examination certificate (Germany).
569415-01	50 g	Molykote G 5032	Dow Corning	NSF Registered H1 (3 June 2005)
-	-	Gerilyn SG MD 2	Fuchs Lubritech	NSF Registered H1 (30 March 2007)
-	-	Chemplex 750	Fuchs Lubritech	DVGW approved according to the German KTW-recommendations for drinking water.
-	-	Paraliq GTE 703	Klüber	NSF Registered H1 (25 Feb 2004). Approved according to WRAS.
-	-	Unisilikon L 250 L	Klüber	Complies with German Environmental Agency on hygiene requirements for tap water. Certified by DVGW-KTW, WRAS, AS4020, ACS.
		ALCO 220	MMCC	NSF Registered H1 (25 March 2002)
		Foodlube Hi-Temp	Rocol	NSF Registered H1 (18 April 2001)

Always follow the lubrication recommendations of the bearing manufacturer.

Grease for ball and roller bearings in electric motors

Part No	Quantity	Designation	Manufacturer	Remark
-	-	Energrease LS2	BP	-
-	-	Energrease LS-EP2	BP	-
-	-	Energrease MP-MG2	BP	-
-	-	APS 2	Castrol	-
-	-	Spheerol EPL 2	Castrol	-
-	-	Multifak EP2	Chevron	-
-	-	Multifak AFB 2	Chevron	-
-	-	Molykote G-0101	Dow Corning	-
-	-	Molykote Multilub	Dow Corning	-
-	-	Unirex N2	ExxonMobil	-
-	-	Mobilith SHC 460	ExxonMobil	-
-	-	Mobilux EP2	ExxonMobil	-
-	-	Lagermeister EP2	Fuchs Lubritech	-
-	-	Rembrandt EP2	Q8/Kuwait Petroleum	-
-	-	Alvania EP2	Shell	-
-	-	LGEP 2	SKF	-
-	-	LGMT 2	SKF	-
-	-	LGFP 2	SKF	NSF Registered H1 (17 Aug 2007)
-	-	Multis EP2	Total	-

### 8.6.3 Recommended lubricating oils

Alfa Laval ref. 553219-09, rev. 1

Type of frame: D/D and P/P with motor < 7,5 kW.

Two different groups of lubricating oils are approved. They are designated as Alfa Laval lubricating oil groups A and D. The numerical value after the letter in the table states the viscosity grade.

The corresponding commercial oil brands are listed on next pages.

Ambient temperature	Alfa Laval lubricating oil group	Time in operation Oil change interval
between +15 and +45 °C	A/150	1500 h
between +2 and +65 °C	D/220	2000 h

**Note:**

- When the separator is operated for short periods, lubricating oil must be changed every 12 months even if the total number of operating hours is less than stated in the recommendations above.
- Check and prelubricate spindle bearings on separators which have been out of service for 6 months or longer.
- In seasonal operation: change oil before every operating period.

### 8.6.4 Recommended oil brands

Alfa Laval ref. 553218-04, rev. 6

**Paraffinic mineral lubricating oil category (ISO-L-) HM 150.**  
Viscosity grade (ISO 3448/3104) VG 150.

The oil shall follow the requirements in one of the standards below.

Standard	Designation
ISO 11158, (ISO 6743/4)	ISO-L-HM or HV 150
ISO 12925-1, (ISO 6743/6)	ISO-L-CKC or CKE 150
DIN 51524 part 2 or 3 (German standard)	DIN 51524 - HLP or HVLP 150
DIN 51517 part 3	DIN 51517 - CLP 150

Alfa Laval lubrication oil group A	
Viscosity grade (ISO 3448/3104) Viscosity index (ISO 2909)	VG 150 VI >95
Manufacturer	Designation
Alfa Laval	546098-81      4 litres 546098-83      1 litre
BP	Bartran 150 Bartran HV 150 Energol SHF-HV 150
Castrol	Alpha ZN 150 Hyspin AWH(-M) 150 Hyspin AWS 150
Chevron	Meropa 150 Rando HD 150 Paper Machine oil XL 150
ExxonMobil	Mobil DTE PM 150 Mobil DTE 10 excel 150 Mobil Vacuoline 528 (ISO VG 150) Nuto H 150 Mobilgear 600 XP 150
Q8/Kuwait Petroleum	Haydn 150
Shell	Morlina 150 Morlina S2 B 150
Statoil	LubeWay XA 150
Total	Azolla ZS 150 Lubmarine Visga 150

**Paraffinic mineral lubricating oil category HM 150 for hygienic applications.**

Conform to U.S. Food and Drug Administration (FDA) requirements of lubricants with incidental food contact, Title CFR 21 178.3570, 178.3620 and/or those generally regarded as safe (US 21 CFR 182).

<b>Lubrication oils for food and hygienic applications</b>	
Viscosity grade (ISO 3448/3104) Viscosity index (ISO 2909)	VG 150 VI >95
<b>Manufacturer</b>	<b>Designation</b>
Bel-Ray	Bel-Ray No-Tox Gear Oil 85 Bel-Ray No-Tox Anti-Wear 40
ExxonMobil	Mobil DTE FM 150 (Mineral/PAO)
Fiske Brothers	Lubriplate FMO-AW 900
Total	(Keystone) Nevastane EP 150

The hygienic oil on the list is in the online “NSF White Book™ Listing” at the time of the revision of this document. For more information about the NSF registration and up to date H1 registration, see [www.nsf.org](http://www.nsf.org) ([http://www.nsf.org/business/nonfood\\_compounds/](http://www.nsf.org/business/nonfood_compounds/))

### 8.6.5 Recommended oil brands

Alfa Laval ref. 553218-08 rev. 6

#### Synthetic lubricating oil, category PAO (ISO-L-) CKE 220

Viscosity grade (ISO 3448/3104) VG 220.

The following are lists of recommended oil brands. Trade names and designations might vary from country to country. Please contact your local oil supplier for more information.

Brands with Alfa Laval article number are approved and recommended for use.

Alfa Laval lubrication oil group D	
Manufacturer	Designation
Alfa Laval	542690-80      20 litres 542690-81      4 litres
BP	Enersyn HTX 220 Enersyn EP-XF 220
Castrol	Alphasyn EP 220 Alphasyn HG 220 Optigear Synthetic A 220
Chevron	(Texaco/Caltex) Pinnacle EP 220 Tegra Synthetic Gear Lubricant 220 Pinnacle Marine Gear 220
ExxonMobil	Mobil SHC 630
Q8/Kuwait Petroleum	Schumann 220
Shell	Shell Morlina S4 B 220 Omala RL 220
Statoil	Mereta 220
Total	Carter SH 220 Elf Epona SA 220

The lists of recommended oil brands are not complete. Other oil brands may be used as long as they have equivalently quality as the brands recommended. The oil must have the same viscosity class and ought to follow the ISO standard 12925-1, category ISO-L-CKC, CKD, CKE or CKT (ISO 6743-6) or DIN 51517, part 3 CLP, but shall have a synthetic base oil of polyalphaolefin type (PAO) instead of mineral base oil. The oil must be endorsed for worm gear with **brass** worm wheel. The use of other lubricants than recommended is done on the exclusive responsibility of the user or oil supplier.

**Synthetic lubricating oil, category PAO (ISO-L-) CKE 220 for hygienic applications**

Conform to U.S. Food and Drug Administration (FDA) requirements of lubricants with incidental food contact, Title CRF 21 178.3570, 178.3620 and/or those generally regarded as safe (US 21 CRF 182).

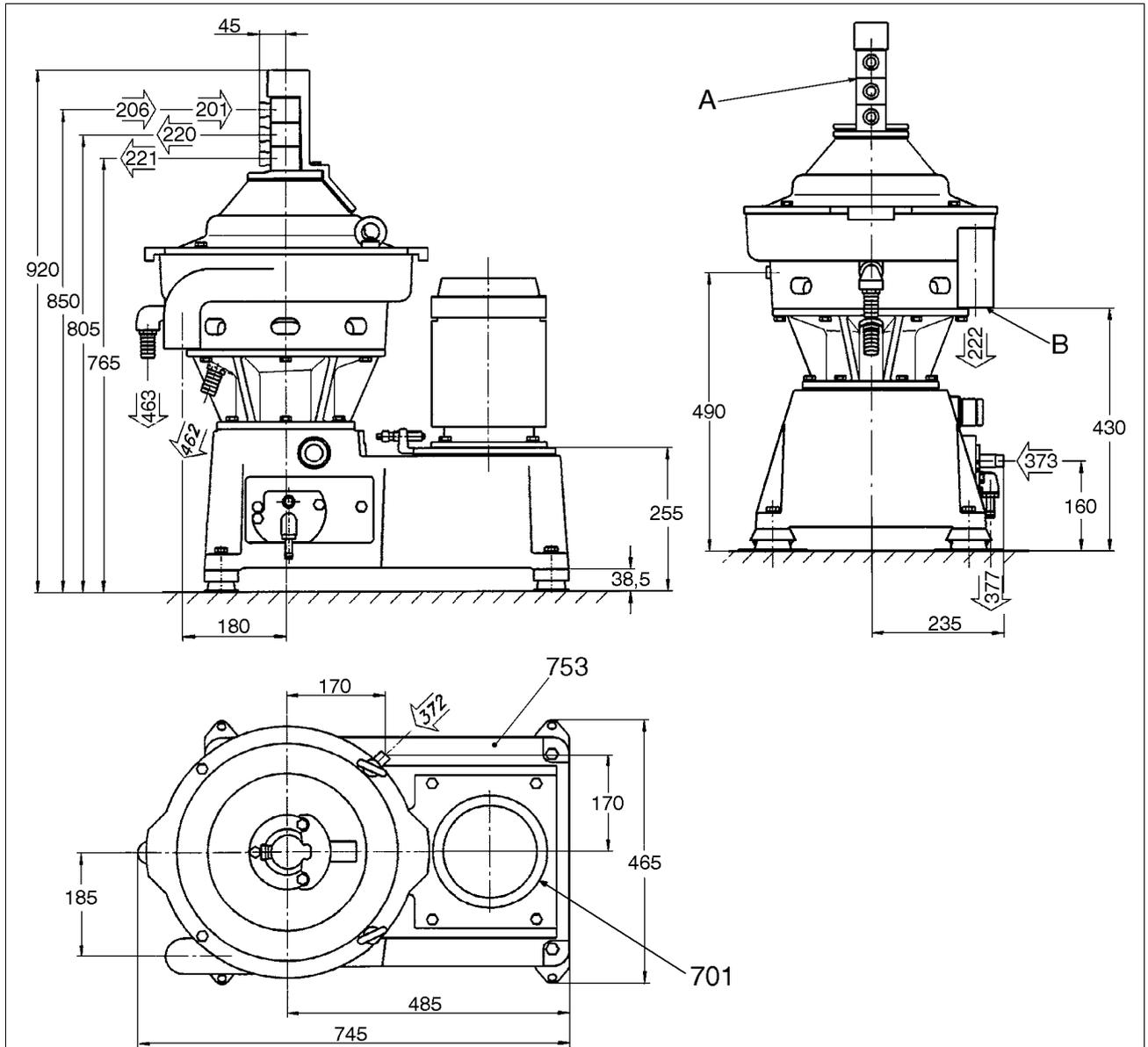
<b>Lubrication oils for food and hygienic applications</b>	
<b>Manufacturer</b>	<b>Designation</b>
Shell	Cassida fluid GL 220

The hygienic oil on the list is in the online “NSF White Book™ Listing” at the time of the revision of this document. For more information about the NSF registration and up to date H1 registration, see [www.nsf.org](http://www.nsf.org) ([http://www.nsf.org/business/nonfood\\_compounds/](http://www.nsf.org/business/nonfood_compounds/))

## 8.7 Drawings

### 8.7.1 Basic size drawing

Alfa Laval ref. 548710 rev. 3



Connections 201, 220 and 220 are turnable

A. Maximum horizontal displacement at the inlet/outlet connections during operation:  $\pm 20$  mm

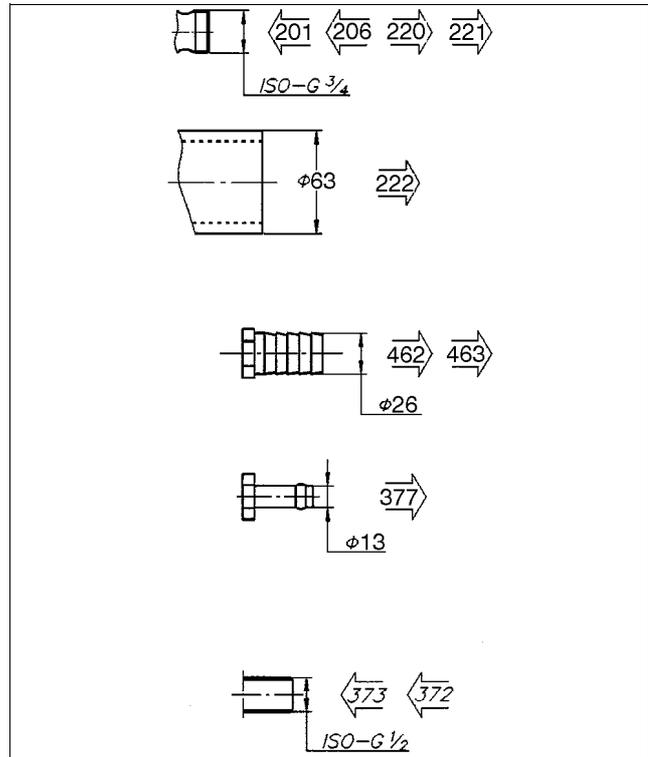
B. Maximum vertical displacement at the solid phase outlet connection during operation:  $\pm 10$  mm

G06/45631

### 8.7.2 Dimensions of connections

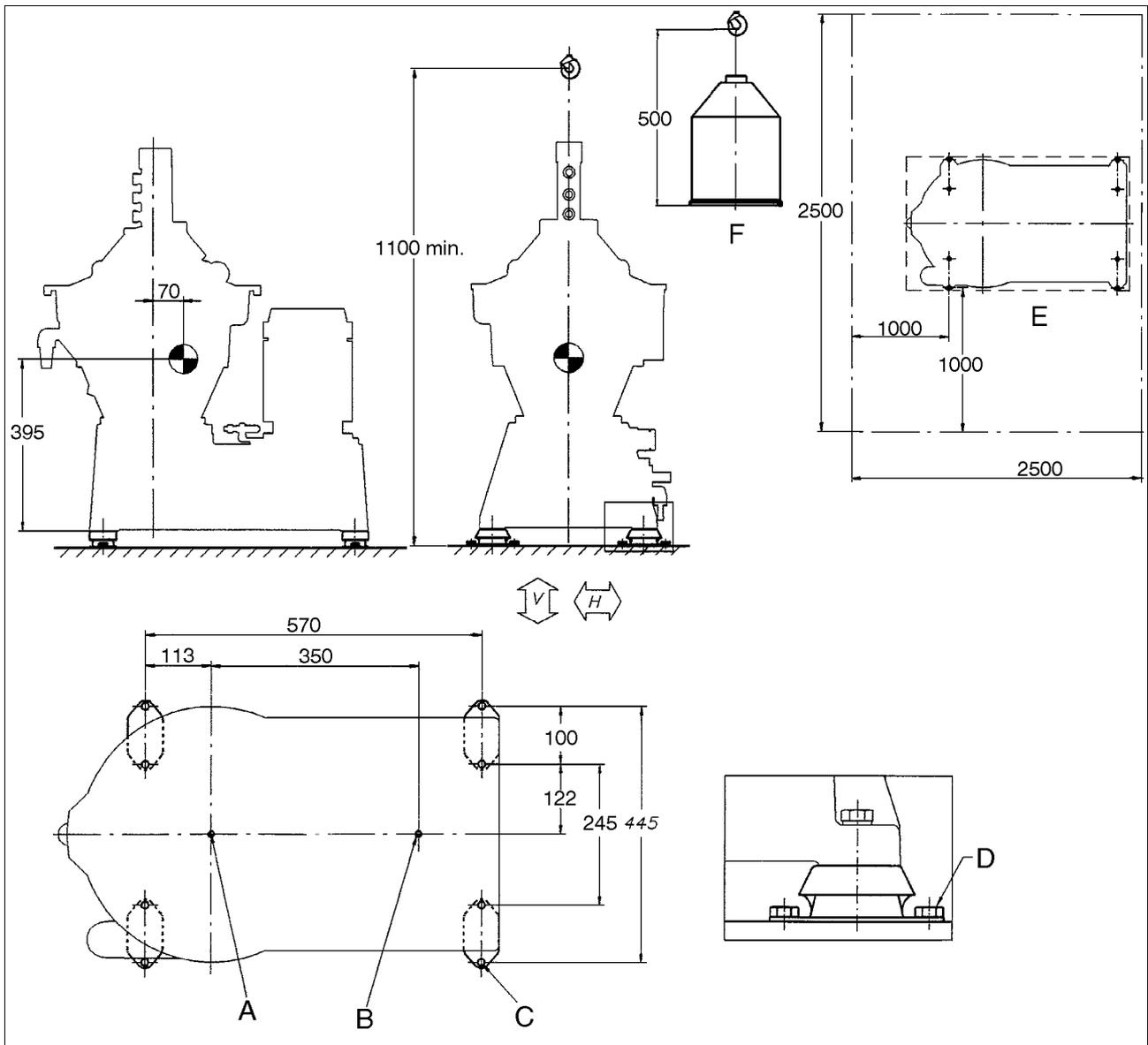
Data for connections see “8.3 Connection list” on page 143.

All connections to be installed non-loaded and flexible.



### 8.7.3 Foundation drawing

Alfa Laval ref. 548711, rev. 2



- A. Center of separator bowl
- B. Center of motor
- C. 8 holes for anchorage
- D. Anchor bolt
- E. Service side
- F. Min. lifting capacity 300 kg  
Max. height of largest component incl. lifting tool

- Recommended free floor space for unloading when doing service
- Min. access area for overhead hoist (no fixed piping within this area)
- Center of gravity (complete machine)
- Vertical force not exceeding 5kN/foot
- Horizontal force not exceeding 7 kN/foot

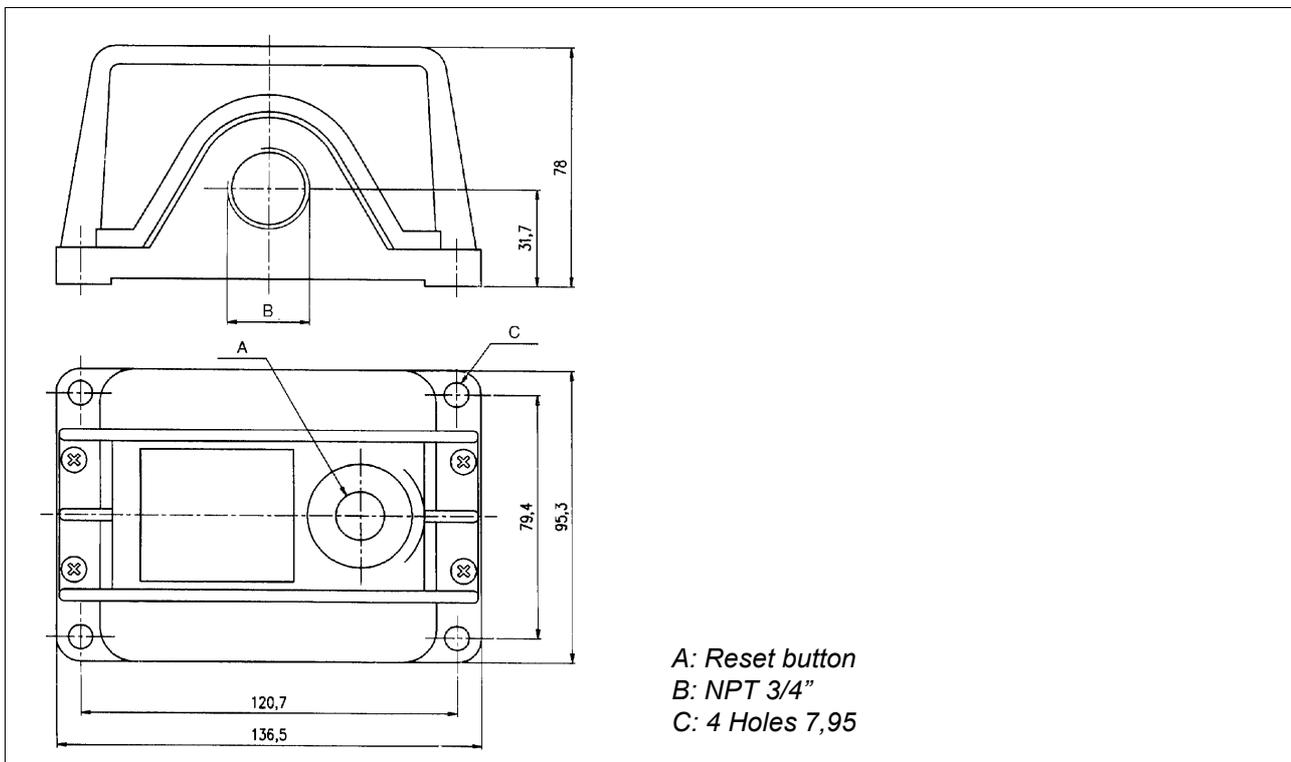
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### 8.7.4 Vibration switch

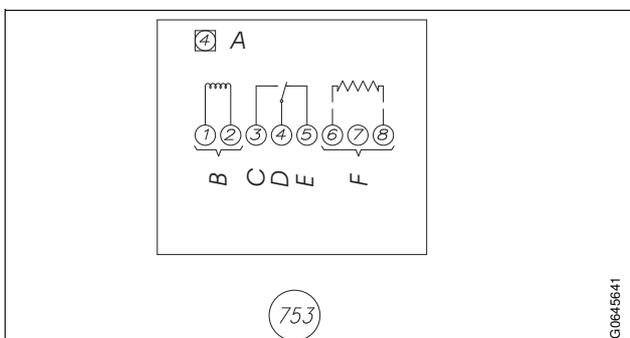
Alfa Laval ref. 530307, rev. 8

Technical data:

Material:	Cover	High impact ABS / Thermoplastic
	Gasket	Thermoplastic
	Base	Aluminium
Enclosure:	NEMA 4	
Ambient temperature:	-40 °C to +93 °C	
Vibration measurement range:	0 to 4,5 G	
Setpoint adjustment:	1 turn per G	
Reset coil power:	Max. 14 W	



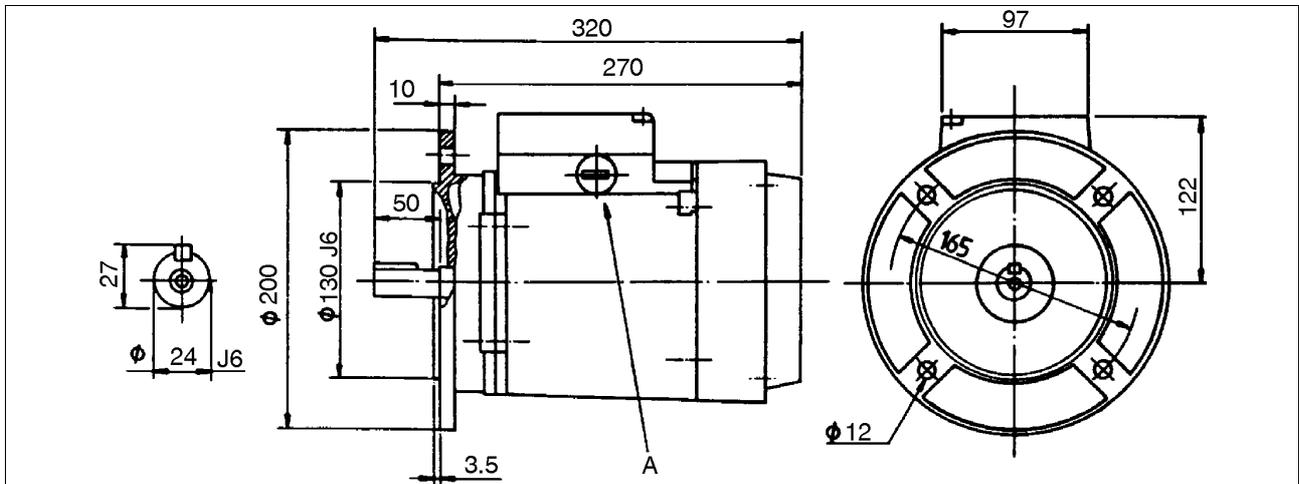
#### Interconnection diagram



**A: Reset button**      **B: Reset coil**  
**C: NO**                      **D: Common**  
**E: NC**                      **F: Heater**

### 8.7.5 Electric motor

Alfa Laval ref. 551218, rev. 0



A. Pg16 (DIN 40430), max. wire area 2,5 mm<sup>2</sup>

**Manufacturer** ASEA, Denmark

**Manufacturers drawing** MK11DdelB3 feb1983

**Standards** IEC 34-1,  
IEC 72-2

**Size** 90L

**Type** MT90L

**Weight** 16 kg

**Poles** 2

**Insulation class** F

**Bearings** DE 6305 C3  
NDE 6204 C3

**Method of cooling** IC 41 (IEC 34-6)

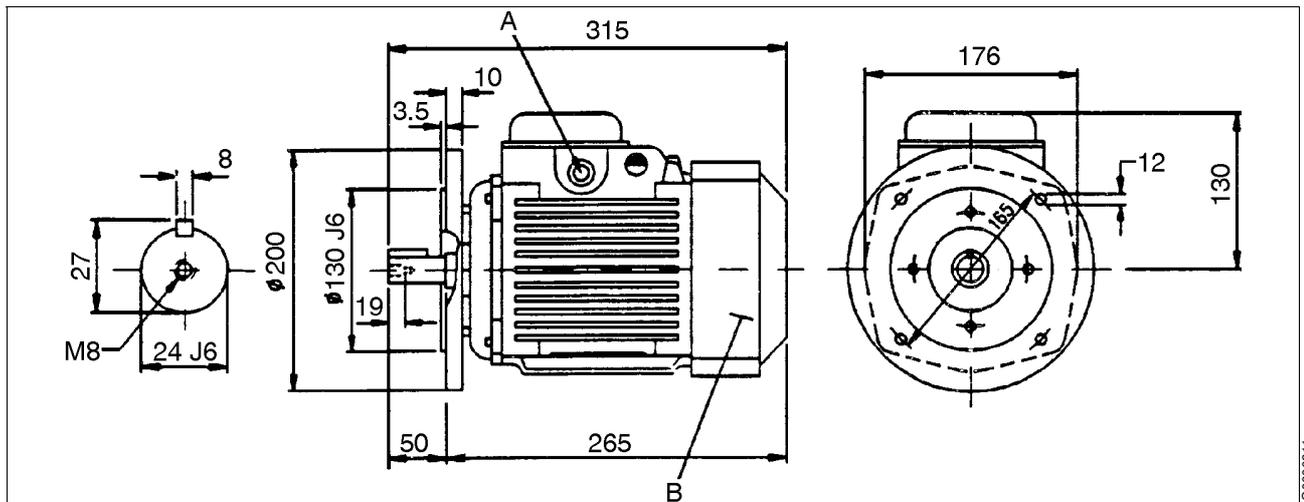
**Specification** TEFC standard motor, marine performance<sup>3)</sup>

Type of mounting (IEC34-7)		Degree of protection (IEC34-5)
	IM 3001	IP 54

**NOTE**  
For complete information about motor variants,  
please contact your Alfa Laval representative.

G0606111

Alfa Laval ref. 552807, rev. 7



A. Max. cable diameter 16 mm  
 B. Metal fan cover

<b>Manufacturer</b>	ABB Motors, Spain
<b>Manufacturers drawing</b>	AC60-01 ParteB2
<b>Standards</b>	IEC 34-1, IEC 72
<b>Size</b>	90L
<b>Type</b>	MBT 90 LB
<b>Weight</b>	16 kg
<b>Poles</b>	2
<b>Insulation class</b>	F
<b>Bearings</b>	DE 6205-Z NDE 6205-Z
<b>Method of cooling</b>	IC 41 (IEC 34-6)
<b>Specification</b>	Totally enclosed three-phase motor for marine service <sup>3)</sup>

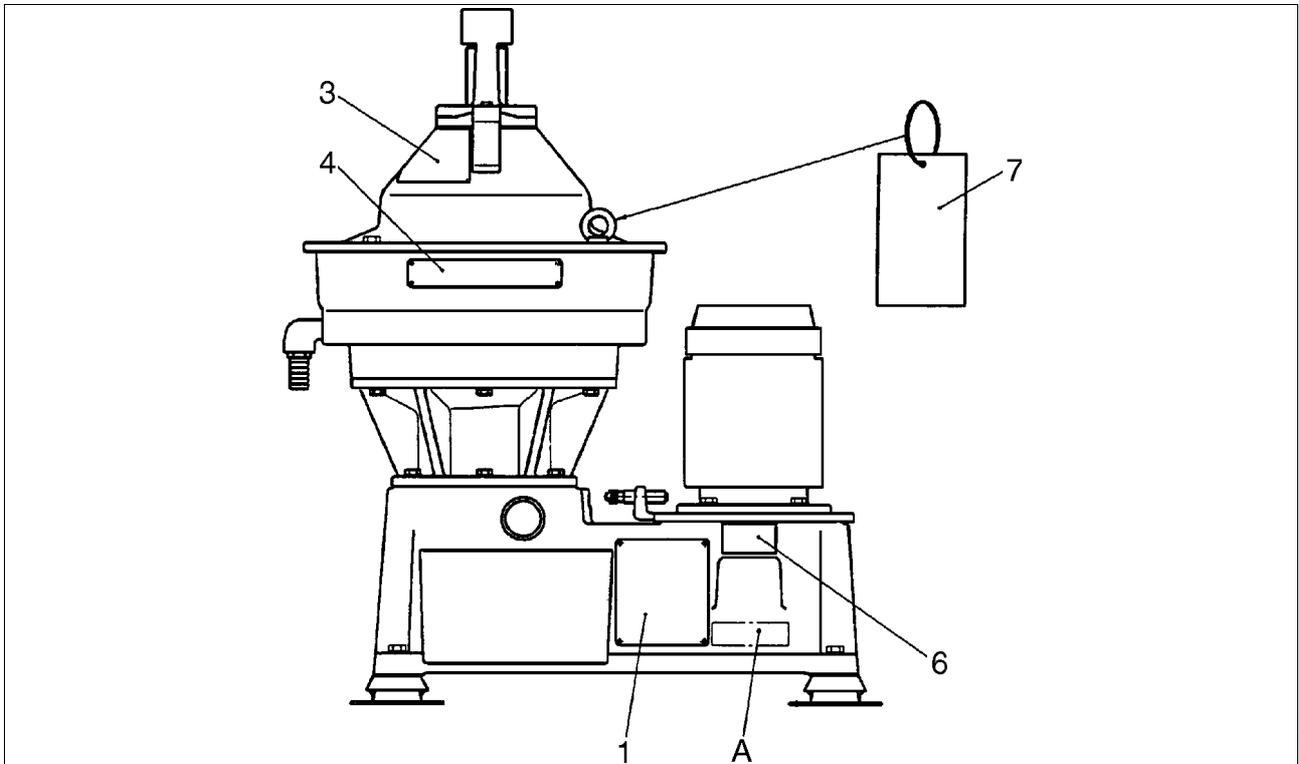
Type of mounting IEC 34-7		Degree of protection IEC 34-5
	IM 3011	IP 55

**NOTE**

For complete information about motor variants, please contact your Alfa Laval representative.

## 8.7.6 Machine plates and safety labels

Alfa Laval ref. 556430



Location of machine plates and safety labels

### 1. Machine plate

Separator

Manufacturing serial No / Year

Product No

Inlet and outlet

Bowl

Machine bottom part

Max. speed (bowl)

Direction of rotation (bowl)

Speed motor shaft

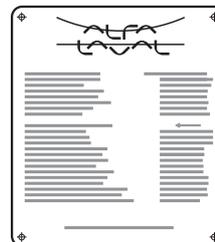
El. current frequency

Recommended motor power

Max. density of feed

Max. density of sediment

Process temperature min./max.



### 3. Safety label

Text on label:

#### WARNING

Read the instruction manuals **before** installation, operation and maintenance. Consider inspection intervals.

Failure to strictly follow instructions can lead to fatal injury.

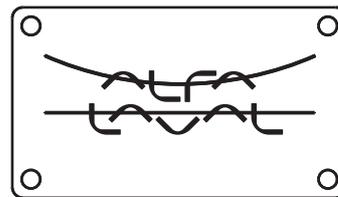
If excessive vibration occurs, **stop** separator and **keep bowl filled** with liquid during rundown.

Out of balance vibration will become worse if bowl is not full.

Separator must **stop rotating** before **any** dismantling work is started.

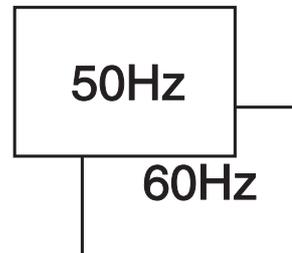
S00690NI

### 4. Name plate



S0063211

### 6. Power supply frequency



S0063111

### 7. Label

Text on label:

Read the instruction manual before lifting.

#### A. Space for label indicating representative



S0069111

## 8.8 Storage and installation

### 8.8.1 Storage and transport of goods

#### Storage

##### **Specification**

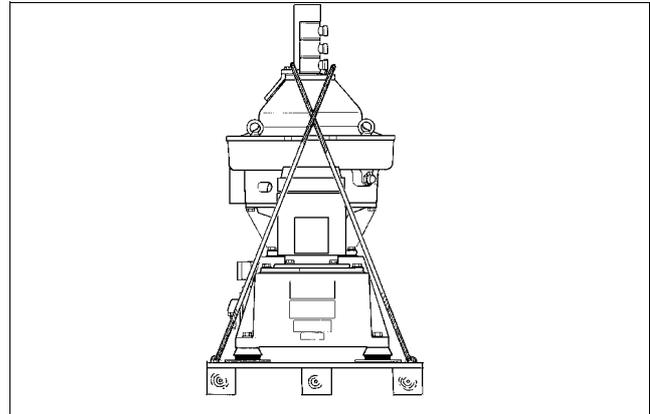
Upon arrival to the store, **check all components and keep them:**

1. Well stored and protected from mechanical damage.
2. Dry and protected from rain and humidity
3. Organized in the store in such a way that the goods will be easily accessible when installation is about to take place.

A separator can be delivered with different types of protection:

- Fixed on a pallet.

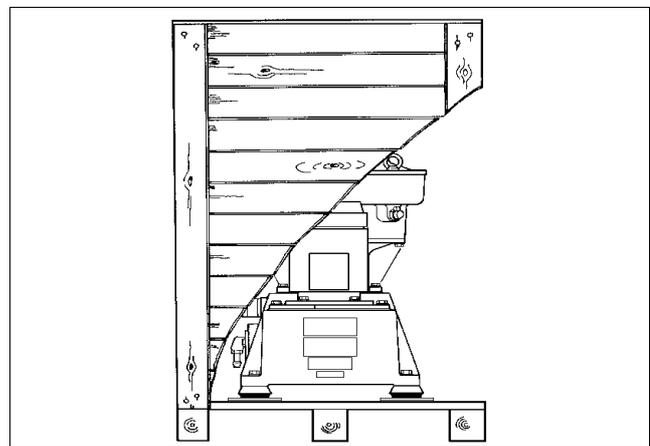
The separator must be stored in a dry storage room, protected from rain and humidity. It must be well protected from mechanical damage and theft.



*Fixed on a pallet*

- In a wooden box which is not water tight.

The separator must be stored in a dry storage room, protected from rain and humidity.

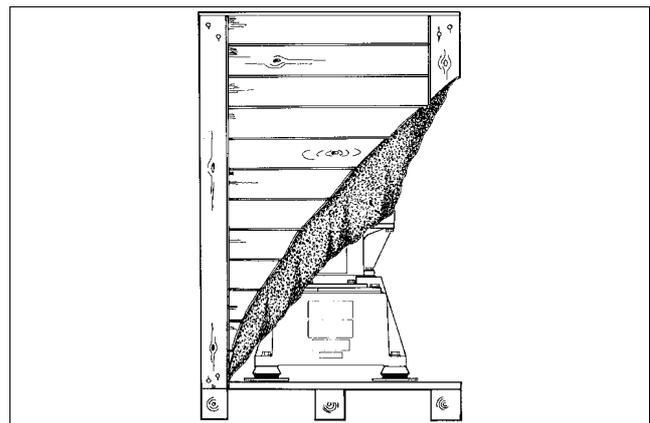


*In a wooden box which is not water tight*

- In a special water-resistant box for outdoor storage.

The separator and its parts have been treated with an anti-corrosion agent. Once the box has been opened, store dry and protected from rain and humidity.

The packaging for outdoor storage is only to special order.



*In a special water-resistant box for outdoor storage*

## Transport

### Specification

- During transport of the separator, the bowl **must always be removed from the machine and transported separately.**
- When lifting a separator it must always be **hung securely.** See details in chapter “5.6 Lifting instructions” on page 70.

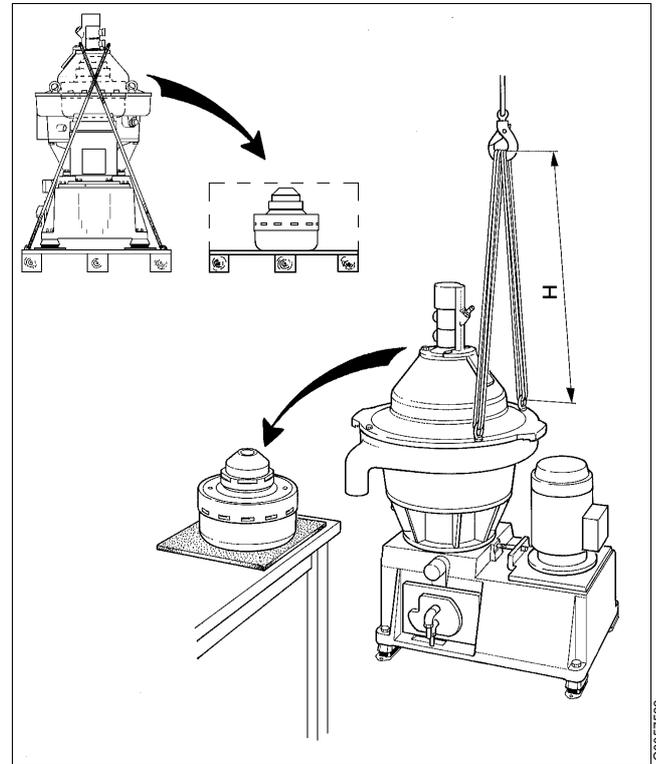


**WARNING**

**Crush hazards**

Use correct lifting tools and follow lifting instructions.

- During erection, all inlets and outlets to separators and accessories must be covered to be protected from dust and dirt.

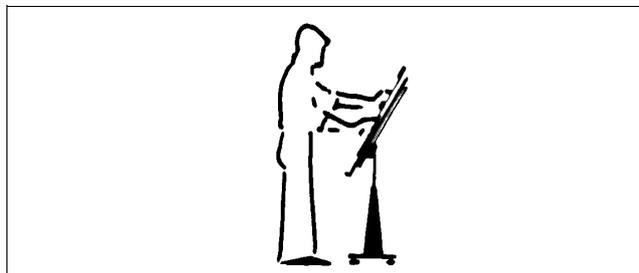


*H = minimum 750 mm*

## 8.8.2 Planning of installation

### Introduction

The space required for one or more separators can be calculated by consulting “8.7.1 Basic size drawing” on page 165, and instructions for ancillary equipment, electrical and electronic equipment and cables.

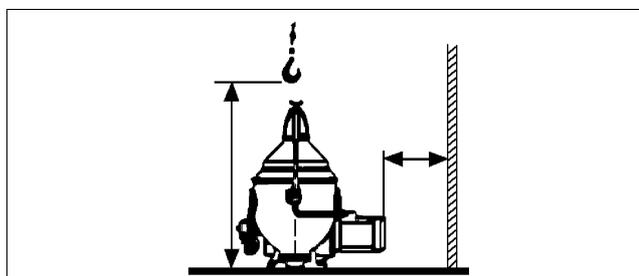


*Check the drawings when planning the installation*

### Important measurements

Important measurements are the minimum lifting height for lifting tackle, shortest distance between driving motor and wall, free passage for dismantling and assembly, maintenance and operation.

Plan your installation with sufficient room for the controls and operation so that instruments are easily visible. Valves and controls must be within convenient reach. Pay attention to space requirements for maintenance work, work benches, dismantled machine parts or for a service trolley.



*Suitable space must be obtained for the maintenance work*

### Space for separator

The separator shall be placed in such a way that suitable space for maintenance and repair is obtained.

### Specification

See the “8.7.3 Foundation drawing” on page 167 for the service space required with the separator installed.

### Recommendation

The spanner for the bowl hood should have sufficient space to make a complete turn without touching any of the ancillary equipment surrounding the separator.

**Lifting height for transport of bowl*****Specification***

A minimum height is required to lift the bowl, bowl parts and the bowl spindle, see the drawing [“8.7.3 Foundation drawing”](#) on page 167.

***Recommendation***

When two or more separators are installed, the lifting height may have to be increased to enable parts from one separator to be lifted and moved over an adjoining assembled separator.

**Space for oil changing*****Specification***

The oil filling device must not be blocked by floor plate arrangement, etc.

***Recommendation***

It should be possible to place a portable collecting tray under the oil filling device drain hole.

### 8.8.3 Foundations

#### NOTE

When lifting a separator it must always be **hung securely**. See the separate lifting instruction in this book.

#### *Specification*

- The separator should be installed at floor level, see [“8.7.3 Foundation drawing” on page 167](#).
- The separator must be installed on a strong and rigid foundation to reduce the influence of vibrations from adjacent machinery.
- The foundation should be provided with a cofferdam.
- Fit the separator frame on the foundation as follows:
  - Check that the bolts do not press against the edges of the holes, otherwise the elasticity of the mounting of the separator frame will be impeded.
  - Fit height adjusting washers required.
  - Check that the separator frame is horizontal and that all feet rest on the foundation.
  - Tighten the screws.

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