

# **SERVICE AND PARTS MANUAL FOR BLOWER MODEL**

**DRS543, DRS75, DRP75, DRS85,  
DRP85**

**DUPLEX REGENERATIVE  
BLOWER**



**AMETEK**

AMETEK Dynamic Fluid Solutions  
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**Your Choice. Our Commitment.™**

# WARRANTY, INSTALLATION, MAINTENANCE AND TROUBLESHOOTING INSTRUCTIONS



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1. AMETEK Rotron DR, EN and HiE regenerative direct drive blowers are guaranteed for one full year from the date of installation (limited to 18 months from the date of shipment) to the original purchaser only. Should the blower fail we will evaluate the failure. If failure is determined to be workmanship or material defect related, we will at our option repair or replace the blower.
2. AMETEK Rotron Minispiral, Revaflow, Multiflow, Nautilair, remote drive blowers, moisture separators, packaged units, CP blowers, Nasty Gas™ models and special built (EO) products are guaranteed for one full year from date of shipment for workmanship and material defect to the original purchaser only. Should the blower fail, If failure is determined to be workmanship or material defect related, we will at our option repair or replace the blower.
3. **Parts Policy** - AMETEK Rotron spare parts and accessories are guaranteed for three months from date of shipment for workmanship and material defect to the original purchaser only. If failure is determined to be workmanship or material defect related we will at our option repair or replace the part.

**Corrective Action** - A written report will be provided indicating reason(s) for failure, with suggestions for corrective action. Subsequent customer failures due to abuse, misuse, misapplication or repeat offense will not be covered. AMETEK Rotron will then notify you of your options. Any failed unit that is tampered with by attempting repair or diagnosis will void the warranty, unless authorized by the factory.

**Terms and Conditions** - Our warranty covers repairs or replacement of regenerative blowers only, and will not cover labor for installation, outbound and inbound shipping costs, accessories or other items not considered integral blower parts. Charges may be incurred on products returned for reasons other than failures covered by their appropriate warranty. Out-of-warranty product and in warranty product returned for failures determined to be caused by abuse, misuse, or repeat offense will be subject to an evaluation charge. Maximum liability will in no case exceed the value of the product purchased. Damage resulting from mishandling during shipment is not covered by this warranty. It is the responsibility of the purchaser to file claims with the carrier. Other terms and conditions of sale are stated on the back of the order acknowledgement.

## Installation Instructions for SL, DR, EN, CP, and HiE Series Blowers

1. **Bolt It Down** - Any blower must be secured against movement prior to starting or testing to prevent injury or damage. The blower does not vibrate much more than a standard electric motor.
2. **Filtration** - All blowers should be filtered prior to starting. Care must be taken so that no foreign material enters the blower. If foreign material does enter the blower, it could cause internal damage or may exit at extremely high velocity.

Should excessive amounts of material pass through the blower, it is suggested that the cover(s) and impeller(s) be removed periodically and cleaned to avoid impeller imbalance. Impeller

imbalance greatly speeds bearing wear, thus reducing blower life. Disassembling the blower will void warranty, so contact the factory for cleaning authorization.

- Support the Piping** - The blower flanges and nozzles are designed as connection points only and are not designed to be support members.

Caution: Plastic piping should not be used on blowers larger than 1 HP that are operating near their maximum pressure or suction point. Blower housing and nearby piping temperatures can exceed 200°F. Access by personnel to the blower or nearby piping should be limited, guarded, or marked, to prevent danger of burns.

- Wiring** - Blowlers must be wired and protected/fused in accordance with local and national electrical codes. All blowlers must be grounded to prevent electrical shock. Slo-Blo or time delay fuses should be used to bypass the first second of start-up amperage.
- Pressure/Suction Maximums** - The maximum pressure and/or suction listed on the model label should not be exceeded. This can be monitored by means of a pressure or suction gage (available from Rotron), installed in the piping at the blower outlet or inlet. Also, if problems do arise, the Rotron Field representative will need to know the operating pressure/suction to properly diagnose the problem.
- Excess Air** - Bleed excess air off. DO NOT throttle to reduce flow. When bleeding off excess air, the blower draws less power and runs cooler.

**Note:** Remote Drive (Motorless) Blowlers - Properly designed and installed guards should be used on all belts, pulleys, couplings, etc. Observe maximum remote drive speed allowable. Due to the range of uses, drive guards are the responsibility of the customer or user. Belts should be tensioned using belt gauge.

Maintenance Procedure

**When properly piped, filtered, and applied, little or no routine maintenance is required. Keep the filter clean. Also, all standard models in the DR, EN, CP, and HiE series have sealed bearings that require no maintenance. Bearing should be changed after 15,000 to 20,000 hours, on average. Replacement bearing information is specified on the chart below.**

Bearing Part Number	Size	Seal Material	Grease	Heat Stabilized
510217 510218 510219	205 206 207	Polyacrylic	Nye Rheotemp 500 30% +/- 5% Fill	Yes – 325 F
510449 516440 516648	203 202 307	Buna N	Exxon Polyrex Grease	NO
516840 516841 516842 516843 516844 516845 516846 516847	206 207 208 210 309 310 311 313	Buna N	Exxon Polyrex Grease	NO

## Troubleshooting

		POSSIBLE CAUSE	OUT OF WARRANTY REMEDY ***
IMPELLER DOES NOT TURN	Humming Sound	<ol style="list-style-type: none"> <li>* One phase of power line not connected</li> <li>* One phase of stator winding open</li> <li>Bearings defective</li> <li>Impeller jammed by foreign material</li> <li>Impeller jammed against housing or cover</li> <li>** Capacitor open</li> </ol>	<ol style="list-style-type: none"> <li>Connect</li> <li>Rewind or buy new motor</li> <li>Change bearings</li> <li>Clean and add filter</li> <li>Adjust</li> <li>Change capacitor</li> </ol>
	No Sound	<ol style="list-style-type: none"> <li>* Two phases of power line not connected</li> <li>* Two phases of stator winding open</li> </ol>	<ol style="list-style-type: none"> <li>Connect</li> <li>Rewind or buy new motor</li> </ol>
IMPELLER TURNS	Blown Fuse	<ol style="list-style-type: none"> <li>Insufficient fuse capacity</li> <li>Short circuit</li> </ol>	<ol style="list-style-type: none"> <li>Use time delay fuse of proper rating</li> <li>Repair</li> </ol>
	Motor Overheated Or Protector Trips	<ol style="list-style-type: none"> <li>High or low voltage</li> <li>* Operating in single phase condition</li> <li>Bearings defective</li> <li>Impeller rubbing against housing or cover</li> <li>Impeller or air passage clogged by foreign material</li> <li>Unit operating beyond performance range</li> <li>Capacitor shorted</li> <li>* One phase of stator winding short circuited</li> </ol>	<ol style="list-style-type: none"> <li>Check input voltage</li> <li>Check connections</li> <li>Check bearings</li> <li>Adjust</li> <li>Clean and add filter</li> <li>Reduce system pressure/vacuum</li> <li>Change capacitor</li> <li>Rewind or buy new motor</li> </ol>
	Abnormal Sound	<ol style="list-style-type: none"> <li>Impeller rubbing against housing or cover</li> <li>Impeller or air passages clogged by foreign material</li> <li>Bearings defective</li> </ol>	<ol style="list-style-type: none"> <li>Adjust</li> <li>Clean and add filter</li> <li>Change bearings</li> </ol>
	Performance Below Standard	<ol style="list-style-type: none"> <li>Leak in piping</li> <li>Piping and air passages clogged</li> <li>Impeller rotation reversed</li> <li>Leak in blower</li> <li>Low voltage</li> </ol>	<ol style="list-style-type: none"> <li>Tighten</li> <li>Clean</li> <li>Check wiring</li> <li>Tighten cover, flange</li> <li>Check input voltage</li> </ol>
<p>* 3 phase units  ** 1 phase units  *** Disassembly and repair of new blowers or motors will void the Rotron warranty. Factory should be contacted prior to any attempt to field repair an in-warranty unit.</p>			

### **Blower Disassembly:**

**WARNING:** Attempting to repair or diagnose a blower may void Rotron's warranty. It may also be difficult to successfully disassemble and reassemble the unit.

- 1) Disconnect the power leads. **CAUTION:** Be sure the power is disconnected before doing any work whatsoever on the unit.
- 2) Remove or separate piping and/or mufflers and filters from the unit.
- 3) Remove the cover bolts and then the cover. **NOTE:** Some units are equipped with seals. It is mandatory that these seals be replaced once the unit has been opened.
- 4) Remove the impeller bolt and washers and then remove the impeller. **NOTE:** Never pry on the edges of the impeller. Use a puller as necessary.
- 5) Carefully note the number and location of the shims. Remove and set them aside. **NOTE:** If the disassembly was for inspection and cleaning the unit may now be reassembled by reversing the above steps. If motor servicing or replacement and/or impeller replacement is required the same shims may not be used. It will be necessary to re-shim the impeller according to the procedure explained under assembly.

- 6) Remove the housing bolts and remove the motor assembly (arbor/housing on remote drive models).
- 7) Arbor disassembly (Applicable on remote drive models only):
  - a) Slide the bearing retraining sleeve off the shaft at the blower end.
  - b) Remove the four (4) screws and the bearing retaining plate from the blower end.
  - c) Lift the shaft assembly far enough out of the arbor to allow removal of the blower end snap ring.
  - d) Remove the shaft assembly from the arbor.
  - e) If necessary, remove the shaft dust seal from the pulley end of the arbor.

*Muffler Material Replacement:*

- 1) Remove the manifold cover bolts and them manifold cover.
- 2) The muffler material can now be removed and replaced if necessary. On blowers with fiberglass acoustical wrap the tubular retaining screens with the fiberglass matting before sliding the muffler pads over the screens.
- 3) Reassemble by reversing the procedure.

**NOTE: On DR068 models with tubular mufflers it is necessary to remove the cover and impeller accessing the muffler material from the housing cavity.**

*Blower Reassembly:*

- 1) Place the assembled motor (assembled arbor assembly for remote drive models) against the rear of the housing and fasten with the bolts and washer.
- 2) To ensure the impeller is centered within the housing cavity re-shim the impeller according to the procedure outlined below.
- 3) If blower had a seal replace the seal with a new one.
- 4) Place the impeller onto the shaft making sure the shaft key is in place and fasten with the bolt, washer and spacer as applicable. Torque the impeller bolt per the table below. Once fastened carefully rotate the impeller to be sure it turns freely.
- 5) Replace the cover and fasten with bolts.
- 6) Reconnect the power leads to the motor per the motor nameplate.

<b>Bolt Size</b>	<b>Torque Pound-Force-Foot</b>
<b>1/4-20</b>	<b>6.25 +/- 0.25</b>
<b>5/16-18</b>	<b>11.5 +/- 0.25</b>
<b>3/8-16</b>	<b>20.0 +/- 0.5</b>
<b>1/2-13</b>	<b>49.0 +/- 1</b>
<b>5/8 -11</b>	<b>90.0 +/- 2</b>

*Impeller Shimming Procedure:*

WARNING: This unit may be difficult to shim. Extreme care may be exercised.

Tools Needed: Machinist's Parallel Bar  
Vernier Caliper with depth measuring capability  
Feeler gauges or depth gauge

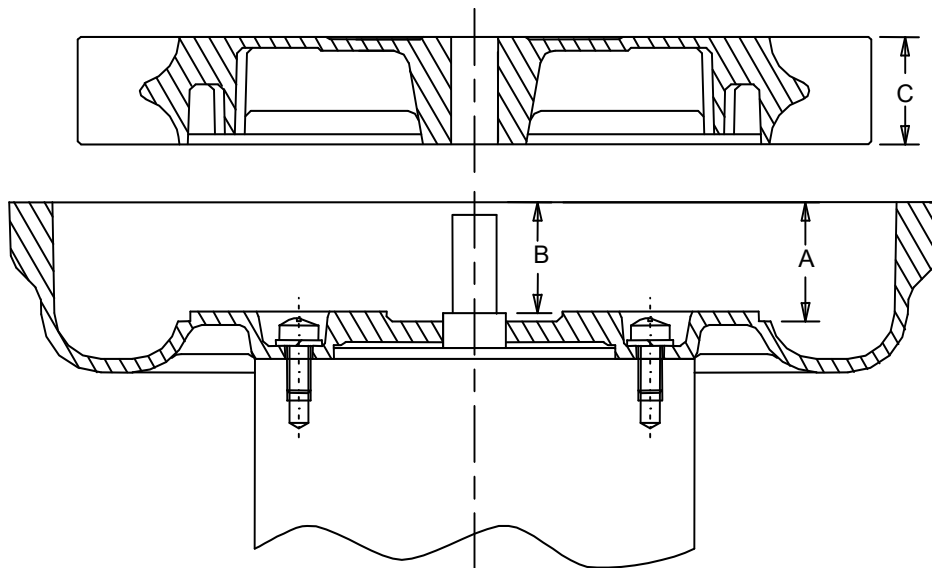
Measure the Following:

- Distance from the flange face to the housing (A)
- Distance from the flange face to the motor shaft shoulder (B)
- Impeller Thickness (C)

Measurements (A) and (B) are made by laying the parallel bar across the housing flange face and measuring to the proper points. Each measurement should be made at three points, and the average of the readings should be used.

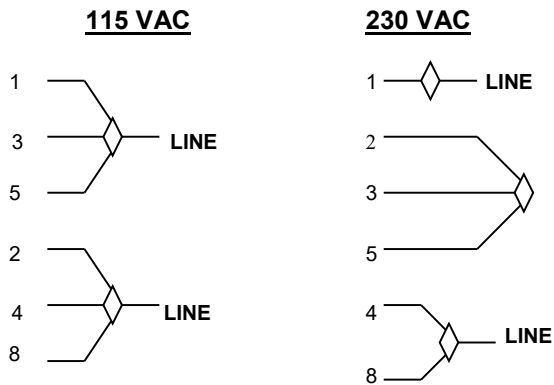
$$\text{Shim Thickness} = B - (A+C)/2$$

After the impeller installation (step #4 above) the impeller/cover clearance can be checked with feeler gauges, laying the parallel bar across the housing flange face. This clearance should nominally be  $(A-C)/2$ .



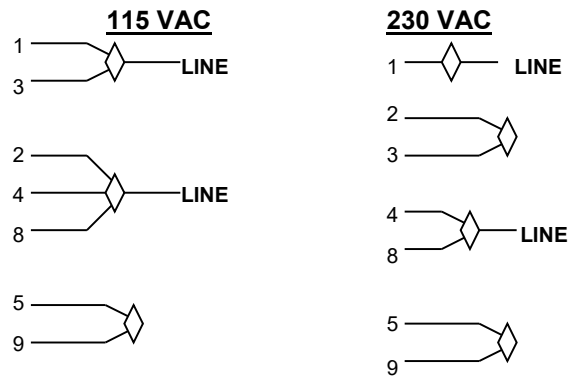
# WIRING DIAGRAMS, TEFC and ODP MOTORS

## A. 1Ø, 6 WIRE



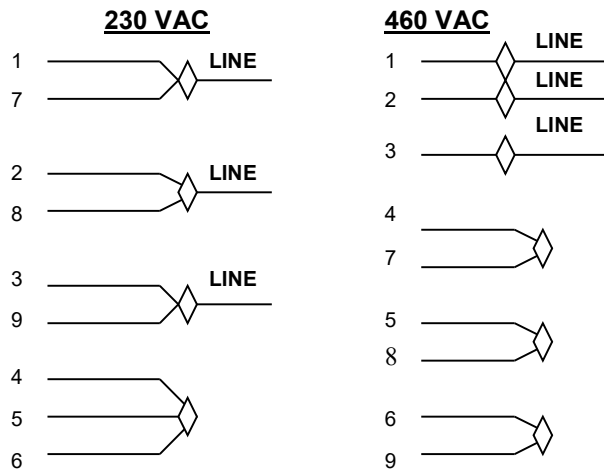
INTERCHANGE LEADWIRES 5 & 8 to REVERSE ROTATION

## B. 1Ø, 7 WIRE



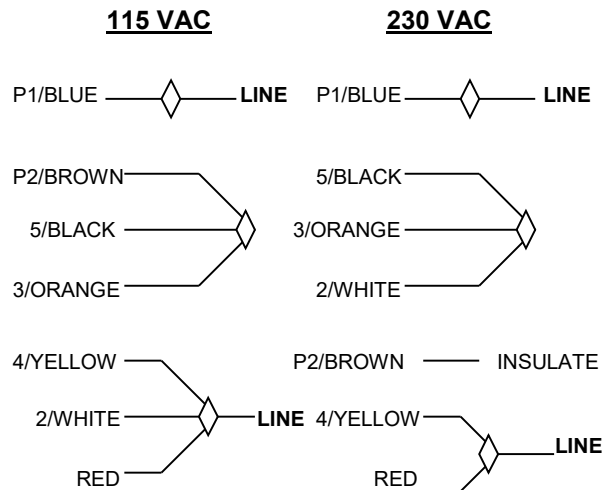
INTERCHANGE LEADWIRES 5 & 8 to REVERSE ROTATION

## C. 3Ø, 9 WIRE



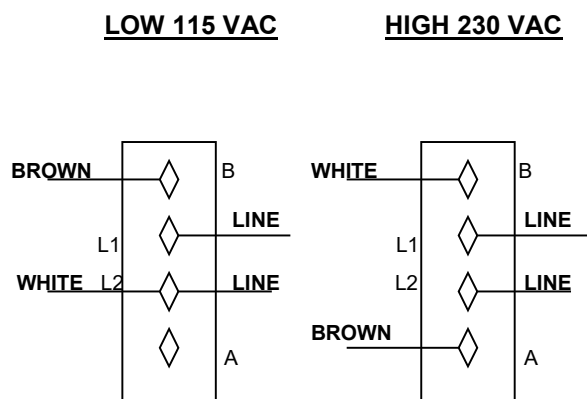
INTERCHANGE ANY TWO LEAD LINES TO REVERSE ROTATION

## D. 1Ø, EMERSON 1/8 HP MOTOR



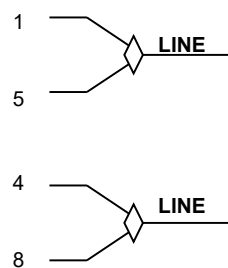
INTERCHANGE RED AND BLACK TO REVERSE ROTATION

## E. 1Ø, SPA DUTY WITH TERMINAL STRIPS



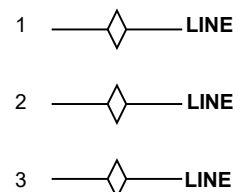
## F. 1Ø, 230 VAC

### SINGLE VOLTAGE



INTERCHANGE LEAD WIRES 5 & 8 TO REVERSE ROTATION

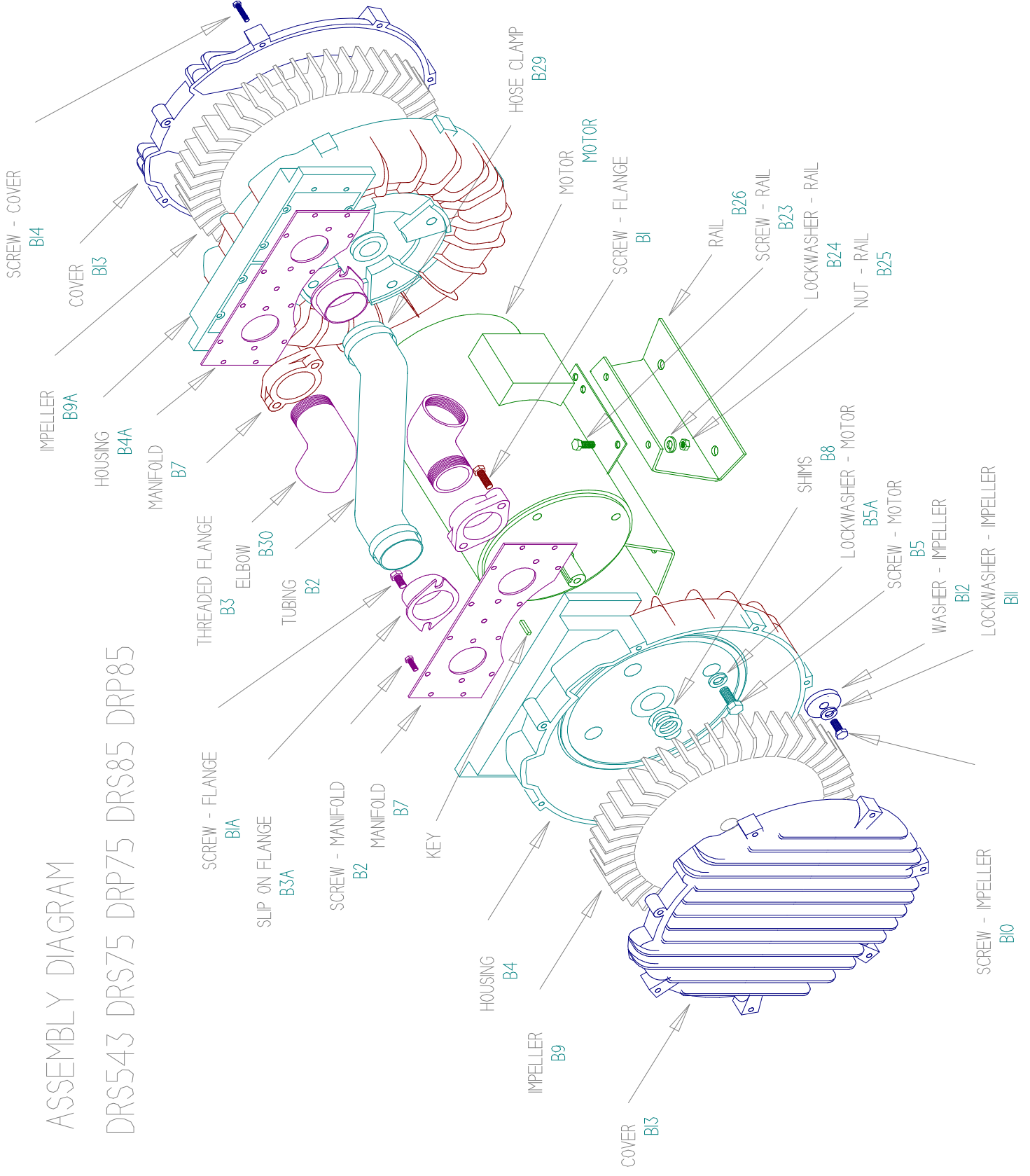
## G. 3Ø, 575 VAC



INTERCHANGE ANY TWO LEAD LINES TO REVERSE ROTATION

# ASSEMBLY DIAGRAM

## DRS543 DRS75 DRP75 DRS85 DRP85





**DRS/P 54375/85**  
**Service and Parts Manual**

**Parts Breakdown**

Model:  
 Part No.:

DRS543	DRS7X	DRS75	DRP75	DRS85	DRP85
<b>037222</b>	036085	036826	<b>036824</b>	037172	<b>037170</b>
<b>037472</b>	036144	<b>036955</b>	<b>036825</b>	<b>037175</b>	<b>037171</b>
			<b>036953</b>		<b>037173</b>
			<b>036954</b>		<b>037174</b>
<b>OBSOLETE</b>	<b>OBSOLETE</b>	<b>OBSOLETE</b>	<b>OBSOLETE</b>	<b>OBSOLETE</b>	<b>OBSOLETE</b>

Item No.	Qty.	Req'd Description	DRS7X	DRS75	DRP75	DRS85	DRP85
M3	2	Key Motor Shaft	510212	510212	510212	511532	511532
B1	4	Screw, Flange	120065	120255	120255	155025	155025
B1A	4	Screw, Hose Flange	251502	251502	251502	155171	155171
B2		Screw, Manifold	Not Used	(26 pcs)120214	(26 pcs)120214	(34 pcs)120214	(34 pcs)120214
B3	2	Flange	510354	511480	511480	511614	511614
B3A	2	Flange, Hose	510862	510086	510086	511296	511296
B4	1	Housing (left side)	516589	515501	515454	516504	516504
B4A	1	Housing (right side facing T-box)	516589	515453	515453	516504	516504
B5	8	Screw, Hsg /Motor	251792	251792	251792	140014	140014
B6	0	Muffler Material	Not Used	Not Used	Not Used	Not Used	Not Used
B7	2	Manifold Plate	529870	529999	529999	529995	529995
B8	*	Shim .002"	500667	272703	272703	511547	511547
	*	Shim .005"	500666	272704	272704	511548	511548
	*	Shim .010"	500665	272705	272705	511549	511549
	*	Shim .020"	500664	272706	272706	511550	511550
	*	Shim .030"	510292	Not Used	Not Used	Not Used	Not Used
B9	1	Impeller	(2 pcs) 516562	515484	515461	516452	516452
B9A	1	Impeller Assembly, Reverse	(2 pcs) 516577	515484	516207	516454	516454
B10	2	Bolt, Impeller	120214	251791	251791	155068	155068
B11	2	Lockwasher, Impeller	120203	251787	251787	251788	251788
B12	0	Washer, Impeller	Not Used	Not Used	Not Used	Not Used	Not Used
B13	2	Cover	516559	515488	515462	516447	516447
B14	16	Screw, Cover	155098	155170	(14 pcs)120215	140016	140016
B15	2	Eye Bolt, Housing	Not Used	Not Used	Not Used	140019	140019
B16	2	Spacer, Impeller Bolt	510355	478336	478336	511529	511529
B17	8	Lockwasher, Housing	Not Used	251788	251788	Not Used	Not Used
B21		Heat Slinger	Not Used	Not Used	Not Used	Not Used	Not Used
B22		Guard Heat Slinger	Not Used	Not Used	Not Used	Not Used	Not Used
		Screw Guard	Not Used	Not Used	Not Used	Not Used	Not Used
B23	4	Bolt Mounting Rail	251791	251791	251791	120255	120255
B24	4	Washer	Not Used	Not Used	Not Used	155091	See Next Page
B24A	4	Lockwasher Rail	251787	(6 pcs)251787	251787	(6 pcs)251787	251787
B25	4	Nut Rail	251789	251789	251789	251789	251789
B26	2	Rail Mounting	478338	478338	478338	See Next Page	See Next Page
B29	4	Clamp Hose	155228	(2 pcs)155228	155288	155229	(8 pcs)155229

\*As needed

B30	2	Elbow Connection	155100	120153	120153	120153	120276	120276
B31	1	Muffler	522948	522948	522948	(2 pcs)522948	515185	(2 pcs)515185
B32	1	Hose, Crossover	516600	510089	510089	(2 pcs)550185	511298	(2 pcs)511297
	1	Tee	Not Used	Not Used	Not Used	510106	Not Used	511295
		Bolt, Motor/Muffler	Not Used	Not Used	Not Used	Not Used	Not Used	Not Used
		Lockwasher, Motor/Muffler	Not Used	Not Used	Not Used	Not Used	Not Used	Not Used
		Washer, Motor/Muffler	Not Used	Not Used	Not Used	Not Used	Not Used	Not Used
		Spacer, Motor/Muffler	Not Used	Not Used	Not Used	Not Used	Not Used	Not Used

Model	Part #	Motor	Wiring Diagram	Specific Parts	Bearing,	Bearing,
DRS543E72	037222	516593	C	Seal 516587 2 pcs.	510218	510218
DRS543E86	037472	517306	G			
DRS7X72	036085	510043	C		510218	510218
DRS7X86	036144	510107	G			
DRS75BC72	036826	515140	C		516841	516841
DRS75BC86	036955	516027	G			
DRP75BC72C	036824	515140	C			
DRP75BC72D	036825					
DRP75BC86C	036953	5160027	G		516841	516648
DRP75BC86D	036954					
DRS85BL72	037172	515565	C	B26 510760 2 pcs	516844	516844
DRS85BL86	037175	516444	G	B26 595301 2 pcs		
DRP85BL72C	037170	515565	C	B24 155091 4 pcs		
DRP85BL72D	037171			B26 510760 2 pcs	516844	516844
DRP85BL86C	037173	516444	G	B24 Not Used		
DRP85BL86D	037174			B26 595301 2 pcs		