

SERVICE AND PARTS MANUAL FOR BLOWER MODEL

DR633, DR833, DR1233

DIRECT DRIVE

REGENERATIVE BLOWER



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"> * One phase of power line not connected * One phase of stator winding open Bearings defective Impeller jammed by foreign material Impeller jammed against housing or cover ** Capacitor open 	<ol style="list-style-type: none"> Connect Rewind or buy new motor Change bearings Clean and add filter Adjust Change capacitor
	No Sound	<ol style="list-style-type: none"> * Two phases of power line not connected * Two phases of stator winding open 	<ol style="list-style-type: none"> Connect Rewind or buy new motor
IMPELLER TURNS	Blown Fuse	<ol style="list-style-type: none"> Insufficient fuse capacity Short circuit 	<ol style="list-style-type: none"> Use time delay fuse of proper rating Repair
	Motor Overheated Or Protector Trips	<ol style="list-style-type: none"> High or low voltage * Operating in single phase condition Bearings defective Impeller rubbing against housing or cover Impeller or air passage clogged by foreign material Unit operating beyond performance range Capacitor shorted * One phase of stator winding short circuited 	<ol style="list-style-type: none"> Check input voltage Check connections Check bearings Adjust Clean and add filter Reduce system pressure/vacuum Change capacitor Rewind or buy new motor
	Abnormal Sound	<ol style="list-style-type: none"> Impeller rubbing against housing or cover Impeller or air passages clogged by foreign material Bearings defective 	<ol style="list-style-type: none"> Adjust Clean and add filter Change bearings
	Performance Below Standard	<ol style="list-style-type: none"> Leak in piping Piping and air passages clogged Impeller rotation reversed Leak in blower Low voltage 	<ol style="list-style-type: none"> Tighten Clean Check wiring Tighten cover, flange Check input voltage
<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.

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

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

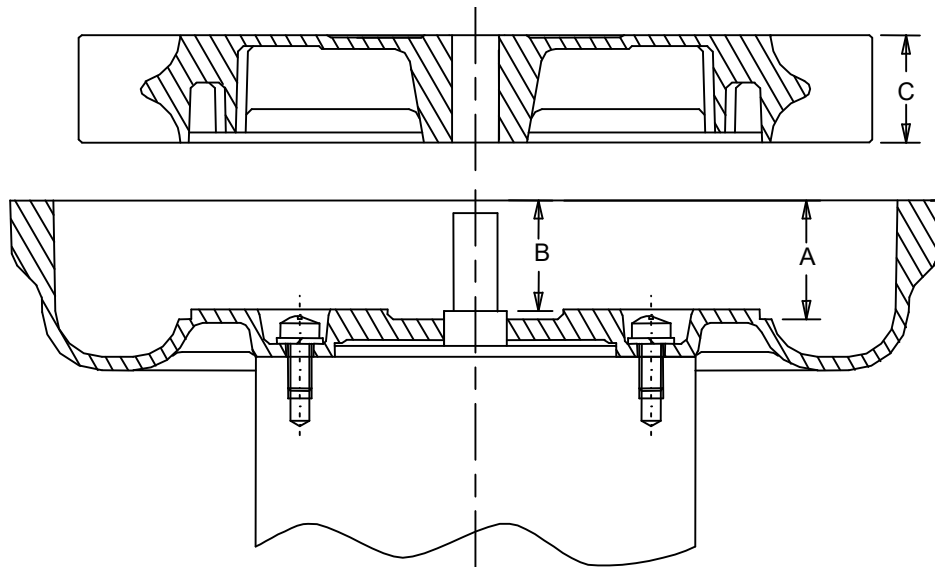
Measure the Following:

- 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.

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

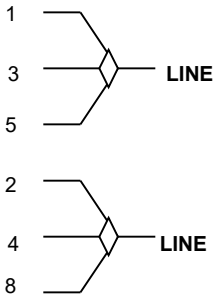
After the impeller installation (step #4 above) the impeller/cover clearance can be checked with feeler gauges, laying the parallel bar across the housing flange face. This clearance should nominally be $(A-C)/2$.



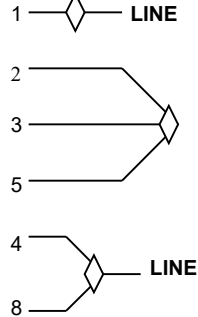
WIRING DIAGRAMS, TEFC and ODP MOTORS

A. 1Ø, 6 WIRE

115 VAC



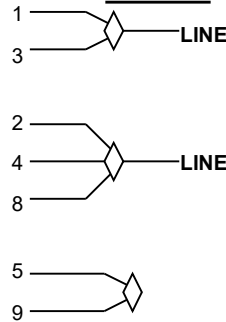
230 VAC



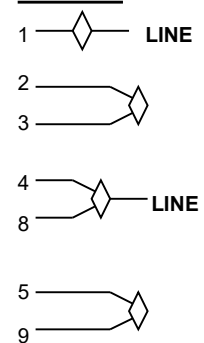
INTERCHANGE LEADWIRES 5 & 8 to REVERSE ROTATION

B. 1Ø, 7 WIRE

115 VAC



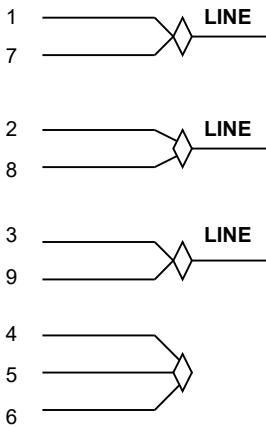
230 VAC



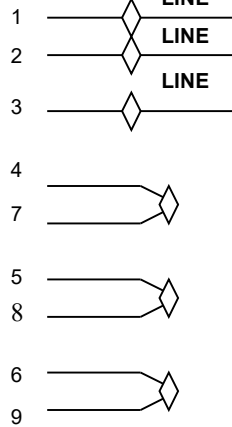
INTERCHANGE LEADWIRES 5 & 8 to REVERSE ROTATION

C. 3Ø, 9 WIRE

230 VAC



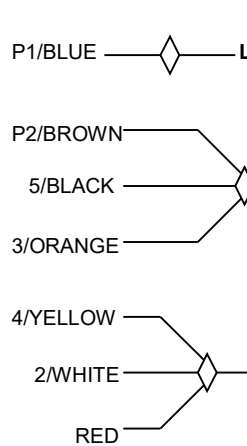
460 VAC



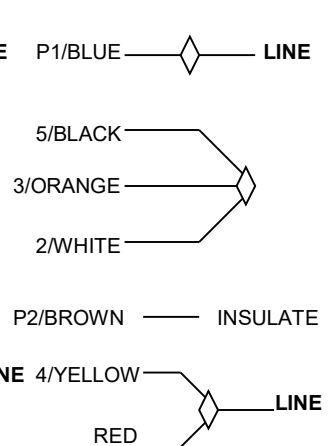
INTERCHANGE ANY TWO LEAD LINES TO REVERSE ROTATION

D. 1Ø, EMERSON 1/8 HP MOTOR

115 VAC



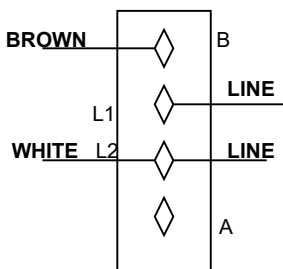
230 VAC



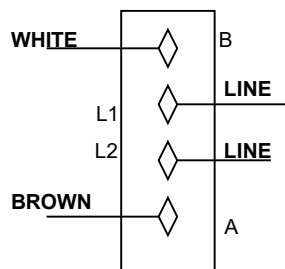
INTERCHANGE RED AND BLACK TO REVERSE ROTATION

E. 1Ø, SPA DUTY WITH TERMINAL STRIPS

LOW 115 VAC

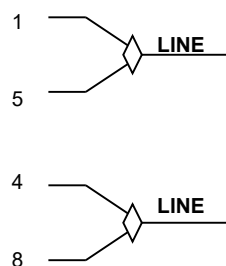


HIGH 230 VAC



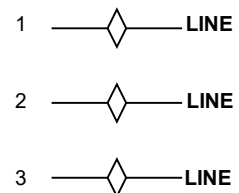
F. 1Ø, 230 VAC

SINGLE VOLTAGE

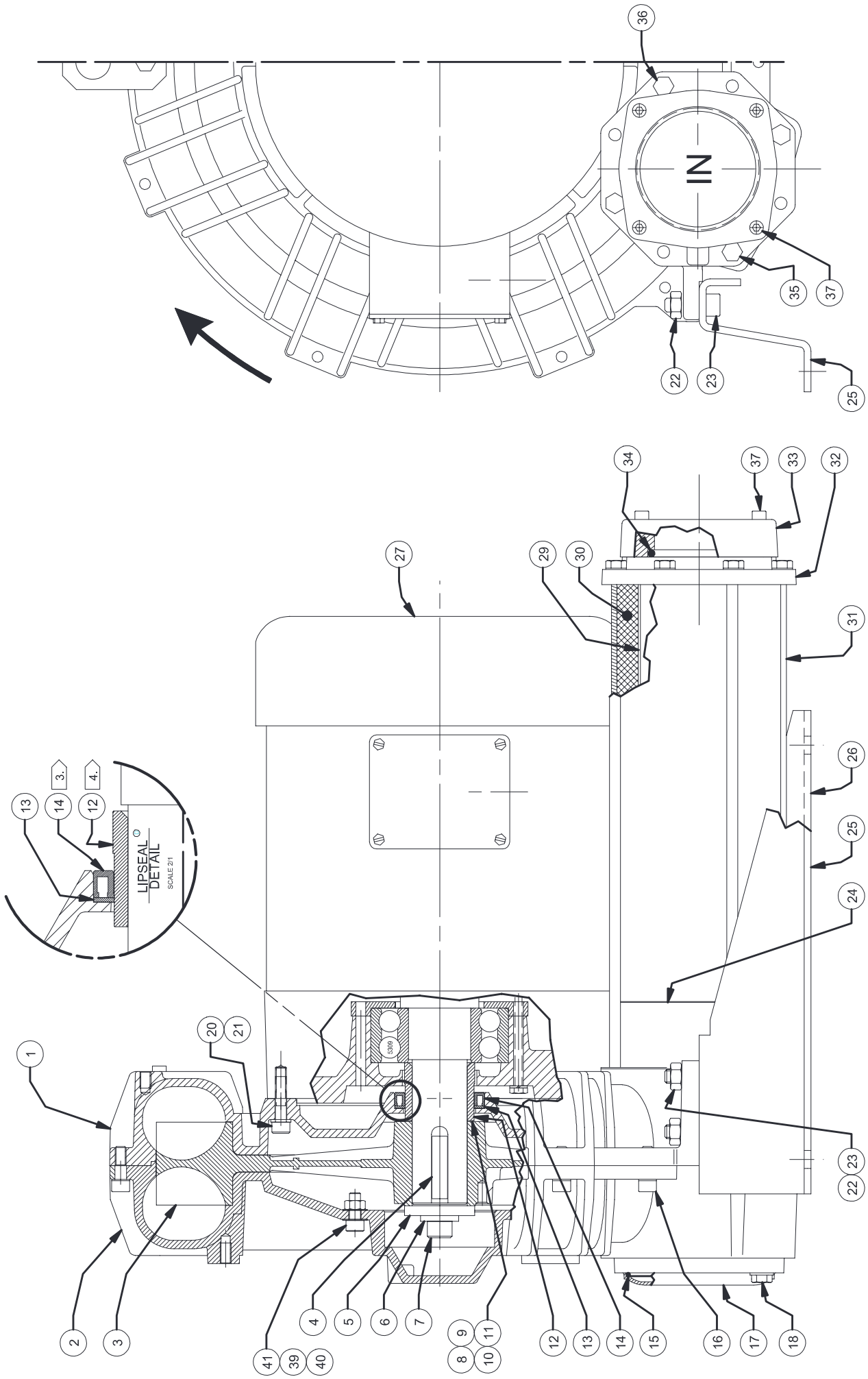


INTERCHANGE LEAD WIRES 5 & 8 TO REVERSE ROTATION

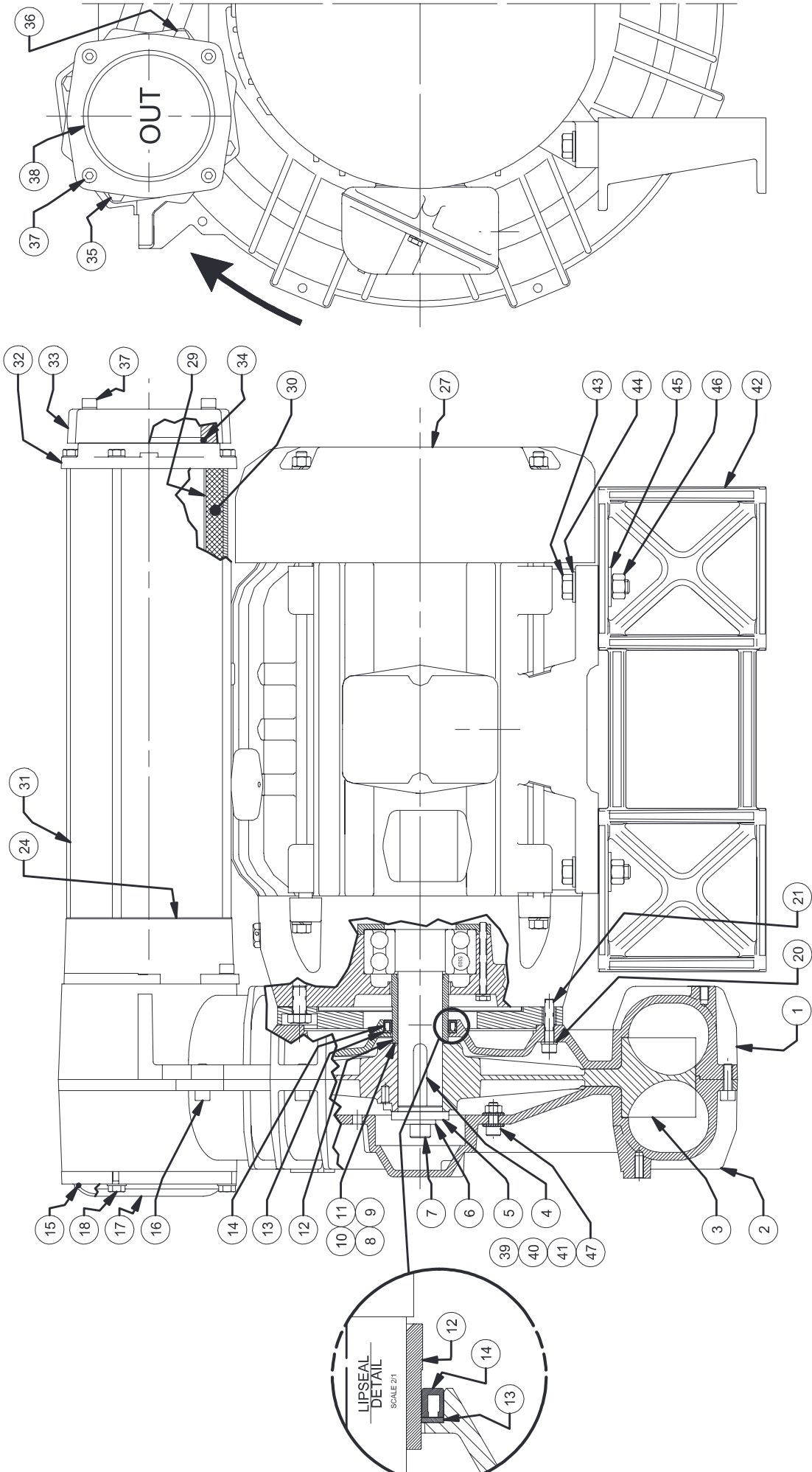
G. 3Ø, 575 VAC



INTERCHANGE ANY TWO LEAD LINES TO REVERSE ROTATION



DR633 AND DR833 ASSEMBLY DRAWING



DR1233 ASSEMBLY DRAWING

DR 633/833/1233
Service and Parts Manual

Model:
 Part No.:

Parts Breakdown

DR633 **DR633** **DR833** **DR833** **DR1233**
081268 **081691** **081281** **081702** **081375**
081270 **081693** **081283** **081704** **081377**
081267 **081689** **081278** **081699** **081377**
Obsolete **081280** **081701**

Obsolete

Item No.	Qty.	Req'd	Description	552132	552132	552133	552133	552133	552134
1	1		Housing						
2	1		Cover	552135	552135	552136	552136	552136	552137
3	1		Impeller	552126	552126	552127	552127	552127	552128
4	1		Key	552138	552138	552138	552138	552138	552138
5	1		Washer- Imp	155367	155367	155367	155367	155367	155367
6	1		Lockwasher - Imp	155384	155384	155384	155384	155384	155384
7	1		Screw - Imp	155359	155359	155359	155359	155359	155359
8	A/R		Shim	155571	155571	155571	155571	155571	155571
9	A/R		Shim	155572	155572	155572	155572	155572	155572
10	A/R		Shim	155573	155573	155573	155573	155573	155573
11	A/R		Shim	155574	155574	155574	155574	155574	155574
12	1		Sleeve - Imp	552130	552130	552130	552130	552130	552184
13	1		Felt washer -Imp	155575	155575	155575	155575	155575	155575
14	1		Lipseal	552140	552140	552140	552140	552140	552140
15	2		O-ring	552141	552141	552141	552141	552141	552142
16	9		Screw housing to cover	155356	155356	155356	155356	155356	155356
17	2		Blind flange	552143	552143	552143	552143	552143	552144
18	8		Screw Blind flange	155356	(12) 155356	155356	155356	155356	155356
19			Not used	Not used	Not used	Not used	Not used	Not used	Not used
20	4		Lockwasher housing to motor	155537	155537	155537	155537	155537	155537
21	4		Screw housing to motor	155576	155576	155576	155576	155576	155576
22	4		Nut -foot	155577	155577	155577	155577	155577	Not used
23	4		Bolt - foot	155362	155362	155362	155362	155362	Not used
24	1		Manifold	552145	552145	552145	552145	552145	552146
25	1		Foot (left)	552147	552147	552147	552147	552147	Not used
26	1		Foot (right)	552148	552148	552148	552148	552148	Not used
27	1		Motor	See Below	See Below	See Below	See Below	See Below	See Below

*As needed **Viewed looking at inlet/outlet ports

DR 633/833/1233
Service and Parts Manual

Model:

Part No.:

Parts Breakdown

DR633	DR633	DR833	DR833	DR1233
081268	081691	081281	081702	081375
081270	081693	081283	081704	081377
081267	081689	081278	081699	
Obsolete		081280	081701	
		Obsolete		

Item No.	Qty.	Req'd	Description	Not used	Not used	Not used	Not used	Not used
28			Not used	Not used	Not used	Not used	Not used	Not used
29	2		Retainer (muffler)	552149	552459	552149	552459	552289
30	6		Muffler foam	(2) 552150	552478	(2) 552150	552478	(2) 552151
				Not used	(2) 552482	Not used	(2) 552482	Not used
31	2		Muffler tower	552152	552458	552152	552458	552706
32	2		Closing plate	552154	not used	552154	not used	552155
33	2		Flange	529834	511480	529834	511480	552157
			flange washers	Not used	(4) 155629	Not used	(4) 155629	Not used
34	2		O-ring	155376	552461	155376	552461	155377
35	7		Screw muffler long	155579	Not used	155579	Not used	155668
36	1		Screw Muffler - Short (inlet side for DR1233)	155581	Not used	155581	Not used	155582
37	8		Screw- Flange	155419	(4) 155419	155419	155419	155363
38			Not used	Not used	Not used	Not used	Not used	Not used
39	3		Bolt - Cover hole	155354	155646	155354	155646	(4) 155646
40	3		Nut - Cover hole	155380	155380	155380	155380	155380
41	6		Washer - Cover hole	155537	155537	155537	155537	155537
42	2		Rails	Not used	Not used	Not used	Not used	551658
43	4		Screw -rails	Not used	Not used	Not used	Not used	155067
44	4		washer - rails	Not used	Not used	Not used	Not used	120211
45	4		Lockwasher rails	Not used	Not used	Not used	Not used	251788
46	4		Nut- rail	Not used	Not used	Not used	Not used	155070
47	6		Lockwasher - Cover hole	Not used	Not used	Not used	Not used	(4) 155531

*As needed **Viewed looking at inlet/outlet ports

**DR 633/833/1233
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Model:
Part No.:

Parts Breakdown

DR633 DR833 DR1233
081268 **081281** **081702** **081375**
081270 **081283** **081704** **081377**
081267 **081278** **081699** **081699**
Obsolete **081280** **081701**

Item No.	Qty. Req'd	Description	Part #	Motor	Wiring Diagram	Inline Filter (included)
DR633AY72			081268	552101	C	515255
DR633AY86			081270	552102	G	515255
DR633D89			081267	552099	C	515255
DR833BB72			081281	552103	C	515255
DR833BB86			081283	552104	G	515255
DR833AY72			081278	552101	C	515255
R833AY86			081280	552102	G	515255
DR633AY72M			081691	552101	C	515255
DR633AY86M			081693	552102	G	515255
DR633D89M			081689	552099	C	515255
DR833BB72M			081702	552103	C	515255
DR833BB86M			081704	552104	G	515255
DR833AY72M			081699	552101	C	515255
833AY86M			081701	552102	G	515255
DR1233BH72W			081375	552233	C	515256
DR1233BH86W			081377	552234	G	515256

Impeller end bearing

552618
552618
552618

*As needed **Viewed looking at inlet/outlet ports

*As needed **Viewed looking at inlet/outlet ports

5/31/16 REV E

*As needed **Viewed looking at inlet/outlet ports

5/31/16 REV E

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