


# Replacing Blower (L.H. or R.H.)

## Function

Replacement of vacuum blower - L.H. or R.H.

## Tools Needed

- Screwdriver
- Combination Wrenches (SAE and Metric)
- Vacuum Gauge
- Select and Use  Before Starting Job

## Machine Setup

1. Locate the machine in a safe working area, under permanent roof support and outby the working face.
2. Remove power to the machine at the power center. Lock and tag out the machine power cable at the power center.
3. Remove cover plates, as required, to access the blower to be replaced.

## Removal Procedure

1. Remove the blower belt guard assembly.

### NOTICE

Tag inlet, outlet and cooling air inlet hoses before removing from blower assembly.

2. Using the blower belt tension adjustment, adjust the belt tension to the point that the belts can be removed from the blower drive sheave.

3. Disconnect the inlet hose from the blower inlet fitting assembly and tag for identification later.
4. Disconnect the outlet hose from the blower outlet fitting assembly and tag for identification later.
5. Disconnect the cooling air inlet hoses from the blower cooling air inlet fitting and tag for identification later.
6. Disconnect the two grease hoses from the blower grease hose fittings.
7. Remove the four blower assembly mounting bolts.
8. Remove the blower assembly.

### CAUTION

**Contamination (dirt) will damage blower.  
Do not allow dirt to enter blower during change out procedure.**

9. Remove the inlet fitting assembly, which may be tack welded, from the existing blower and install in the replacement blower in the same location and with the same orientation.
10. Remove the outlet fitting assembly from the existing blower and install in the replacement blower in the same location and with the same orientation.
11. Remove the cooling air inlet fitting assembly from the existing blower and install in the replacement blower in the same location and with the same orientation.
12. Remove the two grease fitting assemblies from the existing blower and install in the replacement blower in the same location and with the same orientation.
13. Remove the oil fill fitting assembly from the existing blower and install in the replacement blower in the same location and with the same orientation.

14. Remove the drain cock from the existing blower and install in the replacement blower in the same location and with the same orientation.

**WARNING**

Never operate the machine with the blower belt and pump coupling guard removed. Serious injury or even death can occur from operation without having the blower belt and pump coupling guard installed.

**Installation Procedure**

1. Place replacement blower assembly onto blower mount in the same orientation as replaced blower assembly.
2. Install and tighten down the four blower assembly mounting bolts.
3. Install the blower drive belts onto the blower drive sheave.
4. Using the blower belt tension adjusting screws, adjust belt tension. (Correct tension: 1/4" or 6mm deflection at mid-point between sheaves with moderate pressure applied to belts.)
5. Tighten down the locking nuts on the adjusting screws.
6. Re-check belt tension, re-adjust if required.
7. Connect the two grease hoses to the blower assembly grease hose fittings.
8. Connect the inlet hose to the blower inlet fitting assembly.
9. Connect the outlet hose to the blower outlet fitting assembly.
10. Connect the cooling air inlet hoses to the cooling air inlet fitting assembly.
11. Install the blower belt guard.
12. Service both blower grease fittings - two shots with hand operated grease gun. Use SHELL STAMINA RLS2 or equivalent grease.
13. Remove plug from oil fill port fitting.
14. Place the drain cock in the open position.
15. Pour oil (ROOTS Synthetic Oil - ISO-VG-320 Grade) into fill port fitting until oil runs out of the drain cock.
16. Close the drain cock.
17. Re-install the plug in the oil fill port fitting.
18. Restore power to the machine.
19. Start the machine and check vacuum system for proper operation and vacuum level. Re-adjust vacuum level if required.
20. Shut down the machine.
21. Re-install cover plates.

**NOTICE**

Blower must be greased and filled with oil to the proper level prior to start-up. Failure to lubricate properly before starting operation will damage blower beyond repair.

Figure 1

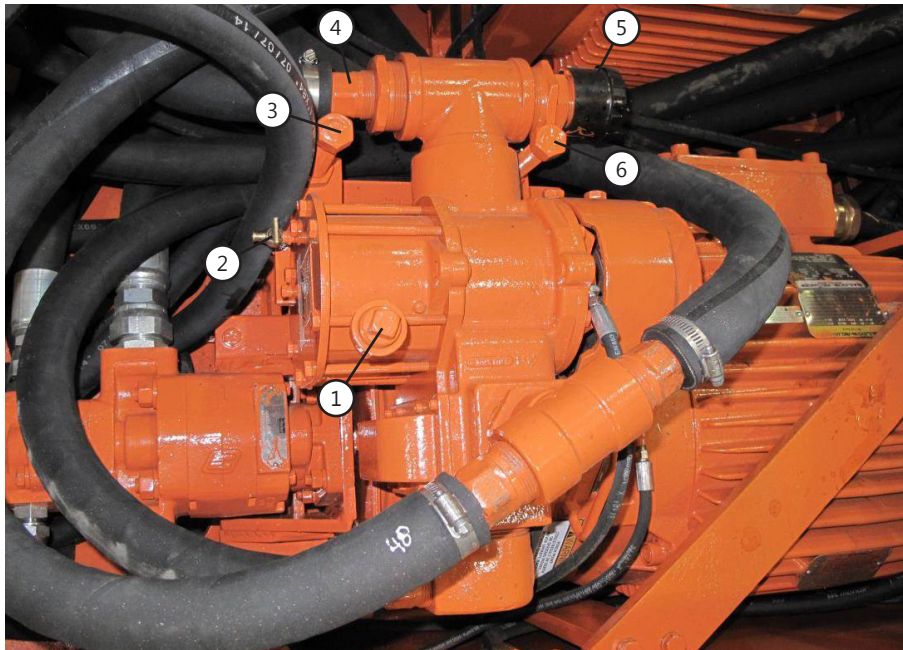
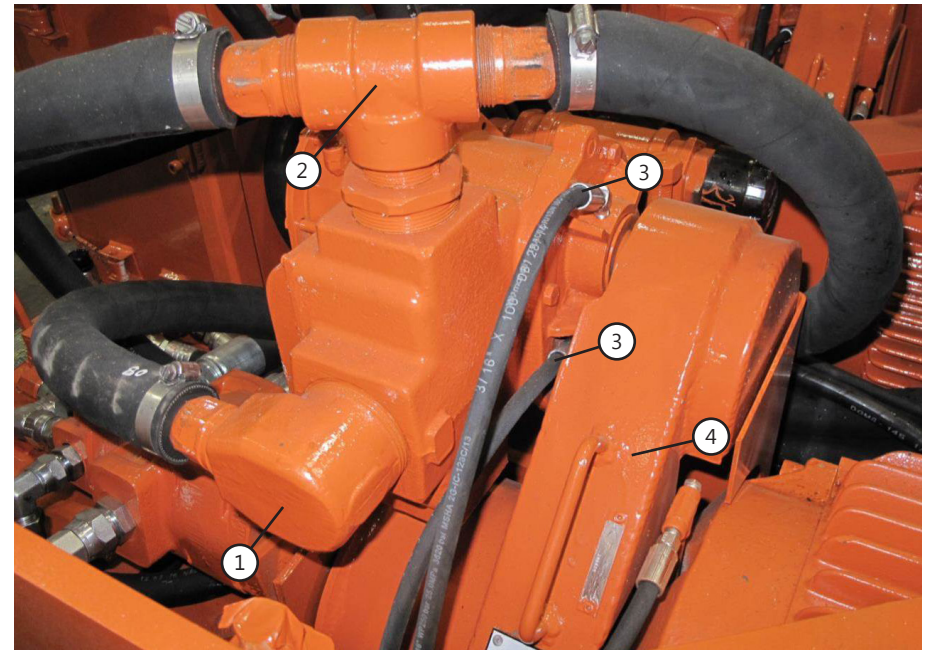


Figure 2



Component Parts (Fig. 1)

ITEM	PART #	DESCRIPTION	QTY
1	-	Oil Fill Fitting	
2	-	Oil Level Drain Cock	
3	-	Blower Belt Tension Adjusting Screw	
4	-	Inlet Port Fitting	
5	-	Vacuum Relief Valve	
6	-	Blower Belt Tension Adjusting Screw	

Component Parts (Fig. 2)

ITEM	PART #	DESCRIPTION	QTY
1	-	Outlet Fitting	
2	-	Cooling Air Inlet Fitting	
3	-	Grease Hose	
4	-	Blower Belt Guard	