



**SERVICE AND OPERATING MANUAL**  
**Original Instructions**  
**Model SET1**  
**Sanitary Type 3**

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# SANDPIPER®

A WARREN RUPP PUMP BRAND

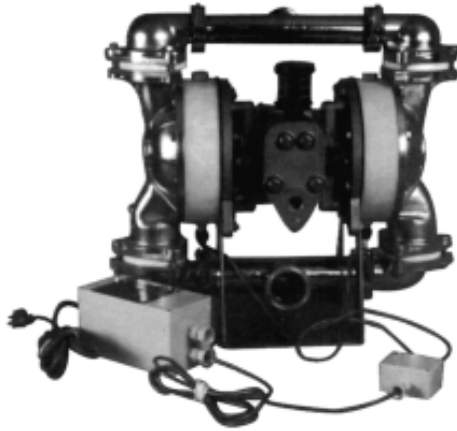
## SET I BALL VALVE Type 3

**Air-Powered  
Double Diaphragm  
Sanitary Containment Pumps**

ENGINEERING, PERFORMANCE  
& CONSTRUCTION DATA

Quality System  
ISO9001 Certified

Environmental  
Management System  
ISO14001 Certified



Pump shown with optional electronic leak detector.



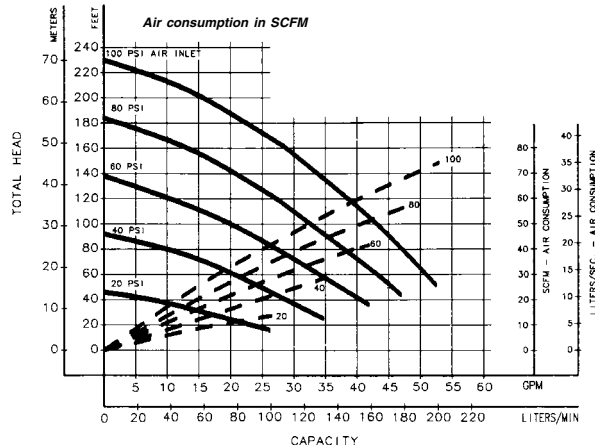
### MODEL SET1

SUCTION/DISCHARGE PIPE SIZE	CAPACITY	AIR VALVE	SOLIDS-HANDLING	HEADS UP TO	DISPLACEMENT/STROKE
1/2" Sanitary Clamp Fittings	0 to 52 gallons per minute (0 to 196 liters per minute)	No-lube, no-stall design	1/4 in. (6 mm)	125 psi or 289 ft. of water (8.8 Kg/cm <sup>2</sup> or 88 meters)	.09 Gallon / .34 liter

### PERFORMANCE CURVE

(SANDPIPER® pumps are designed to be powered only by compressed air)

Temperature Limit: 212°F - 100°C MAXIMUM



### MATERIALS OF CONSTRUCTION

SET1	Driver Chamber	Manifold/Elbow	Outer Chamber	Inner Chamber	Outer Driver Diaphragm Plate	Inner Driver Diaphragm Plate	Intermediate Housing	Diaphragm Rod	Valve Seat	Hardware	Pumping Diaphragm Driver Diaphragm	Ball Valve Material	Seat/Manifold Gasket	Cap/Air Valve	Shipping Weight (lbs)
TGF-3-SS	T	302/304SS	316SS*	AL380DC	316SS*	PS	AL380DC	416SS	T	304SS	T/WN	T	T	AL380DC	65

#### Meanings of Abbreviations:

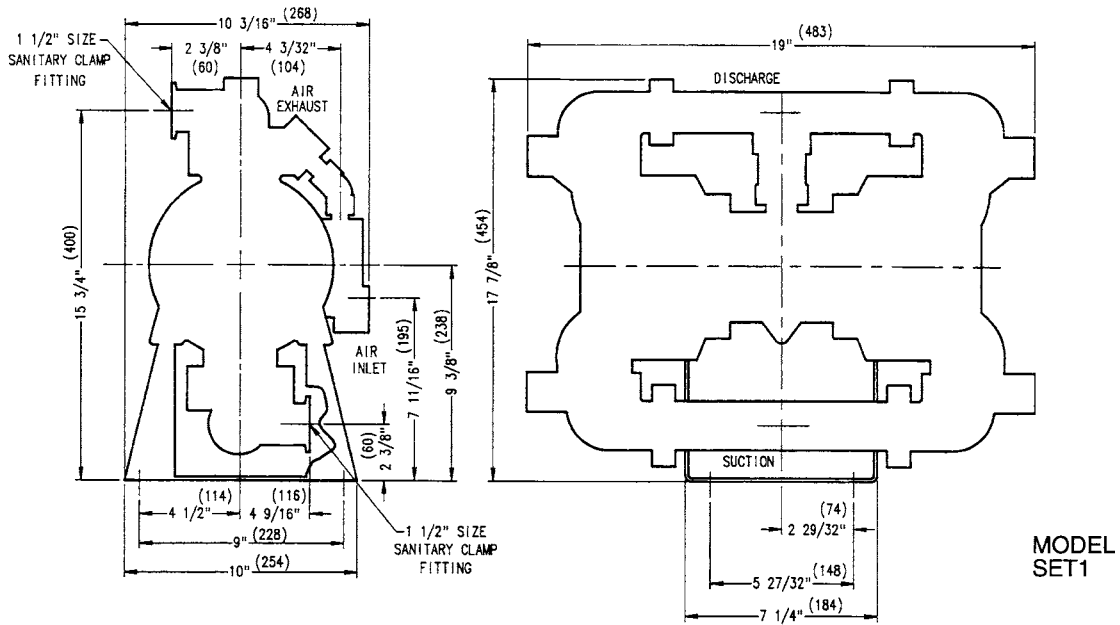
\* = Electropolished  
= Electroless Nickel Plated  
AL = Aluminum  
DC = Die Cast  
PP = Polypropylene - Glass Filled

PS = Plated Steel  
T = PTFE  
SS = Stainless Steel  
WN = White Nitrile - Food Grade

NITRILE TEMPERATURE LIMITATIONS: 190°F (88°C) for Continuous Operation  
280°F (138°C) for Intermittent Operation

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Dimensions are ± 1/8"  
Figures in parenthesis = millimeters



**1 1/2" SANITARY PROCESS CLAMP FITTING SUCTION AND DISCHARGE**  
**1/2" NPT(F) AIR INLET PORT • 3/4" NPT(M) AIR EXHAUST PORT**



# **SERVICE AND OPERATING MANUAL**

## **Original Instructions**

### **Model SET1**

#### **Sanitary Type 3**

### **PRINCIPLE OF OPERATION**

This ball check valve pump is powered by compressed air and is a 1:1 pressure ratio design. It alternately pressurizes the inner side of one diaphragm chamber, while simultaneously exhausting the other inner chamber. This causes the diaphragms, which are connected by a common rod, to move endwise. Air pressure is applied over the entire surface of the diaphragm, while liquid is discharged from the opposite side. The diaphragm operates under a balanced condition during the discharge stroke, which allows the unit to be operated at discharge heads over 200 feet (61 meters) of water head.

Since the diaphragms are connected by a common rod, secured by plates to the center of the diaphragms, one diaphragm performs the discharge stroke, while the other is pulled to perform the suction stroke in the opposite chamber.

For maximum diaphragm life, keep the pump as close to the liquid being pumped as possible. Positive suction head in excess of 10 feet of liquid (3.048 meters) may require a back pressure regulating device. This will maximize diaphragm life.

Alternate pressuring and exhausting of the diaphragm chamber is performed by means of an externally mounted, pilot operated, four-way spool type air distribution valve. When the spool shifts to one end of the valve body, inlet air pressure is applied to one diaphragm chamber and the other diaphragm chamber exhausts. When the spool shifts to the opposite end of the valve body, the porting of chambers is reversed. The air distribution valve spool is moved by an internal pilot valve which alternately pressurizes one side of the air distribution valve spool, while exhausting the other side. The pilot valve is shifted at each end of the diaphragm stroke by the diaphragm plate coming in contact with the end of the pilot valve spool. This pushes it into position for shifting of the air distribution valve.

The chambers are manifolded together with a suction and discharge check valve for each chamber, maintaining flow in one direction through the pump.

This SandPIPER pump differs from others in that it utilizes four diaphragms instead of two. The two rod-connected diaphragms are the driver diaphragms, and the other two (outermost) diaphragms are the actual pumping diaphragms. Each driver diaphragm (of Neoprene or other elastomer), and the pumping diaphragm (of TFE), are separated by a chamber filled with liquid which transmits the reciprocating motion of the driver diaphragm to the pumping diaphragm. The pumping diaphragms, create the alternating suction and discharge action to each outer diaphragm chamber. The pumping diaphragms are the only ones in contact with the liquid being pumped.

### **INSTALLATION & START-UP**

Locate the pump as close to the product being pumped as possible, keeping suction line length and number of fittings to a minimum. Do not reduce line size.

For installations of rigid piping, short flexible sections of hose should be installed between pump and piping. This reduces vibration and strain to the piping system. A Warren Rupp Tranquilizer® surge suppressor is recommended to further reduce pulsation in flow.

This pump was tested at the factory prior to shipment and is ready for operation. It is completely self-priming from a dry start for suction lifts of 10-15 feet (9-14 meters) or less. For suction lifts exceeding 15 feet of liquid, fill the chambers with liquid prior to priming.

## **AIR SUPPLY**

Air supply pressures cannot exceed 125 psi (8.61 bar). Connect the pump air inlet (see Fig. 1) to an air supply of sufficient capacity and pressure required for desired performance. When the air line is solid piping, use a short length of flexible hose (not less than ¾" [19mm] in diameter) between pump and piping to eliminate strain to pipes.

## **AIR INLET & PRIMING**

For start-up, open an air valve approximately ½ to ¾ turn. After the unit primes, an air valve can be opened to increase flow as desired. If opening the valve increases cycling rate, but does not increase flow rate, cavitation has occurred, and the valve should be closed slightly.

For the most efficient use of compressed air and the longest diaphragm life, throttle the air inlet to the lowest cycling rate that does not reduce flow.

## **A NOTE ABOUT AIR VALVE LUBRICATION**

The SandPIPER pump's pilot valve and main air valve assemblies are designed to operate WITHOUT lubrication. This is the preferred mode of operation. There may be instances of personal preference, or poor quality air supplies when lubrication of the compressed air supply is required. The pump air system will operate with properly lubricated compressed air supplies. Proper lubrication of the compressed air supply would entail the use of an air line lubricator (available from Warren Rupp) set to deliver one drop of 10 wt., non-detergent oil for every 20 SCFM of air the pump consumed at its point of operation. Consult the pump's published Performance Curve to determine this.

It is important to remember to inspect the sleeve and spool set routinely. It should move back and forth freely. This is most important when the air supply is lubricated. If a lubricator is used, oil accumulation will, over time, collect any debris from the compressed air. This can prevent the pump from operating properly.

Water in the compressed air supply can create problems such as icing or freezing of the exhaust air causing the pump to cycle erratically, or stop operating. This can be addressed by using a point of use air dryer (available from Warren Rupp) to supplement a plant's air drying equipment. This device will remove excess water from the compressed air supply and alleviate the icing or freezing problem.

## **ESADS: EXTERNALLY SERVICEABLE AIR DISTRIBUTION SYSTEM**

Please refer to the exploded view drawing and parts list in the Service Manual supplied with your pump. If you need replacement or additional copies, contact your local Warren Rupp Distributor, or the Warren Rupp factory Literature Department at the number shown below. To receive the correct manual, you must specify the MODEL and TYPE information found on the name plate of the pump.

## **MODELS WITH 1" SUCTION/DISCHARGE OR LARGER, AND NON-METAL CENTER SECTIONS**

The main air valve sleeve and spool set is located in the valve body mounted on the pump with four hex head capscrews. The valve body assembly is removed from the pump by removing these four hex head capscrews.

With the valve body assembly off the pump, access to the sleeve and spool set is made by removing a retaining ring (each end) securing the end cap on the valve body assembly. With the end caps removed, slide the spool back and forth in the sleeve. The spool is closely sized to the sleeve and must move freely to allow for proper pump operation. An accumulation of oil, dirt or other contaminants from the pump's air supply, or from a failed diaphragm, may prevent the spool from moving freely. This can cause the spool to stick in a position that prevents the pump from operating. If this is the case, the sleeve and spool set should be removed from the valve body for cleaning and further inspection.

Remove the spool from the sleeve. Using an arbor press or bench vise (with an improvised mandrel), press the sleeve from the valve body. Take care not to damage the sleeve. At this point, inspect the o-rings on the sleeve for nicks, tears or abrasions. Damage of this sort could happen during assembly or servicing. A sheared or cut o-ring can allow the pump's compressed air supply to leak or bypass within the air valve assembly, causing the pump to leak compressed air from the pump air exhaust or not cycle properly. This is most noticeable at pump dead head or high discharge pressure conditions. Replace any of these o-rings as required or set up a routine,

preventive maintenance schedule to do so on a regular basis. This practice should include cleaning the spool and sleeve components with a safety solvent or equivalent, inspecting for signs of wear or damage, and replacing worn components.

To re-install the sleeve and spool set, lightly lubricate the o-rings on the sleeve with an o-ring assembly lubricant or lightweight oil (such as 10 wt. air line lubricant). Press the set into the valve body easily, without shearing the o-rings. Re-install one end cap, and retaining ring on the valve body. Using the arbor press or bench vise that was used in disassembly, press the sleeve back into the valve body. Re-install the spool, keeping the counter-bored end toward you, and install the spring, opposite end cap and retaining ring on the valve body. After inspecting and cleaning the gasket surfaces on the valve body and intermediate, re-install the valve body on the pump using new gaskets. Tighten the four hex head capscrews evenly and in an alternating cross pattern, at 150 in./lbs. (16.94 Newton meters).

## **AIR EXHAUST**

If a diaphragm fails, the pumped liquid or fumes can enter the air end of the pump, and be exhausted into the atmosphere. When pumping hazardous or toxic materials, pipe the exhaust to an appropriate area for safe disposition.

This pump can be submerged if materials of construction are compatible with the liquid. The air exhaust must be piped above the liquid level. Piping used for the air exhaust must not be smaller than 1" (2.54 cm). Reducing the pipe size will restrict air flow and reduce pump performance. When the product source is at a higher level than the pump (flooded suction), pipe the exhaust higher than the product source to prevent siphoning spills.

Freezing or icing of the air exhaust can occur under certain temperature and humidity conditions. Use of a Warren Rupp Extractor/Dryer unit should eliminate most icing problems. Check the exhaust periodically for build-up of ice or contaminants (see Fig. 2).

## **BETWEEN USES**

When used for materials that tend to settle out or transform to solid form, the pump should be completely flushed after each use, to prevent damage. Product remaining in the pump between uses could dry out or settle out. This could cause problems with valves and diaphragms at re-start. In freezing temperatures, the pump must be drained between uses in all cases.

## **FILLING OF DRIVER CHAMBER WITH LIQUID**

The driver chambers are filled at the factory with water.

If you need to substitute another liquid to prevent system contamination, first consult the factory for chemical compatibility with pump construction.

Follow the steps listed below to replace the liquid in the pump after disassembly or liquid loss:

1. Filling is accomplished through the pipe plugs at the top of the liquid driver chamber (see Fig. 3).
2. After the driver fluid has been emptied from the pump, the driver diaphragms will naturally come to center.
3. Remove the entire discharge manifold assembly exposing the ports in the outer diaphragm chambers.
4. Fill either side with 600 ml. (20.3 fl. oz.) by volume with the driver liquid. It is imperative that the driver liquid chambers be filled with the correct amount of driver liquid as too little or too much will cause premature diaphragm failure and erratic pumping.
5. After filling with the proper amount of liquid, if the liquid does not come to the top of the fill hole, pressure should be applied to the Virgin PTFE diaphragm with a blunt tool through the discharge material flow port in the outer chamber until it does come to the top (see Fig. 4). To facilitate this filling, a taper punch can be used in the hole of the rod to manually shift the pump.
6. When the driver fluid rises to the top of the fill plug hole, screw the boss plug, with o-ring installed, into the chamber (see Fig. 5). (Do not overtighten.) Remember to keep pressure on the Virgin PTFE diaphragm until the boss plug is tight to prevent air from drawing back into the chamber.
7. Filling the opposite side is accomplished in the same manner as described in 5 and 6. The correct amount of fluid will come to the top of the fill hole. Screw in the boss plug.

## CHECK VALVE SERVICING

Need for inspection or service is usually indicated by poor priming, unstable cycling, reduced performance or the pump's cycling but not pumping.

Remove the six flange bolts securing the inlet and outlet flanges to the manifold. Inspect the surfaces of both check valve and seat for wear or damage that could prevent proper sealing. If pump is to prime properly, valves must seat air tight (see Fig. 6).

## DIAPHRAGM SERVICING

### Driver Diaphragms:

Drain the driver diaphragm chamber by removing the boss plug on the underside of the driver chamber. **NOTE:** This is also the part used for leak detector probes. Remove twelve bolts securing the two manifolds to the chambers. Remove eight bolts securing the diaphragm chamber. This permits inspection of the TFE diaphragm and the driver diaphragm. Loosen the plate which secures the diaphragm and plate to the rod by keeping the diaphragm engaged with the inner diaphragm chamber. Insert two or three capscrews through the bolt holes so the diaphragm cannot rotate when loosening. The diaphragm plates, diaphragm and bumper will now come off the assembly. Repeat all actions if the other diaphragm needs to be inspected or replaced.

**NOTE:** See "Filling of Driver Chamber with Liquid" for the correct procedure to recharge the pump for operation.

Reassembly is the reverse of the tear down. During reassembly, be sure the rubber bumper is on the rod on each side. Install the diaphragm with the natural bulge to the outside as marked on the diaphragm. Be sure that the large radius side of each plate is toward the diaphragm. Place the sealing washer between the inner diaphragm plate and the end of the rod. Tighten the plate to approximately 25 ft. lbs. (3.456 pounds/sq. cm.). Torque while allowing the diaphragm to turn freely with the plate. Hold the opposite side with a wrench on the plate to prevent rotation of the rod. If the opposite chamber is assembled, this will not be necessary.

When reassembling the outer chambers and the manifold, the bolts securing the manifold flange to the chamber should be snugged prior to tightening the manifold flange. Finish tightening the manifold flange bolts after the chamber bolting is secured.

## PILOT VALVE

The pilot valve assembly is accessed by removing the main air distribution valve body from the pump and lifting the pilot valve body out of the intermediate housing (see Fig. 9).

Most problems with the pilot valve can be corrected by replacing the o-rings. Always grease the spool prior to inserting it into the sleeve. If the sleeve is removed from the body, reinsertion must be at the chamfered side. Grease the o-rings to slide the sleeve into the valve body. Securely insert the retaining ring around the sleeve. When reinserting the pilot valve, push both plungers (located inside the intermediate bracket) out of the path of the pilot valve spool ends to avoid damage.

## PILOT VALVE ACTUATOR

Bushings for the pilot valve actuators are held in the inner chambers with retaining rings. An o-ring is behind each bushing. If the plunger has any sideways motion check o-rings and bushings for deterioration or wear. The plunger may be removed for inspection or replacement. First remove the air distribution valve body and the pilot valve body from the pump. The plungers can be located by looking into the intermediate. It may be necessary to use a fine piece of wire to pull them out. The bushing can be turned out through the inner chamber by removing the outer chamber assembly. Replace the bushings if pins have bent (see Fig. 10 and Fig. 11).

## **SERVICE INSTRUCTIONS: TROUBLE SHOOTING**

### **1. Pump will not cycle**

- A. Check to make sure the unit has enough pressure to operate and that the air inlet valve is open.
- B. Check the discharge line to insure that the discharge line is neither closed nor blocked.
- C. If the spool in the air distribution valve is not shifting, check the main spool. It must slide freely.
- D. Excessive air leakage in the pump can prevent cycling. This condition will be evident. Air leakage into the discharge line indicates a ruptured diaphragm. Air leakage from the exhaust port indicates leakage in the air distribution valve. See further service instructions.
- E. Blockage in the liquid chamber can impede movement of diaphragm.

### **2. Pump cycles but will not pump**

- A. Suction side of pump pulling in air. Check the suction line for air leaks and be sure that the end of the suction line is submerged. Check flange bolting. Check valve flanges and manifold to chamber flange joints.
- B. Make certain the suction line or strainer is not plugged. Restriction at the suction is indicated by a high vacuum reading when a vacuum gauge is installed in the suction line.
- C. Check valves may not be seating properly. To check, remove the suction line and cover the suction port with your hand. If the unit does not pull a good suction (vacuum), the check valves should be inspected for proper seating.
- D. Static suction lift may be too high. Priming can be improved by elevating the suction and discharge lines higher than the check valves and pouring liquid into the unit through the suction inlet. When priming at high suction lifts or with long suction lines operate the pump at maximum cycle rate.
- E. Incorrect driver fluid level or air has not been properly purged.

### **3. Low performance**


- A. Capacity is reduced as the discharge pressure increases, as indicated on the performance curve. Performance capability varies with available inlet air supply. Check air pressure at the pump inlet when the pump is operating to make certain that adequate air supply is maintained.
  - B. Check vacuum at the pump suction. Capacity is reduced as vacuum increases. Reduced flow rate due to starved suction will be evident when cycle rate can be varied without change in capacity. This condition will be more prevalent when pumping viscous liquids. When pumping thick, heavy materials the suction line must be kept as large in diameter and as short as possible, to keep suction loss minimal.
  - C. Low flow rate and slow cycling rate indicate restricted flow through the discharge line. Low flow rate and fast cycling rate indicate restriction in the suction line or air leakage into suction.
  - D. Unstable cycling indicates improper check valve seating on one chamber. This condition is confirmed when unstable cycling repeats consistently on alternate exhausts. Cycling that is not consistently unstable may indicate partial exhaust restriction due to freezing and thawing of exhaust air. Use of an anti-freeze lubricant in an air line lubricator should solve this problem.
  - E. Incorrect driver fluid level or air has not been properly purged.
- For additional information, see the Warren Rupp Trouble Shooting Guide.

## **WARRANTY**

This pump is warranted for a period of five years against defective material and workmanship. Failure to comply with the recommendations stated in this manual voids all factory warranty.




# IMPORTANT SAFETY INFORMATION




**IMPORTANT**

Read these safety warnings and instructions in this manual completely, before installation and start-up of the pump. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.



**WARNING**

Take action to prevent static sparking. Fire or explosion can result, especially when handling flammable liquids. The pump, piping, valves, containers or other miscellaneous equipment must be grounded. (See page 32)



**WARNING**

This pump is pressurized internally with air pressure during operation. Always make certain that all bolting is in good condition and that all of the correct bolting is reinstalled during assembly.




**CAUTION**

Before pump operation, inspect all gasketed fasteners for looseness caused by gasket creep. Retorque loose fasteners to prevent leakage. Follow recommended torques stated in this manual.




**WARNING**

When used for toxic or aggressive fluids, the pump should always be flushed clean prior to disassembly.



**CAUTION**

Pump not designed, tested or certified to be powered by compressed natural gas. Powering the pump with natural gas will void the warranty.



**WARNING**

Before doing any maintenance on the pump, be certain all pressure is completely vented from the pump, suction, discharge, piping, and all other openings and connections. Be certain the air supply is locked out or made non-operational, so that it cannot be started while work is being done on the pump. Be certain that approved eye protection and protective clothing are worn all times in the vicinity of the pump. Failure to follow these recommendations may result in serious injury or death.




**WARNING**

In the event of diaphragm rupture, pumped material may enter the air end of the pump, and be discharged into the atmosphere. If pumping a product which is hazardous or toxic, the air exhaust must be piped to an appropriate area for safe disposition.



**WARNING**

Airborne particles and loud noise hazards. Wear ear and eye protection.



**WARNING**

Before maintenance or repair, shut off the compressed air line, bleed the pressure, and disconnect the air line from the pump. The discharge line may be pressurized and must be bled of its pressure.



**WARNING**

Use safe practices when lifting

## RECYCLING

Many components of SANDPIPER® AODD pumps are made of recyclable materials (see chart on page 9 for material specifications). We encourage pump users to recycle worn out parts and pumps whenever possible, after any hazardous pumped fluids are thoroughly flushed.

## MATERIAL CODES THE LAST 3 DIGITS OF PART NUMBER

000	Assembly, sub-assembly; and some purchased items	353	Geolast; Color: BLACK	557	Conductive Polypropylene; Color: BLACK; Color Coded: SILVER
010	Cast Iron	354	Injection Molded #203-40 Santoprene- Duro 40D +/-5; Color: RED	558	Conductive HDPE; Color: BLACK Color Coded: SILVER
012	Powered Metal	355	Thermal Plastic	559	Conductive Polypropylene; Color: BLACK Color Coded: SILVER
015	Ductile Iron	356	Hytrel; Color: BLUE	570	Rulon II
020	Ferritic Malleable Iron	357	Injection Molded Polyurethane; Color: GREEN	580	Ryton
025	Music Wire	358	Urethane Rubber; Color: NATURAL (Some Applications) (Compression Mold)	590	Valox
080	Carbon Steel, AISI B-1112	359	Urethane Rubber; Color: NATURAL	591	Nylatron G-S
100	Alloy 20	360	Nitrile Rubber; Color Coded: RED	592	Nylatron NSB
110	Alloy Type 316 Stainless Steel	361	Nitrile	600	PTFE (virgin material) Tetrafluorocarbon (TFE)
111	Alloy Type 316 Stainless Steel (Electro Polished)	363	FKM (Fluorocarbon). Color Coded: YELLOW	601	PTFE (Bronze and moly filled)
112	Alloy C	364	E.P.D.M. Rubber. Color Coded: BLUE	602	Filled PTFE
113	Alloy Type 316 Stainless Steel (Hand Polished)	365	Neoprene Rubber; Color Coded: GREEN	603	Blue Gylon
114	303 Stainless Steel	366	Food Grade Nitrile; Color: WHITE	604	PTFE
115	302/304 Stainless Steel	368	Food Grade EPDM; Color: GRAY	606	PTFE
117	440-C Stainless Steel (Martensitic)	370	Butyl Rubber Color Coded: BROWN	607	Envelon
120	416 Stainless Steel (Wrought Martensitic)	371	Phlthane (Tuftane)	608	Conductive PTFE; Color: BLACK
123	410 Stainless Steel (Wrought Martensitic)	374	Carboxylated Nitrile	610	PTFE Encapsulated Silicon
148	Hardcoat Anodized Aluminum	375	Fluorinated Nitrile	611	PTFE Encapsulated FKM
149	2024-T4 Aluminum	378	High Density Polypropylene	632	Neoprene/Hytrel
150	6061-T6 Aluminum	379	Conductive Nitrile; Color Coded: RED & SILVER	633	FKM/PTFE
151	6063-T6 Aluminum	384	Conductive Neoprene; Color Coded: GREEN & SILVER	634	EPDM/PTFE
152	2024-T4 Aluminum (2023-T351)	405	Cellulose Fibre	635	Neoprene/PTFE
154	Almag 35 Aluminum	408	Cork and Neoprene	637	PTFE , FKM/PTFE
155	356-T6 Aluminum	425	Compressed Fibre	638	PTFE , Hytrel/PTFE
156	356-T6 Aluminum	426	Blue Gard	639	Nitrile/TFE
157	Die Cast Aluminum Alloy #380	440	Vegetable Fibre	643	Santoprene®/EPDM
158	Aluminum Alloy SR-319	465	Fibre	644	Santoprene®/PTFE
159	Anodized Aluminum	500	Delrin 500	656	Santoprene Diaphragm and Check Balls/EPDM Seats
162	Brass, Yellow, Screw Machine Stock	501	Delrin 570	661	EPDM/Santoprene
165	Cast Bronze, 85-5-5-5	502	Conductive Acetal, ESD-800; Color: BLACK	666	FDA Nitrile Diaphragm, PTFE Overlay, Balls, and Seals
166	Bronze, SAE 660	503	Conductive Acetal, Glass-Filled Color: BLACK; Color Coded: YELLOW	668	PTFE, FDA Santoprene/PTFE
170	Bronze, Bearing Type, Oil Impregnated	505	Acrylic Resin Plastic		
175	Die Cast Zinc	506	Delrin 150		
180	Copper Alloy	520	Injection Molded PVDF; Color: NATURAL		
305	Carbon Steel, Black Epoxy Coated	521	Injection Molded Conductive PVDF; Color: BLACK; Color Coded: LIGHT GREEN		
306	Carbon Steel, Black PTFE Coated	540	Nylon		
307	Aluminum, Black Epoxy Coated	541	Nylon		
308	Stainless Steel, Black PTFE Coated	542	Nylon		
309	Aluminum, Black PTFE Coated	544	Nylon Injection Molded		
310	PVDF Coated	550	Polyethylene		
313	Aluminum, White Epoxy Coated	551	Glass Filled Polypropylene; Color: BLACK		
330	Zinc Plated Steel	552	Unfilled Polypropylene; Color: NATURAL		
331	Chrome Plated Steel	555	Polyvinyl Chloride		
332	Aluminum, Electroless Nickel Plated	556	Black Vinyl		
333	Carbon Steel, Electroless Nickel Plated				
335	Galvanized Steel				
336	Zinc Plated Yellow Brass				
337	Silver Plated Steel				
340	Nickel Plated				
342	Filled Nylon				
351	Food Grade Santoprene; Color: NATURAL				

Delrin is a registered  
tradename of E.I. DuPont.

Gylon is a registered tradename  
of Garlock, Inc.

Nylatron is a registered tradename  
of Polymer Corp.

Santoprene is a registered tradename  
of Exxon Mobil Corp.

Rulon II is a registered tradename  
of Dixon Industries Corp.

Ryton is a registered tradename  
of Phillips Chemical Co.

Valox is a registered tradename  
of General Electric Co.

PortaPump, Tranquilizer and SludgeMaster are  
registered tradenames of Warren Rupp, Inc.



**REPAIR PARTS LIST AND DRAWING**  
**Original Instructions**  
**Model SET1**  
**Sanitary Type 3**

ITEM NO.	PART NUMBER	DESCRIPTION	TOTAL RQD.
1	095-051-558	Body, Spool Valve	1
2	<b>031-039-000</b>	<b>Sleeve &amp; Spool Set</b>	<b>1</b>
3	<b>560-058-360</b>	<b>O-Ring</b>	<b>8</b>
4	165-038-558	Cap, End	2
5	<b>675-043-115</b>	<b>Ring, Retaining</b>	<b>2</b>
6	165-042-332	Cap, Valve Body	1
7	<b>360-056-360</b>	<b>Gasket</b>	<b>1</b>
8	<b>360-057-360</b>	<b>Gasket</b>	<b>1</b>
9	<b>360-058-360</b>	<b>Gasket</b>	<b>1</b>
10	<b>095-074-001</b>	<b>Pilot Valve Body Assembly*</b>	<b>1</b>
10-A	<b>095-071-557</b>	<b>Pilot Valve Body</b>	<b>1</b>
10-B	<b>755-025-000</b>	<b>Sleeve (with O-Ring)</b>	<b>1</b>
10-C	<b>560-033-360</b>	<b>O-Ring (Sleeve)</b>	<b>4</b>
10-D	<b>775-014-000</b>	<b>Spool (with O-Ring)</b>	<b>1</b>
10-E	<b>560-023-360</b>	<b>O-Ring (Spool)</b>	<b>4</b>
10-F	<b>675-037-080</b>	<b>Retaining Ring</b>	<b>1</b>
11	170-063-115	Capscrew, Hex Head	1
12	901-035-115	Washer, Flat	7
13	542-001-115	Nut, Square	1
14	170-033-115	Capscrew, Hex Head	4
15	901-005-115	Washer, Flat	4
16	170-043-115	Capscrew, Hex Head	6
17	114-011-332	Bracket, Intermediate	1
18	196-066-332	Chamber, Inner	1
19	196-064-332	Chamber, Inner	1
20	<b>560-040-360</b>	<b>O-Ring</b>	<b>2</b>
21	<b>560-001-360</b>	<b>O-Ring</b>	<b>2</b>
22	<b>135-013-162</b>	<b>Bushing</b>	<b>2</b>
23	<b>675-042-115</b>	<b>Ring, Retainer</b>	<b>2</b>
24	<b>620-007-114</b>	<b>Plunger, Actuator</b>	<b>2</b>
25	<b>132-022-360</b>	<b>Bumper</b>	<b>2</b>
26	<b>070-012-170</b>	<b>Bearing, Sleeve</b>	<b>2</b>
27	<b>720-010-375</b>	<b>Seal, U-Cup</b>	<b>2</b>
28	196-065-111	Chamber, Outer	2
29	<b>901-012-180</b>	<b>Washer, Sealing</b>	<b>2</b>
30	115-078-115	Bracket, Foot	1
31	<b>675-040-360</b>	<b>Ring, Sealing</b>	<b>2</b>
32	685-039-120	Rod, Diaphragm	1
33	<b>132-019-360</b>	<b>Bumper</b>	<b>2</b>
34	612-101-111	Plate, Outer Diaphragm	2
35	612-022-330	Plate, Inner Diaphragm	2
36	<b>286-008-366</b>	<b>Diaphragm</b>	<b>2</b>
	<b>286-008-368</b>	<b>Diaphragm</b>	<b>2</b>
37	<b>722-045-600</b>	<b>Seat, Valve</b>	<b>4</b>
38	<b>050-024-600</b>	<b>Ball, Check Valve</b>	<b>4</b>
39	518-077-110	Manifold, Suction	1

ITEM NO.	PART NO.	DESCRIPTION	TOTAL RQD.
40	518-076-110	Manifold, Discharge	1
41	312-052-111	Elbow, Suction	2
42	312-051-111	Elbow, Discharge	2
<b>43</b>	<b>361-005-600</b>	<b>Gasket Seal, Suction</b>	<b>2</b>
<b>44</b>	<b>361-006-600</b>	<b>Gasket Seal, Discharge</b>	<b>2</b>
45	200-032-115	Clamp, Suction	2
46	200-033-115	Clamp, Discharge	2
47	542-002-114	Stud Nut	4
48	542-011-000	Stud Nut Assembly	16
49	542-004-000	Stud Nut Assembly	12
50	170-044-115	Capscrew, Hex Head	4
51	900-004-115	Washer, Lock	4
52	545-004-115	Hex Nut	4
53	618-003-110	Pipe Plug	1
54	312-044-555	45° Elbow	1
55	538-025-555	Nipple, Pipe	1
56	530-018-000	Muffler, Exhaust	1
57	780-027-025	Spring	1
58	807-048-115	Stud	2
<b>59</b>	<b>286-040-604</b>	<b>Diaphragm</b>	<b>2</b>
60	196-077-600	Chamber, Driver	2
61	618-025-110	Boss Plug	4
61-A	560-078-611	O-Ring	4

Repair Parts shown in **bold face (darker)** type are more likely to need replacement after extended periods of normal use. The pump owner may prefer to maintain a limited inventory of these parts in his own stock to reduce repair downtime to a minimum.

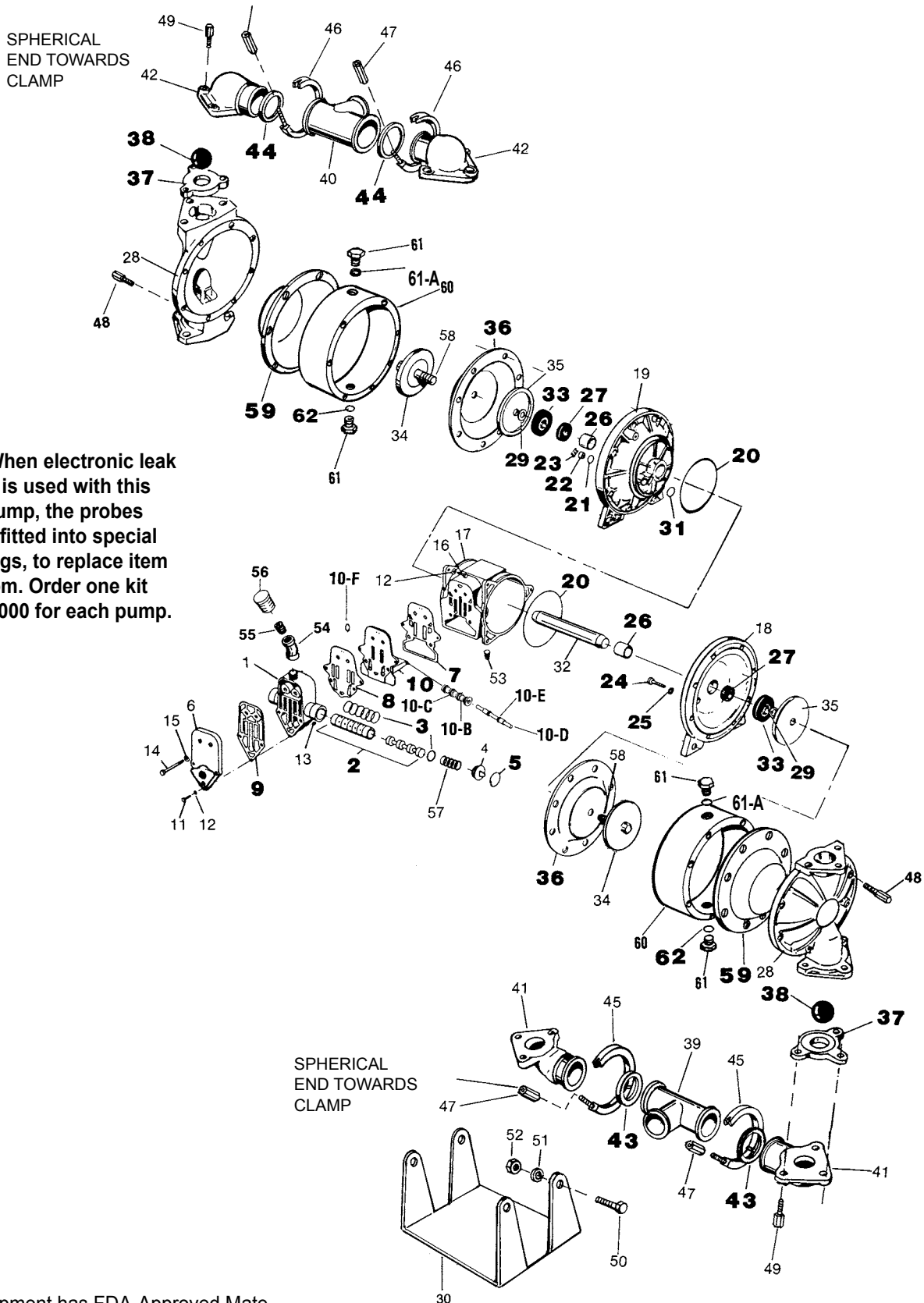
**IMPORTANT:** When ordering repair parts always furnish pump model number, serial number and type number.

Not Shown:

031-030-000	Valve Body Assembly	1
	Includes Items 1,2,3,4,5, & 57	
535-015-000	Name Plate	1
705-002-000	Screw, Drive	4

Parts underlined are only available for sale in kits

\* Available **only** in kit form. Order 031-060-000 which includes Items 7, 8, 9, 24 and 25.



**NOTE:** When electronic leak detector is used with this model pump, the probes must be fitted into special boss plugs, to replace item 61, bottom. Order one kit 475-098-000 for each pump.

This equipment has FDA-Approved Materials of Construction and is USDA acceptable for use in federally inspected meat and poultry plants.

# **WARREN RUPP, INC.®**

## **Declaration of Conformity**

**Manufacturer:**

**Warren Rupp, Inc.®, 800 N. Main Street  
Mansfield, Ohio, 44902 USA**

certifies that Air-Operated Double Diaphragm Pump Series: HDB, HDF, M Non-Metallic, S Non-Metallic, M Metallic, S Metallic, T Series, G Series, RS Series U Series, EH and SH High Pressure, W Series, SMA and SPA Submersibles, and Tranquilizer Surge Suppressors comply with the European Community Directive 2006/42/EC on Machinery, according to Annex VIII. This product has used Harmonized Standard EN809:1998+A1:2009, Pumps and Pump Units for Liquids - Common Safety Requirements, to verify conformance.

David Roseberry  
Signature of authorized person

October 20, 2005

Date of issue

David Roseberry  
Printed name of authorized person

Engineering Manager  
Title

Revision Level: F

April 19, 2012

Date of revision

