



# RS AND RD SERIES PUMPS

**MANUAL  
PART 1 of 3**

# INSTALLATION AND OPERATION

**THE GORMAN-RUPP COMPANY • MANSFIELD, OHIO**

GORMAN-RUPP OF CANADA LIMITED • ST. THOMAS, ONTARIO, CANADA

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Gorman-Rupp pump online at  
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Valid serial number and e-mail address required.

**RECORD YOUR PUMP MODEL AND SERIAL NUMBER**

Please record your pump model and serial number in the spaces provided below. Your Gorman-Rupp distributor needs this information when you require parts or service.

Pump Model: \_\_\_\_\_  
Serial Number: \_\_\_\_\_

## INTRODUCTION

**Thank You** for purchasing a Gorman-Rupp RS or RD Roto-Prime® Series Pump. **Read this manual** carefully to learn how to safely install and operate your pump. Failure to do so could result in personal injury or damage to the pump.

A set of three manuals accompanies your pump. Each set consists of three parts; the Installation/Operation Manual contains essential information on installing and operating the pump. However, since pump installations are seldom identical, some of the information only summarizes general recommendations and practices required to inspect, position, and arrange the pump and piping.

The Parts List Manual provides performance curve(s), a pump model cross-section drawing, and parts list for your pump.

The Maintenance and Repair Manual provides troubleshooting and maintenance instructions required to properly diagnose operational problems, and to service the pump components. Contact the factory for the authorized repair facility closest to you.

This pump is a Roto-Prime® self-priming centrifugal petroleum pump, designed to handle **petroleum products only**. It incorporates an integral variable-capacity vane pump which automatically evacuates air and vapor from the suction line. This pump should **not** be used to handle water or other non-petroleum liquids. For specific service, contact your Gorman-Rupp distributor or the Gorman-Rupp Company.

The basic pump is not furnished with a mounting base and power source; however, these items are

available from the factory as optional equipment. The pump is designed to be driven by an explosion-proof motor with a maximum full load speed of either 1750 RPM (RS Series) or 3450 RPM (RD Series).

Because pump installations are seldom identical, this manual cannot possibly provide detailed instructions and precautions for every aspect of each specific application. Therefore, it is the responsibility of the owner/installer of the pump to ensure that applications not addressed in this manual are performed **only** after establishing that neither operator safety nor pump integrity are compromised by the installation. Pumps and related equipment **must** be installed and operated according to all national, local and industry standards.

If there are any questions regarding the pump which are not covered in this manual or in other literature accompanying the unit, please contact your Gorman-Rupp distributor or the Gorman-Rupp Company:

**The Gorman-Rupp Company**  
**P.O. Box 1217**  
**Mansfield, Ohio 44901-1217**  
**Phone: (419) 755-1011**  
 or:  
**Gorman-Rupp of Canada Limited**  
**70 Burwell Road**  
**St. Thomas, Ontario N5P 3R7**  
**Phone: (519) 631-2870**

## CONTENTS

**SAFETY – SECTION A**

**INSTALLATION – SECTION B**

GENERAL INFORMATION .....	PAGE B – 1
PUMP DIMENSIONS .....	PAGE B – 1
PREINSTALLATION INSPECTION .....	PAGE B – 1
POSITIONING PUMP .....	PAGE B – 2
GROUNDING .....	PAGE B – 2
SUCTION AND DISCHARGE PIPING .....	PAGE B – 2
SUCTION LINES .....	PAGE B – 3
DISCHARGE LINES .....	PAGE B – 6
ALIGNMENT .....	PAGE B – 7

**OPERATION – SECTION C**

GENERAL INFORMATION .....	PAGE C – 1
PRIMING .....	PAGE C – 1
STARTING .....	PAGE C – 4
OPERATION .....	PAGE C – 4
STOPPING .....	PAGE C – 5
BEARING TEMPERATURE CHECK .....	PAGE C – 5

**RECORDING MODEL AND SERIAL NUMBERS**

Please record the pump model, serial number, voltage, and motor frame size in the spaces provided below. Your Gorman-Rupp distributor needs this information when you require parts or service.

Pump Model: \_\_\_\_\_

Serial Number: \_\_\_\_\_

The following are used to alert personnel to procedures which require special attention, to those which could damage equipment, and to those which could be dangerous to personnel:



**Immediate hazards which WILL result in severe personal injury or death. These instructions describe the procedure required and the injury which will result from failure to follow the procedure.**



**Hazards or unsafe practices which COULD result in severe personal injury or death. These instructions describe the procedure required and the injury which could result from failure to follow the procedure.**

**WARRANTY INFORMATION**

The warranty provided with your pump is part of Gorman-Rupp’s support program for customers who operate and maintain their equipment as described in this and the other accompanying literature. Please note that should the equipment be abused or modified to change its performance beyond the original factory specifications, the warranty will become void and any claim will be denied.



Hazards or unsafe practices which COULD result in minor personal injury or product or property damage. These instructions describe the requirements and the possible damage which could result from failure to follow the procedure.

**NOTE**

*Instructions to aid in installation, operation, and maintenance or which clarify a procedure.*

## SAFETY – SECTION A

The following information applies throughout this manual to Gorman-Rupp RS and RD Roto-Prime® Series basic pumps.

Because pump installations are seldom identical, this manual cannot possibly provide detailed instructions and precautions for each specific application. Therefore, it is the owner/installer's responsibility to ensure that applications not addressed in this manual are performed only after establishing that neither operator safety nor pump integrity are compromised by the installation.



Before attempting to install, operate, or service this pump, familiarize yourself with this manual, and with all other literature shipped with the pump. Unfamiliarity with all aspects of pump operation covered in this manual could lead to destruction of equipment, injury, or death to personnel.



Before attempting to open or service the pump:

1. Familiarize yourself with this manual.
2. Shut off the incoming power to the motor and lock it out, or take other action to ensure that the pump will remain inoperative.
3. Allow the pump to completely cool if overheated.

4. Check the temperature before opening any covers, plates, or plugs.
5. Close the suction and discharge valves.
6. Vent the pump slowly and cautiously.
7. Drain the pump.



This pump is designed to handle petroleum products or other similar hydrocarbon liquids. Do not attempt to pump water, corrosive materials, or any liquids which may damage the pump or endanger personnel as a result of pump failure.



This pump is designed to be used with volatile and/or flammable liquids; be certain proper safety practices are followed before operating or servicing the pump. Provide adequate ventilation, prohibit smoking, wear static-resistant clothing and shoes. Clean up all fuel spills immediately after occurrence.



Do not operate the pump against a closed discharge valve for long periods of time. If operated against a closed discharge valve, pump components will deteriorate, and the liquid could come to a boil, build pressure, and cause the pump casing to rupture or explode.



After the pump has been installed, make certain that the pump and all piping connections are tight, properly supported and secure before operation.



This pump is designed to be used with volatile and/or flammable liquids; overheating may produce dangerous fumes. Take precautions to ensure the area surrounding the pump is adequately ventilated. Allow the pump to completely cool and use extreme caution when venting the pump, or when removing covers, plates, plugs, or fittings.



Overheated pumps can cause severe burns and injuries, and produce explosive fumes. If overheating of the pump occurs:

1. Stop the pump immediately.
2. Ventilate the area.
3. Allow the pump to completely cool.
4. Check the temperature before opening any covers, plates, gauges, or plugs.
5. Vent the pump slowly and cautiously.

6. Refer to instructions in this manual before restarting the pump.



Do not install and operate a non-explosion proof motor in an explosive atmosphere. Install, connect, and operate the motor in accordance with The National Electric Code and all local codes. If there is a conflict between the instructions in the manual accompanying the unit and The National Electric Code or the applicable local code, The National or local code shall take precedence. All electrical equipment supplied with this pump conformed to applicable federal regulations and national codes in effect on the date of manufacture.



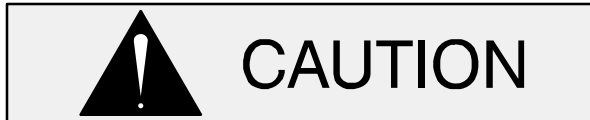
This pump is **not** designed to handle water. Operation of the pump with water or water-based solutions will damage the group grind within the vane-type priming pump. **Do not** connect this pump to a storage tank which has been filled with water until the tank and lines have been completely drained and flushed. Install a commercially available 80 mesh screen and a filter in the suction line to prevent debris from entering the pump. Check pump rotation with the suction line disconnected.

## INSTALLATION – SECTION B

### GENERAL INFORMATION

#### Review all SAFETY information in Section A.

Since pump installations are seldom identical, this section is intended only to summarize general recommendations and practices required to inspect, position, and arrange the pump and piping. If there are any questions concerning your specific installation, contact your Gorman-Rupp distributor or the Gorman-Rupp Company.



This pump is **not** designed to handle water. Operation of the pump with water or water-based solutions will damage the group grind within the vane-type priming pump. **Do not** connect this pump to a storage tank which has been filled with water until the tank and lines have been completely drained and flushed. Install a commercially available 80 mesh screen and a filter in the suction line to prevent debris from entering the pump. Check pump rotation with the suction line disconnected.

Most of the information pertains to a standard **static lift application**, where the pump is positioned above the free level of the liquid to be pumped.

If installed in a **flooded suction application**, where the liquid is supplied to the pump under pressure, some of the information such as mounting, line configuration, and priming must be tailored to the specific application. Since the pressure supplied to the pump is critical to performance and safety, **be sure** to limit the incoming pressure to 50% of the maximum permissible operating pressure shown on the pump performance curve.

For further assistance, contact your Gorman-Rupp distributor or the Gorman-Rupp Company.

### PUMP DIMENSIONS

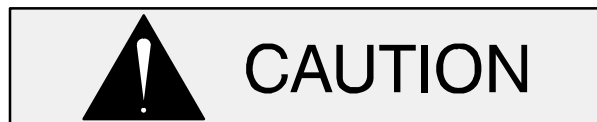
For the approximate physical dimensions of your pump, refer to the pump specification data sheet or

contact your Gorman-Rupp distributor or the Gorman-Rupp Company.

### PREINSTALLATION INSPECTION

The pump assembly was inspected and tested before shipment from the factory. Before installation, inspect the pump for damage which may have occurred during shipment. Check as follows:

- a. Inspect the pump for cracks, dents, damaged threads, and other obvious damage.
- b. Check for and tighten loose attaching hardware. Since gaskets tend to shrink after drying, check for loose hardware at mating surfaces.
- c. Carefully read all tags, decals, and markings on the pump assembly, and perform all duties indicated. Note the direction of rotation indicated on the pump. Check that the pump shaft rotates in the required direction.



Only operate this pump in the direction indicated on the pump body and/or the accompanying decal. Reverse rotation of the shaft will adversely effect pump performance, and the pump could be seriously damaged.

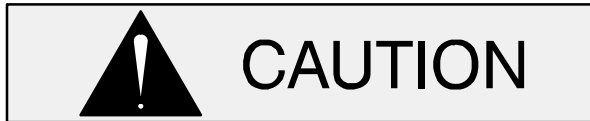
- d. Check levels and lubricate as necessary. Refer to **LUBRICATION** in the **MAINTENANCE AND REPAIR** section of this manual and perform duties as instructed.
- e. If the pump and power source have been stored for more than 12 months, some of the components or lubricants may have exceeded their maximum shelf life. These **must be inspected or replaced** to ensure maximum pump service.

If the maximum shelf life has been exceeded, or if anything appears to be abnormal, contact your Gorman-Rupp distributor or the factory to determine the repair or updating policy. **Do not** put the pump into service until appropriate action has been taken.

## POSITIONING PUMP

### Lifting

Use lifting equipment with a capacity of **at least 5 times the weight of the pump**, including the weight of options and customer installed accessories. Customer installed equipment such as suction and discharge piping and fittings **must** be removed before attempting to lift the pump.



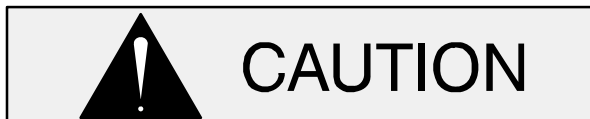
The pump assembly can be seriously damaged if the cables or chains used to lift and move the unit are improperly wrapped around the pump.

For the approximate weight of your pump, refer to the pump specification data sheet or contact your Gorman-Rupp distributor or the Gorman-Rupp Company.

### Mounting

Locate the pump in an accessible place as close as practical to the liquid being pumped. Level mounting is essential for proper operation.

The pump may have to be supported or shimmed to provide for level operation or to eliminate vibration.



When the pump is installed under unusual conditions, the priming tube(s) may vibrate abnormally. If this occurs after the pump and piping are properly secured,

contact the factory to obtain optional springs for the priming pump group grind. If the vibration is not corrected, the tubing could fatigue and rupture, spilling the liquid being pumped and resulting in a fire hazard.

## GROUNDING

To eliminate electrostatic build-up by the liquid being pumped, it is recommended that the pump be grounded by attaching a ground wire assembly to a ground rod. Install the ground rod in accordance with the National Electrical Code and all local codes. Be sure the clamp or fastener has made a tight electrical connection with the rod.



Inspect and test the ground wire assembly for conductivity. Replace broken or frayed wire before resuming operation.

## SUCTION AND DISCHARGE PIPING



Damage to the pump resulting from debris in the suction line will not be covered by the pump warranty. Before connecting the suction and discharge piping, carefully check the storage tank and piping for construction debris such as nuts, bolts, wire, weld slag, and other foreign material. Install a commercially available 80 mesh screen and a filter in the suction line to prevent debris from entering the pump.

Pump performance is adversely effected by increased suction lift, discharge elevation, and friction losses. See the performance curve and operating range shown in the Parts List manual to be sure your overall application allows the pump to operate within the safe operation range.



**Materials**

Either pipe or hose may be used for suction and discharge lines; however, the materials must be compatible with the liquid being pumped. If hose is used in suction lines, it must be the rigid-wall, reinforced type to prevent collapse under suction. Using piping couplings in suction lines is not recommended.

**Line Configuration**

Keep suction and discharge lines as straight as possible to minimize friction losses. Make minimum use of elbows and fittings, which substantially increase friction loss. If elbows are necessary, use the long-radius type to minimize friction loss.

**Connections to Pump**

Before tightening a connecting flange, align it exactly with the pump port. Never pull a pipe line into place by tightening the flange bolts and/or couplings.

Lines near the pump must be independently supported to avoid strain on the pump which could cause excessive vibration, decreased bearing life,

and increased shaft and seal wear. If hose-type lines are used, they should have adequate support to secure them when filled with liquid and under pressure.

**Gauges**

Most pumps are drilled and tapped for installing discharge pressure and vacuum suction gauges. If these gauges are desired for pumps that are not tapped, drill and tap the suction and discharge lines not less than 18 inches (457,2 mm) from the suction and discharge ports and install the lines. Installation closer to the pump may result in erratic readings.

**SUCTION LINES**

To avoid air pockets which could affect pump priming, the suction line must be as short and direct as possible. When operation involves a suction lift, the line must always slope upward to the pump from the source of the liquid being pumped; if the line slopes down to the pump at any point along the suction run, air pockets will be created.

Refer to Figure 1 for the recommended configuration of the suction line.

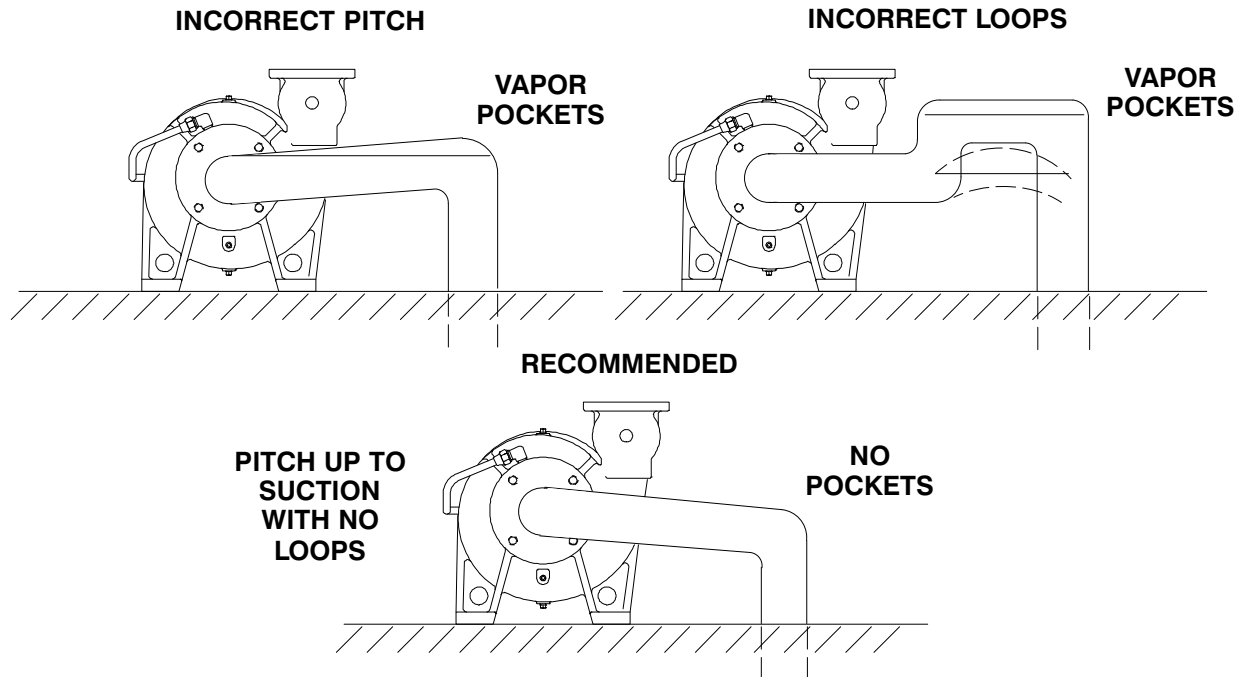


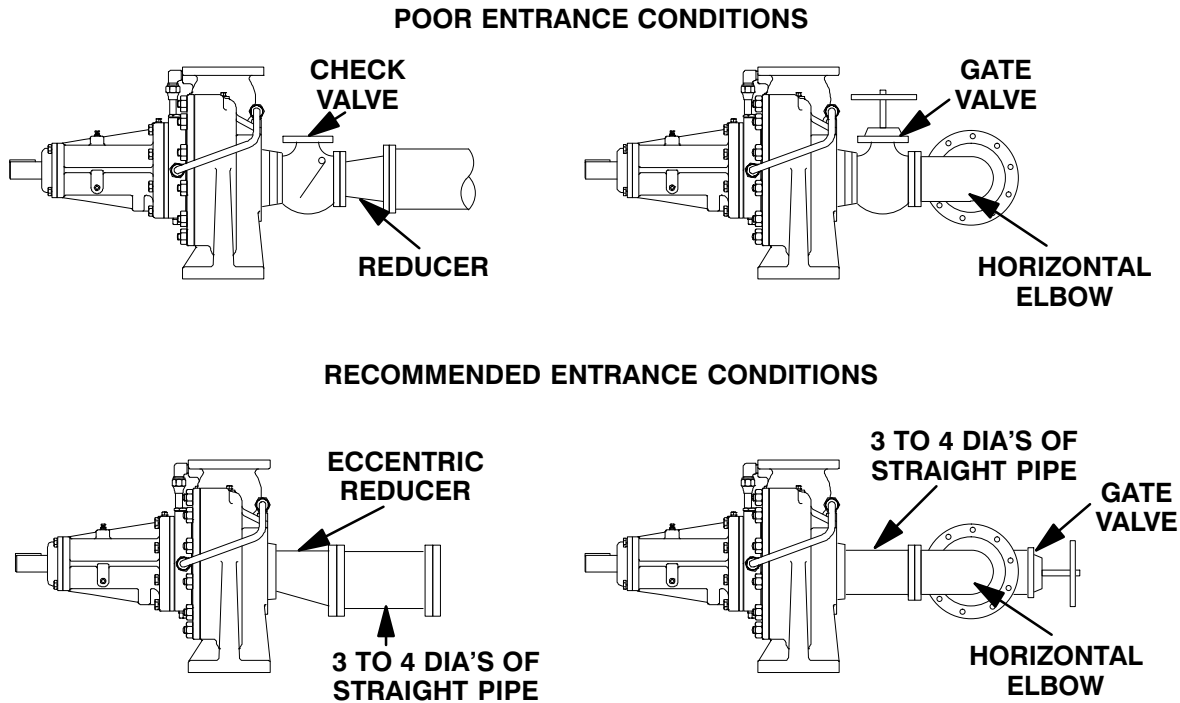
Figure 1. Suction Line Configuration

**Fittings**

Suction lines should be the same size as the pump inlet. If reducers are used in suction lines, they should be the eccentric type, and should be installed with the flat part of the reducers uppermost

to avoid creating air pockets. Valves are not normally used in suction lines, but if a valve is used, install it with the stem horizontal to avoid air pockets.

Refer to Figure 2 for the recommended entrance conditions using fittings.



**Figure 2. Entrance Conditions Using Fittings**

**Strainers**

A suction strainer was not furnished with this pump since it is **not** designed to handle liquids containing solids. However, to protect the pump from accidental damage a commercially available 80 mesh screen should be installed in the suction line. Make certain that the total open area of the screen is at least three or four times the cross section of the suction line to ensure an adequate supply of liquid to the pump.

suction and discharge piping, carefully check the storage tank and piping for construction debris such as nuts, bolts, wire, weld slag, and other foreign material. Install a commercially available 80 mesh screen and a filter in the suction line to prevent debris from entering the pump.

**Sealing**

Since even a slight leak will affect priming, head, and capacity, especially when operating with a high suction lift, all connections in the suction line should be sealed with pipe dope to ensure an airtight seal. Follow the sealant manufacturer's recommendations when selecting and applying the pipe dope. The pipe dope should be compatible with the liquid being pumped.



Damage to the pump resulting from debris in the suction line will not be covered by the pump warranty. Before connecting the

**Suction Lines In Sumps**

If a single suction line is installed in a sump, it should be positioned away from the wall of the sump at a distance equal to 1 1/2 times the diameter of the suction line.

If there is a liquid flow from an open pipe into the sump, the flow should be kept away from the suction inlet because the inflow will carry air down into the sump, and air entering the suction line will reduce pump efficiency.

If it is necessary to position inflow close to the suction inlet, install a baffle between the inflow and the suction inlet at a distance 1 1/2 times the diameter of the suction pipe. The baffle will allow entrained air to escape from the liquid before it is drawn into the suction inlet.

If two suction lines are installed in a single sump, the flow paths may interact, reducing the efficiency

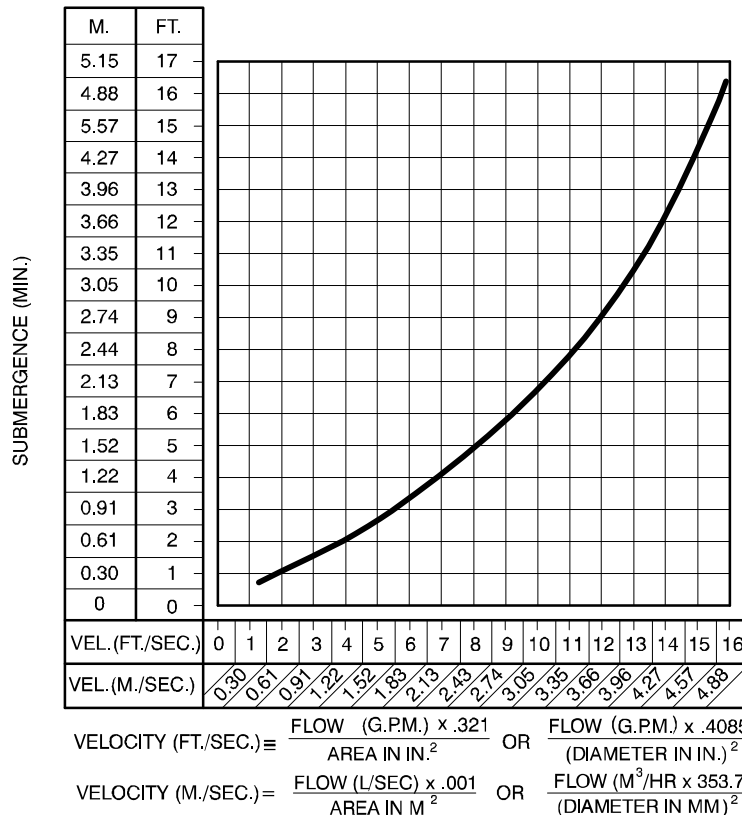
of one or both pumps. To avoid this, position the suction inlets so that they are separated by a distance equal to at least 3 times the diameter of the suction pipe.

**Suction Line Positioning**

The depth of submergence of the suction line is critical to efficient pump operation. Figure 3 shows recommended minimum submergence vs. velocity.

**NOTE**

*The pipe submergence required may be reduced by installing a standard pipe increaser fitting at the end of the suction line. The larger opening size will reduce the inlet velocity. Calculate the required submergence using the following formula based on the increased opening size (area or diameter).*



**Figure 3. Recommended Minimum Suction Line Submergence vs. Velocity**

## DISCHARGE LINES

### Siphoning

Do not terminate the discharge line at a level lower than that of the liquid being pumped unless a siphon breaker is used in the line. Otherwise, a siphoning action causing damage to the pump could result.

### Valves

Some pump models are provided with an integral priming pump check valve in the discharge port. This check valve is designed to prevent recirculation of air or vapor ejected during the priming cycle. It will **not** serve as a discharge check valve in the system piping. If the application involves static discharge head or suction pressures, a check valve **must** be installed to prevent siphoning or loss of prime through the bypass line. If a system check valve is required, it must be installed in addition to the built-in priming pump check valve.

### Priming Lines

The integral Roto-Prime™ priming pump incorporates a priming line which evacuates the suction line effectively against back pressure ranging from atmospheric pressure up to approximately 8 psi (measured downstream of the discharge check valve). If static discharge pressure exceeds 8 psi, an Air Release Valve **must** be installed to permit the escape of air or vapor to atmosphere during initial priming or repriming cycle. This valve functions in conjunction with three priming tubes installed between the Air Release Valve, the priming pump and the pump suction.

### Air Release Valves (“BAR” Models)

Some pump models are provided with an Air Release Valve. If the pump does not have an Air Release Valve, it can be ordered as optional equipment. Since internal changes are required on the pump to facilitate installation and proper function of the Air Release Valve, it is recommended that this be ordered as a **factory installed** option only.

The Air Release Valve works in conjunction with the integral priming pump to expel and prevent recirculation of air or vapor ejected during the priming cycle. The Air Release Valve will **not** serve as a throttling valve or check valve in the system piping. If the application involves static discharge head or suction pressure, system check valve **must** be installed to prevent siphoning or loss of prime through the pump.

If a throttling valve is desired in the discharge line, use a valve as large as the largest pipe to minimize friction losses. Never install a throttling valve in a suction line.

With high discharge heads, it is recommended that a throttling valve and a system check valve be installed in the discharge line to protect the pump from excessive shock pressure and reverse rotation when it is stopped.



If the application involves a high discharge head, gradually close the discharge throttling valve before stopping the pump.

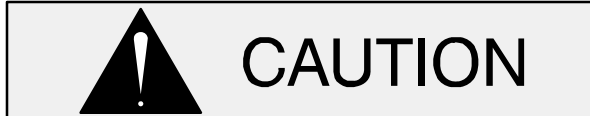
### Air Release Valve Venting (“BAR” Models)

When ordered as a factory installed option, the Air Release Valve is shipped mounted on the pump base with the valve tubing connected. If the Air Release Valve is shipped separately, refer to the installation instructions accompanying the Valve.

Remove the shipping plug in the head of the Air Release Valve so that normal operation and venting can take place. It is suggested that a length of 3/4 inch tubing be installed in the shipping plug opening so that hazardous vapors can be carried away from the immediate vicinity of the pump.

### NOTE

*When two pumps equipped with Air Release Valves are installed in parallel, a check valve must be installed in the venting lines.*



If the pump is installed within a closed building such as a pump house, venting lines to the outside of the building should be installed in accordance with National and local codes.

#### Bypass Lines (“BAR” Models)

The integral Roto-Prime™ priming pump and Air Release Valve work in conjunction with three tube assemblies. One tube assembly draws vapor from the suction flange of the centrifugal pump to the suction port of the priming pump. Another assembly discharges the vapor to the air release. The third tube assembly returns any accumulated liquid from the bottom of the cylindrical air release chamber back into the suction flange of the centrifugal pump.

### ALIGNMENT

The alignment of the pump and its power source is critical for trouble-free mechanical operation. In either a flexible coupling or V-belt driven system, the driver and pump must be mounted so that their shafts are aligned with and parallel to each other. It is imperative that alignment be checked after the pump and piping are installed, and before operation.

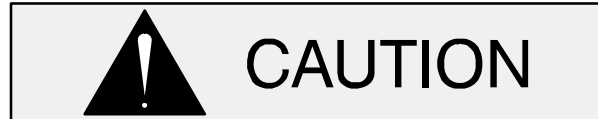
#### NOTE

Check **Rotation**, Section C, before final alignment of the pump.

When mounted at the Gorman-Rupp factory, driver and pump are aligned before shipment. Misalignment will occur in transit and handling. Pumps **must** be checked and realigned before operation. Before checking alignment, tighten the foundation bolts. The pump casing feet and/or pedestal feet, and the driver mounting bolts should also be tightly secured.



**When checking alignment, disconnect the power source to ensure that the pump will remain inoperative.**

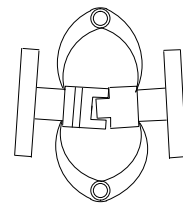


Adjusting the alignment in one direction may alter the alignment in another direction. Check each procedure after altering alignment.

#### Coupled Drives

When using couplings, the axis of the power source must be aligned to the axis of the pump shaft in both the horizontal and vertical planes. Most couplings require a specific gap or clearance between the driving and the driven shafts. Refer to the coupling manufacturer’s service literature.

Align spider insert type couplings by using calipers to measure the dimensions on the circumference of the outer ends of the coupling hub every 90 degrees. The coupling is in alignment when the hub ends are the same distance apart at all points (see Figure 4).

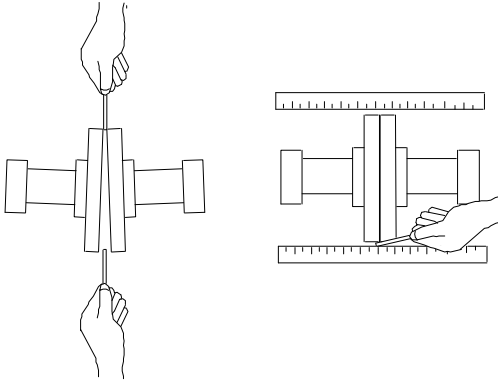


**Figure 4. Aligning Spider-Type Couplings**

Align non-spider type couplings by using a feeler gauge or taper gauge between the coupling halves every 90 degrees. The coupling is in alignment when the hubs are the same distance apart at all points (see Figure 5).

Check parallel adjustment by laying a straightedge across both coupling rims at the top, bottom, and

side. When the straightedge rests evenly on both halves of the coupling, the coupling is in horizontal parallel alignment. If the coupling is misaligned, use a feeler gauge between the coupling and the straightedge to measure the amount of misalignment.



**Figure 5. Aligning Non-Spider Type Couplings**



## WARNING!

**Do not operate the pump without the guard in place over the rotating parts. Exposed rotating parts can catch clothing, fingers, or tools, causing severe injury to personnel.**

## OPERATION – SECTION C

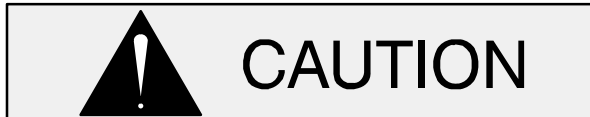
### GENERAL INFORMATION

Review all **SAFETY** information in Section A.

Follow the instructions on all tags, labels and decals attached to the pump.



This pump is designed to handle petroleum products or other similar hydrocarbon liquids. Do not attempt to pump water, corrosive materials, or any liquids which may damage the pump or endanger personnel as a result of pump failure.



This pump is **not** designed to handle water. Operation of the pump with water or water-based solutions will damage the group grind within the vane-type priming pump. **Do not** connect this pump to a storage tank which has been filled with water until the tank and lines have been completely drained and flushed. Install a commercially available 80 mesh screen and a filter in the suction line to prevent debris from entering the pump. Check pump rotation with the suction line disconnected.



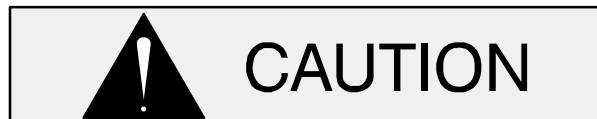
Pump speed and operating condition points must be within the continuous performance range shown on the curve (see the Parts List Manual, Page 1).

### PRIMING

Install the pump and piping as described in **INSTALLATION**. Make sure that the piping connections are tight, and that the pump is securely mounted. Check that the pump is properly lubricated (see **LUBRICATION** in **MAINTENANCE AND REPAIR**).



Never operate this pump unless there is liquid in the pump casing. The pump will not prime when dry. Extended operation of a dry pump will destroy the seal assembly.



If the pump is installed within a closed building such as a pump house, venting lines to the outside of the building should be installed in accordance with National and local codes.

#### Priming Pump

Before starting the pump for the first time, carefully remove the spring cap, gasket and pressure regulating spring located in the top of the group grind (see the parts list for identification). Pour approximately 4 ounces (0,12 liter) of SAE 10 or 20 non-detergent oil into the group grind to lubricate the shaft seal and group grind rotor blades. Reinstall the spring, gasket and cap.

Before attempting to start the motor, rotate the pump shaft by hand to ensure the oil is evenly distributed within the group grind. If the shaft does not rotate by hand, allow the pump to sit to absorb the lubricating oil and then rotate the shaft again. **Do not** start the pump motor until the shaft has been rotated by hand.

Whenever air or vapor is present in the suction line, whether at start-up or during pumping operation,

the spring located on top of the rotor forces the group grind into its maximum eccentric position to automatically evacuate the air vapor through the priming tube and into the pump discharge.



When the pump is installed under unusual conditions, the priming tube(s) may vibrate abnormally. If this occurs after the pump and piping are properly secured, contact the factory to obtain optional springs for the priming pump group grind. If vibration is not corrected, the tubing

could fatigue and spill the liquid being pumped, resulting in a fire hazard.

As air and vapor is evacuated and the main centrifugal pump begins to deliver liquid, the resulting priming pump discharge pressure builds up against the underside of the slide and moves it toward the neutral (centered) position. After all the air and vapor is removed and the centrifugal pump reaches full capacity, the priming pump discharge pressure overcomes the spring pressure on the slide and moves it towards the neutral position where it remains until air or vapor enters the system. While in the neutral position, the priming pump operates at minimum capacity and circulates only a small amount of liquid. See Figure 2 for the theory of priming pump operation.

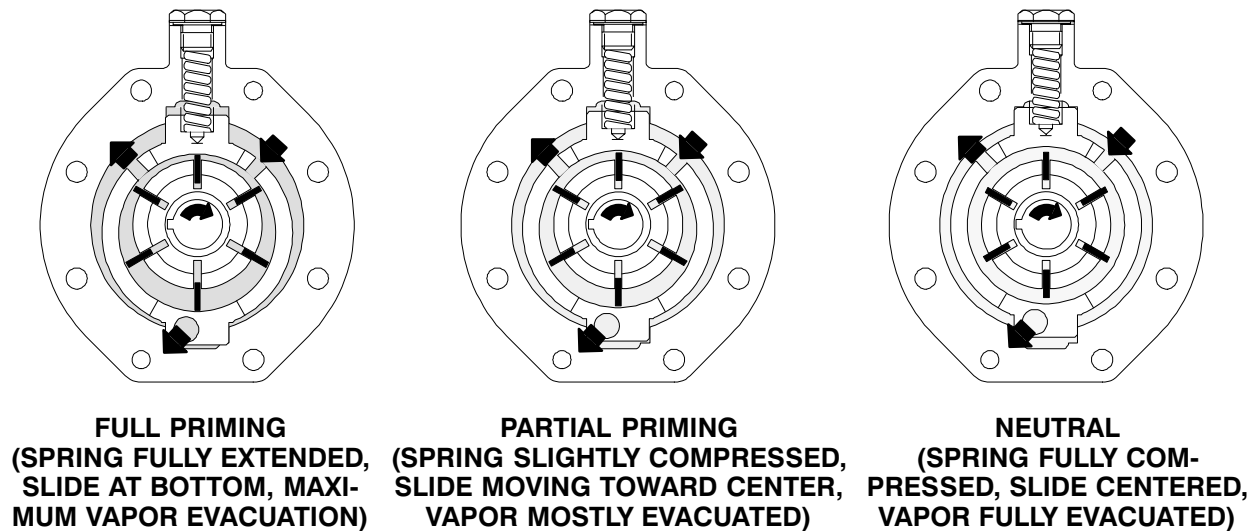


Figure 2. Automatic Priming Sequence

Priming is rapid, but not instantaneous. The priming pump will prime an absolutely dry line of four inch diameter in approximately two seconds per foot of suction pipe. Thus, if the suction line is 10 feet long, the pump will prime in approximately 20 seconds. If the pump continually handles dry liquids, such as gasoline or solvents, priming pump vane wear may result, causing a loss of priming vacuum. If priming time increases significantly over a period of time, check the priming pump vanes for excessive wear.

**NOTE**

A special seal is available for pumps which are to

handle solvents. When ordering a pump or replacement parts, specify what solvent the pump is to handle.

**Priming Pump Group Grind Check**

With the pump inoperative, remove the group grind drain plug and drain any liquid from the group grind. Remove the spring cap and pressure regulating spring. Insert a screwdriver or other suitable tool into the drain plug hole, and move the slide up and down. The slide should travel 1/8 inch (3,2 mm) from the full priming position to the neu-

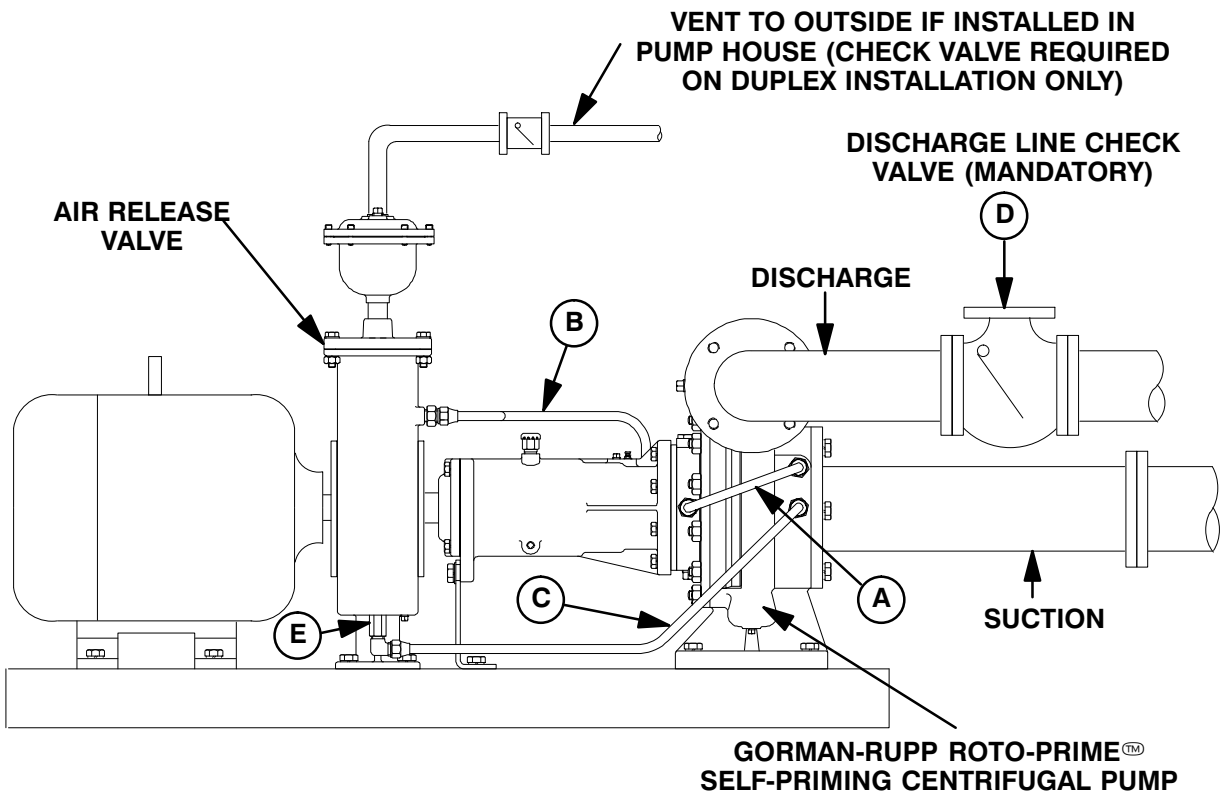


tral position. If it does not, flush the group grind with penetrating oil, and check the slide travel again. The slide should move freely. Reinstall the pressure regulating spring and spring cap, and clean and reinstall the drain plug.

**Air Release Valve (“BAR” Models)**

When properly installed, the Air Release Valve al-

lows the integral Roto-Prime™ priming pump to overcome relatively high static discharge heads or back pressure during the priming cycle. Figure 1 shows a schematic configuration of the valve and is keyed to the following description of operation.



**Figure 1. Gorman–Rupp Air Release Valve Connected To Roto–Prime™ Pump**

The Air Release Valve is designed with an air valve in the head of the assembly and a sump valve in the base of the assembly. These valves are controlled by a common rod which is moved vertically by an attached float.

When the pump is first installed, there is air in the suction line, the Air Release Valve is open, and there is back pressure against the discharge line check valve “D”.

When the pump is started, air is drawn from the suction line into the priming pump through the priming tube “A”, compressed by the priming

pump, and discharged through the discharge tube “B” to the Air Release Valve. This air and vapor is then vented to the atmosphere through the valve head.

With the float down, sump valve “E” is closed; air cannot re-enter the suction piping through the return tube assembly “C”.

As product fills the pump casing, the impeller develops pressure, opening check valve “D” in the discharge piping. The priming pump will deliver product, filling the float chamber. The float will rise, opening sump valve “E”, and closing the air valve.

The product recirculates through the return tube assembly “C” to the pump suction flange. The liquid pressure equalizes the priming pump spring pressure and the priming pump slides into neutral. At this point the pump is fully primed.

In neutral position the priming pump circulates a small amount of liquid through the discharge tube to the float chamber through the return tube and back into the suction flange.

If air or vapor enters the suction piping during the pumping operation, again the discharge line check valve will close, and the priming pump will again evacuate the air through the Air Release Valve.

## STARTING

Consult the operations manual furnished with the power source.

Before connecting a motor to the incoming power, check that the electrical service available matches the pump motor requirements stamped on the motor nameplate. Check that the motor speed meets pump specifications. The pump is designed to be driven at a maximum full load speed of either 1750 RPM (RS Series) or 3450 RPM (RD Series).

### Rotation

The correct direction of pump rotation is indicated by an arrow on the pump body or accompanying decals. The pump could be damaged and performance adversely affected by incorrect rotation. If pump performance is not within the specified limits (see the curve in the Parts List Manual on page 1), check the direction of rotation before further troubleshooting.

Consult the operating manual furnished with the power source before attempting to start the power source.

If an electric motor is used to drive the pump, remove V-belts, couplings, or otherwise disconnect the pump from the motor before checking motor rotation. Operate the motor independently while

observing the direction of the motor shaft, or cooling fan.

If rotation is incorrect on a three-phase motor, have a qualified electrician interchange any two of the three phase wires to change direction. If rotation is incorrect on a single-phase motor, consult the literature supplied with the motor for specific instructions.

## OPERATION

### Leakage

No leakage should be visible at pump mating surfaces, or at pump connections or fittings. Keep all line connections and fittings tight to maintain maximum pump efficiency.

### Liquid Temperature And Overheating

The **maximum** liquid temperature for this pump is 160°F (71°C). Do not apply it at a higher operating temperature.

Overheating can occur if operated with the valves in the suction or discharge lines closed. Operating against closed valves could bring the liquid to a boil, build pressure, and cause the pump to rupture or explode. If overheating occurs, stop the pump and allow it to cool before servicing it. Refill the pump casing with cool liquid.



**Allow an over-heated pump to completely cool before servicing. Do not remove plates, covers, gauges, or fittings from an over-heated pump. Liquid within the pump can reach boiling temperatures, and vapor pressure within the pump can cause parts being disengaged to be ejected with great force. After the pump cools, drain the liquid from the pump by removing the casing drain plug. Use caution when removing the plug to prevent injury to personnel from hot liquid.**

### Strainer Check

A suction strainer was not furnished with this pump but an 80 mesh screen may have been installed by the user. Check the screen regularly, and clean it as necessary. The screen should also be checked if pump flow rate begins to drop. If a vacuum suction gauge has been installed, monitor and record the readings regularly to detect screen blockage.

### Pump Vacuum Check

#### NOTE

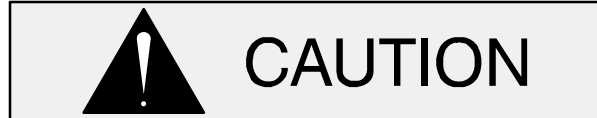
*Petroleum products are very sensitive to changes in temperature. Warmer temperatures elevate the product vapor pressure resulting in low vacuum readings. Do not mistake temperature problems for faulty pump installation or performance.*

With the pump inoperative, install a vacuum gauge in the system, using pipe dope on the threads. Block the suction line and start the pump. At operating speed the pump should pull a vacuum of 15 to 17 inches (381 to 432 mm) or more of mercury for petroleum. If it does not, check for air leaks in the seal, gasket, or discharge valve.

Open the suction line, and read the vacuum gauge with the pump primed and at operation speed. Shut off the pump. The vacuum gauge reading will immediately drop proportionate to static suction lift, and should then stabilize. If the vacuum reading falls off rapidly after stabilization, an air leak exists. Before checking for the source of the leak, check the point of installation of the vacuum gauge.

### STOPPING

Never halt the flow of liquid suddenly. If the liquid being pumped is stopped abruptly, damaging shock waves can be transmitted to the pump and piping system. Close all connecting valves slowly.



If the application involves a high discharge head, gradually close the discharge throttling valve before stopping the pump.

After stopping the pump, shut off the incoming power and lock it out, or take other action to ensure that the pump will remain inoperative.

### Cold Weather Preservation

Since the application of this pump is limited to petroleum products, normal freezing conditions will not damage the pump. However, during extremely severe conditions care should be exercised during start-up, especially if the pump has been idle for more than a few hours.

### BEARING TEMPERATURE CHECK

The standard bearings used in this pump are permanently sealed and lubricated by the manufacturer. However due to temperature changes and the danger of moisture contamination, the bearing cavity is also partially filled with grease.

Optional oil lubricated bearings are not fully sealed, and oil is required within the bearing housing to lubricate them and protect them from moisture condensation.



Monitor the condition of the bearing lubricant regularly for evidence of rust or moisture condensation. This is especially important in areas where variable hot and cold temperatures are common.

Bearings normally run at higher than ambient temperatures because of heat generated by friction. Temperatures up to 160°F (71°C) are considered normal for bearings, and they can operate safely to at least 180°F (82°C).

Checking bearing temperatures by hand is inaccurate. Bearing temperatures can be measured accurately by placing a contact-type thermometer against the housing. Record this temperature for future reference.

A sudden increase in bearing temperatures is a warning that the bearings are at the point of failing to operate properly. Make certain that the bearing

lubricant is of the proper viscosity and at the correct level (see **LUBRICATION** in Section E). Bearing overheating can also be caused by shaft misalignment and/or excessive vibration.

When pumps are first started, the bearings may seem to run at temperatures above normal. Continued operation should bring the temperatures down to normal levels.

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