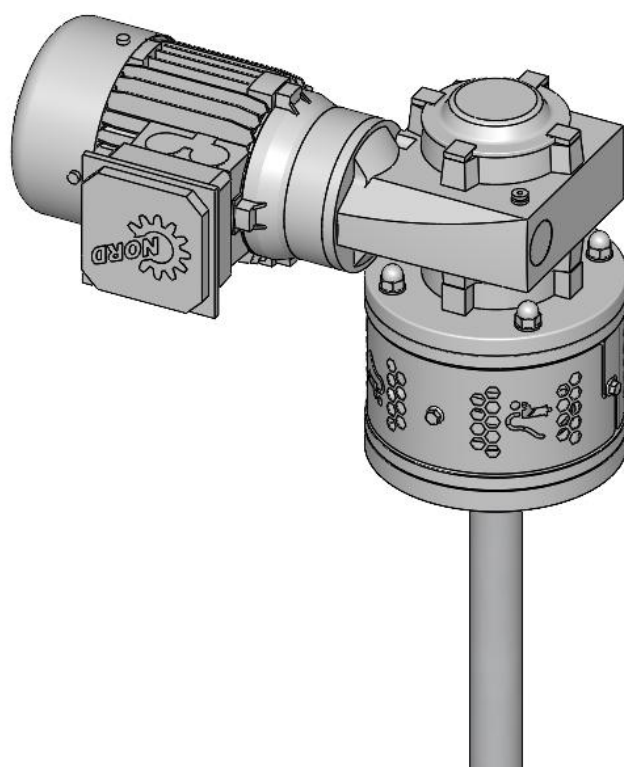


VERTICAL AGITATOR CNC



20.068.32.0001



INOXPA S.A.U.

Telers, 60

17820 - Banyoles (Spain)

hereby declare under our sole responsibility that the

Machine: **VERTICAL AGITATOR**

Model: **CNC**

Serial number: **IXXXXXXXXXX to IXXXXXXXXXX**
XXXXXXXXXXIINXXX to XXXXXXXXXXXXIINXXX

fulfils all the relevant provisions of the following directive:

Machinery Directive 2006/42/EC

Directive 2011/65/EU on the restriction of the use of certain hazardous substances in electrical and electronic equipment

Regulation (EC) n° 1935/2004

Regulation (EC) n° 2023/2006

and with the following harmonized standards:

EN ISO 12100:2010

EN 60204-1:2018

EN ISO 14159:2008

EN 1672-2:2005+A1:2009¹

EN ISO 13857:2019

EN IEC 63000:2018

The technical file has been prepared by the signer of this document.



David Reyero Brunet

Technical Office Manager

25th May 2024



Document: 20.068.30.04EN

Revision: (0) 2024/06

INOXPA S.A.U.

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Machine: **VERTICAL AGITATOR**

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XXXXXXXXXXIINXXX to XXXXXXXXXXXXIINXXX

fulfils all the relevant provisions of these regulations:

Supply of Machinery (Safety) Regulations 2008
The Restriction of the Use of Certain Hazardous Substances in
Electrical and Electronic Equipment Regulations 2012 (as amended)

and with the following designated standards:

EN ISO 12100:2010
EN 60204-1:2018
EN ISO 14159:2008
EN 1672-2:2005+A1:2009
EN ISO 13857:2019
EN IEC 63000:2018

The technical file has been prepared by the signer of this document.



David Reyero Brunet
Technical Office Manager
25th May 2024

UK
CA

Document: 20.068.30.05EN

Revision: (0) 2024/06

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1. Table of Contents

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2. Generalities

2.1. INSTRUCTIONS MANUAL

This manual contains information about the reception, installation, operation, assembly, disassembly, and maintenance of the CNC vertical agitator.

Carefully read the instruction prior to starting the agitator, familiarize yourself with the installation, operation and correct use of the agitator and strictly follow the instructions. These instructions should be kept in a safe location near the installation area.

The information published in the instruction manual is based on updated data.

INOXPA reserves the right to modify this instruction manual without prior notice.

2.2. COMPLIANCE WITH THE INSTRUCTIONS

Not following the instructions may impose a risk for the operators, the environment and the machine, and may result in the loss of the right to claim damages.

This non-compliance may result in the following risks:

- failure of important machine/plant functions,
- failure of specific maintenance and repair procedures,
- possible electrical, mechanical and chemical hazards,
- risk to the environment due to the type of substances released.

2.3. WARRANTY

The conditions of the warranty are specified in the General Sales Condition that has been delivered at the time of placing your order:



The machine may not undergo any modification without prior approval from the manufacturer.

For your safety, only use original spare parts and accessories. The usage of other parts will relieve the manufacturer of any liability.

Changing the service conditions can only be carried out with prior written authorization from INOXPA.

The non-compliance of the prescribed indications in this manual means misuse of this gear on the technical side and the personal safety and this, exempt INOXPA of all responsibility in case of accidents and personal injuries and/or property damage. Also, excluded from the warranty all breakdowns caused by improper use of the gear.

Please do not hesitate to contact us in case of doubts or if further explanations are required regarding specific data (adjustments, assembly, disassembly, etc.).

3. Safety

3.1. WARNING SYMBOLS



Safety hazard for people in general and/or for equipment



Electric hazard

ATTENTION

Important instruction to prevent damage to the equipment and its functions

3.2. GENERAL SAFETY INSTRUCTIONS



Read the instruction manual carefully before installing and starting the agitator. Contact INOXPA in case of doubt.

3.2.1. DURING THE INSTALLATION

The [Technical Specifications](#) of [chapter 9](#) should always be observed.

The installation and use of the agitator should always be in accordance with applicable regulations regarding health and safety.



Before starting up the agitator, check that it is properly anchored and its shaft is perfectly aligned. Incorrect alignment and/or excessive stress during coupling can cause serious mechanical problems in the agitator.

Take all possible precautions when lifting the agitator. Always use properly attached slings when moving the agitator with a crane or other lifting device.

Keep the motor and the switchboard under control, particularly in areas where there is a risk of fire or explosion.



When cleaning, do not spray directly on the engine.

Do not disassemble the agitator until the switchboard has been disconnected. Remove the fuses and disconnect the power cable supplying the motor.

All electric work should be carried out by specialised personnel.

3.2.2. DURING OPERATION



The [Technical Specifications](#) of [chapter 9](#) should always be observed. Under no circumstances can the specified limit values be exceeded.

Before starting up the agitator, remove all the tools used during the assembly.

Do not operate the agitator when the rotating parts are not equipped with their guards or are not properly assembled.



The agitator has rotating parts. Do not place hands or fingers in the agitator while it is operating. This may cause serious injuries.

Do not touch the parts of the agitator that are in contact with the fluid when in operation. When the agitator operates with hot fluids (temperatures above 50°C), there is a risk of skin burning. In such cases, collective-protection means (in this order or priority: separation, protective screen, heat-insulating material) or, in the absence of this, individual protection gear (gloves) must be used.



The agitator and its installation can generate sound levels above 85 dB(A) under unfavourable operating conditions. In such cases, the operators must use devices for protection against noise.

3.2.3. DURING MAINTENANCE



The [Technical Specifications](#) of [chapter 9](#) shall always be observed.

The agitator cannot operate without fluid. Standard agitators are not designed to work during the filling or emptying of tanks.

The maximum operating conditions of the agitator should not be exceeded. Nor should the operating parameters for which the agitator was initially designed be modified without written authorisations from INOXPA.



Do not leave loose parts on the floor.

Do not disassemble the agitator until the switchboard has been disconnected. Remove the fuses and disconnect the power cable supplying the motor.

All the electric work should be carried out by specialised personnel.

4. General Information

4.1. DESCRIPTION

The CNC series comprises a range of sanitary vertical agitators with a worn gear motor, with a service factor able to withstand the radial and axial forces & thrust load from the agitator element. The lantern connected to the tank has a base plate made of stainless steel.

This range includes a sealing system with a mechanical seal and dry-running.

All the parts that come into contact with the product are made of stainless steel, AISI 316L (1.4404).

4.2. PRINCIPLE OF OPERATION

The propeller/anchor is designed for a broad range of viscosities. It can be used in mixing, dissolving and homogenization processes.

Scrapers can be incorporated for products that are likely to adhere to the tank's walls. In double-walled tanks, the scrapers also help transfer heat to the product.

4.3. APPLICATION

Depending on the selected agitation element, this range can be used to carry agitation and mixing processes in closed tanks with a variable viscosity according to the working conditions.

These agitators are suitable for industries as foodstuffs, dairy or pharma.



Each agitator has performance limits. The agitator was selected for a given set of mixing conditions when the order was placed. INOXPA shall not be held responsible for any damage that might be suffered or malfunctioning of the equipment if the information provided by the buyer is incomplete or incorrect. (e.g. nature of the fluids or installation details).

5. Installation

5.1. RECEPTION OF THE AGITATOR

- 

INOXPA is not liable for any deterioration of the material caused by its transport or unpacking. Visually check that the packaging has not been damaged.
- 

If the agitator is supplied without a drive or other element, the purchaser shall be responsible for its assembly, installation, start-up and operation.

When receiving the agitator, check the packaging and its content to ensure that it matches the delivery note. INOXPA packs the agitators in their fully assembled form or disassembled on a case-by-case basis. Ensure that the agitator has not been damaged in any way. If it is not in good condition and/or any parts are missing, the carrier must submit a report as soon as possible.

The following documentation is included with the agitator:

- shipping documents,
- quick installation guide or instruction manual,
- instructions and servicing manual for the gear-motor when the agitator is supplied with a motor by INOXPA.

5.2. IDENTIFICATION OF THE AGITATOR

The agitator is identified using a rating plate fixed onto the motor. The type of agitator and the serial number appear on the nameplate.

 		
INOXPA S.A.U. C. TELERS, 60 - 17820 BANYOLES GIRONA (SPAIN) . www.inoxpa.com		
Type		
Serial	Year	

01.011.32.0047

For example:

CNC	1.	11	-	069	07	-	400
							Diameter of the agitation element
							400 400 mm
							600 600 mm
							800 800 mm
							Motor power
							07 0,75 kW
							15 1,5 kW
							22 2,2 kW
							Motor speed
							036 36 n-1
							069 69 n-1
							138 138 n-1
							Type of agitation elements
							19 High flow propeller type
							16 Gamma propeller type
							11 4 pitched blades propeller type
							1R Anchor type with scrapers
							Number of agitation elements
							1 One agitation element
							2 Two agitation elements
Name of the agitator							
CNC Vertical agitator with mechanical seal							

5.3. TRANSPORT AND STORAGE



ATTENTION

According to the model, the agitators are too heavy to be stored or installed manually. Use an appropriate mode of transport. Do not handle the agitator by the shaft as this may become deformed.



ATTENTION

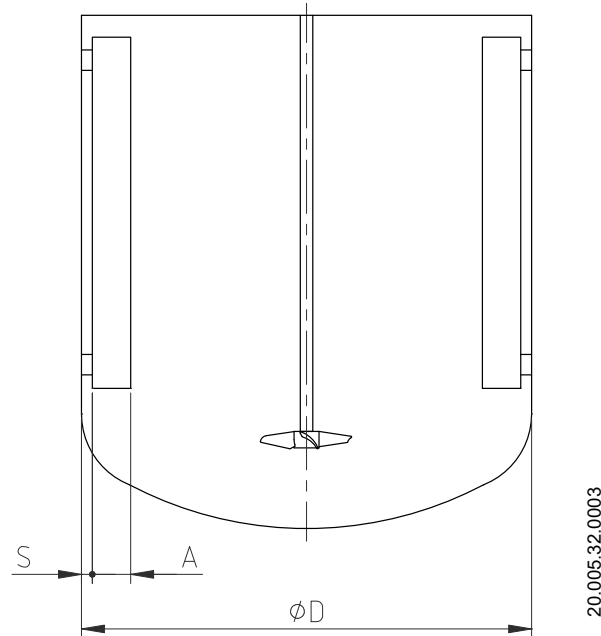
Take all possible precautions when lifting the agitator. Always use properly attached slings when moving the agitator with a crane or other lifting device.

If the agitator is not to be installed immediately, it must be stored in an appropriate place. The shaft must be stored in a horizontal position and placed on wooden supports or for a similar material. In this position, the shaft will not become deformed but it must not be subject to any type of load.

5.4. LOCATION

Place the agitator in such a way as to facilitate inspections and checks. Leave enough room around the agitator for service, disassembly, and maintenance operations. It is very important to be able to access the electric connection device of the agitator, even when in operation.

For a good agitation process, it may be necessary to place a deflector in the tank. Ask our Technical Department for information on any particular application. If required, the approximate dimensions for the deflector for different tank diameter are shown in the next figure and the next table:



Ø D	300	400	500	600	800	1000	1200	1600	2000	2500	3000	3500	4000
A	20	30	35	40	50	70	80	115	130	180	200	240	280
S	5	5	10	10	10	15	20	20	30	30	50	50	50



If the agitator operates in an open tank, the safe distances of the moving parts should be in accordance with ISO 13857:2019.

5.4.1. ELECTRICAL INSTALLATION

Before connecting the electrical motor to the mains, check local regulations on electrical safety as well as the applicable standards.

Check the instructions manual of the manufacturer of the motor for information on how to connect it to the mains.



Take the connection of the electrical motors must be performed by qualified personnel.
Take the appropriate measures to prevent any fault.
The motor must be provided with devices for protection against power overload and short-circuits.
The agitator cannot be used in areas where there is a risk of fire or explosion when this has not been specified in the order.

5.5. ASSEMBLY

To locate and fix the agitator in the support flange of the tank, the propeller must be removed from the shaft. Once the base of the agitator is placed on the supporting flange, the fixing nuts and screws will be assembled in their corresponding holes, without being tightened. When this operation has been carried out, the agitator must be levelled using the following method:

1. Place a spirit level against the shaft.
2. Check 4 points at 90° to each other around the circumference of the shaft and at the same height.
3. Once the shaft is level, firmly tighten the fixing nuts and screws. Finally, the propeller is mounted on the end of the shaft. Be careful when assembling the shaft not to hit or strain it so as to avoid it being bent.

ATTENTION

Force should never be applied to the end of the agitator shaft, as it can easily suffer permanent damage.

ATTENTION

Check the alignment of the agitator shaft with the half shaft once its assembly is completed.

6. Start-up



The start-up of the agitator can be carried out provided the instructions indicated in the chapter 5. [Installation](#) have been followed.

Never touch pipes or the agitator when hot fluids are circulating.

Do not operate the agitator when the rotating parts are not equipped with their guards or are not properly assembled.

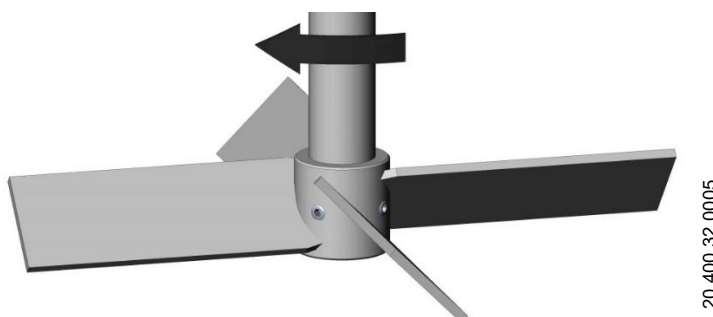
- Check that the power supply matches the rating indicated on the motor plate.
- Check the alignment of the agitator shaft.
- Check the level of fluid in the tank. When not specified in the order, the agitator cannot be operated during the filling or emptying of the tank.
- Check that the mechanical seal is ready for correct operation, in accordance with the assembly specifications found in the seal manual.



ATTENTION

The agitator can NEVER operate without fluid. The agitation elements may only be submerged to a height equal to 1,5 times its diameter.

- All the guards must be in place.
- Start up the agitator.
- Check that the direction of rotation of the propellers is correct (it must rotate clockwise when seen from the drive side). See the next figure:



Follow the direction of rotation of the agitation components as indicated by the arrow attached to the engine. An incorrect direction of rotations results in a loss of agitation performance.

- Check the electrical consumption of the motor.

ATTENTION



Do not modify the operating parameters for which the agitator was initially designed without written authorisation from INOXPA (risk of damage and user hazard).

Follow the instructions for use and the safety requirements described in the instructions manual for the tank in which the agitator is mounted.

Mechanical risks (e.g. drag, shear, cutting, impact, flattening and pinching). If the agitation element is accessible from the top or the tank inspections hatch, then the user will be exposed to the above-mentioned risks.

The tank must be fitted with protective devices and safety equipment. Consult the manufacturer's instructions manual.

ATTENTION



Introducing an object or solid raw material may cause the agitation component and other mechanical parts to break and compromise its safety or guarantee.



Do not open the tank while the agitator is in operation.

7. Troubleshooting

The attached table lists solutions to problems that may arise while operating the agitator. It is assumed that the agitator has been properly installed and that it has been selected correctly for the specific application. Contact INOXPA if technical assistance is required.

Motor overload					
↓ • • • • • • • • •	Insufficient agitation				
	↓ • • • • • • • •	Vibrations and noise			
		↓ • • • • • • • • •	Leaks		
			↓	PROBABLE CAUSES	SOLUTIONS
				Viscosity of the liquid too high	Reduce the viscosity, e.g. by heating the liquid
				High density	Increase motor power
				Tank too big for the chosen agitator	Check with the technical department
				Wrong direction of rotation	Change direction of rotation
				Agitator speed too low	Increase the speed
				Liquid level insufficient or none	Check liquid level in the tank
Shaft bended	Replace the shaft				
Critical speed	Check with the technical department				
Worn bearings	Replace the bearings agitator				
Mechanical or lip seal worn or damaged	If the seal is worn, replace it. If the seal is damaged, consult the technical department.				
Damaged O-ring	Check with the technical department				



If the problems persist stop using the agitator immediately. Contact the agitator manufacturer or the representative.

8. Maintenance

8.1. GENERAL CONSIDERATIONS

This agitator, just like any other machine, requires maintenance. The instructions contained in this manual cover the identification and replacement of spare parts. The instructions are aimed at maintenance personnel and those responsible for the supply of spare parts.

Carefully read chapter 9. [Technical Specifications](#).



Maintenance work can only be carried out by qualified personnel that are trained and equipped with the necessary resources to carrying out this work.

Before beginning maintenance work, ensure that the electric motor is disconnected and that the tank is empty.

All parts or materials that are replaced must be properly disposed of/recycled in accordance with the current directives applicable in each area.



Before beginning maintenance work, ensure that the agitator is disconnected.

8.2. MAINTENANCE

- Inspect the agitator regularly.
- Do not fail to keep the agitator clean.
- Check the state of the motor or the gear motor.
- Check the state of the bearings.
- Check the sealing: seal and/or lip seal.

Motor or gear motor maintenance shall be carried out in accordance with the manufacturer's instructions, see the instructions manual.

8.3. LUBRICATION

Follow the manufacturer's indications when lubricating the geared motor's bearings.

8.4. SPARE PARTS

To order spare parts it is necessary to indicate the type and serial number included on the agitator's characteristics plate, as well as the position and description of the part as found in chapter 9. [Technical Specifications](#).

8.5. CONSERVATION

If the agitator is out of service for a considerable period of time, clean and treat the parts with VG46 mineral oil. The shaft must be stored in the horizontal position and on wooden supports or on supports of a similar material.

8.6. DISASSEMBLY AND ASSEMBLY OF THE AGITATOR



The disassembly and assembly of the agitators should only be carried out by qualified personnel using only appropriate tools. Ensure that staff read these instructions manual attentively, particularly the instructions that relate to their work.



Stop the motor from starting up when carrying out assembly and disassembly work on the agitator.
Place the agitator switch in the “off” position.
Lock out the electrical switchboard or place a warning sign.
Remove the fuses and take them to the workplace.

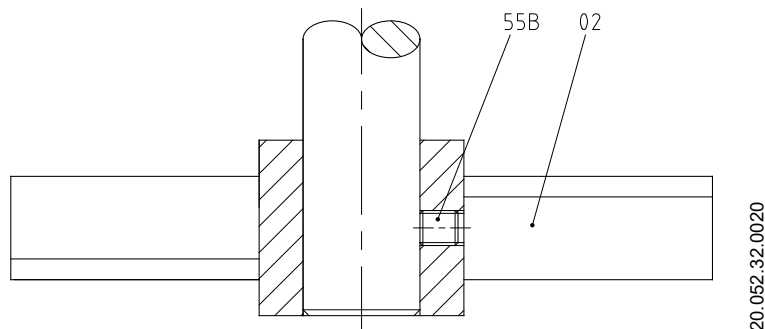
8.6.1. DISASSEMBLY OF THE AGITATOR

Once the motor has been disconnected, disassembly work of the agitator may begin:

- Disassembly the propeller or the propellers if available.
- If there are scrapers disassembly them.
- Removing the agitator head assembly.

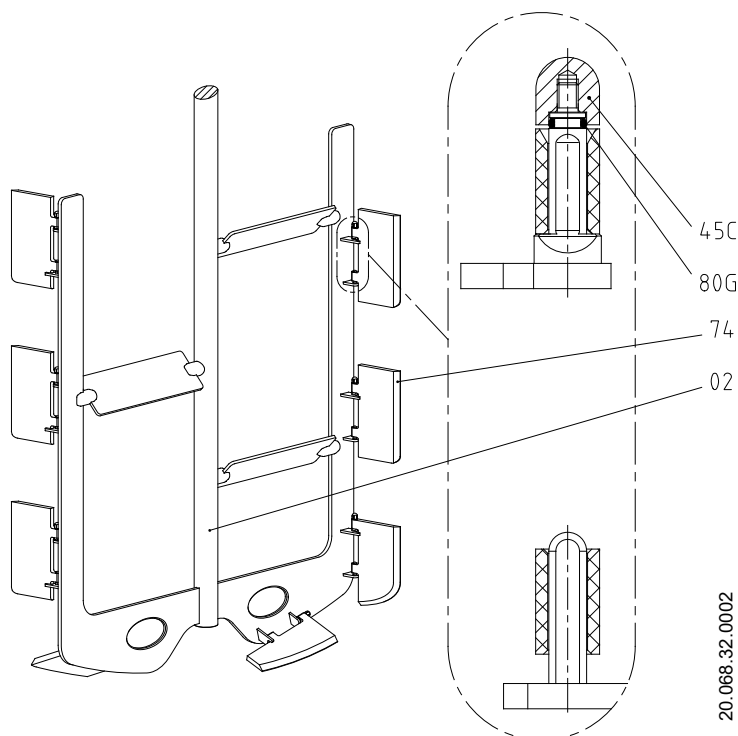
8.6.1.1. DISASSEMBLY OF THE PROPELLER

- Empty the tank.
- Remove the propeller (02) from inside the tank if attached to the shaft using set screws (55). If the propeller is welded and the manhole is large enough remove it with the shaft. Otherwise, disassembly the agitator without removing the shaft (05) from the tank.



8.6.1.2. DISASSEMBLY OF THE SCRAPERS

- Disassembly the scrapers (74A, 74B, 74C, etc.) by removing the blind nuts (45C) and O-ring (80G).



8.6.1.3. DISASSEMBLY OF THE HEAD OF THE AGITATOR

ATTENTION



The agitator following disassembly instructions will be carried out in the tank. Place the shaft (05) of the agitator inside the tank holding it with a soft base.

Head of the agitator with mechanical seal:

- Remove the lantern protectors (47) by removing the screws (50).
- Take out the stud (12) on the rotating part of the mechanical seal (08) (See Figure 8.1 or 8.2)
- Remove screw (50B) and washer (17) which fix the shaft (05) to the gear motor (93).
- With the help of slings, carefully lift the gear motor (93) in an upright position in order to separate it from the shaft (05), removing first the hexagonal screws (52), washers (53) and nuts (54), securing it to the lantern (04). Make sure not to knock or damage the mechanical seal while carrying out this procedure.
- Pull out the key (61) from the shaft (05).
- Remove the rotating part of the mechanical seal (08) to the shaft (05).
- Remove the lantern assembly (04) from the shaft (05) from the top side.
- Separate the lantern (04), to the base plate (42), by removing the screws (50A).
- Remove the seal cover (09) and seal counter cover (11) by removing the hexagonal screws (52C) and washers (53C) that secure it to the base plate (42).
- Extract the stationary part of the mechanical seal (08) from the base plate (42), taking care not to damage it.
- Extract the O-ring (80) from the seal counter cover (09), taking care not to damage it.

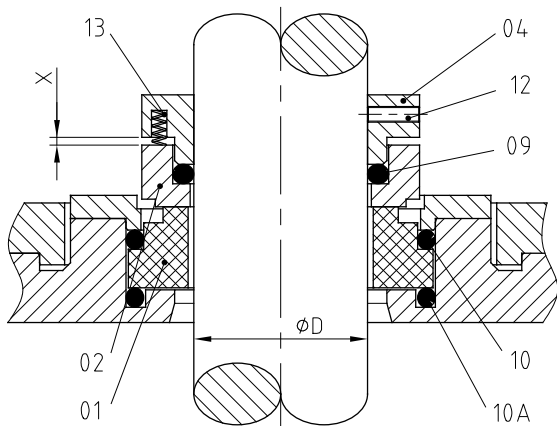


Figure 8.1 Dimensions EDV mechanical seal.

Diameter	Dimension X
D < 80 mm	2 mm
D ≥ 80 mm	3 mm

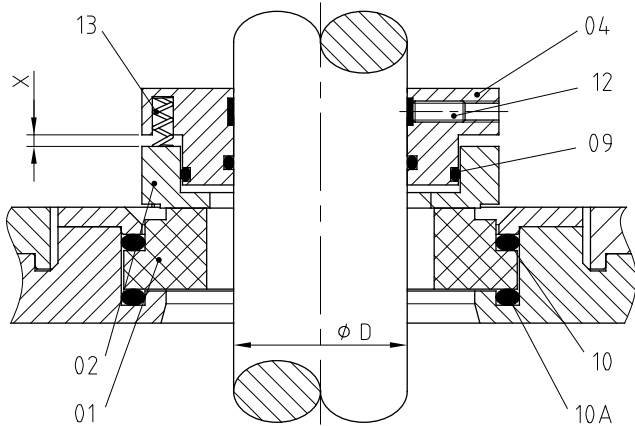
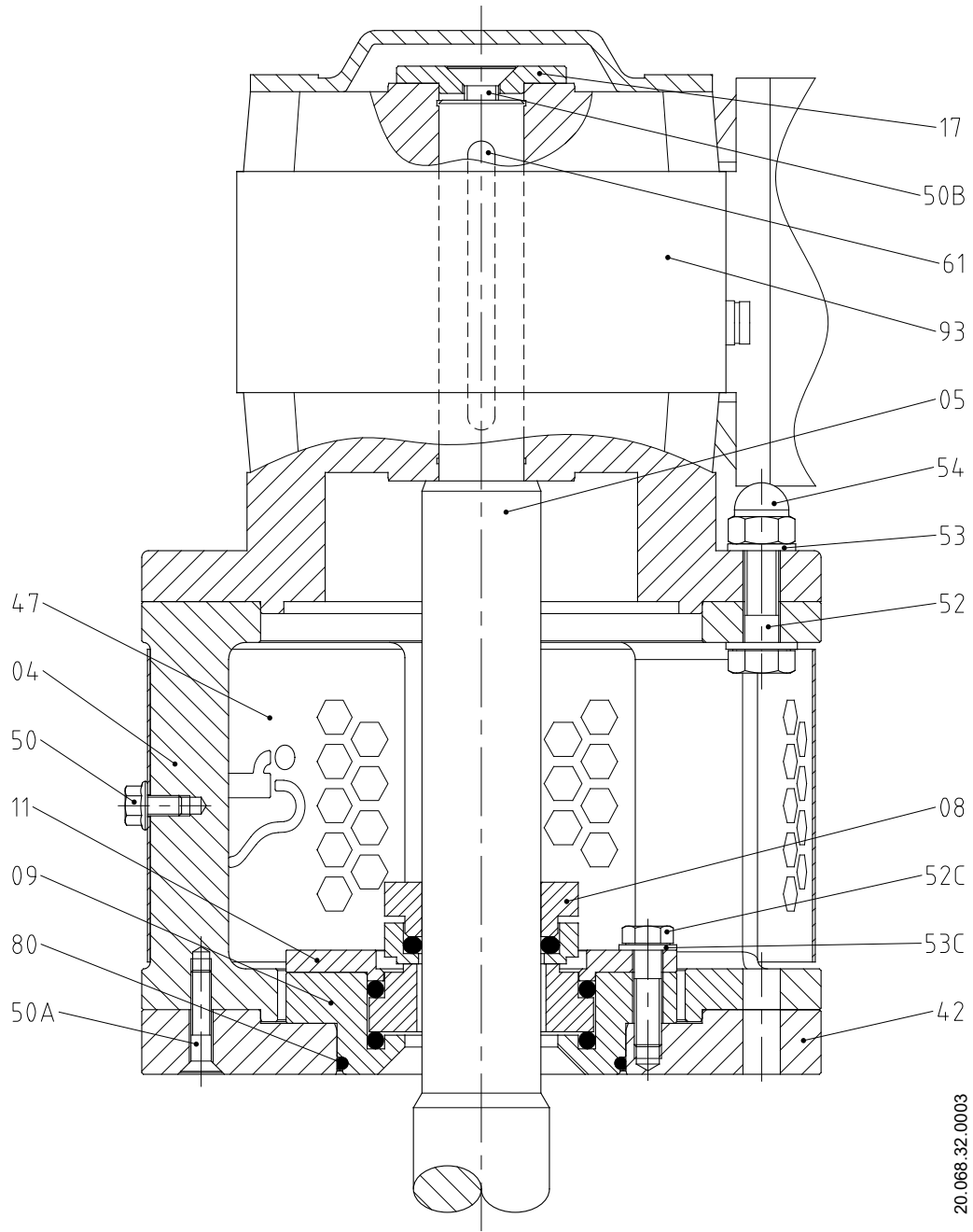


Figure 8.2 Dimensions GTED mechanical seal.

Diameter	Dimension X
D < 65 mm	2 mm
D ≥ 65 mm	3 mm



8.6.2. ASSEMBLY OF THE AGITATOR

The assembly of the agitator must be realized by following order:

- Assembly of the head of the agitator
- If applicable, assembly of the scrapers
- Assembly of the propeller/anchor
- Connect the motor to electrical network

8.6.2.1. ASSEMBLY OF THE HEAD OF THE AGITATOR



The agitator will be mounting the head unit directly on the flange of the tank. Place the shaft (05) of the agitator inside the tank holding it with a soft base in a way that bulge out from the flange of the tank.

Head of the agitator with mechanical seal:

- Place the shaft (05) in an upright position in a suitable location.
- Fit the O-ring (80) in her place to the seal cover (09).
- Fit the stationary part of the mechanical seal (08) on the seal cover (09) secure it seal counter cover (11) on the base plate (42), fix it with the hexagonal screws (52C) and the washers (53C).
- Now mount the lantern (04) on the base plate assembly (42) and secure it using the screws (50A).
- Install this assembly on the shaft (05). Make sure not to knock or damage the seat of the mechanical seal (08) while carrying out this procedure.
- Wet the shaft (05) area where the rotating part of the mechanical seal (08) will be fitted with glycerin or liquid soap compatible with the seal material.
- Then mount the rotating part of the mechanical seal (08) on the shaft (05), pushing it until the seal face makes contact with the stationary part of the seal. Do not fully tighten the stud (12) yet. [\(See Figure 8.1 or 8.2\)](#)
- Place the key (61) on the shaft (05).
- With the help of slings, mount the gear motor (93) in an upright position on the lantern (04) and secure it with the screw (52), washers (53) and nuts (54), then attach and secure the shaft (05) to the gear motor (93) using the screw (50B) and washer (17).
- Check the mounting position of the rotating part of the seal (08) at 3 points with a feeler gauge and tighten the stud (12) in accordance with the assembly specifications. [\(See Figure 8.1 or 8.2\)](#)
- Install the lantern protectors (47) to the lantern (04), using the screws (50) for fix it.
- Them secure it with the corresponding screws on the tank flange.

8.6.2.2. ASSEMBLY OF THE SCRAPERS

- Access inside the tank and mount the scrapers (74A, 74B, 74C, etc.) fit the O-ring (80G) on support scraper and fixing the assembly with nut (45C).

8.6.2.3. ASSEMBLY OF THE PROPELLER

- Access inside the tank and mount the propeller on the shaft (02) with the studs (55B).

9. Technical Specifications

9.1. MATERIALS

Parts in contact with the product	AISI 316L
Other steel parts	AISI 304L
Surface finish	Ra ≤ 0,8 µm (*)

9.2. MECHANICAL SEAL

Type seal	Simple mechanical seal
Material stationary part	Silicon
Material rotary part	Graphite
O-ring	EPDM FDA (*)

9.3. OTHER FEATURES

Motor	IEC B5 – B14 IP 55
Speed (rpm)	maximum 280
Motor power (kW)	0,37 – 4
Power supply (V)	230/400
Shaft length (mm)	*
Propeller diameter (mm)	*
Propeller	T1R: Ribbon or ancho with or without scraper T6: 2 blades propeller type T11: 4 blades propeller type T19: High flow propeller type

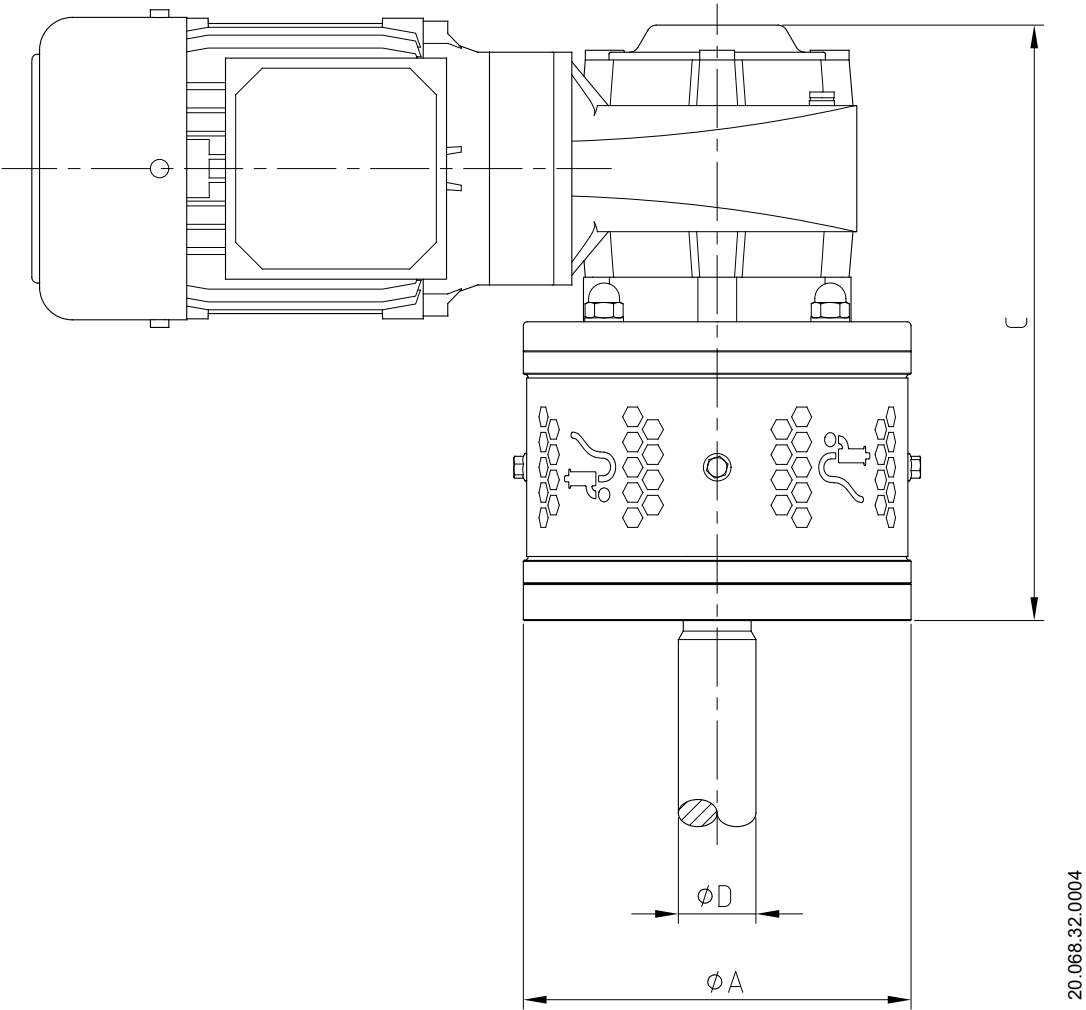
(*) According to project specifications

9.4. WEIGHTS

Type agitator	Weigh (kg)*
CNC – S	25
CNC – M	50
CNC – L	70

1) Table with maximum weight for type
(*) Inoxpa agitator weight request according to specifications

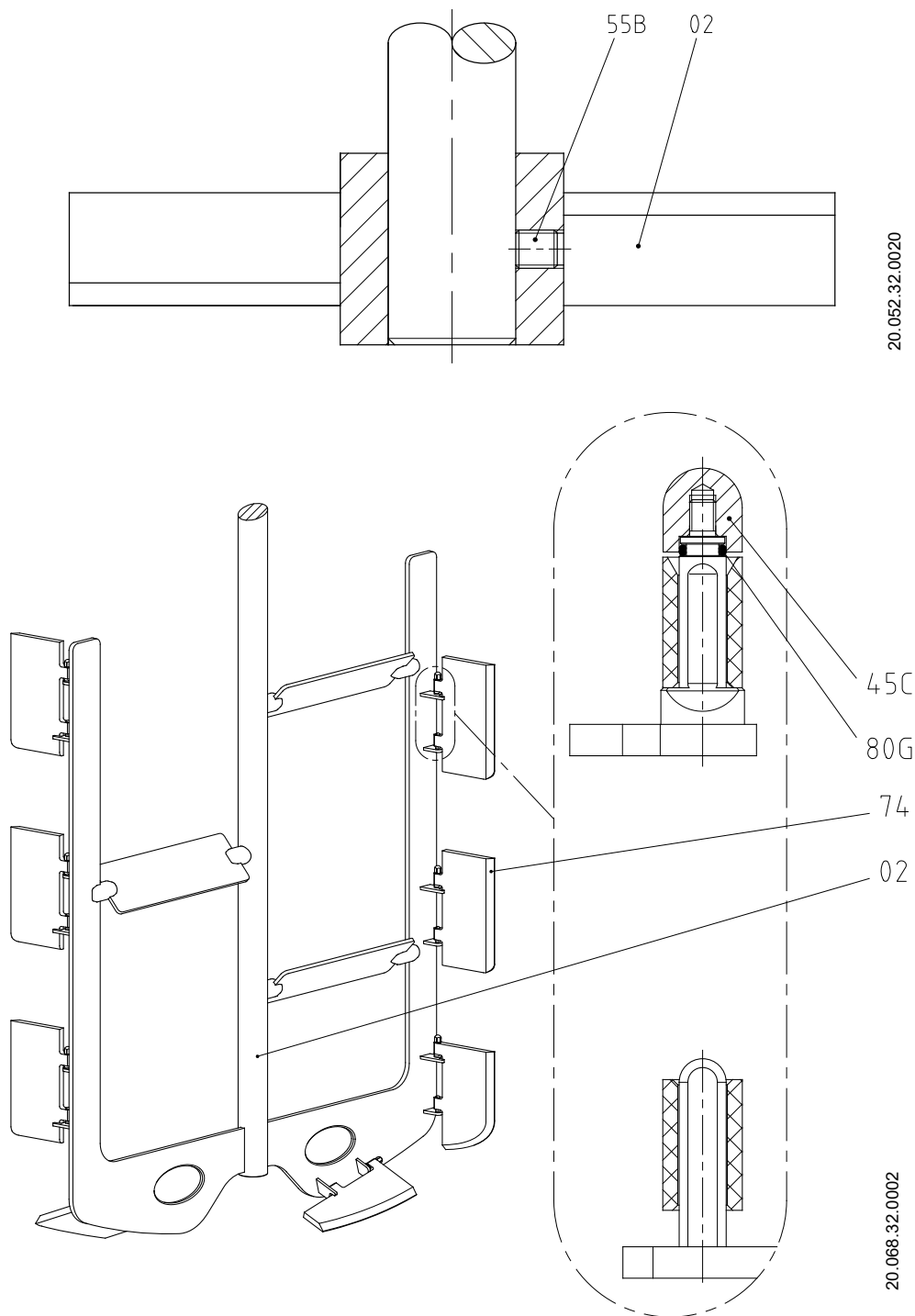
9.5. DIMENSIONS



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Agitator	kW	ØA	C	ØD
CNC-S	0,55	160	290	35
CNC-M	1,1	200	310	40
CNC-L	2,2	200	330	45

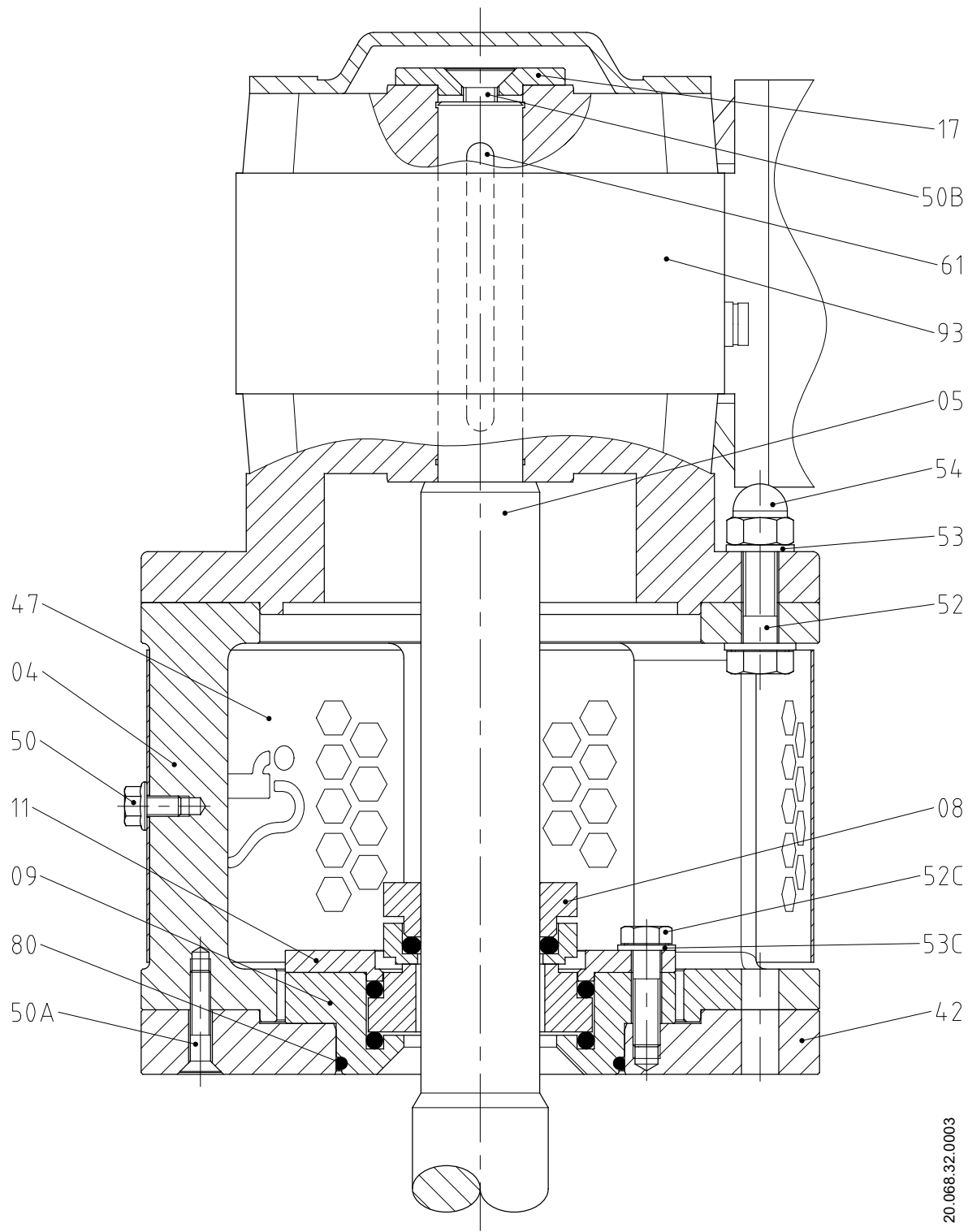
9.6. PARTS LIST OF THE PROPELLER AND ANCHOR



Position	Description	Quantity	Material
02	Propeller / anchor	(*)	AISI 316L
45C	Nut	(*)	AISI 316L
55B	Studs	(*)	A2
74	Scrapers	(*)	PTFE (*)
80G	O-ring	(*)	EPDM (*)

(*) According to project specifications

9.7. PART LIST OF THE HEAD

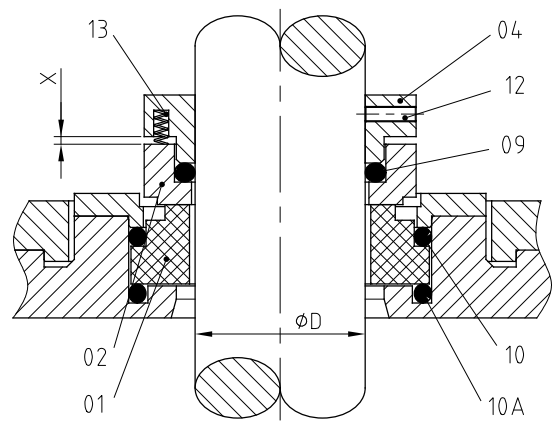


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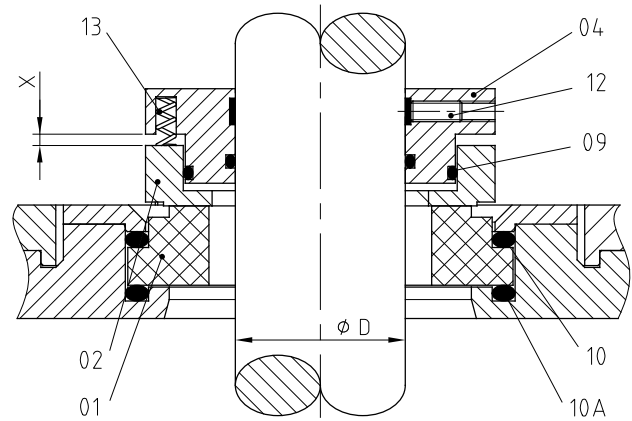
Position	Description	Quantity	Material
04	Lantern	1	AISI 304L
05	Shaft	1	AISI 316L
08	Mechanical seal	1	-
09	Seal cover	1	AISI 316L
11	Seal counter cover	1	AISI 316L
17	Washer	1	AISI 304L
42	Base plate	1	AISI 316L
47	Lantern protector	2	AISI 304L
50	Screw	4	A2
50A	Screw	2	A2
50B	Screw	1	A2
52	Screw	4	A2
52C	Screw	4	A2
53	Flat washer	8	A2
53C	Flat washer	4	A2
54	Nut	4	A2
61	Key	1	F 1114
80	O-ring	1	EPDM (*)
93	Gear-motor	1	-

(*) According to project specifications

9.8. PART LIST SIMPLE MECHANICAL SEAL



Part list EDV mechanical seal.



Part list GTED mechanical seal.

20.067.32.0011

Position	Description	Quantity	Material
01	Stationary ring	1	Graphite
02	Rotating ring	1	Silicon
04	Rotating body	1	AISI 316L
09	O-ring	1	-
10	O-ring	1	-
10A	O-ring	1	-
12	Stud	S / Diameter	AISI 316L
13	Spring	S / Diameter	AISI 316L

NOTES



How to contact INOXPA S.A.U.:

Contact details for all countries are continually updated on our website.

Please visit www.inoxpa.com to access the information.



INOXPA S.A.U.

Telers, 60 – 17820 – Banyoles – Spain

Tel.: +34 972 575 200 – Fax: +34 972 575 502