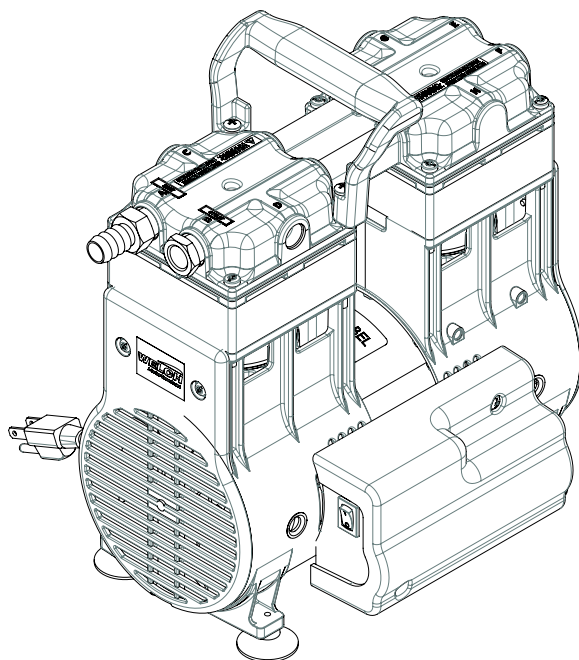




OWNER'S MANUAL FOR DRY VACUUM PUMP MODEL: 2595



Warning
Not recommended for pumping acid, base or
organic vapors or gases.



Warning
Be sure to properly identify intake and discharge
before using pump. See section 2.26

**INSTRUCTION
WARNING AND CAUTION
PLEASE READ BEFORE OPERATION**

While reading your manual, please pay close attention to areas labeled:

WARNING AND CAUTION.

The description of each is found below.

WARNING

Warnings are given where failure to observe instruction could result in injury or death to people.

CAUTION

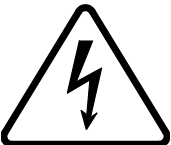
Cautions are found where failure to observe the instruction could result in damage to the equipment, associated equipment and process.

These units confirm to the SI International system of units of measurement.

The following symbols (with recommendation of IEC1010) of warning will be found on the pump.



Caution - refer to accompanying documents



Caution - risk of electrical shock



Caution - hot surface

WARNING

Motor includes a self resetting thermal cutout and the pump could restart without actuation under fault condition.

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Warranty

Section 1: SAFETY INFORMATION

I.10 CAUTION: To prevent injury....

- I.11** Never operate this product if it has a damaged cord or plug. If it is not working properly, has been dropped, damaged or has fallen into water, please return the product to a Welch service center for examination and repair.
- I.12** Keep the cord away from the heated surfaces.
- I.13** Never block any air openings or place it on a soft surface where the openings may be blocked. The air openings are for ventilation of the motor inside the housing. Keep all air openings free of lint, dirt and other foreign objects.
- I.14** The pump is thermally protected and can automatically restart when the protector resets. Always disconnect power source before servicing.
- I.15** Wear safety glasses or goggles when operating this product.
- I.16** Use only in well ventilated areas. The motor is fan cooled enclosed in a shell.



WARNING

Do not operate the pumps in an atmosphere containing flammable or explosive gases/vapors.



WARNING

Never block the exhaust port. If the exhaust is blocked, pressure will build-up in the pump with the potential of the pump head bursting and causing possible injury to personnel in the area.

- I.17** All electrical products generate heat. To avoid serious burns never touch unit during or immediately after operation.
- I.18** Be sure to properly identify intake and discharge before using pump. See Section .
- I.20 CAUTION: To reduce risk of electrical shock....**
- I.21** Do not disassemble. Disassembly or attempted repairs if accomplished incorrectly can create electrical shock hazard. Refer servicing to qualified service agencies only:
Call (847) 676-8800 Ext. 1
- I.22** Unit is supplied with a three pronged plug. Be sure to connect pump to a properly grounded outlet only.
- I.23** WARNING: To reduce risk of electricution...
- I.24** Do not use this product in or near area where it can fall or be pulled into water or other liquids.
- I.25** Do not reach for this product if it has fallen into liquid. Unplug immediately.
- I.26** Never operate this product outdoors in the rain or in a wet area.
- I.27** DANGER: To reduce risk of explosion or fire...
- I.28** Do not use this pump near explosive atmospheres or where aerosol (spray) products are being used.
- I.29** Do not use this product near flames.



WARNING

Failure to observe the above safety precautions could result in severe bodily injury, including death in extreme cases.

Section 2: INSTALLATION

2.10 Introduction

This manual has been compiled not only for the care and maintenance of the Welch Dry Vacuum System now in your possession, but as a helpful reference and guide to prevent many problems which can occur if used improperly.

2.11 Unpacking

Carefully remove the Dry Vacuum System from the shipping carton. Preserve all paperwork for future reference. If damage has occurred from shipment a claim must be filed with the carrier immediately; preserve the shipping carton for inspection by the carrier. If you are required to communicate with your dealer or Welch Vacuum be sure to include your order numbers for quick identification. Do not return the system to the factory without first calling for a returned goods number. Call (847) 676-8800

2.12 System Mounting

Rubber feet are attached to the pump. Rubber feet are excellent for applications involving a semi-flexible surface such as a bench top; they help to isolate noise and eliminate creeping.

2.13 System Location and Environmental Condition

The pump should be located preferably in a clean, dry and well ventilated area. Please be sure not to block the ventilation ports located on the metal shell. The pump should be placed where the surrounding temperature remains between 10°C and 40°C (50°F and 104°F). Always check to insure the location chosen is protected from direct or indirect moisture contact. The pump should be located as closely to its system in order to utilize it most efficiently. The pump is rated for indoor use only. Maximum altitude 2000 meters. Operating temperature range 5°C to 40°C. Maximum relative humidity of 80% for temp. up to 31°C decreasing to 50% at 40°C. Rated for ±10% of supply voltage.

Pollution Degree2, Installation Category II.



WARNING

Don't operate this pump in an atmosphere containing flammable or explosive gases or vapors.



WARNING

The motor is thermally protected and will automatically restart unexpectedly when the overload device resets.

2.14 Inlet and Outlet Provisions

An inlet hose barb which accepts 5/8" I.D. hose makes it easy to connect the pump to your system. For best results, Welch recommends the length of the tubing between the pump and the apparatus be kept as short as possible. Hose clamps should be used to hold the hose in place. The hose barb in the outlet port of the pump accepts 5/8" ID hose. Be sure to call Welch technical service prior to start-up at (847) 676-8800 if you have any questions.



WARNING

**Never Block The Outer Port. If the outlet is blocked, pressure will buildup in the pump which can lead to the pump head bursting creating the potential of serious injury.
Remove plug from outer port.**

2.20 Electrical Power

2.21 Power Source Review

Review the power source and the voltage rating on the units serial number tag to be sure they agree in voltage, phase and frequency. Serious damage may occur to the system if it is connected to an improper voltage. All Welch systems must be grounded. Grounding reduces the risk of electric shock in the event of an electrical short circuit. The plug must be plugged into an outlet properly grounded. Consult your local electrical codes if you have doubts.

2.22 Overload Protection

The motor manufacturer makes motor thermal overload protection available as an aid to minimize motor failure. Overload protection is a standard feature on both 50/60Hz single-phase motors. The motors have automatic overload protection. Automatic reset protection is designed to reset itself after a predetermined cooling period. If the fault to the drive remains unaltered, the motor will cycle on and off until fault is corrected.

2.23 Identification Symbols

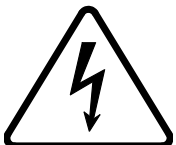
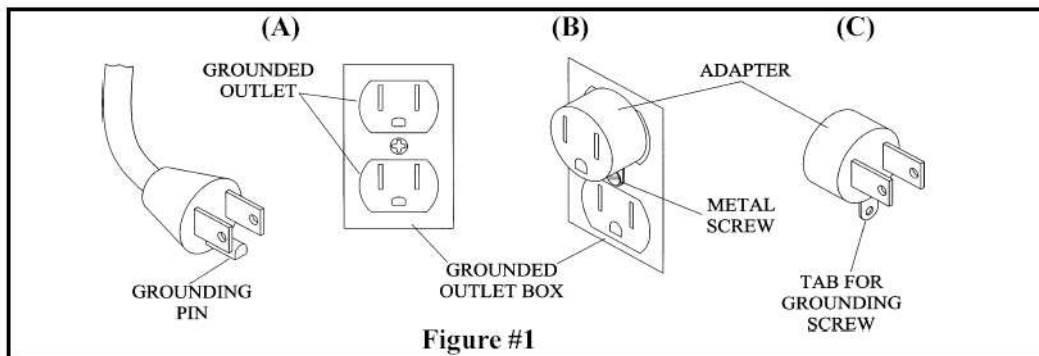
○ OFF (POWER)

■ ON (POWER)

2.24 Grounding Instructions

This product should be grounded. In the event of an electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current. This product is equipped with a cord having a grounding wire with a grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.

This adapter shown in Figure B and Figure C is not acceptable in Canada.



DANGER

**Improper installation of the grounding plug
can result in a risk of electrical shock.**

If repair or replacement of the cord or plug is necessary, do not connect the grounding wire to either flat blade terminal. The wire with insulation having an outer surface that is green with or without yellow stripes is the grounding wire.

Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if in doubt as to whether the product is properly grounded. Do not modify the plug provided; if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

This product is for use on a nominal 120V circuit, and has a grounding plug that looks like the plug illustrated in Sketch A in Figure #1. A temporary adapter, which looks like the adapter illustrated in sketches Band C, may be used to connect this plug to a 2-pole receptacle as shown in sketch B if a properly grounded outlet is not available.

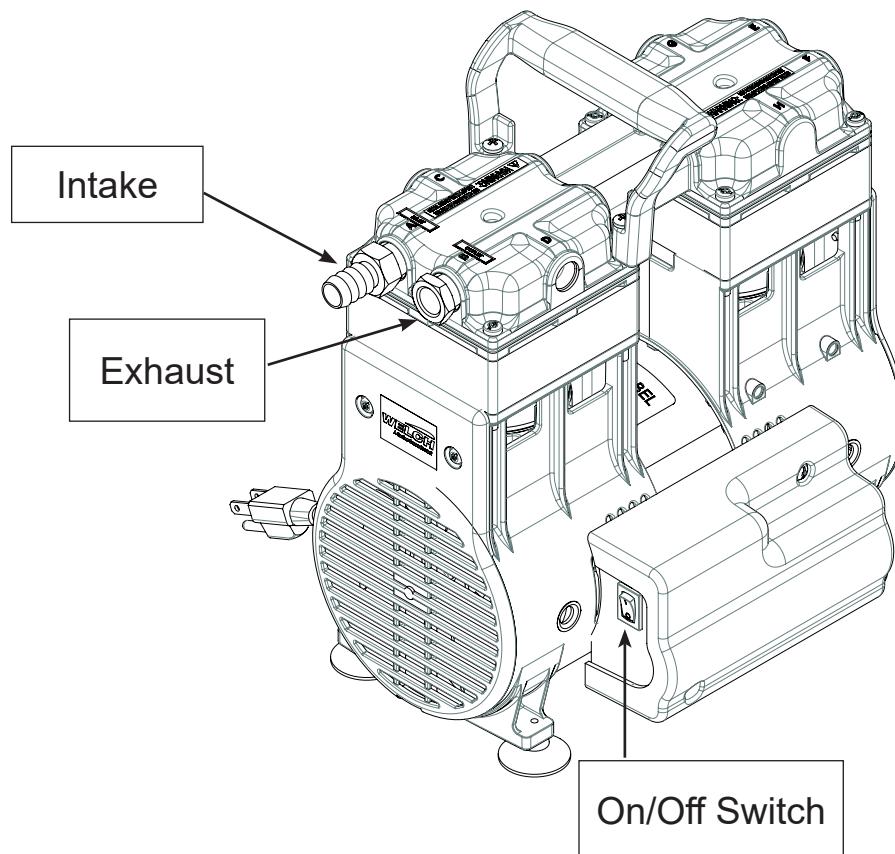
The temporary adapter should be used only until a properly grounded outlet (Sketch A) can be installed by a qualified electrician. The green colored rigid ear, lug, etc. extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box cover. Whenever the adapter is used, it must be held in place by a metal screw.

2.25 Extension Cords

If necessary to use an extension cord, use a 3-wire extension cord that has a 3-blade grounding plug, and a 3-slot receptacle that will accept the plug on the product. Make certain your extension cord is in good condition. Make certain your extension cord wire size is not less than 18 gauge for 25 feet, 16 gauge for 50 feet, and 14 gauge for 100 feet. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. If in doubt, use the next heavier cord. The smaller the gauge number, the heavier the cord.

2.26 Vacuum Connections

The vacuum pump comes with intake hose barbs which accept 5/8" ID rubber vacuum hose. Hose clamps should be used to hold the hose in place. Welch recommends the length of the tubing between the pump and the vacuum chamber or application be kept as short as possible. See photo below to identify intake and exhaust port and On/Off power switch.



Section 3: OPERATION

3.10 Starting Procedures

3.11 Starting a Welch Dry Vacuum Pump

Before attaching the pump to a system it is well to familiarize yourself with the function and action of the vacuum pump that you have acquired. Review the power requirements as described in Section 2.6. Welch recommends running the pump for a few minutes to warm up before use. The warm-up improves the pump's ability to handle humid air.

3.12 Cleanliness

Take every precaution to prevent foreign particulates from entering the pump. Particulates will damage the pump's performance. If you find that particulates will come off the process during evacuation, a particle trap in the foreline will work. A simple, inexpensive trap may be made by placing glass wool in a glass or plastic tube. Screens must be inserted to hold the glass wool in place.



WARNING

The Pump is not recommended for pumping acid, base or organic vapors or gases. Serious damage to the pump will shorten the pump's service life. In addition, pumping flammable vapors or gases can lead to serious safety hazard leading to fire or explosion.

3.13 Leak Detection

The importance of eliminating all leaks in a vacuum system is obvious. The pump must remove this added volume of leaked gas to maintain the desired vacuum. Leaks for these pumps can be located by slightly pressuring the system and painting the suspected area with a thick soap solution. Escaping air will produce soap bubbles.

3.14 Operating Pressure Range

Model 2595 Dry Vacuum Pumps are designed to be run from atmospheric to their maximum vacuum level on the intake side. Consult the Specification Table in the back of this manual for the ratings for your specific model.

3.15 Shutdown Procedures

After use, Welch recommends the pump be run for about 2 minutes disconnected from the vacuum process. The air pumped through the mechanism will purge out water vapor or droplets of water condensate that may have formed on the inside of the pump. This purge of the pump mechanism helps prevent corrosion.

Section 4: MAINTENANCE

Welch Dry Vacuum units are 100% oil-free. The pump employs a non-lube piston and cylinder. No maintenance is necessary for the bearings. All bearings are sealed and permanently lubricated. Lubrication should not be attempted. The units are built for continuous duty operation.

Section 5: TROUBLESHOOTING

5.10 Vacuum Problems

Leakage, contamination and unusual outgassing are the general causes of problems with poor vacuum. To operate at maximum efficiency a system must be thoroughly clean. If the system is completely clean and free from leaks, and unwarranted vacuum problems still exist, the pump should be checked. A simple criterion for the condition of the pump is the determination of its maximum vacuum capability. This can be accomplished by blocking of the intake and reading the vacuum level on the gauge.

5.11 Troubleshooting Guide

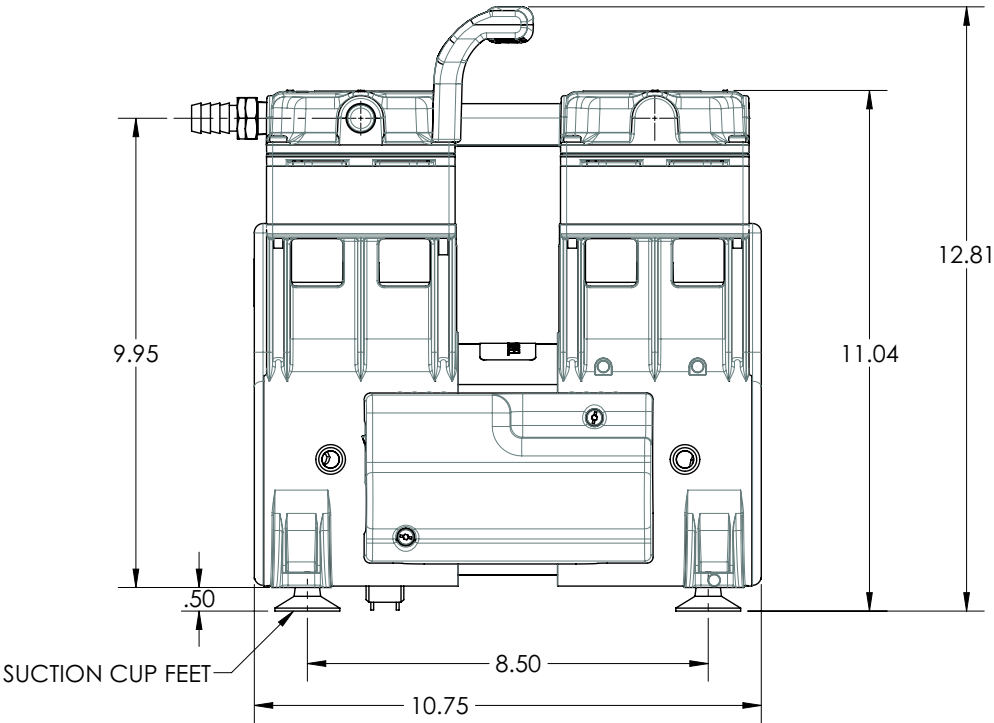
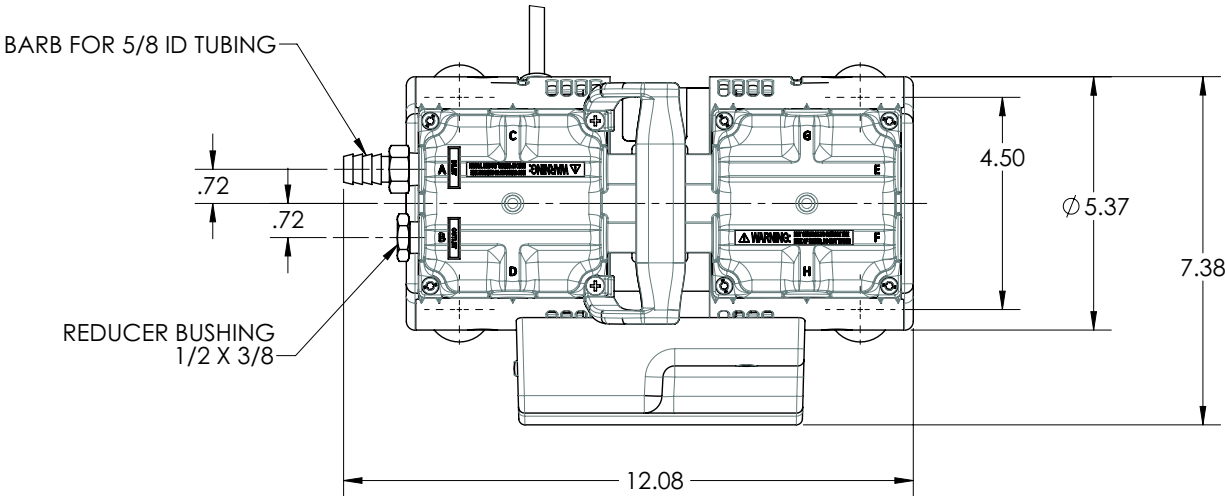
Poor Pumping Speed	Poor Vacuum	Loud Unit	Possible Cause	Corrective Action
X	X	X	Damaged valves	Replace flapper valves
X	X	X	Debris in valves	Remove debris and check for valve damage
X	X	X	Damaged gasket	Replace gasket
X	X	X	Loose head screw	Tighten head screw
X	X	X	Loose fitting	Tighten fitting

Section 6: SPECIFICATION

6.10 Pump Specification Chart

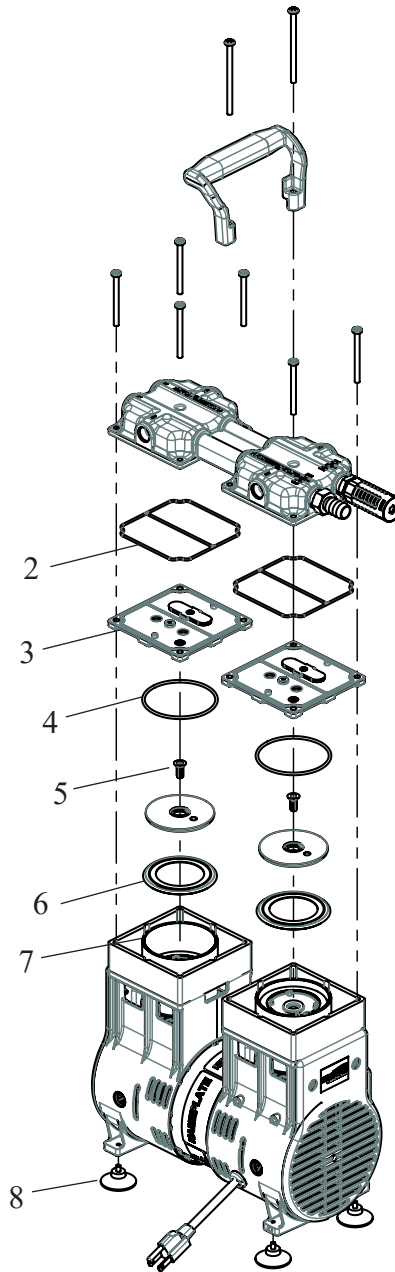
Welch Model	2595
Free Air Displacement	
CFM (L/min.) @60Hz	10.6 (300)
M3 (L/min.) @50Hz	15.0 (250)
Ultimate Pressure	
Torr	60
(mbar)	(80)
Maximum Vacuum In.Hg.	27.6
Motor Horsepower	
Horsepower	1/3
(watts)	(250)
Tubing needed	
I.D. in Inches	5/8
(I.D. in Millimeters)	(10)
Intake & Exhaust Thread NPT	1/2
Weight lbs	22.5
(Kg.)	(10.3)
Overall Dimensions	
L in Inches (cm)	11.8 (30)
W in Inches (cm)	7.8 (19.8)
H in Inches (cm)	12.8 (32.5)
Shipping Weight	
lbs	27.5
(Kg.)	(12.5)
Shipping Dimensions	
L in Inches (cm)	19.5 (49.5)
W in Inches (cm)	20.5 (52.0)
H in Inches (cm)	16.0 (40.6)
Catalog Number	
Catalog Number Wired for 115V, 60Hz, 1Ph with N.American 115V Plug	2595B-01
Catalog Number Wired for 230V, 50/60Hz, 1Ph with Schuko cord set	2595C-02

6.11 Dimensional Drawing



2595

6.12 Parts List and Exploded View for Pump Model 2595



Item Number	Description	Valve Plate Kit	Sleeve/ Seal Kit	Feet Kit
		2585K-12	2595K-13	2500K-04
2	Head Gasket O-Ring	1	2	-
3	Valve Plate Assembly	1	-	-
4	Cylinder O-ring	1	2	-
5	Cup Retainer Screw		2	-
6	Piston Cup Seal		2	-
7	Piston Cylinder Sleeve		2	-
8	Rubber Suction Feet		-	4

Warranty

This Welch Vacuum product is warranted to be free from defects in material and workmanship. This liability of Gardner Denver Welch Vacuum Technology under this warranty is limited to servicing, adjusting, repairing, or replacing any unit or component part which in the judgment of Gardner Denver Welch Vacuum Technology has not been misused, abused, or altered in any way or damaged by ingestion of foreign material causing impaired performance or rendering it inoperative. No other warranties are expressed or implied. The method of executing this warranty: servicing, adjusting, repairing, or replacing, shall be at the discretion of Gardner Denver Welch Vacuum Technology. Vacuum pumps that have been operated within a vacuum system, or other system, for any period, however short, will be repaired under this warranty rather than replaced.

The warranty is effective for one year from the date of original purchase when:

1. The warranty card has been completed and returned.
2. The product is returned to the factory or other designated service centers, freight prepaid.
3. The product in our judgment is defective through no action or fault of the user.

If the product has become defective through misuse, abuse, alteration, or ingestion of foreign material, repairs will be billed regardless of the age of the product. In this event, an estimate of the repair costs will be submitted and authorization of these charges will be required before the product is repaired and returned.

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