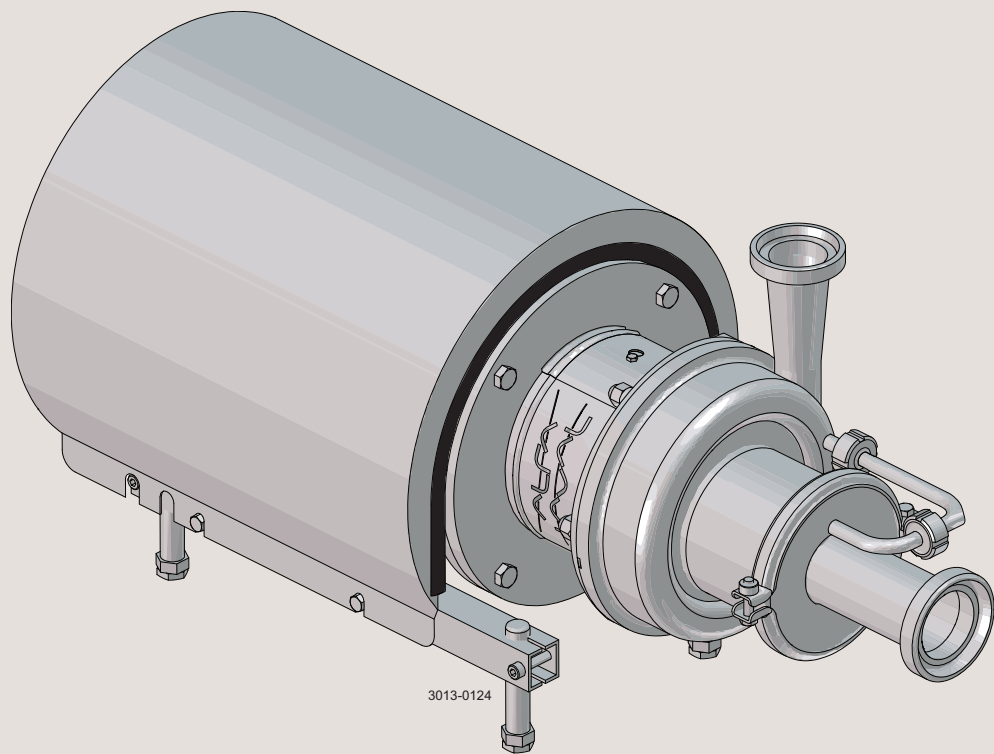




Instruction Manual

LKH Prime Pump



ESE03053-EN7

2020-06

Original manual

The information herein is correct at the time of issue but may be subject to change without prior notice

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1 EC Declaration of Conformity

Revision of Declaration of Conformity 2020-01-23

The Designated Company

Alfa Laval Kolding A/S

Company Name

Albuen 31, DK-6000 Kolding, Denmark

Address

+45 79 32 22 00

Phone No.

hereby declares that

Pump

Designation

LKH Prime 10, LKH Prime 20, LKH Prime 40

Type

Serial number from AAB000000001 to AAB999999999

Serial number from 10.000 to 1.000.000

Serial number from 100700000001-100799999999

is in conformity with the following directive with amendments:

- Machinery Directive 2006/42/EC

The person authorised to compile the technical file is the signer of this document

Global Product Quality Manager
Hygienic Fluid Handling

Title

Lars Kruse Andersen

Name

Kolding
Place

2020-06-01
Date

Signature



*This manual highlights unsafe practices and other important information.
Warnings are emphasised by means of special signs.
Always read the manual before using the pump!*

2.1 Important information

WARNING

Indicates that special procedures must be followed to avoid serious personal injury.

CAUTION

Indicates that special procedures must be followed to avoid damage to the pump.

NOTE

Indicates important information to simplify or clarify procedures.

2.2 Warning signs

General warning:



Dangerous electrical voltage:



Caustic agents:



2 Safety

All warnings in the manual are summarised on this page.

Pay special attention to the instructions below in order to avoid severe personal injury and/or damage to the pump..

2.3 Safety precautions

Installation:

Always read the technical data carefully. (See chapter 6.1 Technical data)

Always use a lifting crane when handling the pump.

Always remove the air screw and impeller before checking the direction of rotation.



Never start the pump if the impeller and air screw are fitted and the pump casing is removed.

Operation:

Always read the technical data carefully. (See chapter 6.1 Technical data)

Never touch the pump or the pipelines when pumping hot liquids or when sterilising.

Never run the pump when both the suction side and the pressure side are blocked.

Never run the pump when partially installed or not fully assembled.



Necessary precautions must be taken in the event of leakage as this can lead to hazardous situations.



Always handle lye and acid with great care.

Never use the pump for products not listed in the Alfa Laval pump selection program.

The Alfa Laval pump selection program can be acquired from your local Alfa Laval sales company.

Maintenance:

Always read the technical data carefully. (See chapter 6.1 Technical data)

Never service the pump when it is hot.

Never service the pump if pressurised.

Always use genuine spare parts from Alfa Laval.



Motors with grease nipples:

Remember to perform lubrication in accordance with the information plate/label on the motor.



Always disconnect the power supply when servicing the pump.

Transportation:

Transportation of the pump or the pump unit:

Never lift or elevate in any way other than that described in this manual

Always drain the pump head and accessories of any liquid

Always ensure that lubricants are not able to leak.

Always transport the pump in an upright position

Always ensure that the unit is securely fixed during transportation

Always use the original packaging or similar during transportation

Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

- See pre-use check in section 3.3 Pre-use check

The pump is heavy.

Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

3.1 Unpacking/delivery

Step 1

Always use a lifting crane when handling the pump (see technical data).

CAUTION

Alfa Laval cannot be held responsible for incorrect unpacking.

WARNING:

Be aware that certain pump configurations can tilt, and therefore cause injury to feet or fingers. The pump should be supported underneath the adapter, when not installed in the process line.

Check the delivery for:

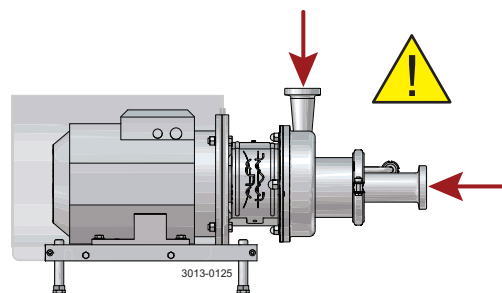
1. Complete pump
2. Delivery note
3. Motor instructions

Step 2

Remove any packing materials from the inlet and outlet.

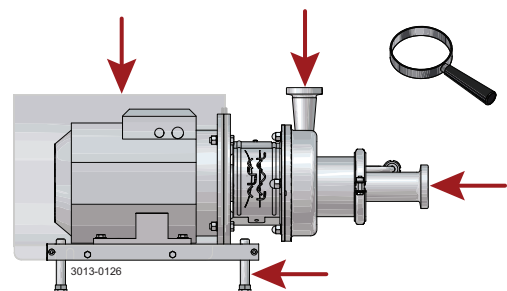
Avoid damaging the inlet and outlet.

Avoid damaging the connections for flushing liquid, if supplied.



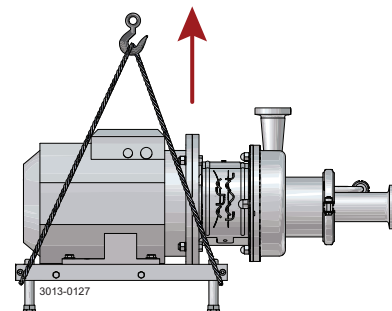
Step 3

Inspect the pump for visible transport damage.



Step 4

Always remove the shroud, if fitted, before lifting the pump.



3 Installation

Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

- See pre-use check in section 3.3 Pre-use check

The pump is heavy.

Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

3.2 Installation

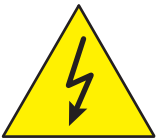
Step 1



Always read the technical data carefully.
(See chapter 6.1 Technical data)



Always use a lifting crane when handling the pump.



Always have the pump electrically connected by authorised personnel. (See the motor instructions).

CAUTION

Alfa Laval cannot be held responsible for incorrect installation.

WARNING:

Alfa Laval recommends the installation of a lockable repair breaker. If the repair breaker is to be used as an emergency stop, the colours of the repair breaker must be red and yellow.

Caution:

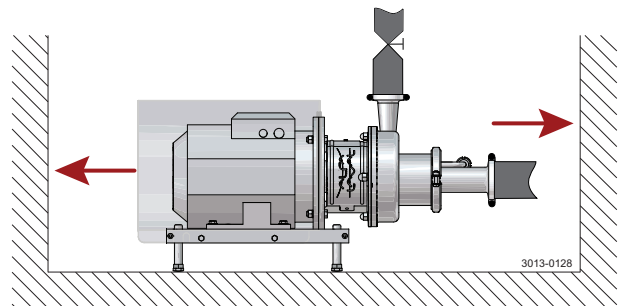
The pump does not prevent back flow when intentionally or unintentionally stopped. If back flow may cause a hazardous situation to arise, precautions must be taken e.g. a check valve can be installed in the system to prevent hazardous situations.

Note:

The 3A standard requires minimum clearance between the lowest part of the base, pump, motor or drive and for the floor to be no less than 4 in. (100 mm)

Step 2

Ensure at least 0.5 m (1.6 ft) clearance around the pump.

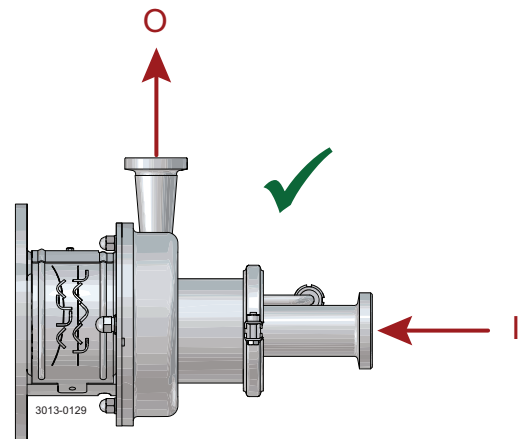


Step 3

Check that the flow direction is correct.

O: Outlet

I: Inlet



3 Installation

Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

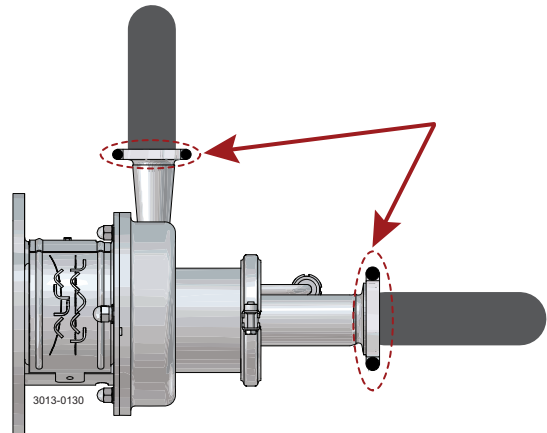
- See pre-use check in section 3.3 Pre-use check

The pump is heavy.

Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

Step 4

1. Ensure that the pipelines are routed correctly.
2. Ensure that the connections are tight.
3. Remember seal rings



Step 5

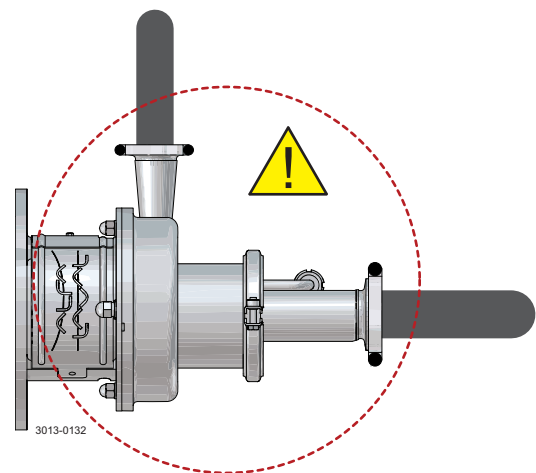
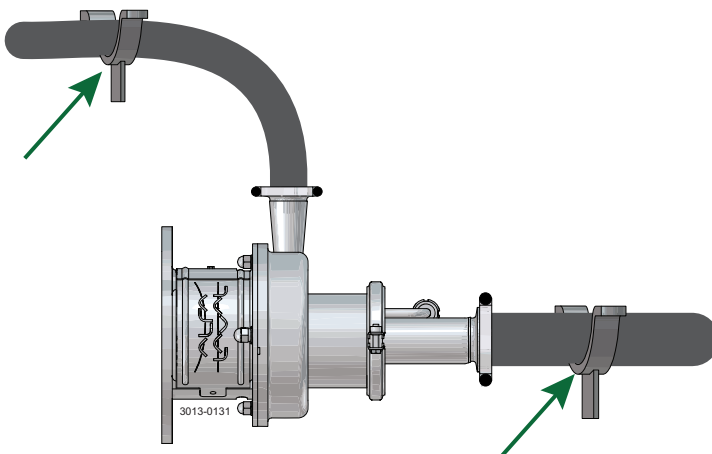
Avoid stress on the pump.

Piping system must be self-supported.

Pay special attention to:

- Vibrations
- Thermal expansion of the tubes
- Excessive welding
- Overloading of the pipelines

Example of piping system self-supported.



3 Installation

Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

- See pre-use check in section 3.3 Pre-use check

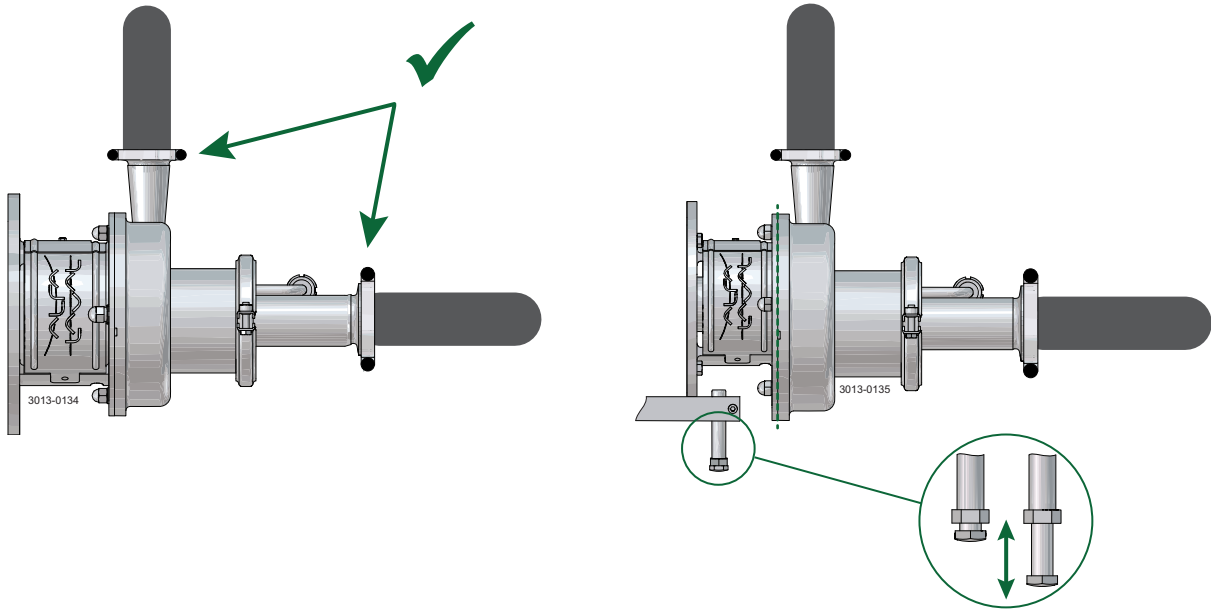
The pump is heavy.

Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

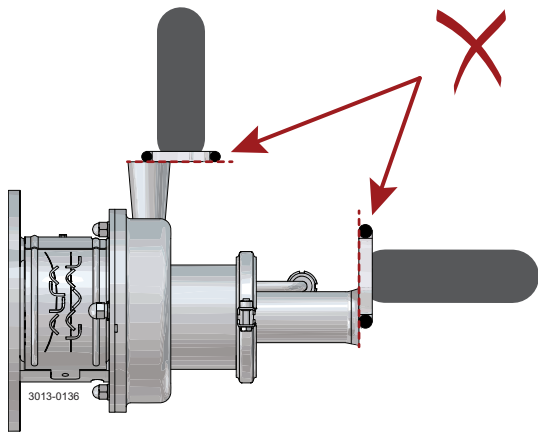
Step 6

Ensure correct alignment of pump inlet and outlet with piping system.

Alignment can be done by adjusting the pump legs.



Centre of inlet and outlet to be aligned with centre of piping system.



3 Installation

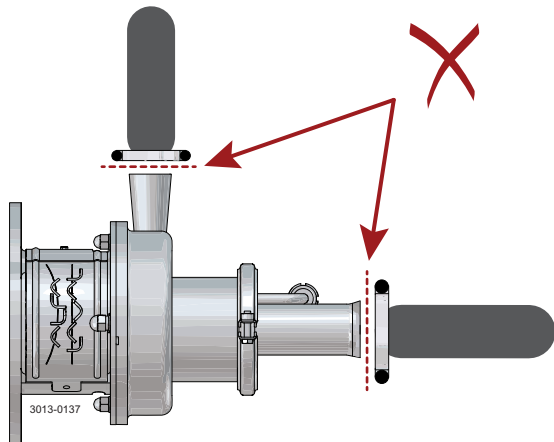
Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

- See pre-use check in section 3.3 Pre-use check

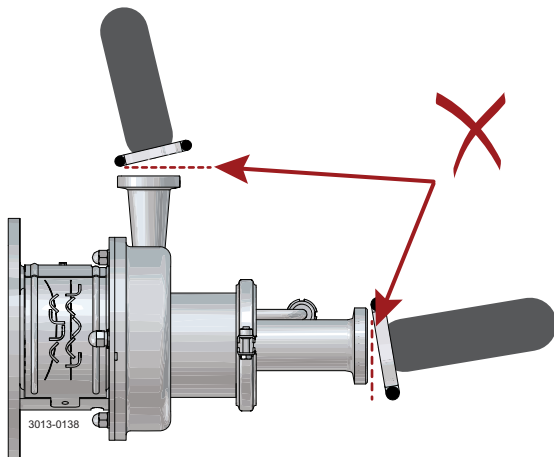
The pump is heavy.

Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

No gaps between connections on pump inlet and inlet pipe, and pump outlet and outlet pipe.



Angel between connections on pump inler and inlet pipe, pump outlet and outlet pipe not allowed.



3 Installation

Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

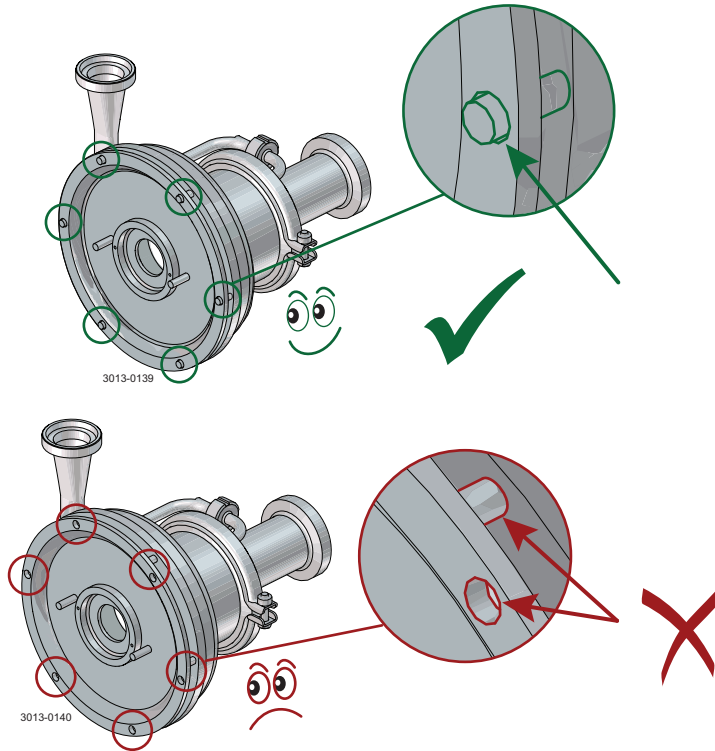
- See pre-use check in section 3.3 Pre-use check

The pump is heavy.

Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

Ensure correct alignment of pump casing and pump backplate. Angle not allowed. Alignment can be done by adjusting the pump legs.

Ensure stud bolts in casings are aligned with holes in backplate.



Note

In case of shaft seal leakage, the media will drip from the slot in the bottom of the adaptor. In case of shaft seal leakage, Alfa Laval recommends putting a drip tray underneath the slot to collect the leakage.

3 Installation

Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

- See pre-use check in section 3.3 Pre-use check

The pump is heavy.

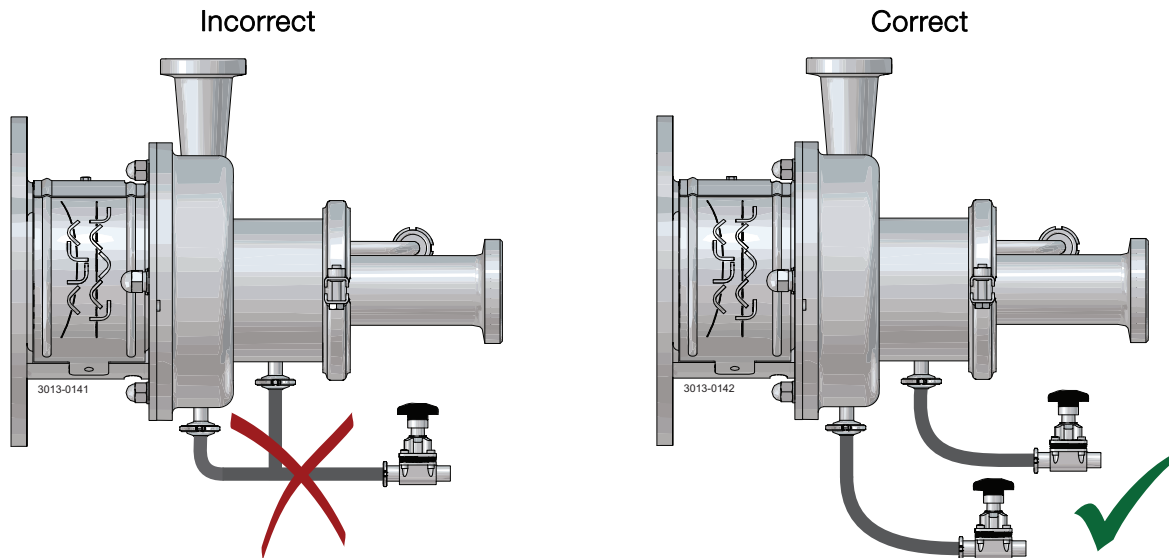
Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

Step 7

If pump is fitted with drain option;

Never short circuit the drain connections as this will reduce the air release capacity

Always use two drain valves

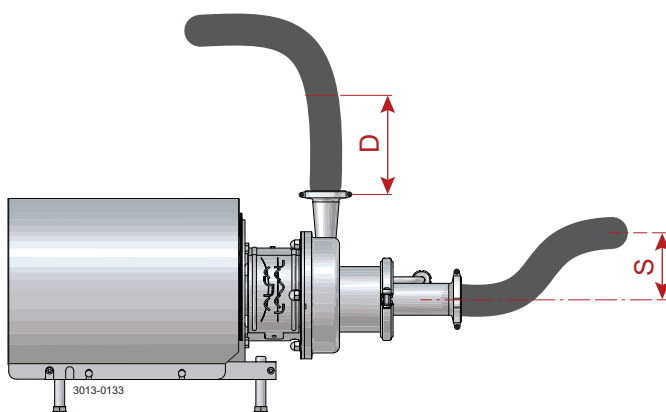


Step 8

To ensure optimal function of the selfpriming capacity, LKH Prime must be installed in such a way that ensures liquid is in the pump on start-up e.g. with a swan neck design as illustrated.

Note

Max running time when releasing air only should not exceed 15 min.



	S min	D min
LKH Prime 10	200 mm	1.5 m 2" pipe
LKH Prime 20	200 mm	1.5 m 3" pipe or 2 m 2" pipe
LKH Prime 40	200 mm	1.5 m 3" pipe or 2 m 2" pipe

3 Installation

Read the instructions carefully and pay special attention to the warnings! Always check the pump before operation.

- See pre-use check in section 3.3 Pre-use check

The pump is heavy.

Alfa Laval therefore recommends the use of a lifting crane when handling the pump.

Step 9

Installation guide lines

1. Suction considerations

- Installation
 - Ensure the suction line is designed so the Prime pump is liquid filled at start up, eg. swan neck. (see table in Step 6)
 - Design suction line with slope down toward the pump to avoid air entrapments
- NPSH
 - Ensure $NPSH_a > NPSH_r$ under all duty conditions including all temperatures
- Air inclusions
 - Controlled start/stop of pump eg. Level Switch (LS)
 - Do not start the LKH Prime before tank bottom is liquid filled
 - Stop the LKH Prime during phase changes

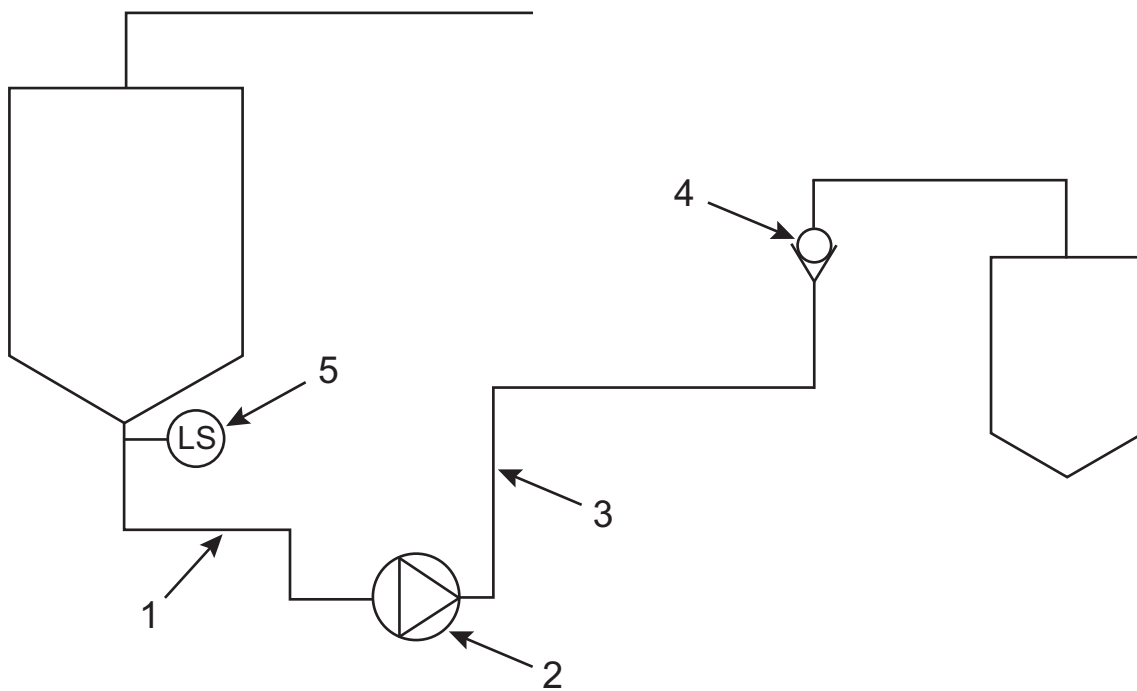
2. General pump considerations

- VFD
 - Minimum speed for effective air evacuation is 2800 RPM
 - Air evacuation ability improves with higher speed (Max speed 3600 RPM)
- Pump sizing
 - The LKH Prime must be sized for the specific duty point

Note: LKH Prime is NOT a one-to-one replacement of the MR pump

3. Discharge considerations

- Installation
 - Ensure minimum length of vertical pipe after the LKH Prime (see table in Step 6)
- Check valve
 - Place check valve as far away from the pump as possible
 - Replace check valve with automated valve if possible



Pos	
1	Suction line
2	LKH Prime Pump
3	Discharge line
4	Check valve
5	Level switch

Read the instructions carefully and pay special attention to the warnings!
 Check the direction of rotation of the impeller before operation.
 - See the indication label on the pump.

3.3 Pre-check

Step 1

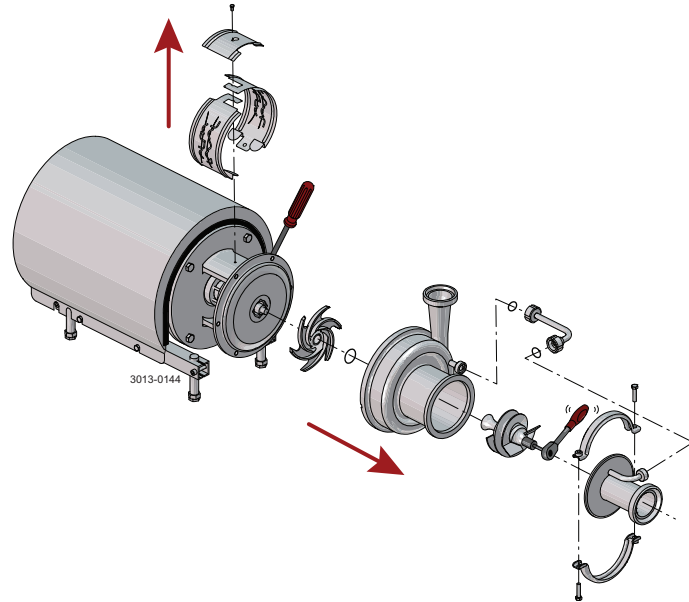


Always remove air screw and impeller before checking the direction of rotation.



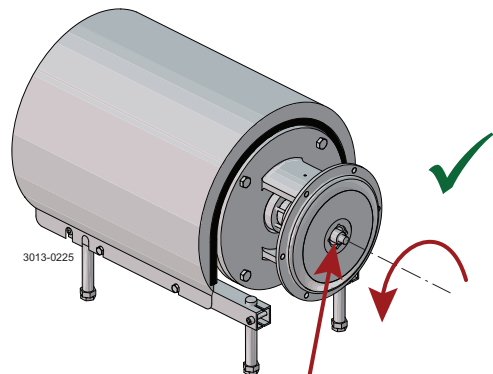
Never start the pump if the impeller is fitted and the pump casing is removed.

1. Remove adapter shields (22)
2. Loosen unions and remove recirculation pipe (56)
3. Remove clamp (57) and front cover (60)
4. Remove air screw (58) with a spanner. Counter hold with a screwdriver. (See also instruction in section 5.3)
5. Unscrew cap nuts (24). Remove washers (24a) and pump casing (29)
6. Remove impeller (27). (See also instruction in section 5.3)



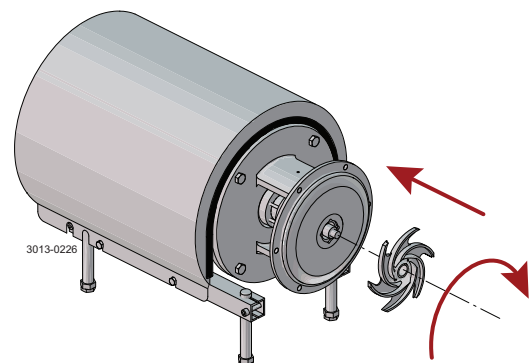
Step 2

1. Start and stop the motor momentarily
2. Ensure that the direction of rotation of the stub shaft (7) is anticlockwise as viewed from the inlet side



Step 3

Fit and tighten the impeller (27)



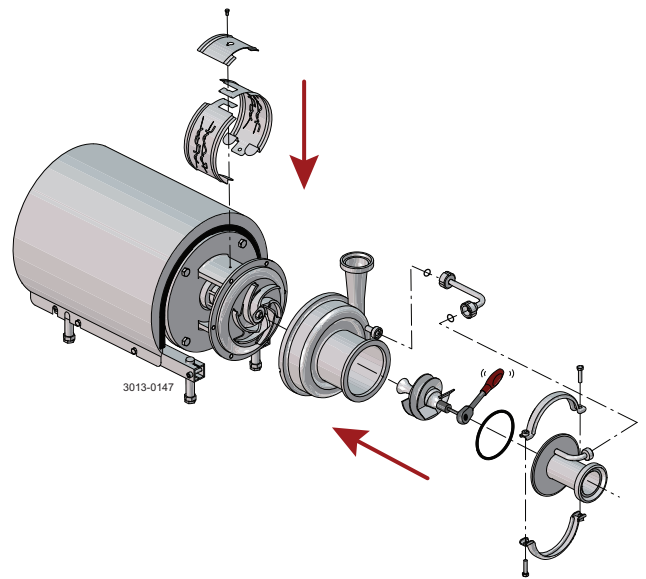
3 Installation

Read the instructions carefully and pay special attention to the warnings!
Check the direction of rotation of the impeller before operation.
- See the indication label on the pump.

Step 4

1. Fit pump casing (29) and washers (24a). Fit and tighten cap nuts (24) according to torque values in chapter 6 Technical data
2. Fit air screw (58) and tighten with a spanner (Torque: see table below)
3. Fit front cover O-ring (59) and fit and align front cover (60). Fit clamp and tighten screws (57) gently
4. Fit recirculations pipe (56), align front cover (60) and tighten unions
5. Tighten clamp screws (57)
6. Fit the apaptor shields (22)

LKH Prime 10:	Torque = 20 Nm (15 lbf-ft)
LKH Prime 20:	Torque = 20 Nm (15 lbf-ft)
LKH Prime 40:	Torque = 40 Nm (30 lbf-ft)



Read the instructions carefully and pay special attention to the warnings!
Check the direction of rotation of the impeller before operation.
- See the indication label on the pump.

3.4 Recycling information

Unpacking

- Packing material consists of wood, plastics, cardboard boxes and, in some cases, metal straps
- Wood and cardboard boxes can be re-used, recycled or used for energy recovery
- Plastics should be recycled or burnt at a licensed waste incineration plant
- Metal straps should be sent for material recycling

Maintenance

- During maintenance, oil and wearing parts in the machine are replaced
- All metal parts should be sent for material recycling
- Worn or defective electronic parts should be sent to a licensed handler for material recycling
- Oil and all non-metal wearing parts must be disposed of in accordance with local regulations

Scrapping

- At the end of use, the equipment must be recycled according to relevant local regulations. In addition to the equipment itself, any hazardous residue from the process liquid must be taken into account and handled in the necessary way. When in doubt, or in the absence of local regulations, please contact your local Alfa Laval sales company.
-

4 Operation

Read the instructions carefully and pay special attention to the warnings!

4.1 Operation/control

Step 1



Always read the technical data carefully. See chapter 6.1 Technical data

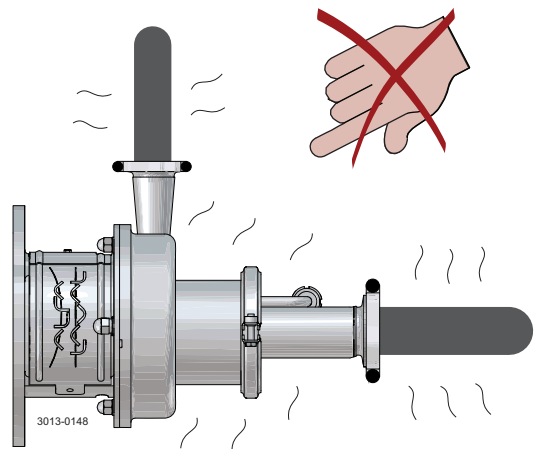
CAUTION

Alfa Laval cannot be held responsible for incorrect operation/control.

Step 2



Never touch the pump or the pipelines when pumping hot liquids or when sterilising.

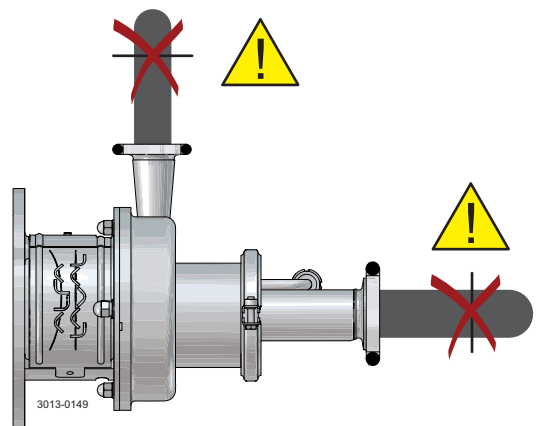


Step 3



Never run the pump when both the suction side and the pressure side are blocked.

Risk of explosion!



Read the instructions carefully and pay special attention to the warnings!

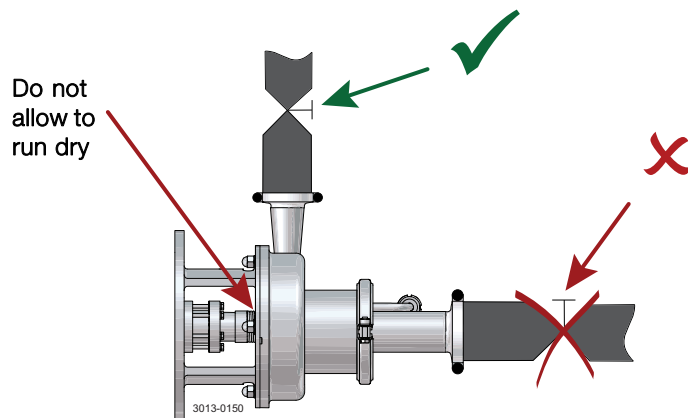
Step 4

CAUTION

The shaft seal must not run dry.

CAUTION

Never throttle the inlet side.



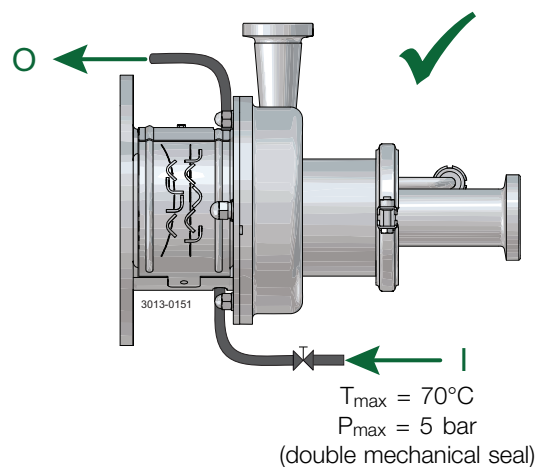
Step 5

Double mechanical shaft seal:

1. Connect the inlet of the flushing liquid correctly (R1/8")
2. Regulate the water supply correctly

O: Outlet

I: Inlet



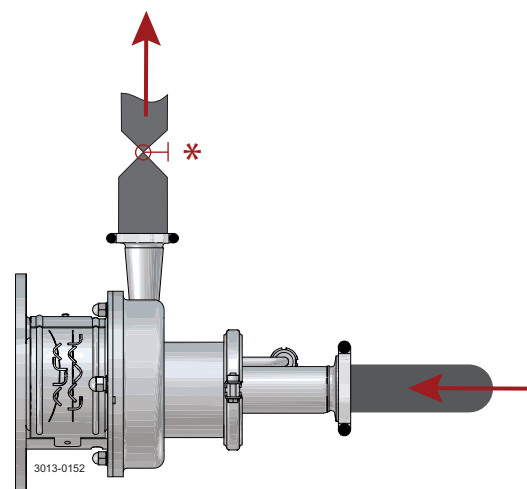
Step 6

Control:

Reduce the capacity and the power consumption by:

- Throttling the pressure side of the pump.
- Reducing the impeller diameter.
- Reducing the speed of the motor (when not releasing air).

* Throttling!



4 Operation

*Pay attention to possible faults.
Read the instructions carefully.*

4.2 Trouble shooting

NOTE!

Read the maintenance instructions carefully before replacing worn parts.

Problem	Cause/result	Remedy
Motor overloaded	<ul style="list-style-type: none"> - Pumping of viscous liquids - Pumping of high density liquids - Low outlet pressure (counter pressure) - Lamination of precipitates from the liquid 	<ul style="list-style-type: none"> - Larger motor or smaller impeller - Higher counter pressure (throttling) - Frequent cleaning
Cavitation: <ul style="list-style-type: none"> - Damage - Pressure reduction (sometimes to zero) - Increase in the noise level 	<ul style="list-style-type: none"> - Low inlet pressure - High liquid temperature 	<ul style="list-style-type: none"> - Increase the inlet pressure - Reduce the liquid temperature - Reduce the pressure drop before pumping - Reduce speed
Leaking shaft seal	<ul style="list-style-type: none"> - Running dry - Incorrect rubber grade - Abrasive particles in the liquid - Incorrect SiC/SiC single seal used 	Replace: All wearing parts If necessary: <ul style="list-style-type: none"> - Change rubber grade - Select stationary and rotating seal ring in silicon carbide/silicon carbide - Change to SiC/SiC seal marked "LKH Prime"
Leaking O-ring seals	Incorrect rubber grade	Change rubber grade
No/little air release	<ul style="list-style-type: none"> - see possible causes in the Installation guide lines chapter 3, Installation 	<ul style="list-style-type: none"> - follow recommendations in the Installation guide lines chapter 3, Installation

The pump is designed for cleaning in place (CIP). CIP = Cleaning In Place.
 Read the instructions carefully and pay special attention to the warnings!
 NaOH = Caustic Soda.
 HNO₃ = Nitric acid.

4.3 Recommended cleaning

Step 1



Always handle lye and acid with great care.

Caustic danger!



Always use rubber gloves!

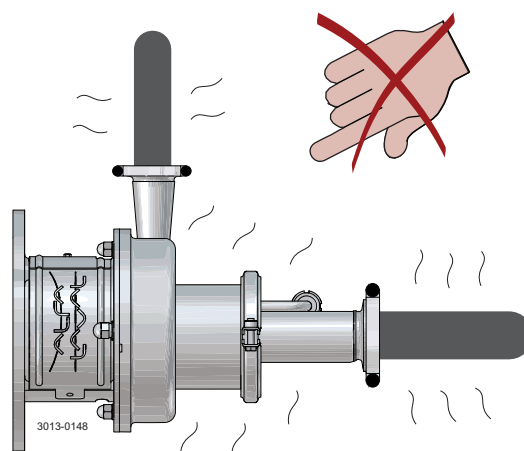


Always use protective goggles!

Step 2



Never touch the pump or the pipelines when sterilising.



Step 3

Examples of cleaning agents: Use clean water, free from chlorides.

1. 1% by weight NaOH at 70°C (158°F)

1 kg (2.2 lb) NaOH	+	100 l (26.4 gal) water	= Cleaning agent
-----------------------	---	---------------------------	------------------

2.2 l (0.6 gal) 33% NaOH	+	100 l (26.4 gal) water	= Cleaning agent
-----------------------------	---	---------------------------	------------------

2. 0.5% by weight HNO₃ at 70°C (158°F)

0.7 l (0.2 gal) 53% HNO ₃	+	100 l (26.4 gal) water	= Cleaning agent
---	---	---------------------------	------------------

1. Avoid excessive concentration of the cleaning agent
 ⇒ Dispense gradually!
2. Adapt the cleaning flow to the process.
 Sterilisation of milk/viscous liquids
 ⇒ Increase the cleaning flow!

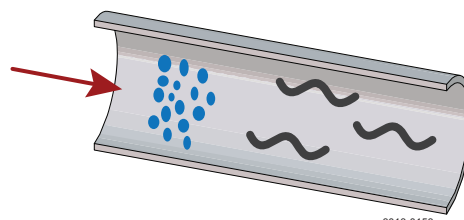
Step 4



Always rinse well with clean water after using a cleaning agent.

NOTE

Cleaning agents must be stored/disposed of in accordance with current regulations/directives.



3013-0153

4 Operation

The pump is designed for cleaning in place (CIP). CIP = Cleaning In Place.

Read the instructions carefully and pay special attention to the warnings!

NaOH = Caustic Soda.

HNO₃ = Nitric acid.

NOTE:

If pumps are sterilised using steam, standard 3A requires the process system to be designed to automatically shut down if the product pressure in the system becomes less than that of the atmosphere and it cannot be started until the system is re-sterilised.

Maintain the pump with care. Read the instructions carefully and pay special attention to the warnings!
 Always have spare shaft seals and rubber seals to hand.
 See separate motor instructions.
 Check the pump for smooth operation after service.

5.1 General maintenance

Step 1



Always read the technical data carefully. (See 6.1 Technical data)



Always disconnect the power supply when servicing the pump.

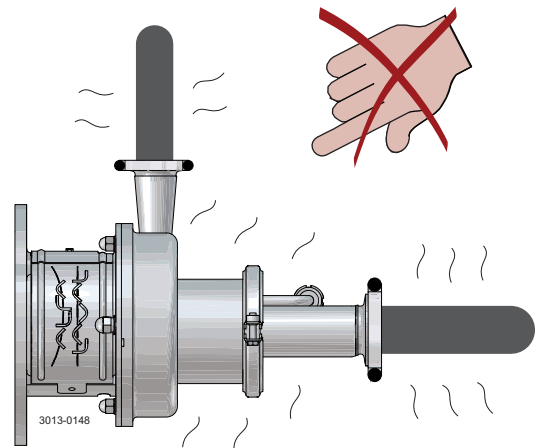
NOTE

All scrap must be stored//disposed of in accordance with current regulations/directives.

Step 2



Never service the pump when it is hot.



Step 3



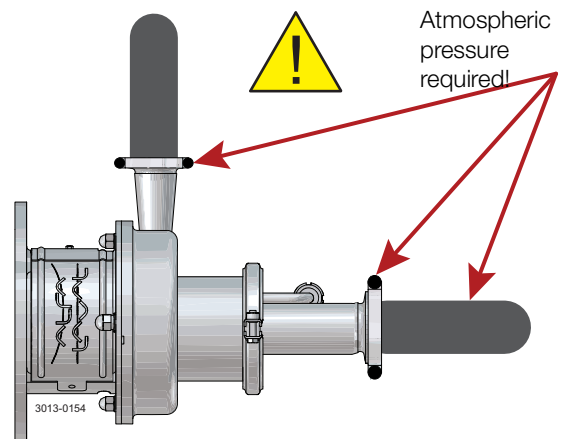
Never service the pump if pressurised.

CAUTION

Fit the electrical connections correctly if they have been removed from the motor during service.

CAUTION

Pay special attention to the warnings!



Step 4

Recommended spare parts:

Order service kits from the service kits list
 (See section 7).

Ordering spare parts

Contact your local Alfa Laval sales company.

5 Maintenance

Maintain the pump with care. Read the instructions carefully and pay special attention to the warnings!
 Always have spare shaft seals and rubber seals to hand.
 See separate motor instructions.
 Check the pump for smooth operation after service.

	Shaft seal	Rubber seals	Motor bearings
Preventive maintenance	Replace after 12 months: (one-shift) complete shaft seal	Replace when replacing the shaft seal	
Maintenance after leakage (leakage normally starts slowly)	Replace at the end of the day: complete shaft seal	Replace when replacing the shaft seal	
Planned maintenance	<ul style="list-style-type: none"> - Regular inspection for leakage and smooth operation - Keep a record of the pump - Use the statistics for inspection planning Replace after leakage: Complete shaft seal	Replace when replacing the shaft seal	Yearly inspection is recommended <ul style="list-style-type: none"> - Replace complete bearing if worn - Ensure that the bearing is axially locked (see motor instructions)
Lubrication	Before fitting Lubricate the O-rings with silicone grease or silicone oil	Before fitting Silicone grease or silicone oil	

Pre-use check

CAUTION!

Fit the electrical connections correctly if they have been removed from the motor during servicing.
 (See pre-use check in section 3.1 Unpacking/delivery).

Pay special attention to warnings!

1. Start and stop the motor momentarily
2. Ensure that the pump operates smoothly.

Maintain the pump with care. Read the instructions carefully and pay special attention to the warnings!
Always have spare shaft seals and rubber seals to hand.
See separate motor instructions.
Check the pump for smooth operation after service.

5.2 Cleaning procedure

Step 1

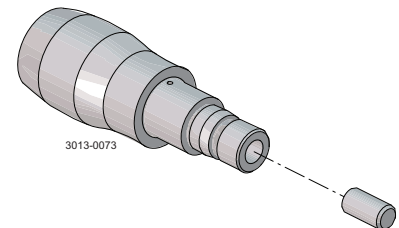
Cleaning procedure for soiled air screw tapped hole:

1. Remove air screw (58) as per section 5.3 of the Service manual.
 2. Submerge and soak the air screw for 5 minutes in COP tank with 2% caustic wash.
 3. Scrub the blind tapped air screw hole vigorously by plunging a clean 1/2" diameter sanitary bristle pipe brush in and out of the hole for two minutes while submerged.
 4. Soak air screw in acid sanitiser for 5 minutes, then scrub blind tapped hole as described in step 3 above.
 5. Rinse well with clean water and blow-dry blind tapped hole with clean air.
 6. Swab test the inside of the tapped hole to determine cleanliness.
 7. Should the swab test fail, repeat steps 2 to 6 above until the swab test is passed.
- Should swab testing continue to fail, or time is of the essence, install a new (spare) air shaft.
-

Step 2

Cleaning procedure for soiled shaft tapped hole (LKH Prime 10, LKH Prime 20):

1. Remove shaft (7) as per section 5.3 of the Service manual.
 2. Remove stud bolt (7a) from shaft.
 3. Submerge and soak the shaft for 5 minutes in COP tank with 2% caustic wash.
 4. Scrub the blind tapped shaft hole vigorously by plunging a clean 1/2" diameter sanitary bristle pipe brush in and out of the hole for two minutes while submerged.
 5. Soak shaft in acid sanitiser for 5 minutes, then scrub blind tapped hole as described in step 4 above.
 6. Rinse well with clean water and blow-dry blind tapped hole with clean air.
 7. Swab test the inside of the tapped hole to determine cleanliness.
 8. After approved swab test, assemble stud bolt (7a) in shaft (7), only finger tight (no torque)
 9. Should the swab test fail, repeat steps 3 to 7 above until the swab test is passed.
- Should swab testing continue to fail, or time is of the essence, install a new (spare) shaft.



5 Maintenance

Read the instructions carefully. The items refer to the parts list and service kits section.

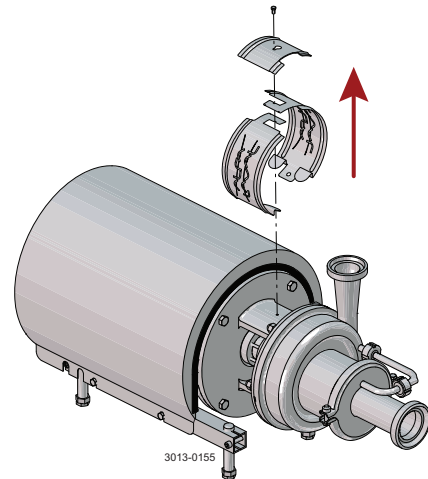
Handle scrap correctly.

* : Relates to the shaft seal.

5.3 Dismantling of pump/shaft seals

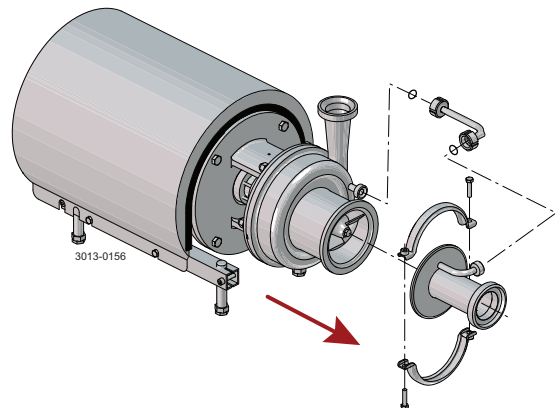
Step 1

Remove screw (23) and safety guard (22)



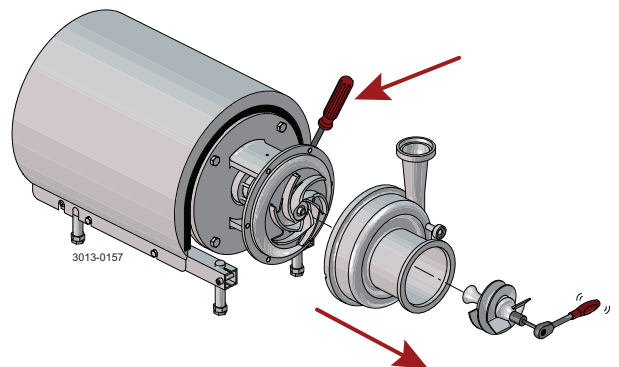
Step 2

1. Loosen unions and remove recirculation pipe (56)
2. Remove clamp (57) and front cover (60)



Step 3

1. Remove air screw (58) with a spanner. Counter hold with a screwdriver on pump shaft (7)
2. Unscrew cap nuts (24). Remove washers (24a) and pump casing (29)

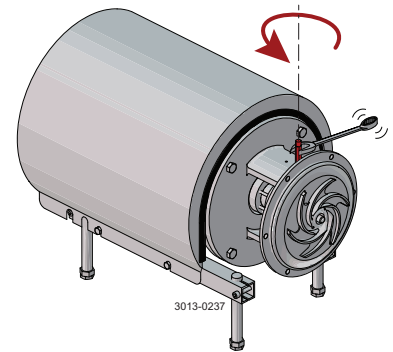


Read the instructions carefully. The items refer to the parts list and service kits section.
Handle scrap correctly.
* : Relates to the shaft seal.

Step 4

Double mechanical shaft seal:

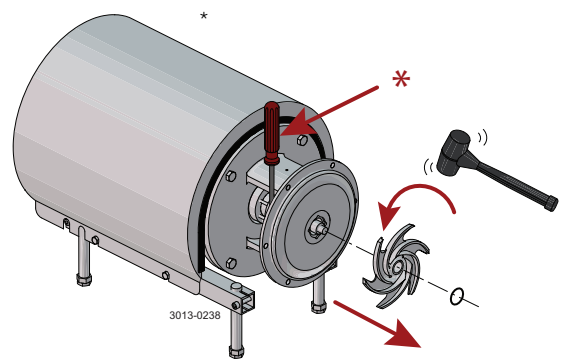
Unscrew tubes (42) using a spanner



Step 5

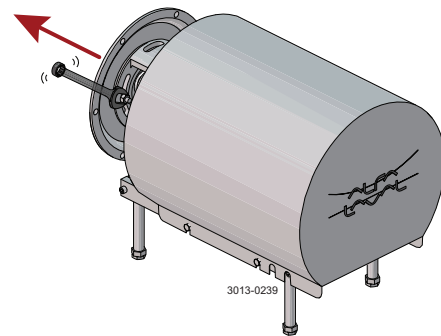
1. Remove impeller (27). If necessary, loosen the impeller by tapping gently on the impeller vanes
2. Remove the O-ring (38) from the impeller

* Counter hold with a screwdriver - if necessary!



Step 6

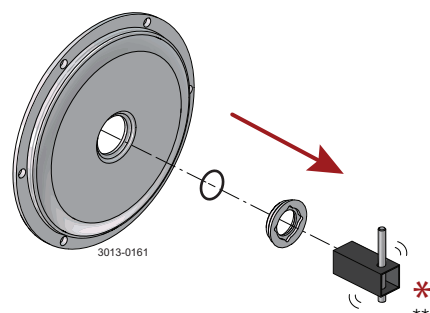
1. Remove the O-ring (26) from the back plate (25)
2. Unscrew nuts (20) and remove the washers (21) and the back plate (25)



Step 7

1. Remove the stationary seal ring (11)
2. Remove the O-ring (12) from the back plate (25)

* Use the tool supplied
** Left-hand thread!



5 Maintenance

Read the instructions carefully. The items refer to the parts list and service kits section.

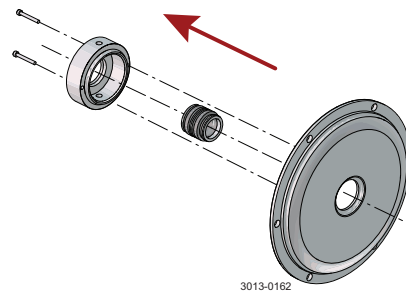
Handle scrap correctly.

* : Relates to the shaft seal.

Step 8

Double mechanical shaft seal:

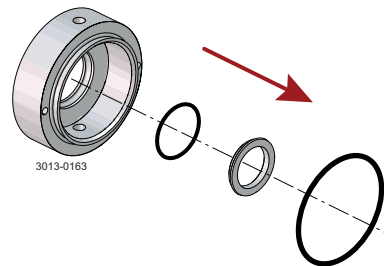
1. Remove screws (41) and seal housing (40a)
2. Remove rotating seal rings (14) and drive ring (52) from spring (13)
3. Remove O-rings (15) from rotating seal rings (14)



Step 9

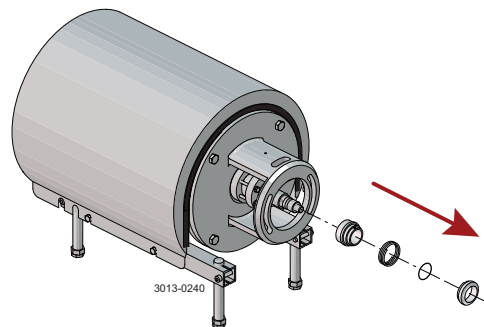
Double mechanical shaft seal:

1. Remove stationary seal ring (51) from seal housing (40a)
2. Remove O-ring (50) from stationary seal ring (51)
3. Remove O-ring (44) from seal housing (40a)



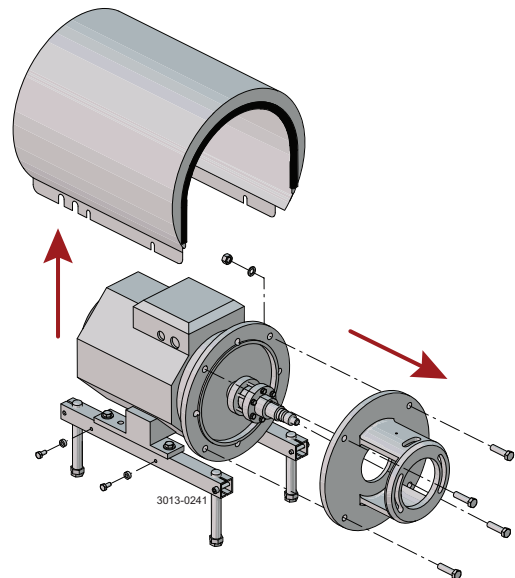
Step 10

1. Remove the complete shaft seal from the stub shaft (7)
2. Remove spring (13) and rotating seal ring (14) from the drive ring (10)



Step 11

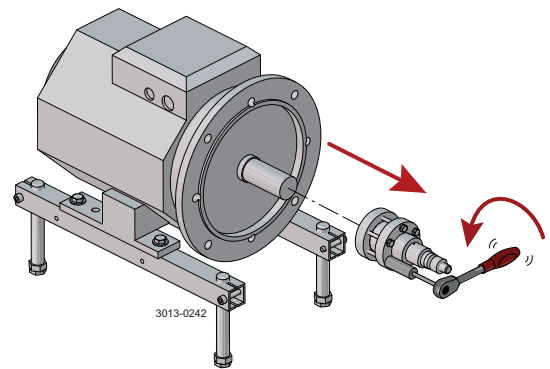
1. Remove shroud (2)
2. Unscrew nuts (18) and remove washers (19), screws (17) and adapter (16)



Read the instructions carefully. The items refer to the parts list and service kits section.
Handle scrap correctly.
* : Relates to the shaft seal.

Step 12

1. Slide off stub shaft (7) together with compression rings (5a, 5b)



5 Maintenance

Read the instructions carefully. The items refer to the parts list and service kits section.

Handle scrap correctly.

* : Relates to the shaft seal.

5.4 Assembly of pump/single shaft seal

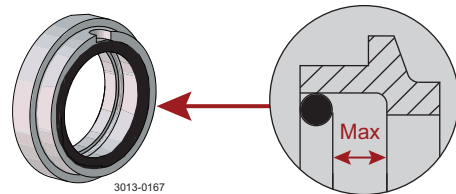
NOTE: If fitting SiC/SiC single seal, the static seal face must be marked "LKH Prime".

Step 1

1. Remove spring (13)

NOTE!

Make sure that O-ring (15) has maximum clearance from the sealing surface

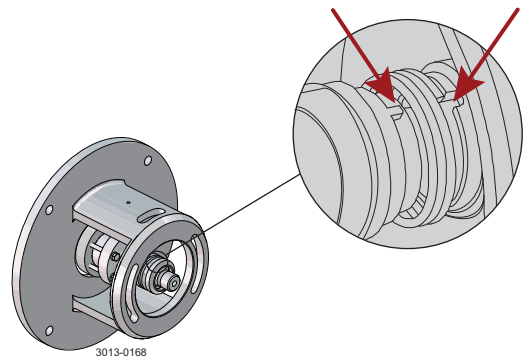


Step 2

1. Refit spring (13) on rotating seal ring (14)
2. Fit the spring and the rotating seal ring on drive ring (10)

CAUTION

Ensure that the driver on the drive ring is inserted into the notch in the rotating seal ring.

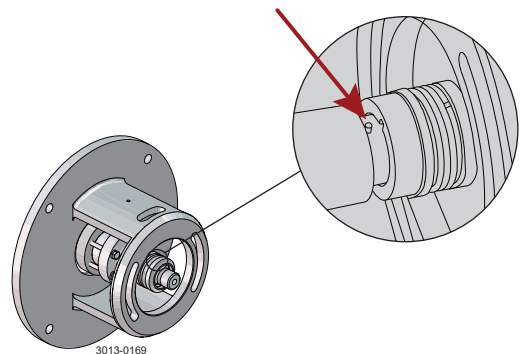


Step 3

Fit the complete shaft seal onto the stub shaft (7)

NOTE!

Make sure that the Connex pin (8) onto the the stub shaft is inserted into the notch in the drive ring (10)

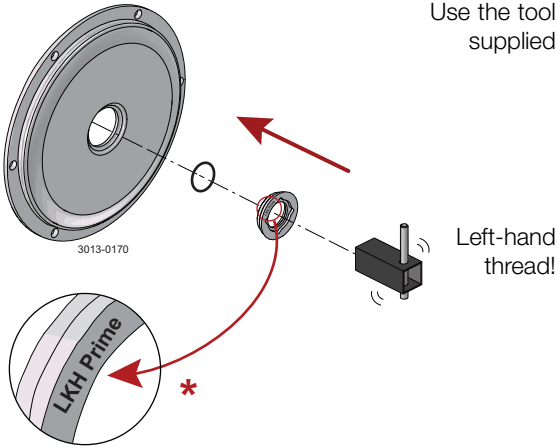


Read the instructions carefully. The items refer to the parts list and service kits section.
Handle scrap correctly.
* : Relates to the shaft seal.

Step 4

- 1. Fit O-ring (12) on stationary seal ring (11) and lubricate
- 2. Screw the stationary seal ring into back plate (25)

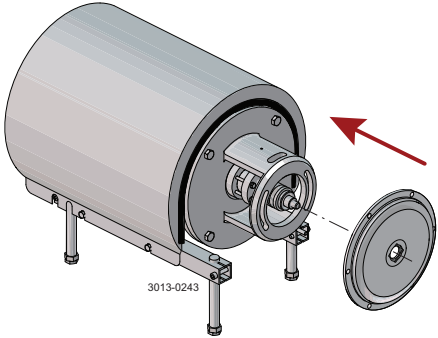
CAUTION
Only tighten by hand to avoid deforming the stationary seal ring.
(Max. 7 Nm/5 lbf-ft)



*) **NOTE!** : If fitting SiC/SiC single seal, the static seal face must be marked "LKH Prime".

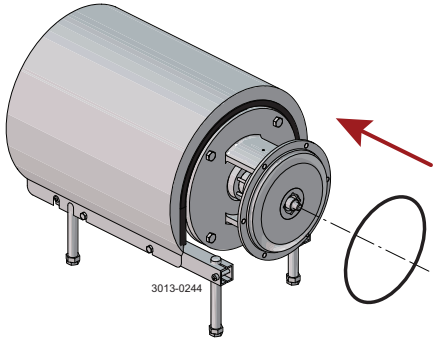
Step 5

- 1. Clean the sealing surfaces with contact cleaner before fitting the back plate (25)
- 2. Carefully guide the back plate onto the adapter (16)
- 3. Fit washers (21) and nuts (20)



Step 6

Lubricate O-ring (26) and slide it onto back plate (25)



5 Maintenance

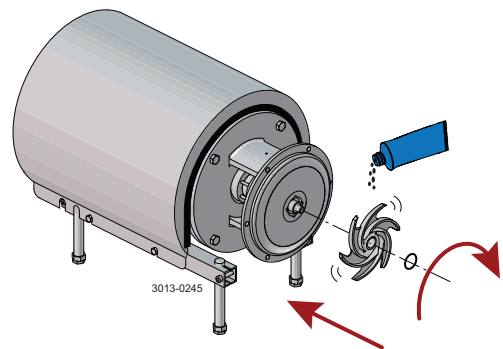
Read the instructions carefully. The items refer to the parts list and service kits section.

Handle scrap correctly.

* : Relates to the shaft seal.

Step 7

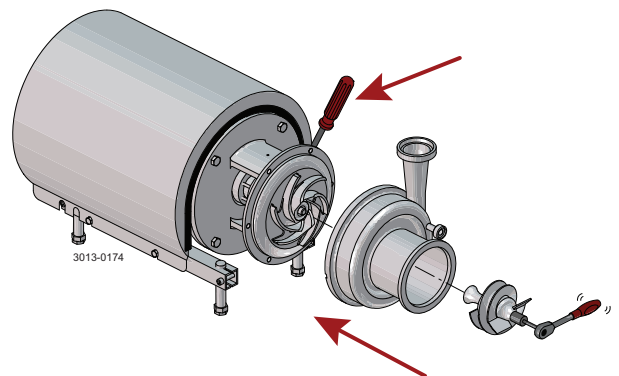
1. Lubricate O-ring (38) and fit it into the impeller (37)
2. Lubricate impeller hub with silicone grease or oil
3. Screw the impeller onto the stub shaft (7)



Step 8

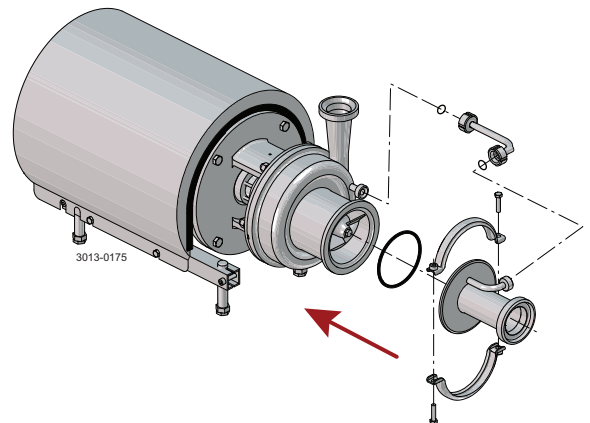
1. Fit pump casing (29) and washers (24a). Fit and tighten cap nuts (24) according to torque values in chapter 6 Technical data
2. Adjust pump casing (29) to correct position
3. Tighten nuts (20) for back plate (25), according to torque values in chapter 6 Technical data
4. Fit air screw (58) and tighten with a spanner (Torque: see table below)

LKH Prime 10:	Torque = 20 Nm (15 lbf-ft)
LKH Prime 20:	Torque = 20 Nm (15 lbf-ft)
LKH Prime 40:	Torque = 40 Nm (30 lbf-ft)



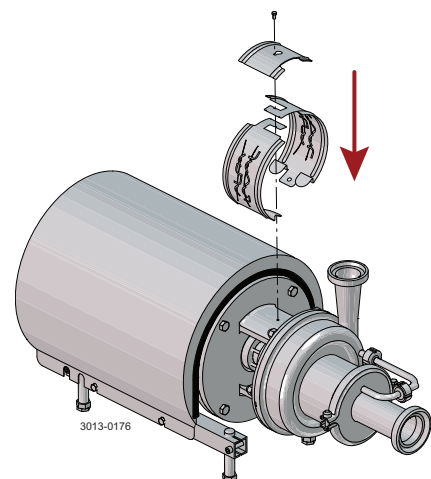
Step 9

1. Fit front cover O-ring (59) and fit and align front cover (60)
2. Fit clamp and tighten screws (57) gently
3. Fit recirculation pipe (56), align front cover (60) and tighten unions
4. Tighten clamp screws (57)



Step 10

Fit safety guards (22) and screw (23), and tighten
If pump is not supplied with flush connections, the holes in the adapter will be covered by the guard



Read the instructions carefully. The items refer to the parts list and service kits section.

Lubricate the rubber seals before fitting them.

* : Relates to the shaft seal.

5.5 Assembly of pump/double mechanical shaft seal

Step 1

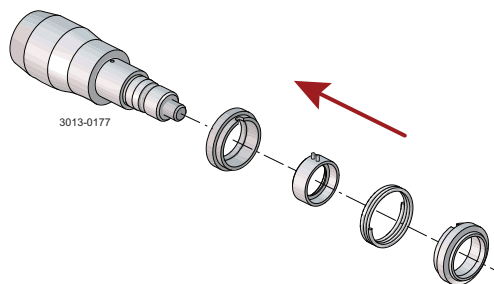
1. Fit O-rings (15) in rotating seal rings (14)
2. Fit spring (13) onto one of the rotating seal rings (14) and place the drive ring (52) in between

Step 2

1. Fit the second rotating ring (14) on the other end of the spring
2. Place the parts on the stationary seal ring fitted in the back plate (25)

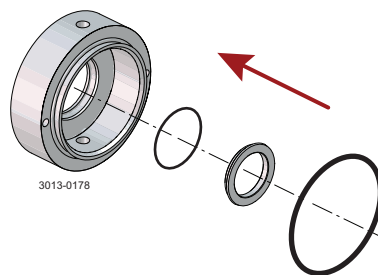
NOTE

Ensure that both drive pins on the drive ring are inserted into the notches in the rotating seal rings.



Step 3

1. Lubricate O-ring (44) and slide onto seal housing (40a)
2. Lubricate O-ring (50) and fit on stationary seal ring (51), then fit this in the seal housing

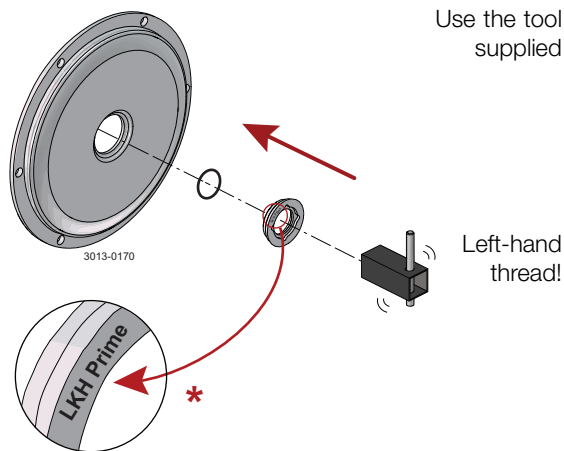


Step 4

1. Fit O-ring (12) on stationary seal ring (11) and lubricate
2. Screw the stationary seal ring into the back plate (25)

CAUTION

Only tighten by hand to avoid deforming the stationary seal ring.
(Max. 7 Nm/5 lbf-ft)



*) **NOTE!** : If fitting SiC/SiC single seal, the static seal face must be marked "LKH Prime".

5 Maintenance

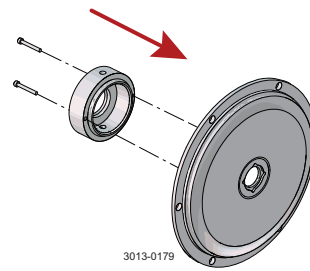
Read the instructions carefully. The items refer to the parts list and service kits section.

Lubricate the rubber seals before fitting them.

* : Relates to the shaft seal.

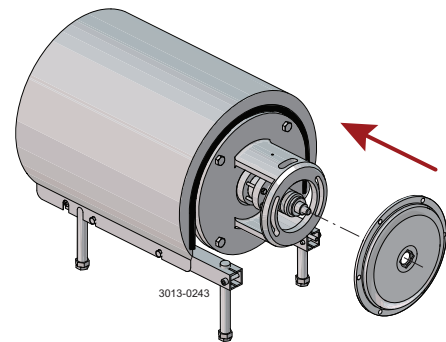
Step 5

1. Clean the sealing surfaces with contact cleaner
2. Fit seal housing (40a) on the back plate (25) and tighten screws (41)



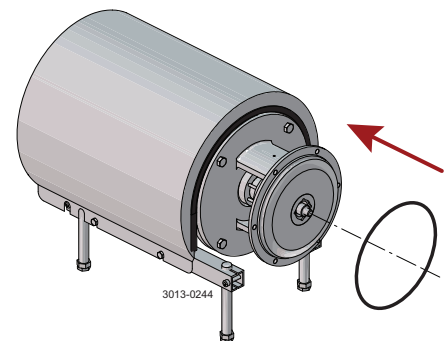
Step 6

1. To enable the fitting of the back plate (25) with the shaft seal, remove the Connex pin (8) from the stub shaft (7) (if fitted)
2. Carefully guide the back plate onto the adapter (16)
3. Fit washers (21) and nuts (20)



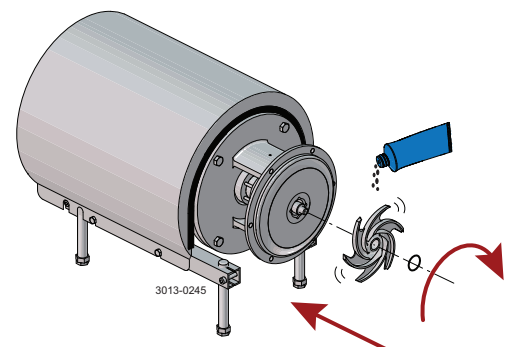
Step 7

Lubricate O-ring (26) and slide it onto back plate (25)



Step 8

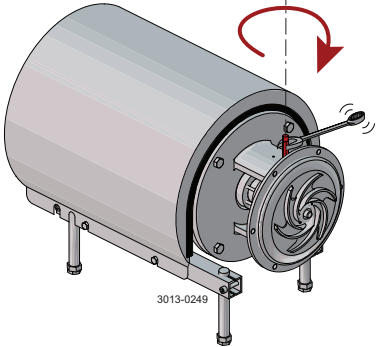
1. Lubricate the O-ring (38) and fit it into the impeller (37)
2. Lubricate the impeller hub with silicone grease or oil
3. Screw impeller (27) onto stub shaft (7)



Read the instructions carefully. The items refer to the parts list and service kits section.
 Lubricate the rubber seals before fitting them.
 * : Relates to the shaft seal.

Step 9

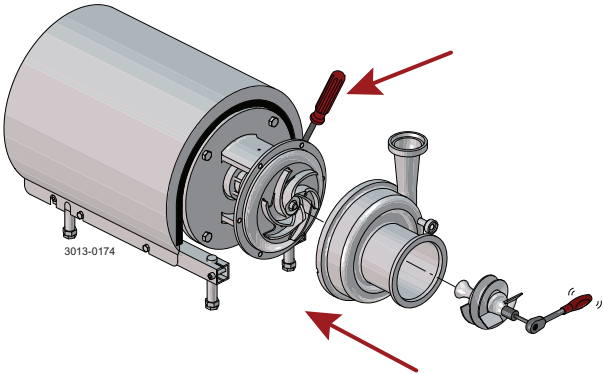
1. Screw tubes (42) into seal housing (40a)
2. Tighten with a spanner



Step 10

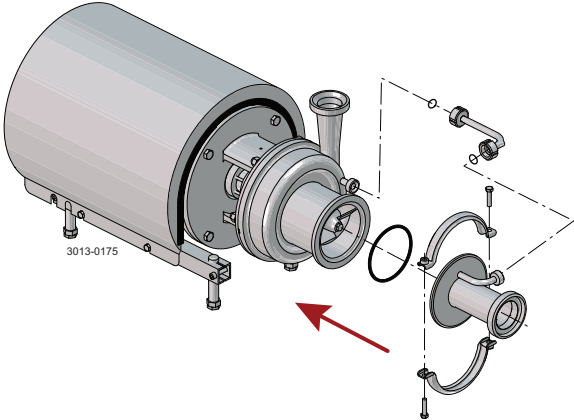
1. Fit pump casing (29) and washers (24a). Fit and tighten cap nuts (24) according to torque values in chapter 6 Technical data
2. Adjust pump casing (29) to correct position
3. Tighten nuts (20) for back plate (25), according to torque values in chapter 6, Technical data
4. Fit air screw (58) and tighten with a spanner (Torque: see table below)

LKH Prime 10:	Torque = 20 Nm (15 lbf-ft)
LKH Prime 20:	Torque = 20 Nm (15 lbf-ft)
LKH Prime 40:	Torque = 40 Nm (30 lbf-ft)



Step 11

1. Fit front cover O-ring (59) and fit and align front cover (60)
2. Fit clamp and tighten screws (57) gently
3. Fit recirculations pipe (56), align front cover (60) and tighten unions
4. Tighten clamp screws (57)



5 Maintenance

Read the instructions carefully. The items refer to the parts list and service kits section.

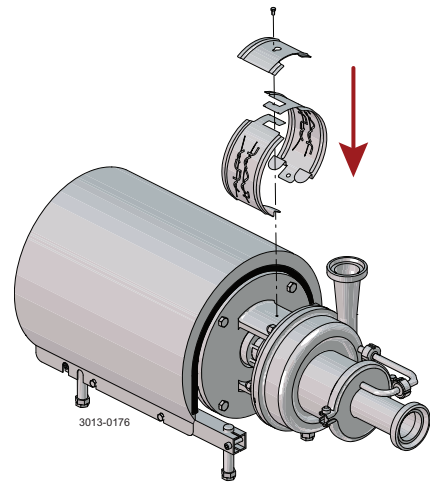
Lubricate the rubber seals before fitting them.

* : Relates to the shaft seal.

Step 12

Fit safety guard (22) and screw (23), then tighten

If pump is not supplied with flush connections, the holes in the adapter will be covered by the guard

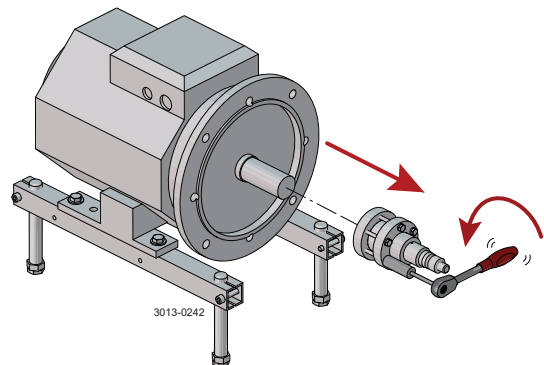


Read the instructions carefully. The items refer to the parts list and service kits section.
Lubricate the rubber seals before fitting them.
* : Relates to the shaft seal.

5.6 Adjustment of shaft

Step 1

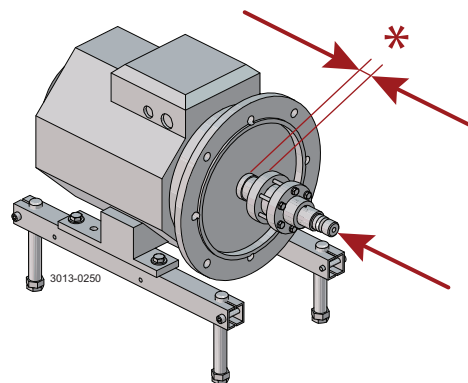
1. Loosen screws (6)
2. Pull off stub shaft (7) together with compression rings (5a, 5b)



Step 2

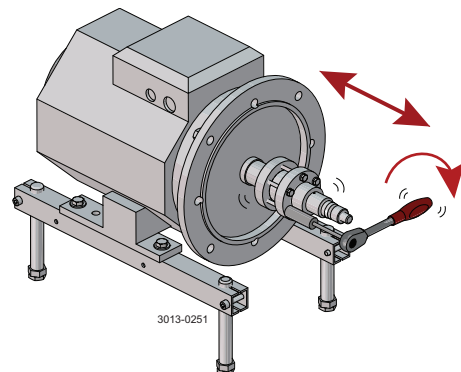
1. Push stub shaft (7) together with compression rings (5a, 5b) onto the motor shaft
2. Check that the clearance between the end of the stub shaft and the motor flange is 10-20 mm (0.39 - 0.78 inch)

* 10-20 mm
(0.39-0.78 inch)



Step 3

1. Tighten screws (6) gently and evenly
2. Ensure that the stub shaft (7) can be moved on the motor shaft



5 Maintenance

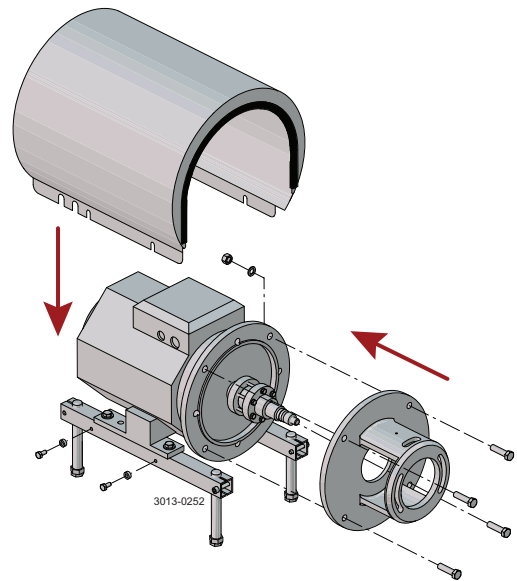
Read the instructions carefully. The items refer to the parts list and service kits section.

Lubricate the rubber seals before fitting them.

* : Relates to the shaft seal.

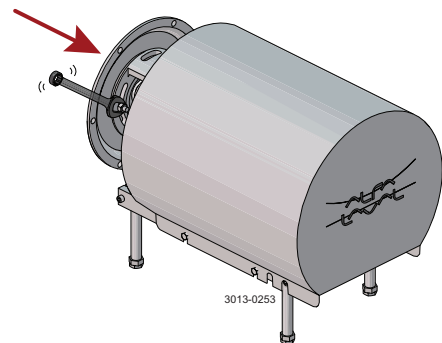
Step 4

1. Fit shroud (2)
2. Fit adapter (16), screws (17), washers (19) and nuts (18), and tighten



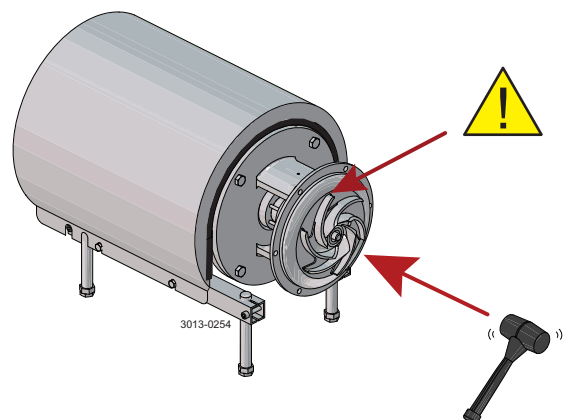
Step 5

1. For the double mechanical shaft seal:
Fit drive ring (52) on stub shaft (7)
2. Fit back plate (25), washers (21) and nuts (20), and tighten



Step 6

1. Fit impeller (27) on stub shaft (7)
2. Ensure that the clearance between the impeller and back plate (25) is correct: 0.5 mm (0.02 inch)
3. Tighten screws (6) evenly until the stub shaft (7) cannot move on the motor shaft

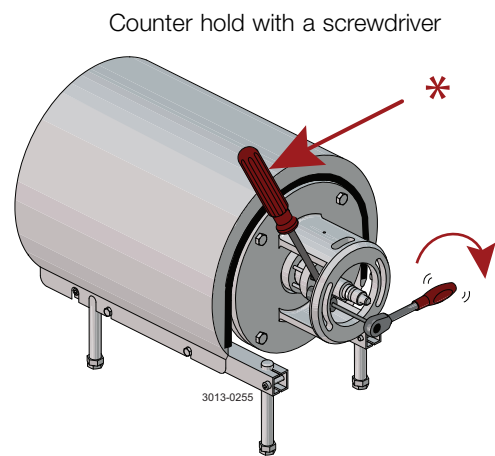


Read the instructions carefully. The items refer to the parts list and service kits section.
Lubricate the rubber seals before fitting them.
* : Relates to the shaft seal.

Step 7

1. Remove impeller (27), back plate (25) and drive ring (52)
2. Tighten screws (6) evenly to 15 Nm (11 lbf-ft)
3. Pump is assembled according to section 5.4 for single shaft seal and section 5.5 for double mechanical seal

* 15Nm
(11 lbf-ft)



6 Technical data

*It is important to observe the technical data during installation, operation and maintenance.
Inform personnel about the technical data.*

6.1 Technical data

The LKH pump is a highly efficient and economical centrifugal pump, which meets the requirements of sanitary and gentle product treatment and chemical resistance. LKH Prime is available in the sizes specified on the declaration of conformity chapter 1. The instruction manual is part of the delivery. Read the instructions carefully. The pump is very heavy. Alfa Laval recommends the use of a lifting crane when handling the pump.

Data	
Max. inlet pressure	500 kPa (5 bar) (72.5 psi)
Temperature range	-10°C to +140°C (EPDM) (14 to 284°F)
Max. speed:	3600 rpm
Min. speed, pumping product (no air):	900RPM
Min. speed, releasing air:	2800RPM (full speed 2 poled motor, 50Hz)
Materials	
Product wetted steel parts	AISI 316L
Other steel parts	Stainless steel
Finish	Standard blasted
Product wetted seals	EPDM (standard)
Other O-rings	EPDM (standard)
Alternative seals	Nitrile (NBR) and fluorinated rubber (FPM)
Shaft seal	
Seal types	External single or double mechanical seal
Max. temperature flush medium	70°C
Max. water pressure (DMS)	Normally atmospheric (max. 5 bar) (max. 72.5 psi)
Water consumption (double mechanical seal)	0.25-0.5 l/min. (0.07-0.13 gl)
Material, stationary seal ring	Acid-resistant steel with sealing surface of silicon carbide
Material, rotating seal ring	Carbon (standard) or silicon carbide
Material, O-rings	EPDM (standard)
Alternative material, O-rings	Nitrile (NBR) and fluorinated rubber (FPM).
Air release time (no medium supply)	Max 15 min
NOTE: If running SiC/SiC single seal, the static seal face must be marked "LKH Prime".	
Motor	
Foot-flanged motor according to IEC metric or NEMA standard, 2 poles = 3000/3600 rpm. at 50/60 Hz IP55, insulation class F	

For further information, see PD sheet.

*It is important to observe the technical data during installation, operation and maintenance.
Inform personnel about the technical data.*

6.2 Relubrication intervals

For recommended grease types and general maintenance follow the recommendations in the motor instruction manual.
For relubrication intervals see motor name plate.
For further information contact your local Alfa Laval Technical Support

6.3 Torque specifications

The table below specifies the tightening torques for the screws, bolts and nuts in this pump.
Always use the torques specified below if no other values are shown. This may affect of personal safety.

Size	Tightening torque	
	Nm	lbf-ft
M8	20	15
M10	40	30
M12	67	49
M14	110	81

6.4 Weight (kg)

Pump Type: LKH Prime

Size	Frame size					
	90	100	112	132	160	180
10	65	80	85	110		
20		80	85	110	180	
40				120	185	220

6 Technical data

*It is important to observe the technical data during installation, operation and maintenance.
Inform personnel about the technical data.*

6.5 Noise emission

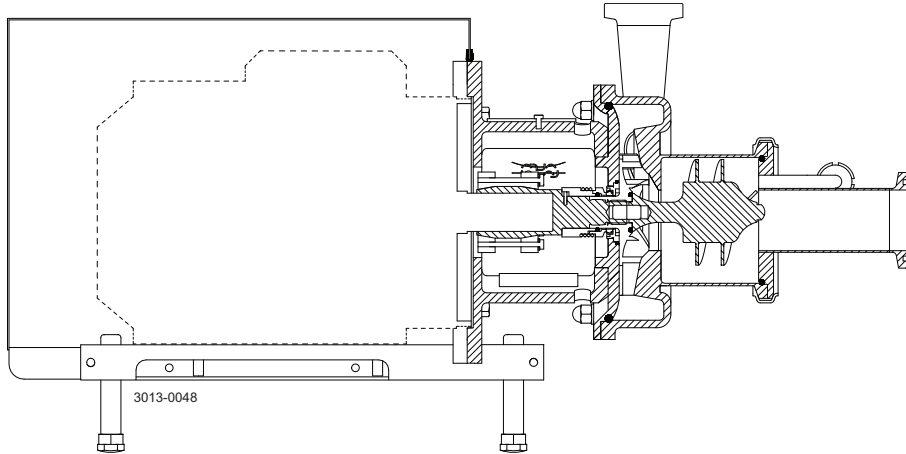
Pump Type	Sound pressure level (dBA)
LKH-5	60
LKH-10	69
LKH-15	72
LKH-20	70
LKH-25	74
LKH-35	71
LKH-40	75
LKH-45	70
LKH-50	75
LKH-60	77
LKH-70	88
LKH-75	79
LKH-85	86
LKH-90	75
LKH Prime 10	69
LKH Prime 20	74
LKH Prime 40	77
LKH-112	70
LKH-113	69
LKH-114	68
LKH-122	75
LKH-123	77
LKH-124	80
SolidC-1	68
SolidC-2	72
SolidC-3	73
SolidC-4	72
MR-166	76
MR-185	82
MR-200	81
MR-300	82
GM	54
FM-OS	61

The above LKH noise levels are the same for LKHPF, LKHI, LKH UltraPure, LKH Evap and LKHHex.
The above LKH Prime is the same for LKH Prime UltraPure.
The above SolidC noise levels are the same for SolidC UltraPure.

The noise measurements have been carried out with the original motor and shroud, approximately at the Best Efficiency Point (BEP) with water at ambient temperature and at 50Hz.
Often the noise level generated by the flow through the process system (eg. valves, pipes, tanks etc.) is much higher than that generated by the pump itself. Therefore it is important to consider the noise level from the whole system and take the necessary precautions with regard to personal safety, if required.

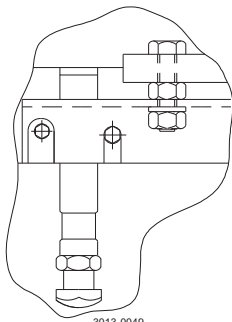
The drawing shows the LKH Prime pump, sanitary version.

7.1 LKH Prime sanitary version

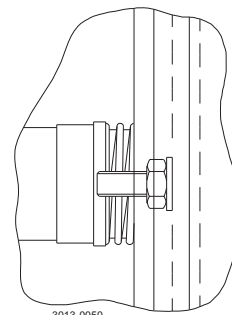


LKH Prime

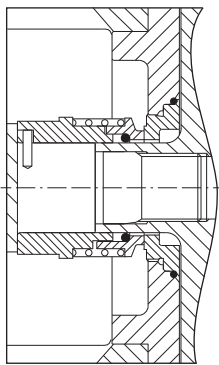
US legs are different to those shown. For further information, see US spare parts.



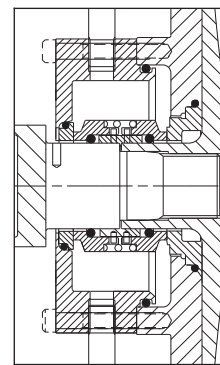
Only used for 3 kW
Fitting of legs



Fitting of back plate



Single shaft seal

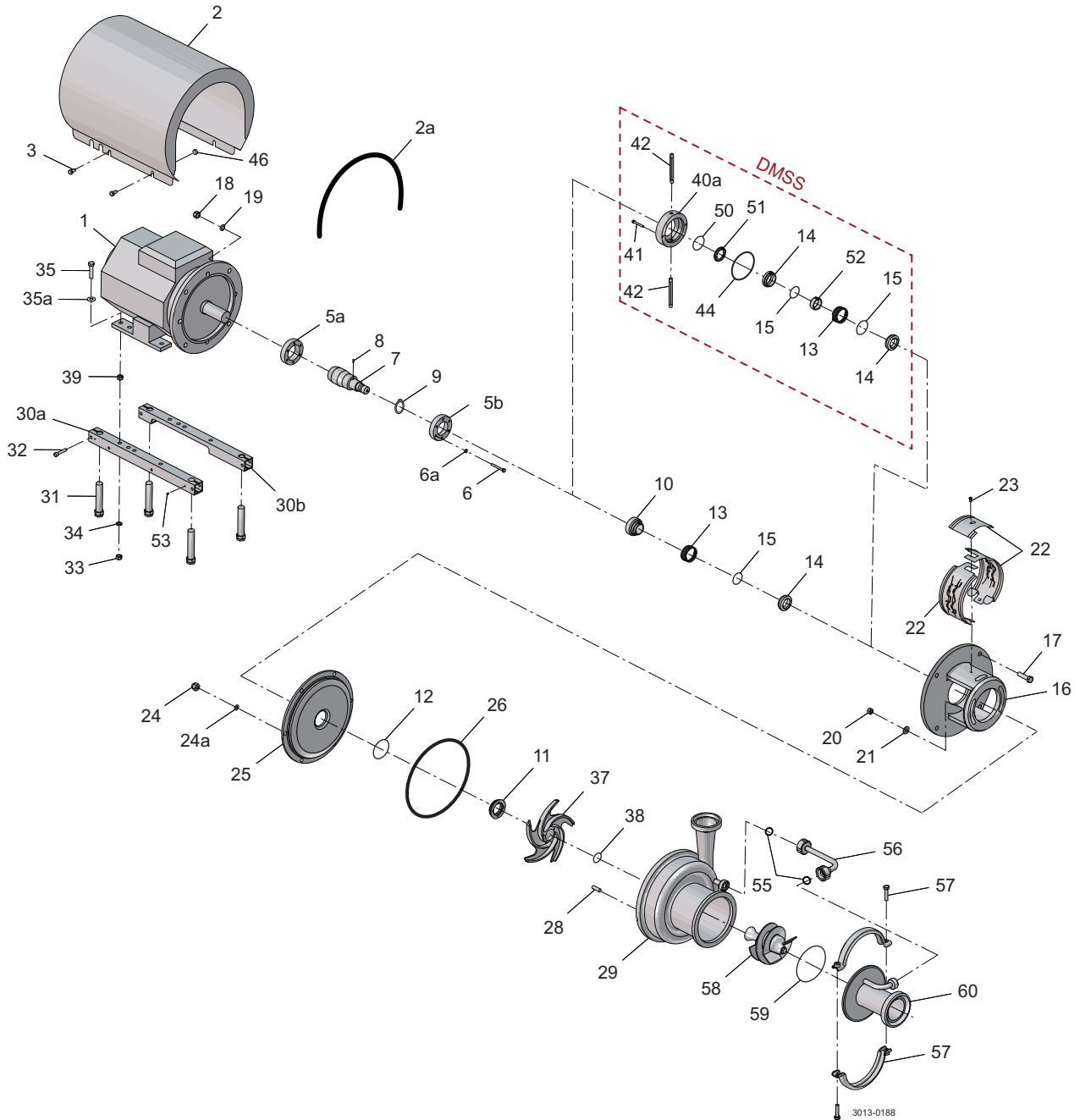


Double mechanical shaft seal

7 Part list and service kits

The drawing shows the LKH Prime pump, sanitary version.

7.2 LKH Prime - Product wetted parts



7 Part list and service kits

The drawing shows the LKH Prime pump, sanitary version.

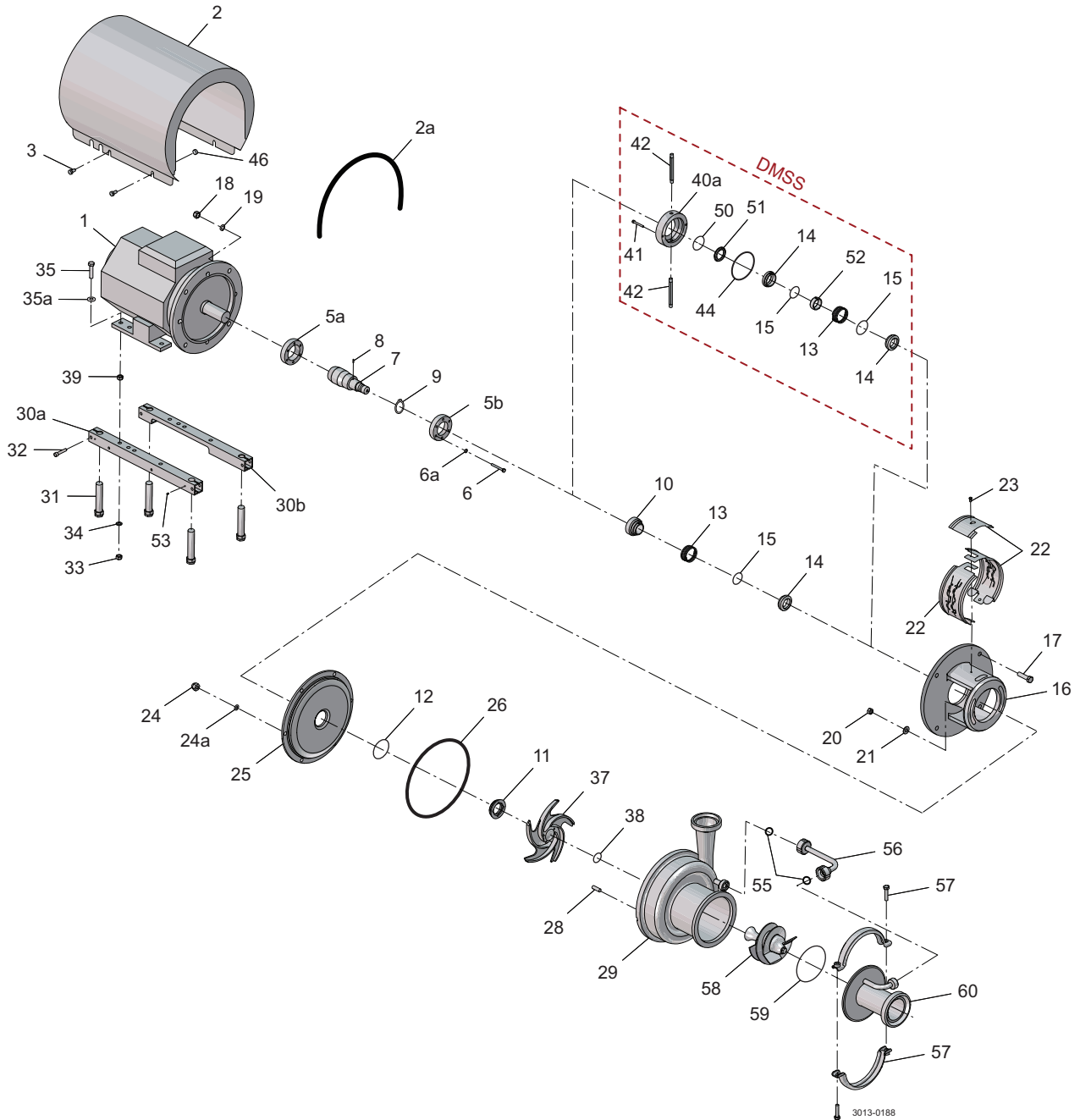
Parts list

Pos.	Qty	Denomination
20	2	Nut
21	2	Washer
24	6	Cap nut
24a	6	Washer
25	1	Back plate
26 ◆△◆●	1	O-ring
28	6	Bolt
29		Pump casing
37	1	Impeller
38 ◆△◆●	1	O-ring
55 ◆△◆●	2	O-ring
56	1	Recirculation pipe
57	1	Clamp set
58	1	Air screw
59 ◆△◆●	1	O-ring
60		Front cover

7 Part list and service kits

The drawing shows the LKH Prime pump, sanitary version.

7.3 LKH Prime - Motor-dependent parts



7 Part list and service kits

The drawing shows the LKH Prime pump, sanitary version.

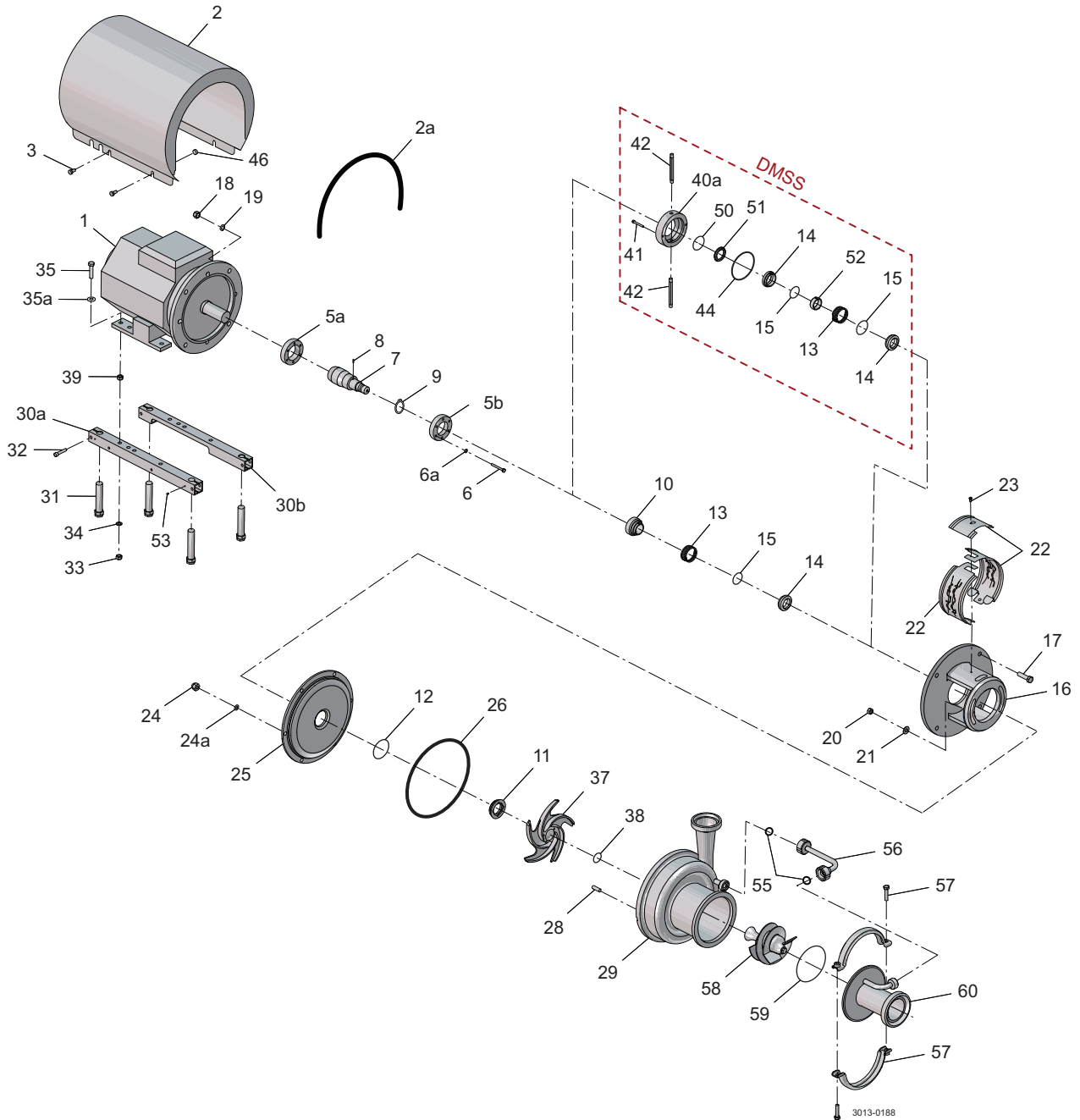
Parts list

Pos.	Qty	Denomination
1	1	Motor ABB
2	1	Shroud
2a	1	Edge list
3	4	Screw
5a	1	Compression ring with thread
5b	1	Compression ring without thread
6	6	Screw
6a	6	Washer
7	1	Shaft LKH Prime 20
	1	Shaft LKH Prime 40
7a	1	Stud bolt (included in pos 7 , LKH Prime 20)
	1	Connex pin, (included in pos 7)
9	1	Retaining ring, (included in pos 7)
16	1	Adaptor
17	4	Screw for adapter
18	4	Nut for adapter
19	4	Washer for adapter
22	1	Safety guard set
23	1	Screw for safety guard
30a	1	Support bar, right
30b	1	Support bar, left
31	4	Leg
32	4	Screw
33	4	Nut
34	4	Spring washer
35	4	Screw
35a	4	Washer
39	4	Nut
46	4	Distance sleeve
53	4	Pivot screw

7 Part list and service kits

The drawing shows the LKH Prime pump, sanitary version.

7.4 LKH Prime - Shaft seal



7 Part list and service kits

The drawing shows the LKH Prime pump, sanitary version.

Parts list

Pos.	Qty	Denomination
◆	1	Tool complete
◆		Complete shaft seal
◇		Complete shaft seal
△		Complete seal
●		Complete shaft seal
10	1	Drive ring
11	1	Stationary seal ring
12	1	O-ring
13	1	Spring
14	1	Rotating seal ring
15	1	O-ring
40a	1	Seal housing
41	2	Screw for seal housing
42	2	Tube
44	1	O-ring for seal housing
50	1	O-ring
51	1	Sec. stationary seal ring
52	1	Drive ring

Service kits

Denomination	EPDM	NBR	FPM
Service kit for single shaft seal C/SiC			
◆ Service kit, C/SiC (LKH Prime 10)	8010001210	8010001211	8010001212
◆ Service kit, C/SiC (LKH Prime 20)	9611927175	9611927176	9611927177
◆ Service kit, C/SiC (LKH Prime 40)	9611927210	9611927211	9611927212
Service kit for single shaft seal SiC/SiC			
◇ Service kit, SiC/SiC (LKH Prime 10)	8010001213	8010001214	8010001215
◇ Service kit, SiC/SiC (LKH Prime 20)	9611927178	9611927179	9611927180
◇ Service kit, SiC/SiC (LKH Prime 40)	9611927213	9611927214	9611927215
Service kit for double mechanical shaft seal C/SiC			
△ Service kit, C/SiC (LKH Prime 10)	8010001216	8010001217	8010001218
△ Service kit, C/SiC (LKH Prime 20)	9611927181	9611927182	9611927183
△ Service kit, C/SiC (LKH Prime 40)	9611927216	9611927217	9611927218
Service kit for double mechanical shaft seal SiC/SiC			
● Service kit, SiC/SiC (LKH Prime 10)	8010001219	8010001220	8010001221
● Service kit, SiC/SiC (LKH Prime 20)	9611927184	9611927185	9611927186
● Service kit, SiC/SiC (LKH Prime 40)	9611927219	9611927220	9611927221

Parts marked with ◆△◇● are included in the service kits.

Conversion kit single to double mechanical shaft seal : Please order double mechanical service kit + pos. 40a + 41 + 42.

Recommended spare parts: Service kits.

(900687/5)

How to contact Alfa Laval

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

Please visit www.alfalaval.com to access the information directly.

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