

# ROTO-JET® PUMP

01-30-2016 Rev 3

## RO, ROH, RG, 2100, 2200 & R-11 BALANCING SPECIFICATION

- 1) Clean the inside of the rotor and rotor cover. Make sure that the insides of the vanes are free from matter.
- 2) Assemble the rotor, rotor cover and shaft. The rotor cover should be installed with the rotor o-ring and rotor cover drain plugs.
- 3) Fill the rotor assembly with water. Install a balancing plug on the rotor cover. The balancing plug should have a hole in the center which will allow air to purge.
- 4) While holding the rotor assembly in a vertical position, spin the assembly to vent any air out of the balancing plug hole. Continue to spin the assembly until all the air has been removed. This may take up to 10 complete spins.
- 5) Place a pipe plug into the balancing plug to prevent any leakage.
- 6) Place the rotor assembly on the balancing machine.
- 7) The rollers on the balancing machine should be positioned on the bearing shaft surfaces.
- 8) Perform a two-plane balance. (Reference drawing below).
- 9) Place a ½ key (**RG/RO** 3.00"L x .500"W x .250"H - **R11** 2.500"L x .375" W x 2.250"H ) into the shaft key slot, flush with the end of the shaft. For ROH assembly use a full-length half key. **NOTE: The full-length haft key is recommend for operating speeds above 4380rpm on ROH Pumps which is based on current types of shaft key being used by customer with coupling hub or sheave bushing.**
- 10) Balance the assembly at 1000 for RO, RG, 2100, 2200 & R-11's. **For ROH's the balancing speed should as close to 1000 RPM as possible.**
- 11) **RG, 2100, 2200, RO & ROH balance within .15 in oz. Max per plane. R-11 balance within .20 in oz. Max per plane.**
- 12) **G 0.4 SPEC**
- 13) Make sure not to drill into the rotor cover capscrews.

*Capscrews      Place balancing plug here      Note: Max drill depth, max drill size & drill locations*

