



## NEW STYLE MICRO-DEOX/2000 WET SIDE

### NEW STYLE CASTING DIMENSIONS

Dear Evoqua Team Members,

We have recently seen peristaltic pump motor gearbox failures on units that have already been retrofitted with the new occlusion ring and mounting bolts. To correct the condition we have defined several assembly procedures to assure proper assembly and operation when the rotor and occlusion ring are installed. In addition to the dimensional differences on the casting when first released (as outlined in Aug 2014 Tech Service bulletin on Micro-Deox/2000 wet sides), there is also the possibility of error in the machining of the casting, which results in the occlusion ring mounting position being out of spec and off center with the motor shaft.

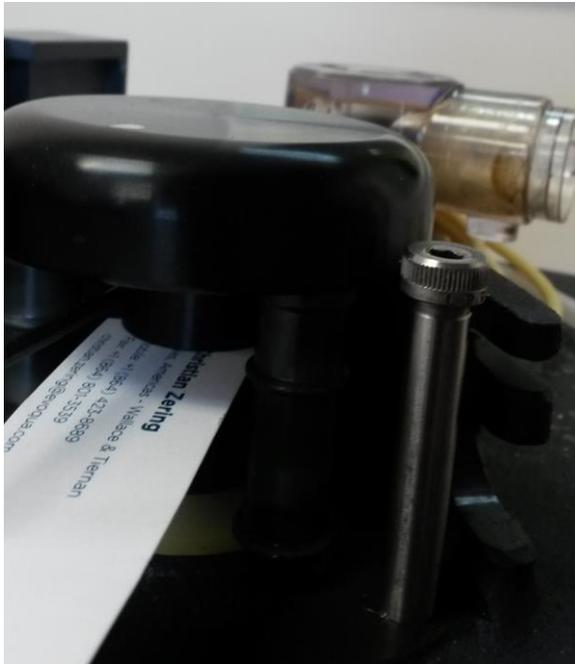
#### Existing Field Units Initial Failure With Original As Shipped Casting and Occlusion Ring

- If a customer has a motor failure we should determine whether it is an old issue casting (see bullet point below).
- All units with CA serial numbers should have the proper revised casting dimensions and new occlusion ring and shoulder bolts in both bolt positions. They are correct as shipped, but the rotor should be checked for proper clearance, see special assembly instructions below.
- For units with BZ serial numbers not shipped with the revised occlusion ring, replace the occlusion ring, motor and occlusion ring bolts included in retrofit kit W3T327839. Be sure to install all the new parts for proper repair.
- For the old issue casting with the 0.010" machining difference (all serial numbers BX and earlier), in addition to the retrofit kit parts, the lower bolt should be replaced with the original ¼" diameter hex bolt with the shoulder bolt still installed in the upper hole. This will allow the smaller diameter hex bolt to compensate for the machining differences. See special assembly instructions below.
- Retrofit kits will be supplied as NC warranty parts through the standard warranty process. Submit NC form with original PO number and ship to address to Tech Service for processing.
- If another failure occurs within a year after making these modifications contact Tech Service immediately. Upon review of the failure specifics a determination will be made if the unit can be repaired or should then be replaced.

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### Special Reassembly Instructions

- Gap all rotors to 0.010" when installing. A business card works well as a spacer if a feeler gauge is not available. Insert the gapping device between the rotor and the casting (see photo below) and tighten set screw being sure the set screw is on the flat surface milled into the end of the motor shaft.



- For BX and earlier serial number units, install the shoulder bolt in the top position first and tighten all the way. Install the original standard hex bolt in the lower position. Tighten lower bolt to finger tight until the occlusion ring is flat against the machined casting surface, then ¼ turn to final position. DO NOT overtighten lower bolt.
- Be sure rotor pins, rollers and thrust washer are free of scaring and clean of dirt and debris before reassembly. Apply a thin coat of silicone grease to rotor pins only when installing the rotor and rollers. Do not use Molykote or graphite based lubricants or any other type of grease.

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