

Gast Rotary Vane Recommended Service Intervals

Intake Air Filter and Muffler Assembly

Intake air filters should be replaced annually for maximum performance and protection of the compressor. The intake filter should be changed more often when the compressor is operating in extreme conditions with high levels of contaminants in the air. Muffler assemblies should be replaced every 6 months under normal operating conditions and more often when operating under extreme conditions. The most common cause for broken vanes and scored units is due to poor filtration and exhaust restriction causing back pressure.

Separate Drive Non-Lubricated			
Separate Drive Oilless	Vacuum Filter Elements	Muffler Elements	Compressor Intake Filter
0240 Oilless	B344A (Qty 2)	B344A (Qty 2)	B344A (Qty 2)
0440-0465 Oilless	B344A (Qty 2)	B344A (Qty 2)	B344A (Qty 2)
0740 Oilless	B344A (Qty 2)	B344A (Qty 2)	B344A (Qty 2)
1067 Oilless	AC393	AC393	AC393
1550 Oilless	AC393	AC393	AC393
2067-2565-2567 Oilless	AC393	AC393	AC393
3040 Oilless	AC393	AC393	AD752
5565 Oilless	AD752	AD752	AD752
6066 Oilless	AD752	AD752	AD752

Separate Drive Lubricated			
Separate Drive Lubricated	Vacuum Filter Elements	Muffler Elements	Compressor Intake Filter
0240 lubricated	B344A (Qty 2)	B344A (Qty 2)	B344A (Qty 2)
0440-0465 lubricated	B344A (Qty 2)	B344A (Qty 2)	B344A (Qty 2)
1065 lubricated	AC393	AC393	AC393
0740-0765 lubricated	B344A (Qty 2)	B344A (Qty 2)	B344A (Qty 2)
2065 lubricated	AC393	AC393	AC393
2067-2565-2567 lubricated	AC393	AC393	AC393
3040 lubricated	AC393	AC393	AD752
5565 lubricated	AD752	AD752	N/A

Vanes

Gast rotary vanes are engineered to have low wear rate, but like all rotary vane compressors, the vanes will eventually require replacement. The vanes should be replaced when any one of vanes in the compressors wears to the point that it measures less than the minimum height dimension illustrated in the chart below. Vanes should always be replaced as a complete set.

Separate Drive Non-Lubricated Vanes				Replace Vane if size is smaller than below
Used On Model	Part No.	Material	No. Required	Width
0240 Oilless	AD286	Carbon	4	35/64"
0440-0465 Oilless	AD372	Carbon	4	35/64"
0740 Oilless	AA510A	Carbon	4	45/64"
1067 Oilless	AH430	Carbon	4	1.9/16"
1550 Oilless	AB125B	Carbon	4	7/8"
2067-2565-2567 Oilless	AH195	Carbon	4	53/64"
3040 Oilless	AB934A	Carbon	4	1.11/64"
5565 Oilless	AE310	Carbon	4	1 3/8"
6066 Oilless	AK738	Carbon	4	1 3/8"
Separate Drive Lubricated Vanes				Replace Vane if size is smaller than below
Used On Model	Part No.	Material	No. Required	Width
0240 lubricated	B2335C	Woven	4	35/64"
0440-0465 lubricated	B335H	Woven	4	35/64"
1065 lubricated	D335K	Woven	4	53/64"
0740-0765 lubricated	AA510E	Woven	4	45/64"
2065 lubricated	AA8D	Woven	4	53/64"
2067-2565-2567 lubricated	AA750G	Woven	4	53/64"
3040 lubricated	AB934H	Woven	4	1 11/64"
5565 lubricated	AE313A	Woven	4	1 7/64"

How to measure vane height:



40, 67 & 66 Series Oil-Less

1. Make sure unit is unplugged or is disconnected from power.
2. Remove filter and muffler assemblies from the unit and set aside.
3. Remove the fan or fan pulley using a pulley puller.
4. Remove the end cap with adjustable spanner wrench.
5. Remove snap ring along with Bellville springs and washer.
6. Remove the bolts from the dead endplate, than remove the endplate with the puller.
7. Press out the rotor assembly by using an arbor press.
8. Remove the drive end bearing deflector.
9. Do not take apart any further, you do not want to remove the drive end plate as this will change the internal clearances.
10. Inspect the vanes, noting the direction of the beveled edge and remove the vanes.
11. Clean the rotor and inside of the body and end plates using Gast AH255D flushing solvent to remove any carbon dust buildup.
12. Replace the rotor into the body and through the drive end plate.
13. Install deflector and press on bearing with arbor press.
14. Replace vanes, making sure that the beveled edge matches the contour of the body.
15. Replace dead endplate.
16. Install deflector and press on bearing with arbor press.
17. Replace dead end plate bolts and dowel pin. Torque bolts to 110 in-lbs.
18. Install Bellville springs, washer and snap ring.
19. Place a dial indicator against the dead end of the shaft to measure axial movement when setting the end clearance.
20. Place one drop of 222 Loctite to the threads of the drive end cap and install the end cap.
21. Set the end clearance by tightening the end cap with the adjustable spanner wrench until the dial indicator moves .001" on 0240, 0440 and 0740 models and .002" on 2067, 2567, 1550, 3040 and 6066 models.
22. Remove the old filters and muffler elements and clean the jars.
23. Remove the old gaskets and install new gaskets.
24. Install new elements and replace the jars. Tighten the jars so that they do not leak but make sure not over tighten which could cause damage.
25. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
26. Reconnect power and test unit performance.

40 & 67 Series Lubricated

1. Make sure unit is unplugged or is disconnected from power.
2. Remove filter, muffler and oil reservoir from the unit and set aside.
3. Remove the oiler feed tubes from the end plates.
4. Remove the fan or fan pulley using a pulley puller.
5. Remove the drive end cap with adjustable spanner wrench.
6. Remove snap ring along with Bellville springs & washer.
7. Remove the bolts from the dead endplate and remove the endplate with the puller.
8. Press out the rotor assembly using an arbor press.
9. Remove the drive end bearing deflector.
10. Do not take apart any further, you do not want to remove the drive end plate as this will change the internal clearances.
11. Inspect the vanes, noting the direction of the beveled edge and remove the vanes.
12. Clean the rotor and inside of the body and end plates using Gast AH255D flushing solvent to remove any carbon dust buildup.
13. Replace the rotor into the body and through the drive end plate.
14. Install deflector and press on bearing with arbor press.
15. Replace vanes, making sure to place a coating of oil on them and that the beveled edge matches the contour of the body.
16. Replace dead endplate.
17. Install deflector and press on bearing with arbor press.
18. Replace dead end plate bolts and dowel pin. Torque bolts to 110 in-lbs.
19. Install Bellville springs, washer and snap ring.
20. Place a dial indicator against the dead end of the shaft to measure axial movement when setting the end clearance.
21. Place one drop of 222 Loctite on the threads of the drive end cap and install the end cap.
22. To set the end clearance, tighten the end cap with the adjustable spanner wrench until the dial indicator moves .001" on 0240, 0440 and 0740 models and .002" on 2067, 2567, 1550 and 3040 models.
23. Remove the old filters, muffler elements and oiler wicks and clean the jar assemblies.
24. Remove the old gaskets and install new gaskets.
25. Install new elements and wicks and replace the jars. Tighten the jars so that they do not leak but make sure not over tighten which could cause damage.
26. Install oiler feed tubs to end plates and oil reservoir and refill the oil reservoir with Gast AD220 oil.
27. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
28. Reconnect power and test unit performance.

65 Series Lubricated

1. Make sure unit is unplugged or is disconnected from power.
2. Remove filter, muffler and oil reservoir from the unit and set aside.
3. Remove oiler feed tubes from the end plates.
4. Remove the fan guards, fans or fan pulley using a pulley puller.
5. Remove the oil feed tubes from the end plates.
6. Remove the dead end and drive end caps.
7. Remove the bolts from the dead endplate, than remove endplate with the puller.
8. Press out the rotor assembly by using an arbor press.
9. Remove the drive end seal and bearing.
10. Do not take apart any further, you do not want to remove the drive end plate as this will change the internal clearances.
11. Inspect the vanes, noting the direction of the beveled edge and remove the vanes.
12. Clean the rotor and inside of the body and end plates using Gast AH255D flushing solvent to remove any carbon dust buildup.
13. Replace the rotor into the body and through the drive end plate.
14. Install bearing and press all the way down using an arbor press.
15. Replace vanes, making sure to place a coating of oil on them and that the beveled edge matches the contour of the body.
16. Replace dead endplate.
17. Install bearing and press all the way down using an arbor press.
18. Replace dead end plate bolts and dowel pin. Torque bolts to 110 in-lbs.
19. Replace the shaft seal and o-ring on the drive end cap.
20. Install the drive end cap which sets the end clearance.
21. Reinstall the cooling fans and fan guards.
22. Remove the old filters, muffler elements and old wicks. Clean jar assemblies.
23. Install new filters, muffler elements and wicks and replace the jars. Tighten the jars so that they do not leak but make sure not over tighten which could cause damage.
24. Re-install the oiler feed tubes to the end plates and the oil reservoir.
25. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
26. Reconnect power and test unit performance