



Operation and Maintenance Manual

Gast® Lubricated 65 and 67 Series Rotary Vane Vacuum Pumps and Compressors

Including, but not limited to:

1065-XXX, 2065-XXX, 2565-XXX, 2567-XXX

(XXX denotes up to 4 alphanumeric characters)



Additional Languages.



Declaration of Conformity.

gastmfg.com

Dear Customer,

Thank you for purchasing this Gast® series rotary vane vacuum pump or compressor. It's intended to be used in various commercial and industrial applications where compressed air or a vacuum is required.



WARNING



PLEASE READ THIS MANUAL COMPLETELY BEFORE INSTALLING AND USING THIS PRODUCT. SAVE THIS MANUAL FOR FUTURE REFERENCE AND KEEP IN THE VICINITY OF THE PRODUCT.

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SAFETY

Please note that pictures and figures referenced in the text can be found throughout the manual.

Your safety and the safety of others is extremely important. We have provided many important safety messages in this manual and on your product. Always read and obey all safety messages.

! This is the safety alert symbol. This symbol alerts you to hazards that can kill or hurt you and others. The safety alert symbol and the words "DANGER" and "WARNING" will precede all safety messages. Definitions for these words are provided below.



DANGER

YOU WILL BE KILLED OR SERIOUSLY INJURED
IF YOU DON'T FOLLOW INSTRUCTIONS.



WARNING

YOU CAN BE KILLED OR SERIOUSLY INJURED
IF YOU DON'T FOLLOW INSTRUCTIONS.

All safety messages will identify the hazard, tell you how to reduce the chance of injury, and tell you what can happen if the safety instructions are not followed.

Product Use Criteria:

- Operate at 32°F - 104°F (0°C - 40°C).
- Protect unit from dirt and moisture.
- Protect all surrounding items from hot exhaust air. This exhaust air can become very hot.
- Product is not a consumer product and is for commercial applications only.
- Do not pump flammable or explosive gases or use in an atmosphere that contains such gases.
- Corrosive gases and particulate material will damage unit. Water vapor, oil-based contaminants or other liquids must be filtered out.
- Consult your Gast® distributor/representative before using at high altitudes. Performance will adversely be affected at high altitudes.
- Use Gast® #AD220 or a detergent SAE#10 automotive engine oil for lubricating.
- Wear eye protection.
- Must only be used for pumping/evacuating.
- Do not pump any other gases or liquids.
- Protect from inclement weather. Indoor use only.
- Do not obtain higher pressures or vacuums than recommended.
- Damage will occur if used at higher speeds than recommended.

INSTALLATION


WARNING



ELECTRICAL SHOCK HAZARD.

Disconnect electrical power at the circuit breaker or fuse box before installing this product.

Install this product where it will not come into contact with water or other liquids.

Install this product where it will be weather protected.

Electrically ground this product.

Failure to follow these instructions can result in death, fire, or electrical shock.


WARNING



INJURY HAZARD.

Do not stand in line with air stream. Wear eye protection.

Install proper safety guards as needed.

Keep fingers and objects away from rotating parts and openings.

Product surfaces may become very hot during operation, allow product surfaces to cool before handling.

Failure to follow these instructions can result in burns, eye injury, or other serious injury.


WARNING

Some models are equipped with glass jars. Proper measures should be taken to guard against glass fragmenting or breaking if an alternative material is not used.

If hazard is ignored, severe personal injury can occur.

Correct installation is your responsibility. Make sure you have the proper installation conditions and that installation clearances do not block air flow. Proper guards should be installed to prevent contact with moveable parts of this pump. Do not lift the unit by the fan shroud. Unit is to be lifted by means of eyebolts.

Blocking air flow over the product in any way can cause the product to overheat. Also, do not place objects, fingers, metal tools, etc. through the ventilation holes.

Transportation and Storage Conditions:

- Temperature: -25°C (-13°F) to 55°C (131°F)
- Relative humidity: Maximum of 95%
- Keep the system dry at all times.
- Do not stack units during shipment, installation, or while being used.

Unpacking

1. Open the carton and remove any packaging inserts.
2. Visually inspect the entire compressor for shipping damage and verify any applicable accessories have been included.
 - a. If the contents were damaged during shipping, contact the freight carrier to file a claim.
 - b. If parts are missing, contact the supplier.
3. Use caution when removing the system from the remaining packaging. Retain the packaging material for future use if necessary.

Lift the unit by eyebolt, the motor shell, housing, handle, or motor foot (depending on design). Do not lift unit by shroud, filters, or mufflers. These parts are not designed to support the weight of the unit.

Mounting

Mounting the product to a stable, rigid operating surface and using shock mounts will reduce noise and vibration. It is also essential to maintaining stability during use, assembly, transport, and servicing.

For the 67 series product, the pump base should be anchored to either a metal surface such as a shelf, floor, or another piece of machinery. To save time and avoid inconvenience, position pump to provide easy access to all lubricators, filters, and mufflers.

Plumbing

To prevent air flow restriction, use pipe and fittings that are the same size or larger than the threaded ports of the pump. The ports are marked "IN" and "OUT." If the distance is great, use lines with a larger diameter than the connections. Give lines a uniform slope, place drain cock at low point, and avoid extra elbows. For ease of servicing, use a union or hose with clamps near the pump (a hose helps eliminate noise and vibration). If a vacuum/pressure supply tank is used, slope the line towards tank, provide a drain at the bottom, and place a check valve between the tank and pump so the pump will not run backwards when turned off.

Accessories

Intake and exhaust filters are external to the pump and will provide adequate filtration for most applications. Check filters periodically and replace when necessary. Consult a Gast® representative for additional filter recommendations. Install relief valves and gauges at the inlet or outlet, or both, to monitor performance. Check valves may be required to prevent backstreaming through the pump.

For pressure applications, always fit a relief valve set to the

INSTALLATION

maximum working pressure but never higher than the maximum permitted pressure specified on the technical data sheet.

For vacuum applications, it is recommended that a relief valve is fitted set to the duty vacuum required. When an intermittent vacuum is advised, the product is only permitted to operate at this level for short cyclic periods.

Motor Control

It is your responsibility to contact a qualified electrician and assure that the electrical installation is adequate and in conformance with all national and local codes and ordinances.

Determine the correct overload setting required to protect the motor (see motor starter manufacturer's recommendations). Select fuses, motor protective switches or thermal protective switches to provide protection. Fuses act as short circuit protection for the motor, not as protection against overload. Incoming line fuses must be able to withstand the motor's starting current. Motor starters with thermal-magnetic overload or circuit breakers protect motor from overload or reduced voltage conditions.

The wiring diagram supplied with the product provides required electrical information. Check that power source is correct to properly operate the dual-voltage motors.

Electrical Connection

WARNING

ELECTRICAL SHOCK HAZARD.

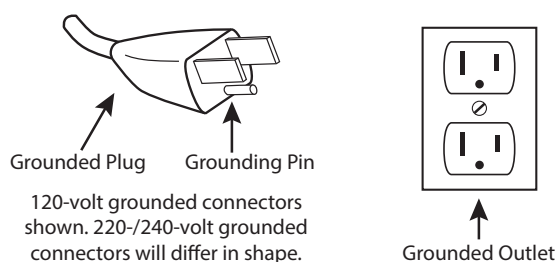
This product must be properly grounded.

Check the condition of the power supply wiring. Do not permanently connect this product to wiring that is not in good condition or is inadequate for the requirements of this product.

Failure to follow these instructions can result in death, fire, or electrical shock.

Model with a Power Supply Cord

This product must be grounded. For either 120-volt or 220/240-volt circuits, connect power supply cord grounding plug to a matching grounded outlet. Do not use an adapter. See diagram below.



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 may be equipped with a power supply cord having a grounding wire with an appropriate grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if you are not sure 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.

WARNING

The product will start as soon as electricity is turned on if permanently wired, or switch is turned "ON," if a switch is included.

Model that is Permanently Wired

This product must be connected to a grounded, metallic, permanent wiring system, or an equipment grounding terminal or lead on the product.

Power supply wiring must conform to all required safety codes and be installed by a qualified person. Check that supply voltage agrees with that listed on product nameplate.

Extension Cords

Use only a 3-wire extension cord that has a 3-blade grounding plug. Connect extension cord plug to a matching 3-slot receptacle. Do not use an adapter. Make sure your extension cord is in good condition. Check that the gauge wire of the extension cord is the correct size wire to carry the current this product will draw.

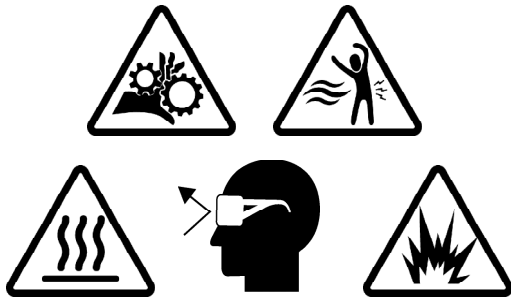
An undersized cord is a potential fire hazard and will cause a drop in line voltage, resulting in loss of power causing the product to overheat. The following table indicates the correct size cord for length required and the ampere rating listed on the product nameplate. If in doubt, use the next heavier gauge cord. The smaller the gauge number, the heavier the wire gauge.

Minimum Gauge for Extension Cords

Amps	Volts	Length of cord in feet								
	120v	25	50	100	150	200	250	300	400	500
	240v	50	100	200	300	400	500	600	800	1,000
0-2		18	18	18	16	16	14	14	12	12
2-3		18	18	16	14	14	12	12	10	10
3-4		18	18	16	14	12	12	10	10	8
4-5		18	18	14	12	12	10	10	8	8
5-6		18	16	14	12	10	10	8	8	8
6-8		18	16	12	10	10	8	6	6	6
8-10		18	14	12	10	8	8	6	6	4
10-12		16	14	10	8	8	6	6	4	4
12-14		16	12	10	8	6	6	6	4	2
14-16		16	12	10	8	6	6	4	4	2
16-18		14	12	8	8	6	4	4	2	2
18-20		14	12	8	6	6	4	4	2	2

OPERATION

WARNING



INJURY HAZARD.

Install proper safety guards as needed. Pumps with glass jars need safety guards to protect against breaking glass.

Use only recommended air handling parts acceptable for pressure not less than 70 psi.

Keep fingers and objects away from openings and rotating parts.

When provided, motor terminal covers must be in place for safe operation.

Check that coupling guard and shroud are in place before operating.

Product surfaces may become hot during operation. Allow product surfaces to cool before handling.

Do not direct air stream at body. Air stream from product may contain solid or liquid material that can result in eye or skin damage, wear proper eye protection.

Do not spray flammable or combustible liquid.

Wear hearing protection. Sound level from product may exceed 85 dB(A).

Failure to follow these instructions can result in burns, eye injury, or other serious injury.

WARNING

The product will start as soon as electricity is turned on if permanently wired, or when the switch is turned "ON," if a switch is included.

It is your responsibility to operate this product at recommended pressures or vacuum duties and room ambient temperatures. Do not start against a vacuum or pressure load.

Start Up

If pump is extremely cold, let it warm up to room temperature before starting. If motor fails to start or slows down significantly under load, shut off and disconnect from power supply. Check that the voltage is correct for motor and that motor is turning in the proper direction. Turning in the wrong direction will drastically reduce vane life. Vane life will be drastically reduced if motor is not operating properly. Vanes can break or be damaged if motor/pump runs in the wrong direction.

Model	Sound Pressure Level
1065-XXX, 2065-XXX, 2565-XXX	≤77 dB(A)
2567-XXX	≤78 dB(A)

MAINTENANCE

**WARNING**

**ELECTRIC SHOCK HAZARD.**

Disconnect electrical power supply cord before performing maintenance on this product.

If product is hard-wired into system, disconnect electrical power at the circuit breaker or fuse box before performing maintenance on this product.

Failure to follow these instructions can result in death, fire, or electrical shock.

**WARNING**

**INJURY HAZARD.**

Wear eye protection when flushing this product.

Air stream from product may contain solid or liquid material that can result in eye or skin damage.

Flush this product in a well-ventilated area.

Do not use kerosene or other combustible solvents to flush this product.

Failure to follow these instructions can result in burns, eye injury, or other serious injury.

It is your responsibility to:

- Regularly inspect and make necessary repairs to product in order to maintain proper operation.
- Make sure that pressure and vacuum is released from product before starting maintenance.
- Switch the electrical supply off and isolate the product prior to performing maintenance.

Check intake and exhaust filters after first 500 hours of operation. Clean filters and determine how frequently filters should be checked during future operation. This one procedure will help to assure the product's performance and service life.

Remove glass filter/muffler jar. Remove cartridges from intake and exhaust filters and inspect them. If there are any cuts or excessive foreign material, replace them. If serviceable, clean filters.

Clean filters when necessary by removing and washing in a solvent or soap and water. After cleaning, dry with compressed air to make sure all moisture is removed before replacing filters.

Flushing

Flushing this product to remove excessive dirt, foreign particles, moisture or oil that occurs in the operating environment will help to maintain proper vane performance. If your pump is not getting the vacuum or pressure level expected, flushing is required. Vanes will stick when dirty and may cause pump to be noisy or inefficient.

Use only Gast®-recommended flushing solvent or other non-petroleum based flushing solvent. Do not use kerosene or ANY other combustible solvent to flush product.

1. Disconnect electrical power supply.
2. Release all pressure and vacuum from pump.
3. Remove all accessories at the inlet and exhaust ports.
4. Remove filter.
5. Start product. Place towel over exhaust port to clean up solvent. If using liquid solvent, pour several tablespoons directly into inlet port. If using Gast®-recommended flushing solvent, spray solvent for 5-10 seconds into inlet port.
6. Block the inlet port and draw a deep vacuum for 15-20 seconds. Release the vacuum.
7. Listen for changes in the sound of the motor. If motor sounds smooth, go to next step. If motor does not sound like it is running smoothly, repeat steps 5 and 6 until you can hear a difference in the operating sound of the pump.
8. Start the pump and let it run for 1 minute, then turn pump off.
9. Replace all accessories at the inlet and exhaust ports.
10. Replace filter before resuming operation.

Check that all external accessories such as relief valves and gauges are attached to the cover and are not damaged before reoperating the product.

Shutdown Procedures

It is your responsibility to follow proper shutdown procedures to prevent product damage.

Failure to do so may result in premature pump failure. The Gast® Manufacturing lubricated vacuum pumps and compressors are constructed of ferrous metals or aluminum which are subject to rust and corrosion when pumping condensable vapors such as water. Follow the steps below to assure correct storage and shutdown between operating periods.

1. Disconnect plumbing.
2. Operate product for at least 5 minutes without plumbing.
3. Cover inlet port (vacuum side) and run pump for 1-3 minutes. Shut the pump down under vacuum.
4. This unit requires lubrication. Refill oil reservoir to proper level before storage.
5. Be sure to plug open ports so dirt and other contaminants do not enter the unit. It is now ready for shutdown.

MAINTENANCE

Service Kit Installation


WARNING





ELECTRICAL SHOCK HAZARD.

Disconnect electrical power supply before installing Service Kit.

If product is hard-wired into system, disconnect electrical power at the circuit breaker or fuse box before installing Service Kit.

Disconnect air supply and vent all air lines to release pressure or vacuum.

Failure to follow these instructions can result in death, fire, or electrical shock.

Gast® will NOT guarantee field-rebuilt product performance. For performance guarantee, the product must be returned to a Gast® authorized service facility.

65 Series Pump Disassembly

Service Kit contents vary. Most contain vanes, gaskets, oiler wick, and filter elements.

1. Remove dead end shroud, fan and fan spacer.
2. Use a wheel puller to remove dead end plate and bearing from unit body; note direction of vane's bevel edge. Do not damage dowel pins between end plate and body.
3. Save bearing spacer on shaft's dead end for re-assembly.
4. Remove snap ring from end plate.
5. Save snap ring, Belleville springs, and washer for re-assembly.
6. Remove bearing from dead-end plate.
7. Check exposed surfaces of rotor, body, and end plate for scoring. If no scoring is found, perform Minor Rebuild to replace only vanes and dead end bearing. If severe damage is found, perform Major Rebuild.

67 Series Pump Disassembly

1. Remove fan, fan guard and (4) end cap screws.
2. Remove dead end plate.
3. Check for scoring on end plate, rotor and body. Surfaces should be smooth. If severe scoring is visible, contact a Gast® authorized service facility.
4. Remove vanes.
5. Clean all surfaces with Gast®-recommended flushing solvent and dry well.

65 Series Minor Rebuild

1. Install new vanes supplied with kit. Be careful to face vane bevels in proper direction.
2. Place end plate over shaft with dowel pins aligned.
3. Place bearing spacer on dead end of shaft.
4. Place new bearing in its bore in dead end plate. Be careful to press only on inner bearing race.
5. Install and tighten unit body bolts.
6. Install Belleville springs with washer between them and snap ring.

Major Rebuild

1. Remove drive end cap.
2. Use a wheel puller to remove drive end plate and bearing from body. Do not remove or damage dowel pins in body.
3. Save bearing spacer and endplate gasket for re-assembly.
4. Place one of new bearings in its seat in drive-end plate, then place one of shoulder rings on drive-end of shaft.
5. Using an arbor press, press bearing onto shaft. Be careful to press only on inner bearing race.
6. Tighten unit body bolts.
7. Install new vanes supplied with kit. Be careful to face vane bevels in proper direction.
8. Perform steps #2-4 from Minor Rebuild.
9. Install Belleville springs with washer between them and snap ring.
10. Install and tighten unit body bolts.
11. Apply a thread-lock adhesive.
12. Start drive end cap into its thread in drive end plate, but do not tighten it.
13. Place a dial indicator against dead-end of shaft to measure axial movement.
14. Tighten drive end cap until indicator shows .002" to .003" of shaft movement against Belleville springs.
15. Replace filter elements.
16. Verify unit rotates freely by hand before reconnecting power.
17. Before putting unit into service, ensure that any external accessories have not been damaged.
18. Reconnect power.
19. Check for proper rotation if unit is three-phase motor.

If unit fails to produce proper vacuum or pressure, or is excessively noisy, turn off and return unit to a Gast® authorized service facility.

MAINTENANCE

67 Series Re-Assembly

1. Apply a light coat of Gast®-recommended oil part number AD220 (or an equivalent 10 wt. high-detergent oil can also be used) to vanes.
2. Re-install vanes, noting proper direction of beveled edge (refer to exploded view).
3. Install dead end plate and install dead end plate bolts loosely.
4. Install bearings into dead end plate; be sure to press inner race of bearing when installing.
5. Reassemble end cap screws, fan guard and fan.
6. Verify unit rotates freely by hand before reconnecting power.
7. Before putting pump into service, ensure that any external accessories have not been damaged.
8. Reconnect power.
9. Check for proper rotation if unit is 3-phase.



Disposal (Please note current regulations) Parts of the rotary vane pumps and compressors, shafts, iron or aluminum castings, plastic or glass parts or bearings, may be recycled as scrap materials.

FAULT FINDING AND REPAIR

Operating Method in the Event of a Breakdown

- In the event of breakdown, switch off and isolate from compressed air energy supply. Only qualified personnel should perform troubleshooting/repair activities.
- Do not attempt to dismantle any part of the product before the electricity is disconnected.
- Wait until the product has cooled down.
- Refer to the Troubleshooting Guide.
- Contact the factory or distributor for further advice.

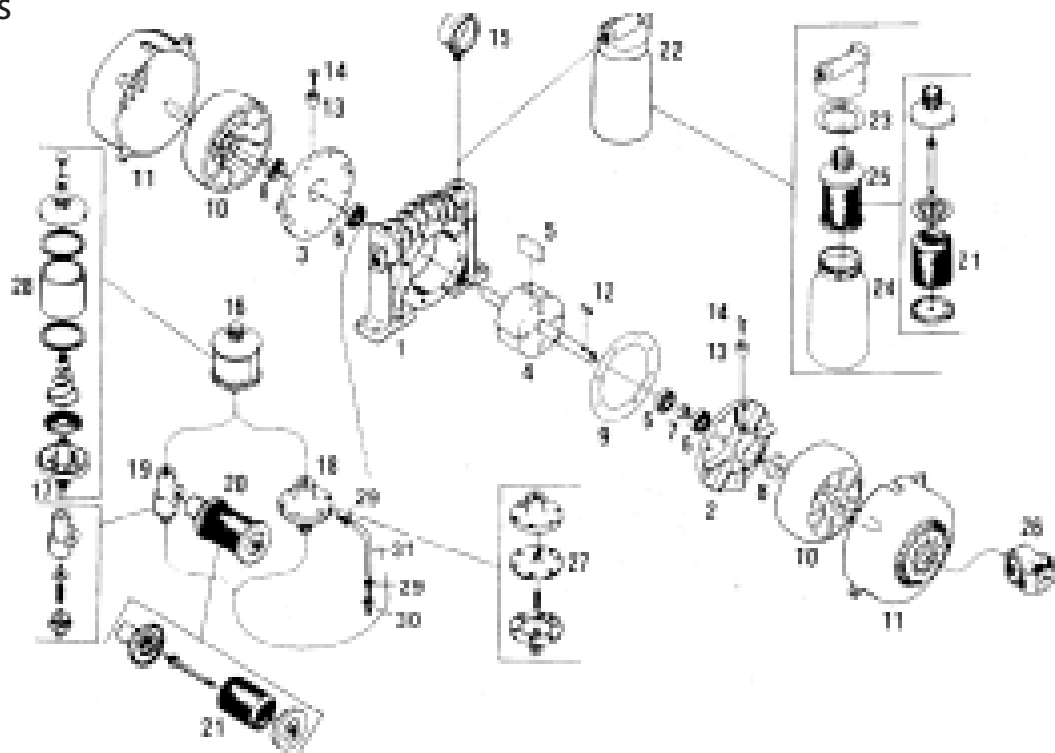
Troubleshooting Guide

Low Vacuum	Low Pressure	High Vacuum	High Pressure	Pump Overheat	Motor Overload	Reason and Remedy for Problem
•	•	At pump		•	•	Filter dirty. Clean or replace.
	•		At pump	•	•	Muffler dirty. Clean or replace.
•		At pump		•	•	Vacuum line collapsed. Repair or replace.
•			•	•	•	Relief valve set too high. Inspect and adjust.
•	•					Relief valve set too low. Inspect and adjust.
•	•	At pump	At pump	•	•	Plugged vacuum/pressure line. Inspect and repair.
•	•					Vanes sticking. Clean or replace.
•	•					Vanes worn. Replace.
•	•					Shaft seal worn. Replace.
•	•			•	•	Dust or offset powder in pump. Inspect and clean.
•	•			•		Motor not wired correctly. Check wiring diagram and line voltage.
		•	•	•	•	Running at too high an RPM. Check wiring diagram and line voltage.

For the name of the nearest Gast® authorized service facility, contact one of our offices or visit our website at www.gastmfg.com.

PARTS AND ACCESSORIES

1065 Series



ITEM NO.	DESCRIPTION	QTY.	1065-V2A
1	BODY	1	AC860
2	DRIVE END PLATE	1	D1322
3	DEAD END PLATE	1	D1322A
4	ROTOR AND SHAFT ASSEMBLY	1	D334H
5 Δ	VANE	4	D335K
6 Δ	BEARINGS	3	D327
7 Δ	BEARING SPACER	1	–
8 Δ	SHAFT SEAL	2	AA150
9 Δ	BODY SPACER	1	AH567
10	COOLING FAN	2	AC326A
11	FAN GUARD	2	AC102B
12 Δ	COUPLING KEY	1	AB136D
13	OILER BODY	2	–
14	OILER CAP	2	–
15	PRESSURE GAUGE	1	–
16	OIL RESERVOIR ASSEMBLY	1	AA960-2
17 Δ	FEED WICK	1	AA273-1
18	VACUUM LUB ASSEMBLY	1	V40F
19	PRESSURE LUB ASSEMBLY	1	–
20	INTAKE FILTER ASSEMBLY	1	AA800C
21	CARTRIDGE	2	AC393
22	EXHAUST MUFFLER AND OIL TRAP	1	AA800D
23	COVER GASKET	1	AA404
24	GLASS JAR	1	AA401
25	MUFFLER ELEMENT ASSEMBLY	1	AC434
26	COUPLING ASSEMBLY	1	AE542A
27	DIAPHRAGM	1	V33
28	OIL CYLINDER	1	AA967A
29	FITTING	4	V31
30	CONNECTOR	2	V32A
31	TUBE	2	AF339H
***	SERVICE KIT	1	K297

*** Item not shown.

** Retainer Ring must be ordered with cooling fan.

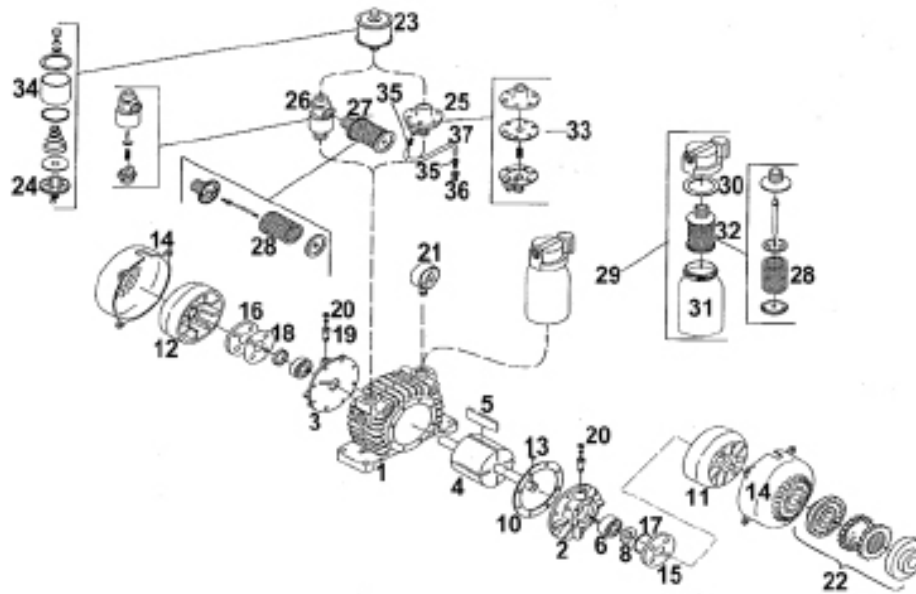
Δ Denotes parts included in the Service Kit. Parts listed are for stock models. For specific OEM models, please consult the factory.

When corresponding or ordering parts, please give complete model and serial numbers.

Gast® reserves the right to make technical modifications as needed.

PARTS AND ACCESSORIES

2065/2565 Series



ITEM NO.	DESCRIPTION	QTY.	2065-V2A	2565-V2A
1	BODY	1	AC101E	AC101F
2	DRIVE END PLATE	1	AA851	AA846
3	DEAD END PLATE	1	AA851	AA846
4	ROTOR ASSEMBLY	1	AC843A	AC840
5 Δ	VANE	4	AA8D	AA750G
6 Δ	DRIVE END BEARING	1	AA735	AA735
7 Δ	DEAD END BEARING	1	AA755D	AA755D
8 Δ	DRIVE END SHAFT SEAL	1	AC848	AC848
9 Δ	DEAD END SHAFT SEAL	1	AC849	AC849
10	BODY SPACER	1	AH567	AH567
11	COOLING FAN	1	AC326C	AC326C
12	COOLING FAN	1	AC326B	AC326B
13	COUPLING KEY	1	AB136D	AB136D
14	FAN GUARD	2	AC102B	AC102B
15	DRIVE END CAP	1	AA856	AA856
16	DEAD END CAP	1	AG466	AG466
17 Δ	O-RING	1	AC808	AC808
18	END CAP GASKET	2	AG467	AG467
19	OILER BODY	2	—	—
20	OILER CAP	2	—	—
21	PRESSURE GAUGE	1	—	—
22	COUPLING ASSEMBLY	1	—	—
23 Δ	OIL RESERVOIR ASSEMBLY	1	AA960-1	AA960-1
24 Δ	FEED WICK	1	AA973-1	AA973-1
25	VACUUM LUB ASSEMBLY	1	V40F	V40F
26	PRESSURE LUB ASSEMBLY	1	—	—
27 Δ	INTAKE FILTER ASSEMBLY	1	AA900D	AA900D
28 Δ	CARTRIDGE	2	AC393	AC393
29 Δ	EXHAUST MUFFLER AND OIL TRAP	1	AA900E	AA900E
30	COVER GASKET	1	AA404	AA404
31	GLASS JAR	1	AA401	AA401
32 Δ	MUFFLER ELEMENT ASSEMBLY	1	AC436	AC436
33	DIAPHRAGM	1	V33	V33
34	OIL CYLINDER	1	AA967A	AA967A
35	FITTING	4	V31	V31
36	CONNECTOR	2	V32A	V32A
37	TUBE	2	AF339H	AF339H
***	SERVICE KIT	1	K295	K296

*** Item not shown.

** Retainer Ring must be ordered with cooling fan.

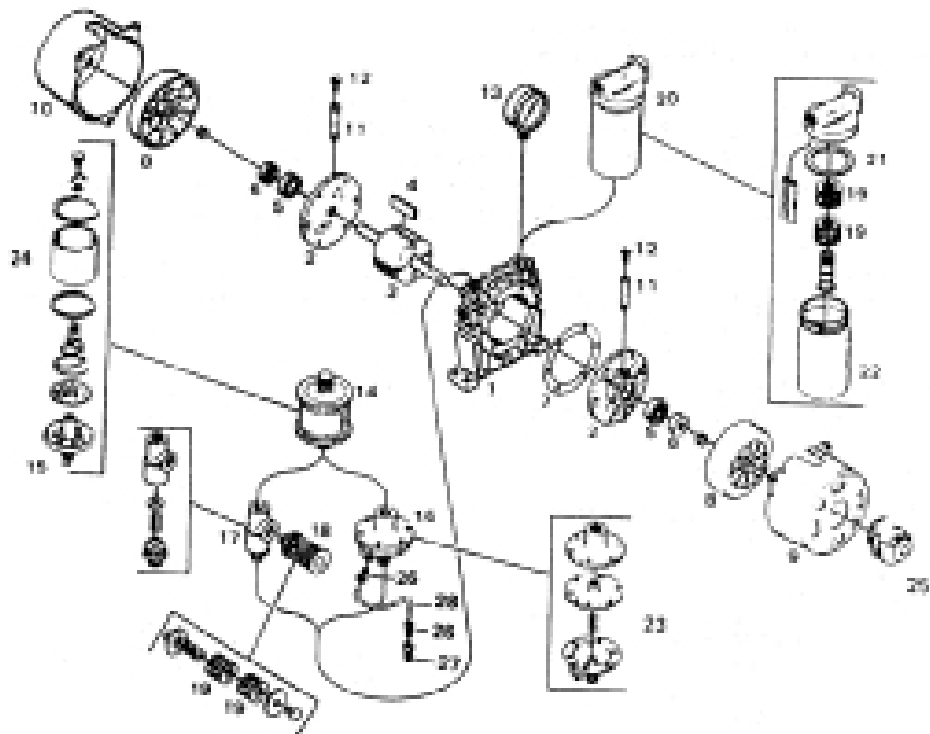
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When corresponding or ordering parts, please give complete model and serial numbers.

Gast® reserves the right to make technical modifications as needed.

PARTS AND ACCESSORIES

0765 Series



ITEM NO.	DESCRIPTION	QTY.	0765-V6A 0765-V7C
1	BODY	1	AC681A
2	END PLATE	2	AA502
3	ROTOR AND SHAFT ASSEMBLY	1	AA508A
4 Δ	VANE	4	AA510E
5 Δ	BEARING	2	AA37
6 Δ	SHAFT SEAL	2	AA466B
7 Δ	BODY SPACER	1	B330
8	COOLING FAN	2	B340C
9	FAN GUARD	1	AC684A
10	FAN GUARD	1	AC684A
11	OILER BODY	0	–
12	OILER CAP	0	–
13	PRESSURE GAUGE	0	–
14	OIL RESERVOIR ASSEMBLY	1	AA960-2
15 Δ	FEED WICK	1	AA273-1
16	VACUUM LUBRICATOR ASSEMBLY	1	V40C
17	PRESSURE LUBRICATOR ASSEMBLY	0	–
18	INTAKE FILTER ASSEMBLY	1	B343B
19 Δ	FILTER FELT	4	B344A
20	EXHAUST MUFFLER AND OIL TRAP	1	V525
21 Δ	COVER GASKET	1	B62A
22	GLASS JAR	1	AA125
23	DIAPHRAGM	1	V33
24	OIL CYLINDER	1	AA967A
25	COUPLING	1	AE541C
26	FITTING	4	V31
27	CONNECTOR	2	V32A
28	TUBE	2	V57
***	SERVICE KIT	1	K235

*** Item not shown.

** Retainer Ring must be ordered with cooling fan.

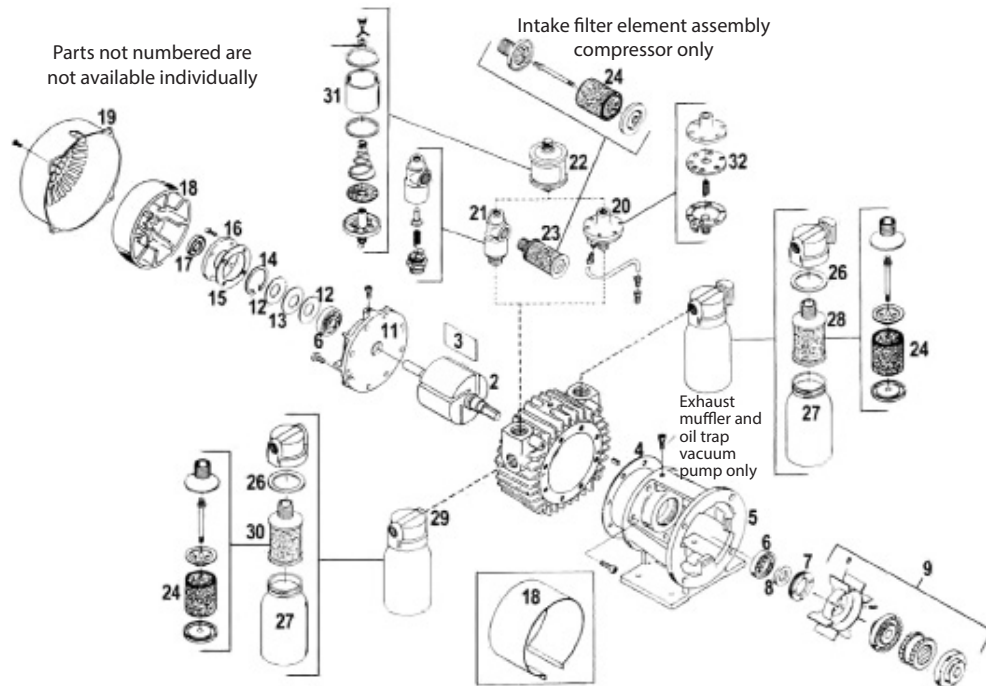
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PARTS AND ACCESSORIES

1067 Series



ITEM NO.	DESCRIPTION	QTY.	VACUUM PUMP 1067-V1	VACUUM PUMP 2567-V1
1	BODY	1	AH345	AH355
2	ROTOR ASSEMBLY	1	AH428	AH192
3 Δ	VANE	4	AH429	AA750G
4 Δ	BODY SPACER	1	AH567H	AH567
5	FOOT BRACKET	1	AH206	AH206
6 Δ	BEARING (DRIVE AND DEAD)	2	AH755D	AA755D
7	DRIVE END CAP	1	AB339A	AB339A
8 Δ	DRIVE SEAL	1	AC848	AC848
9	FAN COUPLING ASSEMBLY	1	AH198	AH198-1
10	FAN GUARD	1	AH194A	AH194A
11	DEAD END PLATE	1	AH203	AH203
12	BELLEVILLE SPRINGS	2	AB337	AB337
13	WASHER	1	AB338	AB338
14	SNAP RING	1	AB335	AB335
15 Δ	END CAP GASKET	1	AG467	AG467
16	DEAD END CAP	1	AG466	AG466
17 Δ	DEAD END SEAL	1	AC849	AC849
18	FAN	1	AC326B	AC326B
19	FAN GUARD	1	AC102B	AH194A
20	VACUUM LUBRICATOR ASSEMBLY	1	V40C	V40F
21	PRESSURE LUBRICATOR	1	—	—
22	OIL RESERVOIR ASSEMBLY	1	AA960-2	AA960-1
23	INTAKE FILTER ASSEMBLY-COMP	1	—	—
24 Δ	CARTRIDGE	1/2	(2) AC393	(2) AC393
25	EXHAUST MUFFLER AND OIL TRAP	1	AA800D	AA900E
26	COVER GASKET	2	AA405	AA404
27	GLASS JAR	2	AA401	AA401
28	MUFFLER ELEMENT ASSEMBLY	2	AC434-1	AC436-1
29	INTAKE FILTER ASSEMBLY-VACUUM	1	AA800C	AA900D
30	INTAKE FILTER ELEMENT ASSEMBLY	1	AC433-1	AC435-1
31	OIL CYLINDER	1	AA967A	AA967A
32	DIAPHRAGM	1	V33	V33
***	SERVICE KIT	1	K355	K349

*** Item not shown.

** Retainer Ring must be ordered with cooling fan.

Δ Denotes parts included in the Service Kit. Parts listed are for stock models. For specific OEM models, please consult the factory.

When corresponding or ordering parts, please give complete model and serial numbers.

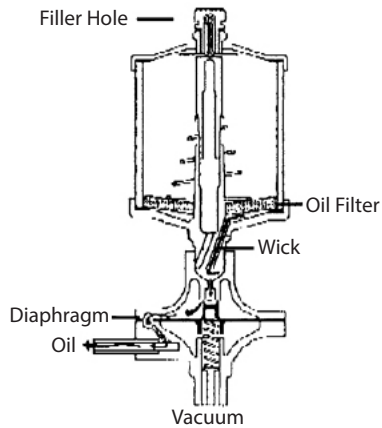
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GAST® LUBRICATOR ASSEMBLIES

The following information on oil reservoirs and lubricators has been written to give an understanding of various assemblies used on Gast® pumps and compressors.

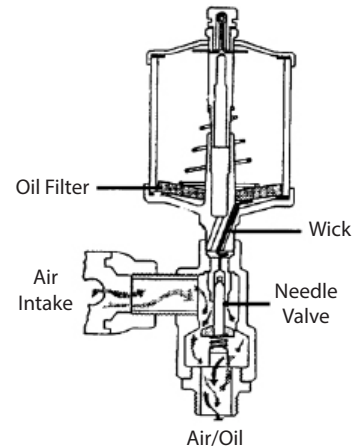
Oil Reservoir AA960 Series

AA960 oil reservoir type has a wick that regulates oil flow and a bleed hole that equalizes pressure between bearing cavity and air on top of oil in reservoir. V40H, below reservoir, is a valve that is vacuum actuated (it opens at about 850 mbar) and stops oil flow when unit is turned off. It does not regulate oil flow in any way. *Reservoir must be sealed tightly at top filler hole so that atmospheric air does not leak in and increase oil flow. Wick in reservoir regulates oil flow. A single wick gives highest flow rate and a double or triple wick, progressively less. If there are no leaks in lubrication system, oil flows by gravity to unit bearings and into pumping chamber to lubricate vanes as well.



Pressure Lubricator Assembly AA95A/AD730

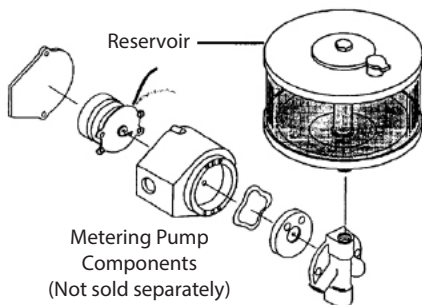
A380C pressure oiler using an AA960 type reservoir, acts as a valve to stop oil flow when unit is off. Inside a spring-loaded poppet opens due to airflow and pulls a tapered pin from oil hole and allows lubrication to start. When unit is turned off, tapered pin pops back into place and oil flow stops. AA95A and AD730 function the same way.



Lighter duty pumps use wicks to regulate oil flow, while heavy-duty oilers are available for those applications where large units are operating continuously under harsh conditions.

Motorized Assembly AD190 Series

Heavy-duty AD190 oiler uses a large AD185 1-liter reservoir and an electrically driven metering pump that dispenses oil to two tubes leading to bearings. Different discs are available for unit to dispense 1, 2, 3, or 4 drops per minute. Different units are used for vacuum and pressure. To change a vacuum lubricator into a pressure type, change springs loading metering disc against housing. On pressure applications, tubes carrying oil to bearings will be pressurized by air inside unit to about half operating pressure. If pressure is excessive, there will be oil leakage.



SYMBOLS

The symbols found on the product and packing are explained below.

Symbol	Description
	DANGER: Hazardous situation or extreme condition. Will result in serious or fatal injury if not avoided. WARNING: Hazardous situation. May result in serious injury if not avoided. CAUTION: Potentially hazardous situation/avoid unsafe practices. Could result in minor or moderate injury if not avoided.
	EQUIPMENT ALERT: Hazardous situation that could result in equipment damage if not avoided.
	WARNING: Hot surfaces. Risk of burns. Do not touch surface during operation. Do not touch the compressor head.
	CAUTION: Risk of explosion. Risk of bursting. Do not adjust regulator to result in output pressure greater than marked maximum pressure of attachment.
	WARNING: Risk of injury. Do not direct air stream at body.
	Keep dry. Do not expose to rain.
	Transport and storage temperature: -25°C (-13°F) to 55°C (131°F)
	Transport and storage relative humidity: Maximum 95%
	This side up.
	Fragile. Handle with care.
	Disposal in accordance with existing regulations for electric and electronic equipment.
	Read operation and maintenance manual before operating.
	A/C power
	Ground
	ELECTRICAL SHOCK HAZARD: Risk of electric shock present. Make sure power is disconnected before attempting this procedure.
	ELECTRICAL SHOCK HAZARD: Risk of electric shock present. Make sure power is disconnected before attempting this procedure.
	WARNING: Air stream from motor may contain solid or liquid material that can result in eye or skin damage. Wear eye protection.
	MOVING PARTS PRESENT: Can result in serious injury to hands or fingers. Keep hands away from moving parts. Disconnect and lockout power before servicing.

POTENTIAL WARNING LABELS ON PRODUCT

**WARNING**

THIS MOTOR IS THERMALLY PROTECTED AND WILL AUTOMATICALLY RESTART WHEN PROTECTOR RESETS. ALWAYS DISCONNECT POWER SUPPLY BEFORE SERVICING.

**WARNING**



ELECTRIC SHOCK RISK.
DISCONNECT BEFORE
SERVICING.

**CAUTION**



TO REDUCE THE RISK OF ELECTRIC SHOCK, DO NOT EXPOSE TO RAIN. STORE INDOORS.

**CAUTION**



RISK OF INJURY - DO NOT DIRECT AIR STREAM AT BODY.

**WARNING**



PLEASE READ THIS MANUAL COMPLETELY BEFORE INSTALLING AND USING THIS PRODUCT. SAVE THIS MANUAL FOR FUTURE REFERENCE AND KEEP IN THE VICINITY OF THE PRODUCT.

**WARNING**



HOT SURFACE. RISK OF BURNS. DO NOT TOUCH.

**ROTATION**

**WARNING**

DO NOT RETURN UNIT AFTER RADIATION, TOXIC SUBSTANCE, OR BIOHAZARD USE.

**CAUTION**

NEVER OPERATE ABOVE MAXIMUM DUTIES.

**WARNING**



RISK OF FIRE OR EXPLOSION - DO NOT SPRAY FLAMMABLE OR COMBUSTIBLE LIQUID IN A CONFINED AREA. SPRAY AREA MUST BE WELL-VENTILATED. DO NOT SMOKE WHILE SPRAYING OR SPRAY WHERE SPARKS OR FLAME ARE PRESENT. KEEP COMPRESSOR AS FAR FROM SPRAY AREA AS POSSIBLE.



SERVICE KIT	PART NUMBER	SERVICE INTERVAL



Scan this code or visit gastmfg.com for more information on where to purchase genuine Gast® maintenance kits.

WARRANTY

Warranty Policy

Gast® finished products, when properly installed and operated under normal conditions of use, are warranted by Gast® to be free from defects in material and workmanship for a period of twelve (12) months from the date of purchase from Gast® or an authorized Gast® representative or distributor. In order to obtain performance under this warranty, the buyer must promptly (in no event later than thirty (30) days after discovery of the defect) give written notice of the defect to Gast® Manufacturing Incorporated, 2300 M139 Highway, Benton Harbor, Michigan, USA 49022-6114 or an authorized service center (unless specifically agreed upon in writing signed by both parties or specified in writing as part of a Gast® OEM Quotation). Buyer is responsible for freight charges both to and from Gast® in all cases.

This warranty does not apply to electric motors, electrical controls, and gasoline engines not supplied by Gast®. The Gast® warranty also does not extend to any goods or parts which have been subjected to misuse, lack of maintenance, neglect, damage by accident or transit damage.

THIS EXPRESS WARRANTY EXCLUDES ALL OTHER WARRANTIES OR REPRESENTATIONS EXPRESSED OR IMPLIED BY ANY LITERATURE, DATA, OR PERSON. THE GAST® MAXIMUM LIABILITY UNDER THIS EXCLUSIVE REMEDY SHALL NEVER EXCEED THE COST OF THE SUBJECT PRODUCT AND GAST® RESERVES THE RIGHT, AT ITS SOLE DISCRETION, TO REFUND THE PURCHASE PRICE IN LIEU OF REPAIR OR REPLACEMENT.

GAST® WILL NOT BE RESPONSIBLE OR LIABLE FOR INDIRECT OR CONSEQUENTIAL DAMAGES OF ANY KIND, however arising, including but not limited to those for use of any products, loss of time, inconvenience, lost profit, labor charges, or other incidental or consequential damages with respect to persons, business, or property, whether as a result of breach of warranty, negligence or otherwise. Notwithstanding any other provision of this warranty, BUYER'S REMEDY AGAINST GAST® FOR GOODS SUPPLIED OR FOR NON-DELIVERED GOODS OR FAILURE TO FURNISH GOODS, WHETHER OR NOT BASED ON NEGLIGENCE, STRICT LIABILITY OR BREACH OF EXPRESS OR IMPLIED WARRANTY IS LIMITED SOLELY, AT THE OPTION OF GAST®, TO REPLACEMENT OF OR CURE OF SUCH NONCONFORMING OR NON-DELIVERED GOODS OR RETURN OF THE PURCHASE PRICE FOR SUCH GOODS AND IN NO EVENT SHALL EXCEED THE PRICE OR CHARGE FOR SUCH GOODS. GAST® EXPRESSLY DISCLAIMS ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR PURPOSE WITH RESPECT TO THE GOODS SOLD. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTIONS SET FORTH IN THIS WARRANTY, notwithstanding any knowledge of Gast® regarding the use or uses intended to be made of goods, proposed changes or additions to goods, or any assistance or suggestions that may have been made by Gast® personnel.

Unauthorized extensions of warranties by the customer shall remain the customer's responsibility.

CUSTOMER IS RESPONSIBLE FOR DETERMINING THE SUITABILITY OF GAST® PRODUCTS FOR CUSTOMER'S USE OR RESALE, OR FOR INCORPORATING THEM INTO OBJECTS OR APPLICATIONS WHICH CUSTOMER DESIGNS, ASSEMBLES, CONSTRUCTS OR MANUFACTURES.

This warranty can be modified only by authorized Gast® personnel by signing a specific, written description of any modifications.

For more warranty information, visit gastmfg.com/warranty.

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Additional Languages.



Declaration of Conformity.

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