

# **BLAGDON PUMP®**

**IDEX**  
FLUID & METERING



See page 16 for  
ATEX ratings



## **SERVICE AND OPERATING MANUAL**

Original Instructions

### **X25 Metal Flap Valve Pump**

**Design Level 1**

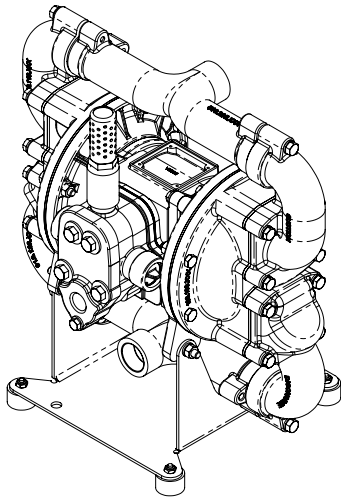
## **Table of Contents**

Engineering Data, Temperature Limitations & Performance Curve.....	1
Explanation of Pump Nomenclature .....	2
Dimensions.....	3
Principle of Operation .....	4
Installation and Start-Up.....	4
Air Supply .....	4
Installation Guide.....	5
Air Inlet & Priming.....	6
Air Exhaust .....	6
Between Uses .....	6
Flap Valve Servicing.....	6
Diaphragm Servicing .....	6
Air Valve Lubrication.....	7
Recommended Accessories .....	7
Externally Serviceable Air Distribution System .....	7
Pilot Valve.....	8
Pilot Valve Actuator.....	8
Service Instructions: Troubleshooting .....	8
Warranty .....	8
Important Safety Information .....	9
Recycling .....	9
Grounding The Pump .....	10
Material Codes .....	11
Composite Repair Parts List.....	12-13
Composite Repair Drawing.....	14
CE Declaration of Conformity - Machinery .....	15
CE Declaration fo Conformity - ATEX.....	16

IDEX Pump Technologies (Ireland) Ltd., • A Unit of IDEX Corporation, R79, Shannon, Co Clare, IRELAND.

• TEL: +353 61 471933 FAX: +353 61 475046 www.blagdonpump.com • e-Mail: sales@blagdonpump.com





# BLAGDON PUMP®

## X25 Metal Flap Valve Pump Design Level 1

### Air-Operated Double Diaphragm Pump

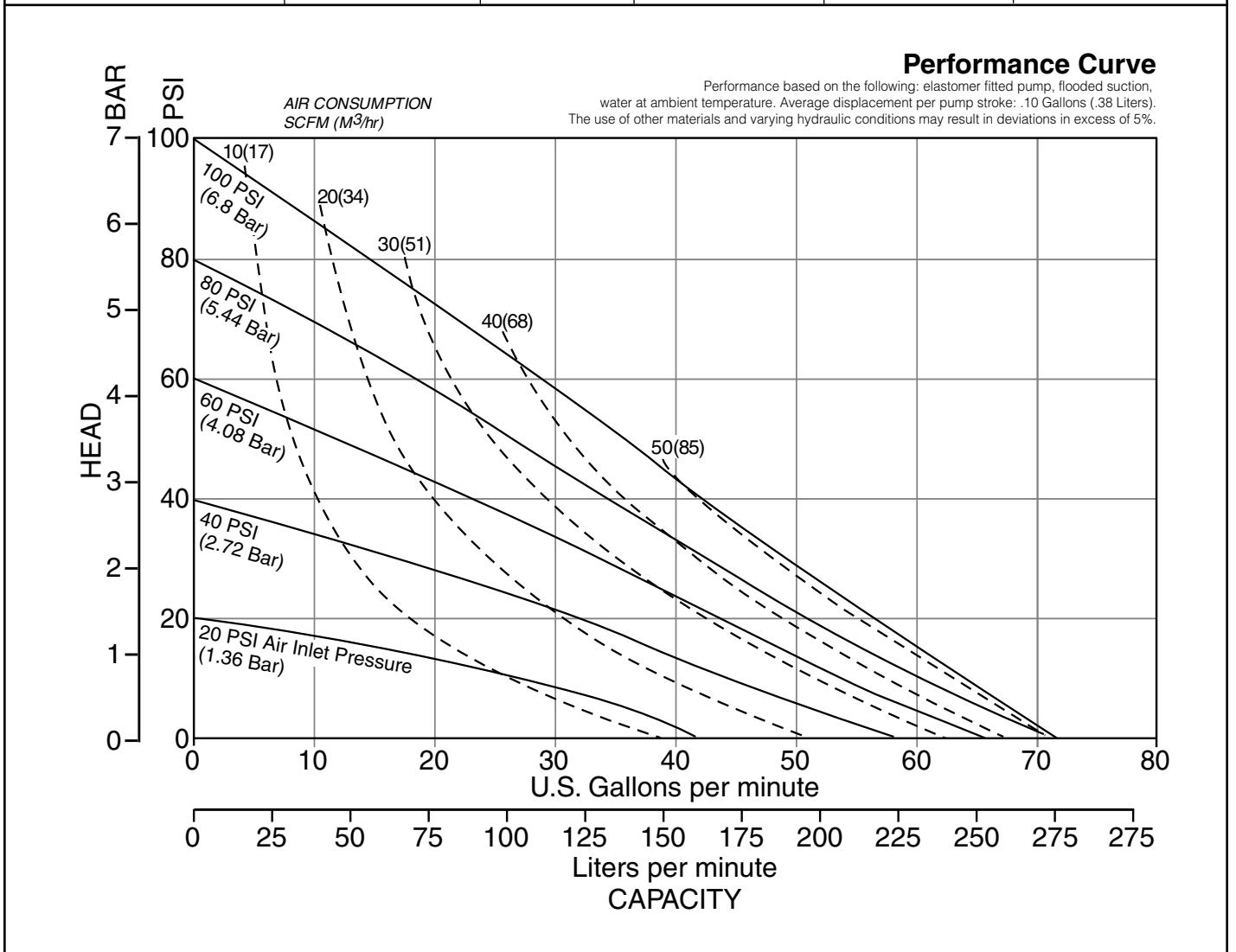
ENGINEERING, PERFORMANCE  
& CONSTRUCTION DATA



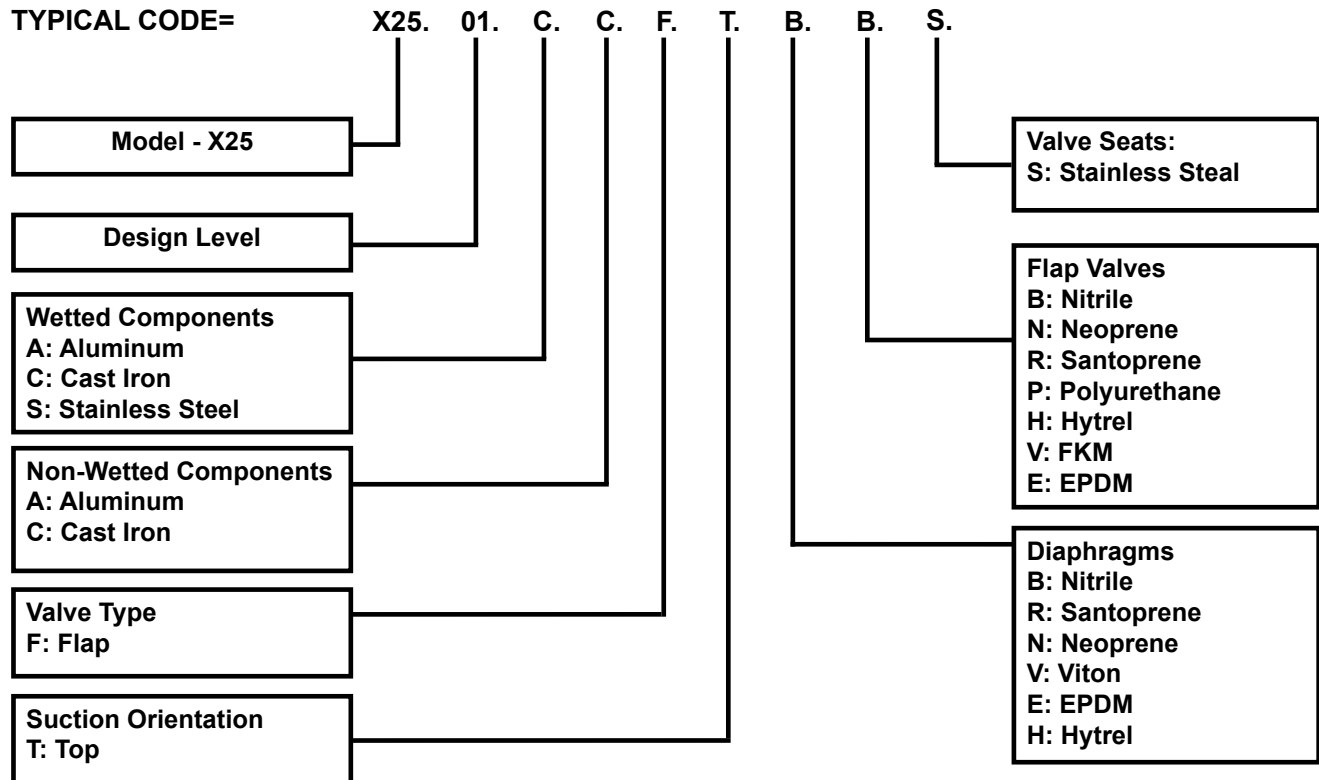
See page 16  
for ATEX ratings



SUCTION/DISCHARGE PIPE SIZE	CAPACITY	AIR VALVE	SOLIDS-HANDLING	HEADS UP TO	DISPLACEMENT/STROKE
1" (25.4mm) NPT(F) 1" (25.4mm) BSP Tapered	0 to 70 gallons per minute (0 to 265 liters per minute)	No-lube, no-stall design	1" (25.4mm)	125 psi or 289 ft. of water (8.8 Kg/cm <sup>2</sup> or 88 meters)	.10 Gallon / .38 liter



**TYPICAL CODE=**



II 2GD T5  
II 1G c T5  
II 3/1 G c T5  
II 1D c T100°C  
I M1 c  
I M2 c

Models equipped with Wetted Options  
C or S, Non-Wetted Options C.  
Note: EC-Type Certificate.

**Maximum delivery: 265 ltrs/min**  
**Max. working pressure: 8.6 bar**  
**Max. solid particle size: 25mm**  
**Air inlet: 1/2" NPT**  
**Temperatur limits: Determined by elastomers**  
**Fluid inlet/outlet: 1" NPT or 1" BSP Tapered**

**Intallation: Surface mounted**  
**Accessories included: Metal Exhaust air silencer**  
**Shipping weights with**  
**Aluminum mid sections: A: 52kg Cast Iron mid sections: C: 29**  
**B: 23kg S: 30**  
**C: 24kg**



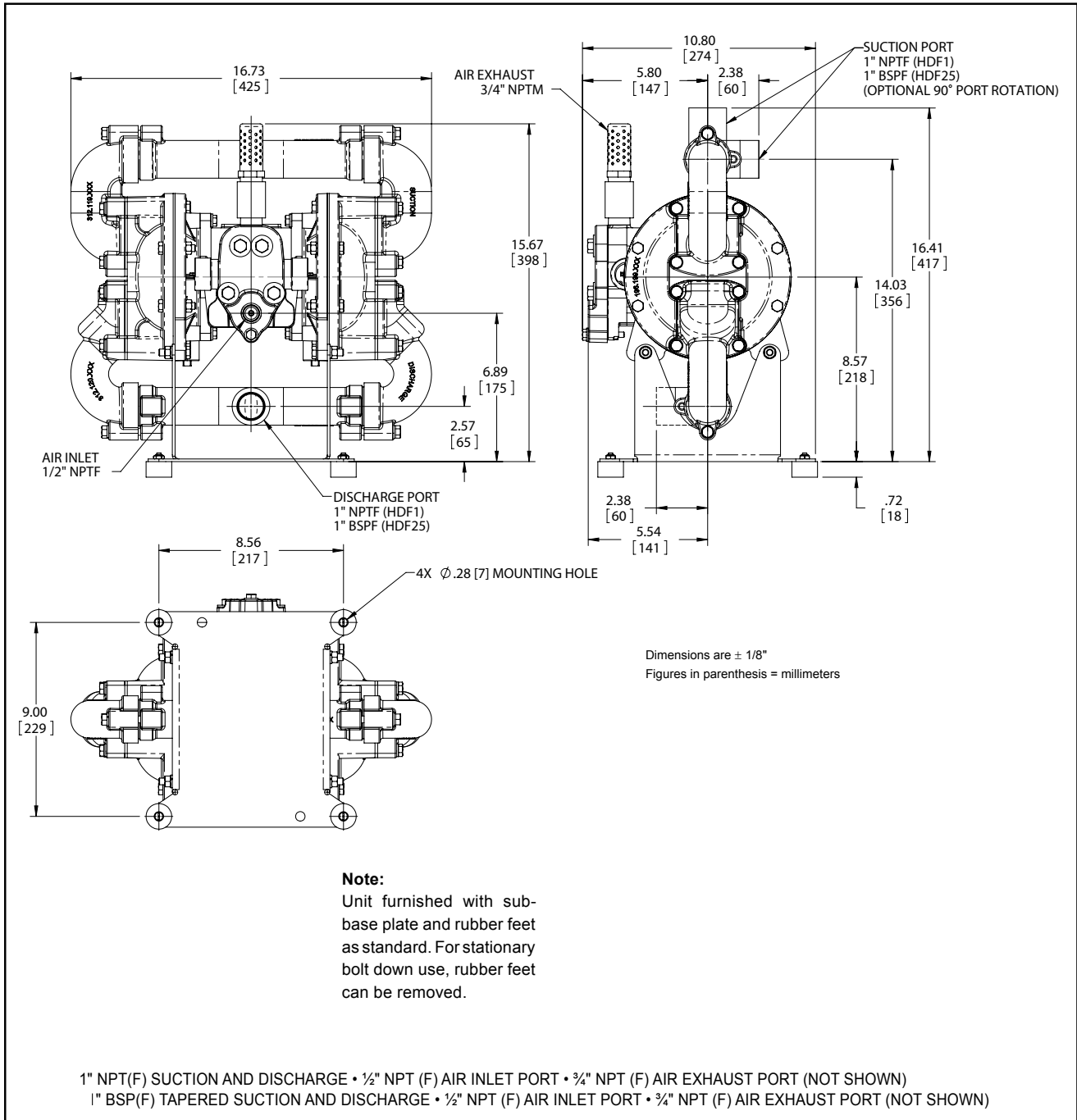
II 2G c T5  
II 3/2 G c T5  
II 2D c T100°C

Models equipped with Aluminium components  
Note: Type Examination

*Maximum and Minimum Temperatures are the limits for which these materials can be operated. Temperatures coupled with pressure affect the longevity of diaphragm pump components. Maximum life should not be expected at the extreme limits of the temperature ranges.*

Materials	Operating Temperatures	
	Maximum	Minimum
<b>Nitrile/FDA White Nitrile</b> General purpose, oil-resistant. Shows good solvent, oil, water and hydraulic fluid resistance. Should not be used with highly polar solvents like acetone and MEK, ozone, chlorinated hydrocarbons and nitro hydrocarbons.	190°F 88°C	-10°F -23°C
<b>EPDM</b> Shows very good water and chemical resistance. Has poor resistance to oil and solvents, but is fair in ketones and alcohols.	280°F 138°C	-40°F -40°C
<b>NEOPRENE</b> All purpose. Resistant to vegetable oils. Generally not affected by moderate chemicals, fats, greases and many oils and solvents. Generally attacked by strong oxidizing acids, ketones, esters, nitro hydrocarbons and chlorinated aromatic hydrocarbons.	200°F 93°C	-10°F -23°C
<b>HYTREL®</b> Good on acids, bases, amines and glycols at room temperature.	220°F 104°C	-20°F -29°C
<b>FKM (Fluorocarbon)</b> shows good resistance to a wide range of oils and solvents; especially all aliphatic, aromatic and halogenated hydrocarbons, acids, animal and vegetable oils. Hot water or hot aqueous solutions (over 70°F) will attack FKM.	350°F 177°C	-40°F -40°C
<b>Urethane</b> Shows good resistance to abrasives. Has poor resistance to most solvents and oils.	150°F 66°C	32°F 0°C
<b>Santoprene®</b> Injection molded thermoplastic elastomer with no fabric layer. Long mechanical flex life. Excellent abrasion resistance.	275°F 135°C	-40°F -40°C
<b>CF-8M Stainless Steel</b> equal to or exceeding ASTM specification A743 for corrosion resistant iron chromium, iron chromium nickel, and nickel based alloy castings for general applications. Commonly referred to as 316 Stainless Steel in the pump industry.		

For specific applications, always consult "Chemical Resistance Chart" Technical Bulletin



### **PLEASE NOTE!**

The photos shown in this manual are for general instruction only. Your specific model may not be shown. Always refer to the parts list and exploded view drawing for your specific model when installing, disassembling or servicing your pump.

### **PRINCIPLE OF PUMP OPERATION**

This ball valve pump is powered by compressed air and is a 1:1 pressure ratio design. It alternately pressurizes the inner side of one diaphragm chamber, while simultaneously exhausting the other inner chamber. This causes the diaphragms, which are connected by a common rod, to move endwise. Air pressure is applied over the entire surface of the diaphragm, while liquid is discharged from the opposite side. The diaphragm operates under a balanced condition during the discharge stroke, which allows the unit to be operated at discharge heads over 200 feet (61 meters) of water head.

Since the diaphragms are connected by a common rod, secured by plates to the center of the diaphragms, one diaphragm performs the discharge stroke, while the other is pulled to perform the suction stroke in the opposite chamber.

For maximum diaphragm life, keep the pump as close to the liquid being pumped as possible. Positive suction head in excess of 10 feet of liquid (3.048 meters) is not recommended. For applications with higher suction heads, consult the factory.

Alternate pressuring and exhausting of the diaphragm chamber is performed by means of an externally mounted, pilot operated, four-way spool type air distribution valve. When the spool shifts to one end of the valve body, inlet air pressure is applied to one diaphragm chamber and the other diaphragm chamber exhausts. When the spool shifts to the opposite end of the valve body, the porting of chambers is reversed. The air distribution valve spool is moved by an internal pilot valve which alternately pressurizes one side of the air distribution valve spool, while exhausting the other side. The pilot valve is shifted at each end of the diaphragm stroke by the diaphragm plate coming in contact with the end of the pilot valve spool. This pushes it into position for shifting of the air distribution valve.

The chambers are manifolded together with a suction and discharge check valve for each chamber, maintaining flow in one direction through the pump.

### **INSTALLATION & START-UP**

Locate the pump as close to the product being pumped as possible, keeping suction line length and number of fittings to a minimum. Do not reduce line size.

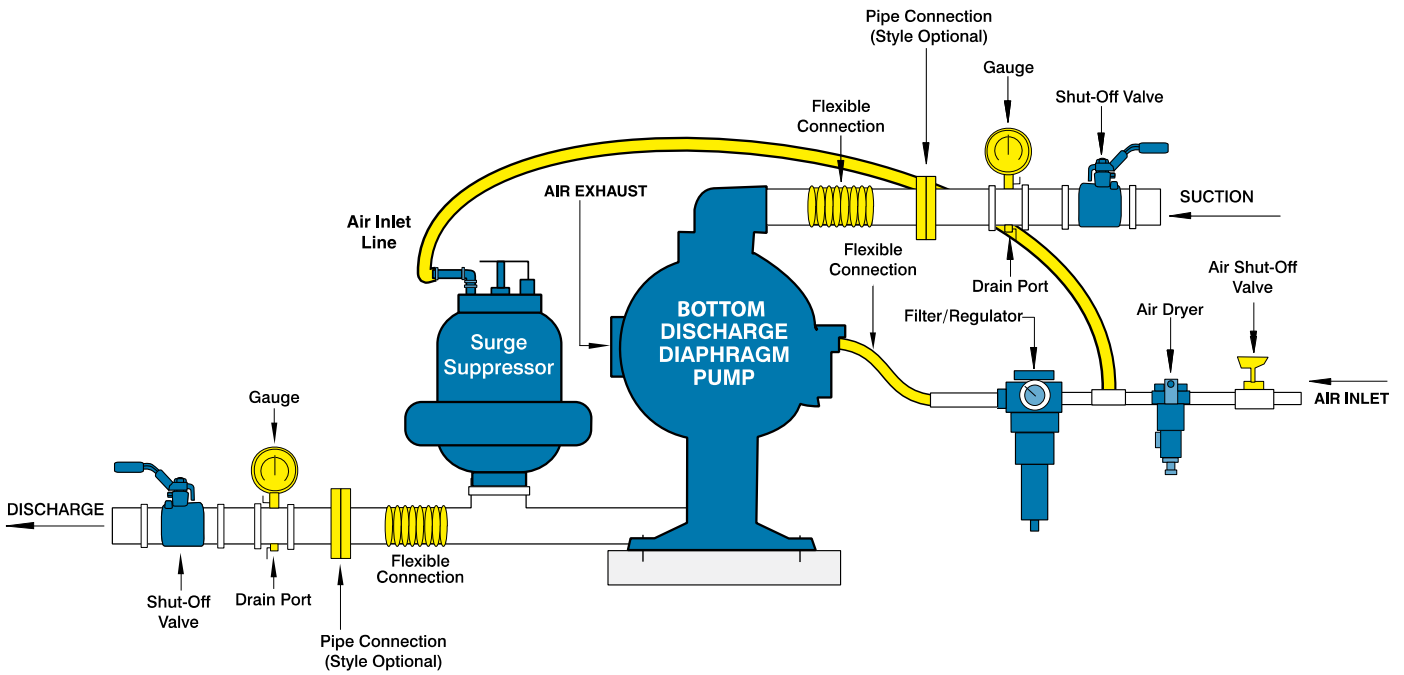
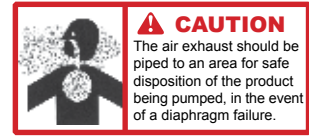
For installations of rigid piping, short flexible sections of hose should be installed between pump and piping. This reduces vibration and strain to the piping system. A surge suppressor is recommended to further reduce pulsation in flow. Tighten all fasteners before pump startup.

This pump was tested at the factory prior to shipment and is ready for operation. It is completely self-priming from a dry start for suction lifts of 17 feet (5.8 meters) or less. For suction lifts exceeding 17 feet of liquid, fill the chambers with liquid prior to priming.

# INSTALLATION GUIDE

## Bottom Discharge Flap Valve Unit

Available from Distributor



## **AIR SUPPLY**

Air supply pressures cannot exceed 125 psi (8.61 bar). Connect the pump air inlet to an air supply of sufficient capacity and pressure required for desired performance. When the air line is solid piping, use a short length of flexible hose (not less than 1/2" (12.7 mm) in diameter) between pump and piping to eliminate strain to pipes.

## **AIR INLET & PRIMING**

For start-up, open an air valve approximately 1/2" to 3/4" turn. After the unit primes, an air valve can be opened to increase flow as desired. If opening the valve increases cycling rate, but does not increase flow rate, cavitation has occurred, and the valve should be closed slightly.

For the most efficient use of compressed air and the longest diaphragm life, throttle the air inlet to the lowest cycling rate that does not reduce flow.

## **AIR EXHAUST**

If a diaphragm fails, the pumped liquid or fumes can enter the air end of the pump, and be exhausted into the atmosphere. When pumping hazardous or toxic materials, pipe the exhaust to an appropriate area for safe disposition.

This pump can be submerged if materials of construction are compatible with the liquid. The air exhaust must be piped above the liquid level. Piping used for the air exhaust must not be smaller than 1" (2.54 cm). Reducing the pipe size will restrict air flow and reduce pump performance. When the product source is at a higher level than the pump (flooded suction), pipe the exhaust higher than the product source to prevent siphoning spills.

Freezing or icing-up of the air exhaust can occur under certain temperature and humidity conditions. Use of an air dryer should eliminate most icing problems.

## **BETWEEN USES**

When used for materials that tend to settle out or transform to solid form, the pump should be completely flushed after each use, to prevent damage. Product remaining in the pump between uses could dry out or settle out. This could cause problems with valves and diaphragms at re-start. In freezing temperatures, the pump must be drained between uses in all cases.

## **FLAP VALVE SERVICING**

Valve inspection requires removal of Capscrews and elbows. When the top suction elbows are removed, the valve and seat are connected as an assembly. When the bottom discharge elbows are removed, the valve and seat stay with the outer chamber. Visual inspection and cleaning is possible. If parts are to be replaced, remove the self-locking nuts and all parts are accessible.

Caution should be used while reassembling Flap valves. The valves are designed for some preload over the retainer hinge pad. This is done to insure proper face contact with the seat. After all parts are in place, tighten the lock nuts down on the assembly to the point where visual inspection shows that seat and valve face mate without gap. This is important for dry prime. However, after priming action has started, valves will function due to differential pressure without concern or trouble.

## **DIAPHRAGM SERVICING**

Remove the eight bolts securing the elbows to the chamber. Remove the four nuts and four capscrews securing the outer diaphragm chamber flange and remove the chamber. Loosen the capscrew securing the diaphragm and plate to the rod by leaving the diaphragm engaged with the capscrews around the outer flange, preventing rotation of the rod. **DO NOT USE A WRENCH ON THE DIAPHRAGM ROD. FLAWS ON THE SURFACE MAY DAMAGE BEARINGS AND SEAL.**

During reassembly make certain that the rubber bumper is on the rod on each side. Install the diaphragm with the natural bulge outward as indicated on the diaphragm. Install the outer plate on the outside of the diaphragm. Place the sealing washer between the inner diaphragm plate and the end of the rod. Tighten the capscrew to approximately 25 ft. lbs. (33.9 Newton meters). Torque while allowing diaphragm to turn freely with plates. Except for EPDM Rubber, use a lightweight oil between plates and diaphragm when doing this procedure. For EPDM water can be used. Use a wrench on the Hex of the opposite side to keep the rod from rotating. If the opposite chamber is assembled, the rod need not be held. The Flap Valves can also be inspected for proper seating at this point.



## AIR VALVE LUBRICATION

*The pump's pilot valve and main air valve assemblies are designed to operate WITHOUT lubrication. This is the preferred mode of operation.* There may be instances of personal preference, or poor quality air supplies when lubrication of the compressed air supply is required. The pump air system will operate with properly lubricated compressed air supplies. Proper lubrication of the compressed air supply would entail the use of an air line lubricator (set to deliver one drop of 10 weight, non-detergent oil for every 20 SCFM of air the pump consumed at its point of operation. Consult the pump's published Performance Curve to determine this.

It is important to remember to inspect the sleeve and spool set routinely. It should move back and forth freely. This is most important when the air supply is lubricated. If a lubricator is used, oil accumulation will, over time, collect any debris from the compressed air. This can prevent the pump from operating properly.

Water in the compressed air supply can create problems such as icing or freezing of the exhaust air causing the pump to cycle erratically, or stop operating. This can be addressed by using a point of use air dryer to supplement a plant's air drying equipment. This device will remove excess water from the compressed air supply and alleviate the icing or freezing problem.

## EXTERNALLY SERVICEABLE AIR DISTRIBUTION SYSTEM

Please refer to the exploded view drawing and parts list in the Service Manual supplied with your pump. If you need replacement or additional copies, contact your local Distributor, or the factory Literature Department. To receive the correct manual, you must specify the MODEL information found on the name plate of the pump.

The main air valve sleeve and spool set is located in the valve body mounted on the pump with four hex head capscrews. The valve body assembly is removed from the pump by removing these four hex head capscrews.

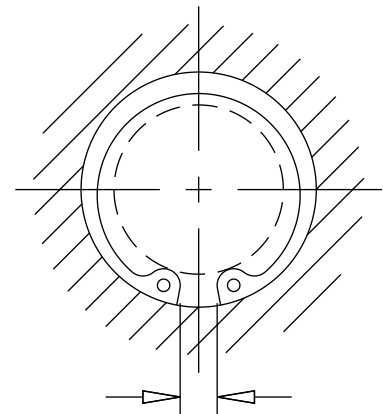
With the valve body assembly off the pump, access to the sleeve and spool set is made by removing a retaining ring (each end) securing the end cap on the valve body assembly. With the end caps removed, slide the spool back and forth in the sleeve. The spool is closely sized to the sleeve and must move freely to allow for proper pump operation. An accumulation of oil, dirt or other contaminants from the pump's air supply, or from a failed diaphragm, may prevent the spool from moving freely. This can cause the spool to stick in a position that prevents the pump from operating. If this is the case, the sleeve and spool set should be removed from the valve body for cleaning and further inspection.

Remove the spool from the sleeve. Using an arbor press or bench vise (with an improvised mandrel), press the sleeve from the valve body. Take care not to damage the sleeve. At this point, inspect the o-rings on the sleeve for nicks, tears or abrasions. Damage of this sort could happen during assembly or servicing. A sheared or cut o-ring can allow the pump's compressed air supply to leak or bypass within the air valve assembly, causing the pump to leak compressed air from the pump air exhaust or not cycle properly. This is most noticeable at pump dead head or high discharge pressure conditions. Replace any of these o-rings as required or set up a routine, preventive maintenance schedule to do so on a regular basis. This practice should include cleaning the spool and sleeve components with a safety solvent or equivalent, inspecting for signs of wear or damage, and replacing worn components.

To re-install the sleeve and spool set, lightly lubricate the o-rings on the sleeve with an o-ring assembly lubricant or lightweight oil (such as 10 wt. air line lubricant). Re-install one end cap, and retaining ring (see safety warning), on the valve body. Using the arbor press or bench vise that was used in disassembly, carefully press the sleeve back into the valve body, without shearing the o-rings. Re-install the spool, opposite end cap and retaining ring (see safety warning), on the valve body. After inspecting and cleaning the gasket surfaces on the valve body and intermediate, reinstall the valve body on the pump using new gaskets. Tighten the four hex head capscrews evenly and in an alternating cross pattern, at 150 in./lbs. (16.94 Newton meters).

## PILOT VALVE

The pilot valve assembly is accessed by removing the main air distribution valve body from the pump and lifting the pilot valve body out of the intermediate housing.



$\geq .232$  "G"  
Dimensions between lugs



# IMPORTANT SAFETY INFORMATION



## ⚠ IMPORTANT

Read these safety warnings and instructions in this manual completely, before installation and start-up of the pump. It is the responsibility of the purchaser to retain this manual for reference. Failure to comply with the recommendations stated in this manual will damage the pump, and void factory warranty.



## ⚠ CAUTION

Before pump operation, inspect all gasketed fasteners for looseness caused by gasket creep. Retorque loose fasteners to prevent leakage. Follow recommended torques stated in this manual.



## ⚠ WARNING

Before maintenance or repair, shut off the compressed air line, bleed the pressure, and disconnect the air line from the pump. The discharge line may be pressurized and must be bled of its pressure.



## ⚠ WARNING

In the event of diaphragm rupture, pumped material may enter the air end of the pump, and be discharged into the atmosphere. If pumping a product which is hazardous or toxic, the air exhaust must be piped to an appropriate area for safe disposition.



## ⚠ WARNING

Take action to prevent static sparking. Fire or explosion can result, especially when handling flammable liquids. The pump, piping, valves, containers or other miscellaneous equipment must be grounded. (See page 10)



## ⚠ WARNING

This pump is pressurized internally with air pressure during operation. Always make certain that all bolting is in good condition and that all of the correct bolting is reinstalled during assembly.



## ⚠ WARNING

When used for toxic or aggressive fluids, the pump should always be flushed clean prior to disassembly.



## ⚠ WARNING

Before doing any maintenance on the pump, be certain all pressure is completely vented from the pump, suction, discharge, piping, and all other openings and connections. Be certain the air supply is locked out or made non-operational, so that it cannot be started while work is being done on the pump. Be certain that approved eye protection and protective clothing are worn all times in the vicinity of the pump. Failure to follow these recommendations may result in serious injury or death.



## ⚠ WARNING

Airborne particles and loud noise hazards. Wear ear and eye protection.

## RECYCLING

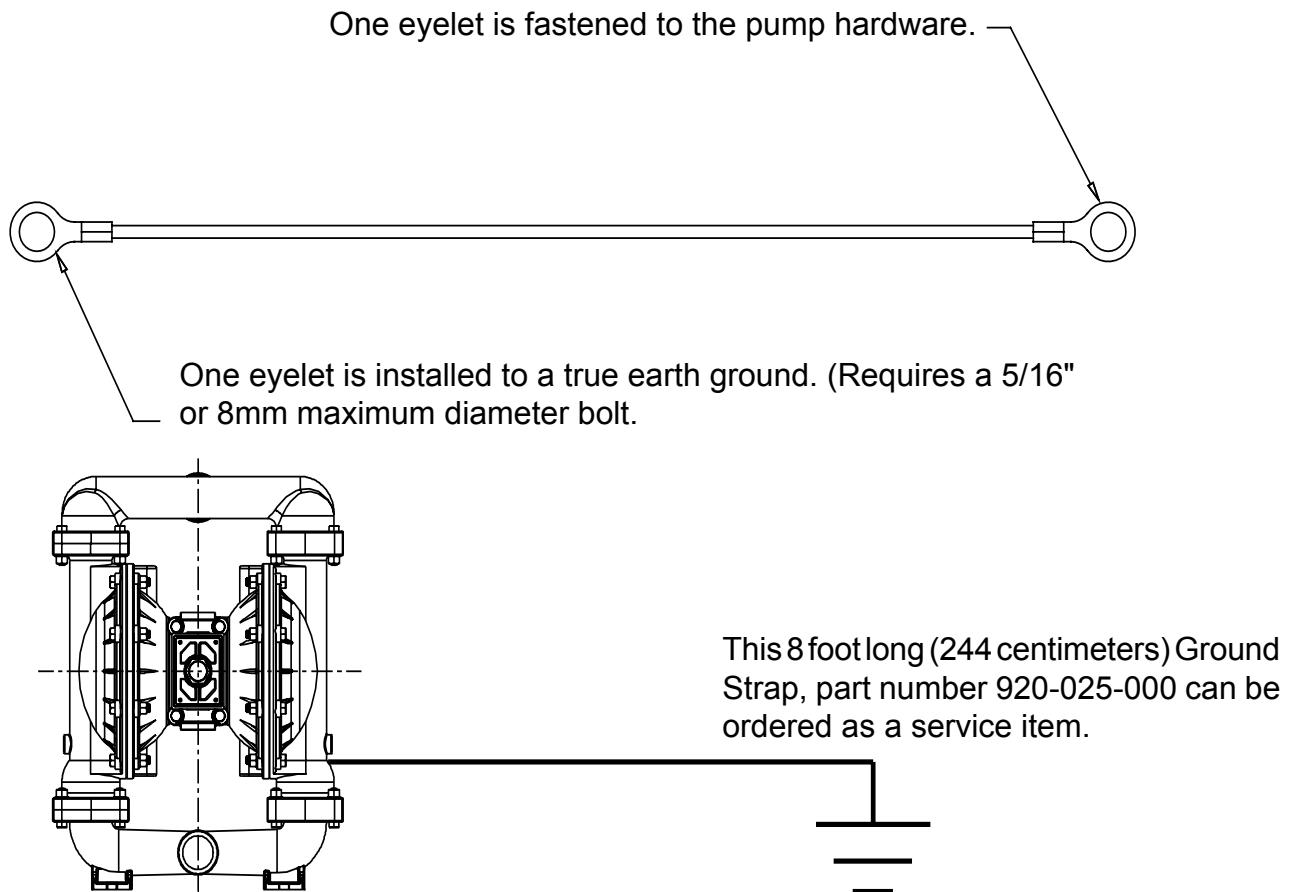
Many components of pumps are made of recyclable materials (see chart on page 11 for material specifications). We encourage pump users to recycle worn out parts and pumps whenever possible, after any hazardous pumped fluids are thoroughly flushed.

# GROUNDING THE PUMP

To be fully groundable, the pumps must be ATEX Compliant. Refer to pump data sheet for ordering.

**! WARNING !**

*Take action to prevent static sparking. Fire or explosion can result, especially when handling flammable liquids. The pump, piping, valves, containers or other miscellaneous equipment must be grounded.*



To reduce the risk of static electrical sparking, this pump must be grounded. Check the local electrical code for detailed grounding instruction and the type of equipment required, or in the absence of local codes, an industry or nationally recognized code having jurisdiction over specific installations.

## MATERIAL CODES THE LAST 3 DIGITS OF PART NUMBER

000	Assembly, sub-assembly; and some purchased items	353	Geolast; Color: BLACK	557	Conductive Polypropylene; Color: BLACK; Color Coded: SILVER
010	Cast Iron	354	Injection Molded #203-40 Santoprene- Duro 40D +/-5; Color: RED	558	Conductive HDPE; Color: BLACK Color Coded: SILVER
012	Powered Metal	355	Thermal Plastic	559	Conductive Polypropylene; Color: BLACK Color Coded: SILVER
015	Ductile Iron	356	HytreI; Color: BLUE	570	Rulon II
020	Ferritic Malleable Iron	357	Injection Molded Polyurethane; Color: GREEN	580	Ryton
025	Music Wire	358	Urethane Rubber; Color: NATURAL (Some Applications)	590	Valox
080	Carbon Steel, AISI B-1112		(Compression Mold)	591	Nylatron G-S
100	Alloy 20	359	Urethane Rubber; Color: NATURAL	592	Nylatron NSB
110	Alloy Type 316 Stainless Steel	360	Nitrile Rubber; Color Coded: RED	600	PTFE (virgin material) Tetrafluorocarbon (TFE)
111	Alloy Type 316 Stainless Steel (Electro Polished)	361	Nitrile	601	PTFE (Bronze and moly filled)
112	Alloy C	363	FKM (Fluorocarbon). Color Coded: YELLOW	602	Filled PTFE
113	Alloy Type 316 Stainless Steel (Hand Polished)	364	E.P.D.M. Rubber. Color Coded: BLUE	603	Blue Gylon
114	303 Stainless Steel	365	Neoprene Rubber; Color Coded: GREEN	604	PTFE
115	302/304 Stainless Steel	366	Food Grade Nitrile; Color: WHITE	606	PTFE
117	440-C Stainless Steel (Martensitic)	368	Food Grade EPDM; Color: GRAY	607	Envelon
120	416 Stainless Steel (Wrought Martensitic)	370	Butyl Rubber Color Coded: BROWN	608	Conductive PTFE; Color: BLACK
123	410 Stainless Steel (Wrought Martensitic)	371	Phlthane (Tuftane)	610	PTFE Encapsulated Silicon
148	Hardcoat Anodized Aluminum	374	Carboxylated Nitrile	611	PTFE Encapsulated FKM
149	2024-T4 Aluminum	375	Fluorinated Nitrile	632	Neoprene/Hytrel
150	6061-T6 Aluminum	378	High Density Polypropylene	633	FKM/PTFE
151	6063-T6 Aluminum	379	Conductive Nitrile; Color Coded: RED & SILVER	634	EPDM/PTFE
152	2024-T4 Aluminum (2023-T351)	384	Conductive Neoprene; Color Coded: GREEN & SILVER	635	Neoprene/PTFE
154	Almag 35 Aluminum	405	Cellulose Fibre	637	PTFE , FKM/PTFE
155	356-T6 Aluminum	408	Cork and Neoprene	638	PTFE , Hytrel/PTFE
156	356-T6 Aluminum	425	Compressed Fibre	639	Nitrile/TFE
157	Die Cast Aluminum Alloy #380	426	Blue Gard	643	Santoprene®/EPDM
158	Aluminum Alloy SR-319	440	Vegetable Fibre	644	Santoprene®/PTFE
159	Anodized Aluminum	465	Fibre	656	Santoprene Diaphragm and Check Balls/EPDM Seats
162	Brass, Yellow, Screw Machine Stock	500	Delrin 500	661	EPDM/Santoprene
165	Cast Bronze, 85-5-5-5	501	Delrin 570	666	FDA Nitrile Diaphragm, PTFE Overlay, Balls, and Seals
166	Bronze, SAE 660	502	Conductive Acetal, ESD-800; Color: BLACK	668	PTFE, FDA Santoprene/PTFE
170	Bronze, Bearing Type, Oil Impregnated	503	Conductive Acetal, Glass-Filled Color: BLACK; Color Coded: YELLOW		
175	Die Cast Zinc	505	Acrylic Resin Plastic		
180	Copper Alloy	506	Delrin 150		
305	Carbon Steel, Black Epoxy Coated	520	Injection Molded PVDF; Color: NATURAL		
306	Carbon Steel, Black PTFE Coated	521	Injection Molded Conductive PVDF; Color: BLACK; Color Coded: LIGHT GREEN		
307	Aluminum, Black Epoxy Coated	540	Nylon		
308	Stainless Steel, Black PTFE Coated	541	Nylon		
309	Aluminum, Black PTFE Coated	542	Nylon		
310	PVDF Coated	544	Nylon Injection Molded		
313	Aluminum, White Epoxy Coated	550	Polyethylene		
330	Zinc Plated Steel	551	Glass Filled Polypropylene; Color: BLACK		
331	Chrome Plated Steel	552	Unfilled Polypropylene; Color: NATURAL		
332	Aluminum, Electroless Nickel Plated	555	Polyvinyl Chloride		
333	Carbon Steel, Electroless Nickel Plated	556	Black Vinyl		
335	Galvanized Steel				
336	Zinc Plated Yellow Brass				
337	Silver Plated Steel				
340	Nickel Plated				
342	Filled Nylon				
351	Food Grade Santoprene; Color: NATURAL				

Delrin is a registered  
tradename of E.I. DuPont.

Gylon is a registered tradename  
of Garlock, Inc.

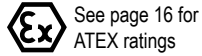
Nylatron is a registered tradename  
of Polymer Corp.

Santoprene is a registered tradename  
of Exxon Mobil Corp.

Rulon II is a registered tradename  
of Dixon Industries Corp.

Ryton is a registered tradename  
of Phillips Chemical Co.

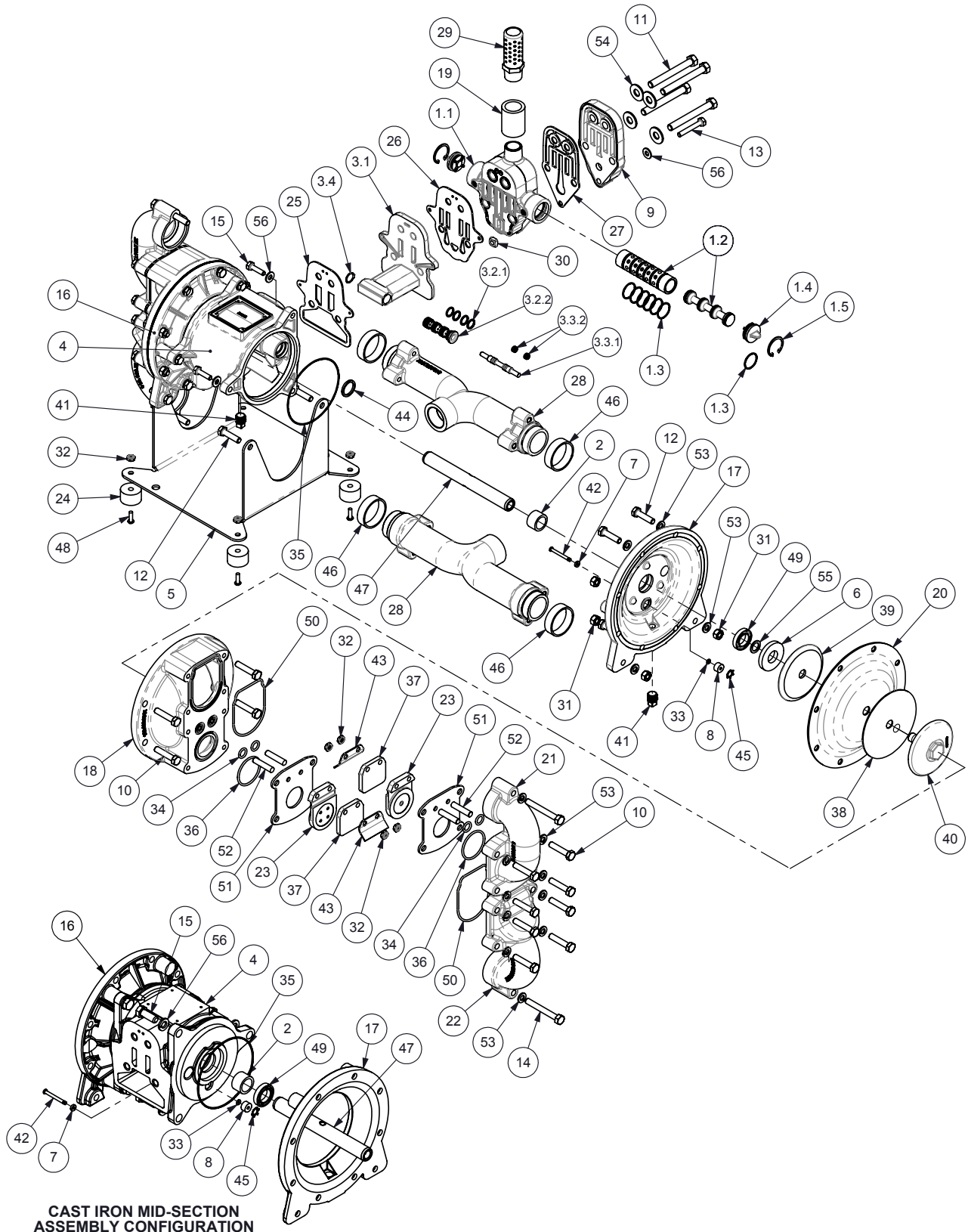
Valox is a registered tradename  
of General Electric Co.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	031.030.558	Assembly, Air Valve	1
1.1	095.051.558	Body, Air Valve	1
1.2	031.039.000	Sleeve & Spool Set	1
1.3	560.058.360	O-Ring	8
1.4	165.038.558	Cap, End	2
1.5	675.043.115	Ring, Retaining	2
2	070.012.170	Bearing, Sleeve	2
3	095.074.001	Pilot Valve Assembly	1
3.1	095.071.551	Body, Pilot Valve	1
3.2	755.025.000	Sleeve Assembly (w/ O-Rings)	1
3.2.1	560.033.360	O-Ring	4
3.2.2	755.025.162	Sleeve, Pilot Valve	1
3.3	775.014.000	Spool Assembly (w/ O-Rings)	1
3.3.1	775.014.115	Spool, Pilot Valve	1
3.3.2	560.023.360	O-Ring	4
3.4	675.037.080	Ring, Retaining	1
4	114.007.157	Bracket, Intermediate (AL Center)	1
	114.012.010	Bracket, Intermediate (CI Center)	1
5	115.071.330	Bracket, Mounting	1
6	132.019.360	Bumper	2
7	132.022.360	Bumper, Actuator	2
8	135.034.506	Bushing, Plunger	2
9	165.134.157	Cap, Air Inlet, Ass'y (AL Center)	1
	165.134.558	Cap, Air Inlet, Ass'y (CI Center)	1
10	170.029.330	Capscrew, Hex HD	24
11	170.033.330	Capscrew, Hex HD	4
12	170.045.330	Capscrew, Hex HD	12
13	170.063.330	Capscrew, Hex HD	1
14	170.080.330	Capscrew, Hex HD	4
15	170.043.330	Capscrew, Hex HD (AL Center)	6
	170.006.330	Capscrew, Hex HD (CI Center)	6
16	196.042.157	Chamber, Inner (AL Center)	1
	196.084.010	Chamber, Inner (CI Center)	1
17	196.043.157	Chamber, Inner (AL Center)	1
	196.090.010	Chamber, Inner (CI Center)	1
18	196.199.156	Chamber, Outer	2
	196.199.010	Chamber, Outer	2
	196.199.110	Chamber, Outer	2
19	255.012.335	Coupling, Pipe, 3/4 NPT	1
20	286.008.354	Diaphragm	2
	286.008.356	Diaphragm	2
	286.008.360	Diaphragm	2
	286.008.363	Diaphragm	2
	286.008.364	Diaphragm	2
	286.008.365	Diaphragm	2
21	312.119.156	Elbow, Suction	2
	312.119.010	Elbow, Suction	2
	312.119.110	Elbow, Suction	2
22	312.120.156	Elbow, Discharge	2
	312.120.010	Elbow, Discharge	2
	312.120.110	Elbow, Discharge	2
23	338.014.354	Flap Valve	4
	338.014.356	Flap Valve	4

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
	338.014.360	Flap Valve	4
	338.014.363	Flap Valve	4
	338.014.364	Flap Valve	4
	338.014.365	Flap Valve	4
24	350.002.360	Foot, Rubber	4
25	360.056.379	Gasket	1
26	360.057.360	Gasket	1
27	360.058.360	Gasket	1
28	518.205.156	Manifold	2
	518.205.156 E	Manifold	2
	518.205.010	Manifold	2
	518.205.010 E	Manifold	2
	518.205.110	Manifold	2
	518.205.110 E	Manifold	2
29	530.036.000	Muffler	1
30	542.001.330	Nut, Square	1
31	545.004.330	Nut, Hex, 5/16-18	14
32	547.002.110	Nut, Stop	12
33	560.001.360	O-Ring	2
34	560.038.360	O-Ring	8
	560.038.363	O-Ring	8
	560.038.364	O-Ring	8
	560.038.365	O-Ring	8
35	560.040.360	O-Ring	2
36	560.198.360	O-Ring	4
	560.198.363	O-Ring	4
	560.198.364	O-Ring	4
	560.198.365	O-Ring	4
37	570.018.360	Pad, Hinge	4
	570.018.363	Pad, Hinge	4
	570.018.364	Pad, Hinge	4
	570.018.365	Pad, Hinge	4
38	570.019.360	Pad, Wear	2
	570.019.363	Pad, Wear	2
	570.019.364	Pad, Wear	2
	570.019.365	Pad, Wear	2
39	612.022.330	Plate, Diaphragm, Inner	2
40	612.108.157	Assembly, Diaphragm Plate	2
	612.101.082	Assembly, Diaphragm Plate	2
	612.101.110	Assembly, Diaphragm Plate	2
41	618.003.330	Plug, Pipe, 1/4	3
42	620.007.114	Plunger, Actuator	2
43	670.053.110	Retainer	4
44	675.040.360	Ring, Sealing	2
45	675.042.115	Ring, Retaining	2
46	675.065.360	Ring, Sealing	4
	675.065.363	Ring, Sealing	4
	675.065.364	Ring, Sealing	4
	675.065.364	Ring, Sealing	4
47	685.039.120	Rod, Diaphragm	1
48	706.013.330	Screw, Machine	4
49	720.010.375	Seal, U-Cup	2
50	720.066.360	Seal, Seat	4
	720.066.363	Seal, Seat	4
	720.066.364	Seal, Seat	4
	720.066.365	Seal, Seat	4
51	722.101.110	Seat, Flap	4
52	807.018.110	Stud, 1/4-20	8
53	900.004.330	Washer, Lock, 5/16	32
54	901.005.330	Washer, Flat, 3/8	4
55	901.012.180	Washer, Sealing	2
56	901.035.330	Washer, Flat	7

# Composite Repair Drawing



©Neverseize is a registered trademark of Loctite



# **BLAGDON PUMP®**

## **Declaration of Conformity**

**Manufacturer: IDEX Pump Technologies (Ireland) Ltd., • A Unit of IDEX Corporation  
R79, Shannon, Co Clare, Ireland**

Certifies that Air-Operated Double Diaphragm Pump Series: B75, X75, AVB75, AVX75 and Pulsation Dampener models: PD25M, PD40M, PD50M & PD80M comply with comply with the European Community Directive 2006/42/EC on Machinery, according to Annex VIII. This product has used Harmonized Standard EN 809, Pumps and Pump Units for Liquids - Common Safety Requirements, to verify conformance.

  
\_\_\_\_\_  
Signature of authorized person

October 20, 2005  
\_\_\_\_\_  
Date of issue

Des Monaghan  
\_\_\_\_\_  
Printed name of authorized person

Production & Tech. Manager  
\_\_\_\_\_  
Title

Revision Level: E

May 27, 2010  
\_\_\_\_\_  
Date of revision



# **BLAGDON PUMP®**

## **EC Declaration of Conformity**

In accordance with ATEX Directive 94/9/EC,  
Equipment intended for use in potentially explosive environments.

**Manufacturer:** IDEX Pump Technologies (Ireland) Ltd.,  
A Unit of IDEX Corporation, R79, Shannon, Co Clare, IRELAND.

**AODD Pumps Equipped with Aluminium**  
Type Examination Certificate: KEMA 09ATEX0072 X


**AODD (Air-Operated Double Diaphragm) Pumps**  
EC Type Examination Certificate No. Pumps: KEMA 09ATEX0071 X  
KEMA Quality B.V.  
Utrechtseweg 310  
6812 AR Arnhem, The Netherlands



**Applicable Standard:**  
EN13463-1: 2001,  
EN13463-5: 2003



**DATE/APPROVAL/TITLE:**  
27 MAY 2010

  
Production and Technical Manager

Declaration of Conformity

Declaration of Conformity