



VACGEN

Assembly Guide

RD91 & RD94 Bellows Assembly Replacement AS0006

VGS03-02T06



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DISCLAIMER

This Assembly Guide should be used in conjunction with the owner's manual where available, and is intended as a guide only as there may be variations between versions and therefore must be used at the Owner's Risk. For more detailed assistance, please contact our Support desk +44 (0) 1323 379 335 or support@vacgen.com.

HEALTH AND SAFETY

All repairs and services should be carried out by a qualified engineer, using the correct tools and procedures to carry out the repair. VACGEN are not liable for any errors within the assembly guides which may cause inconsistencies during repair.

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RD91

1. Release grub screws in lower index ring (6)
2. Release grub screws that now can be seen in the body and pull assembly off, noting that this has to be carefully angled to pass the bellows.

RD94

1. Remove the grub screws from the body (2)
2. Carefully pull off the body noting that this has to be carefully angled to pass the bellows.

RD91 / RD94

3. On the bellows assembly, remove the clip (21)
4. Carefully pull the shaft out noting the top part of the shaft is bent.

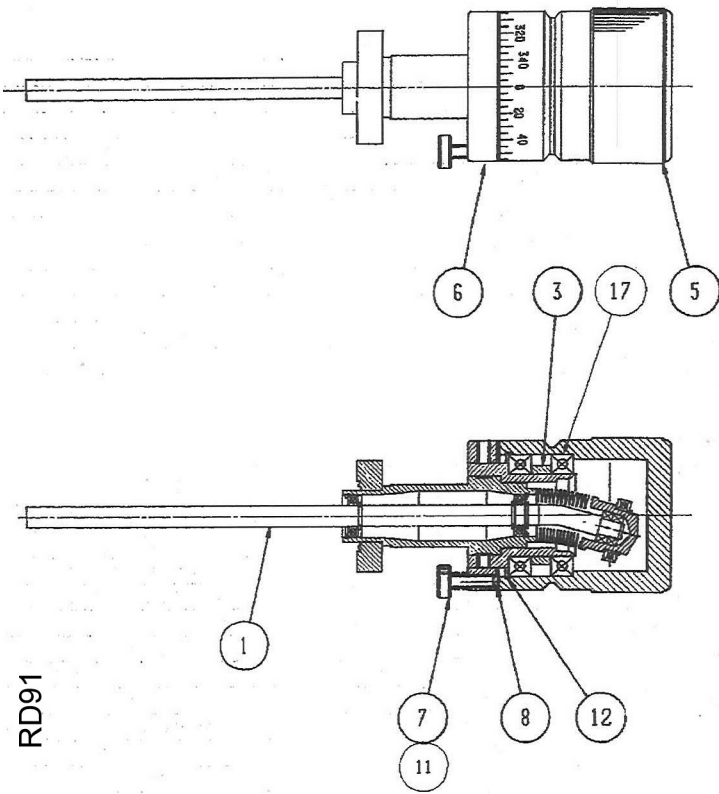
RD91 / RD94

5. Remove spiral clip (21)
6. Pull the shaft out with the bearing, noting once the bearing is out, the shaft needs to be angled slightly to get the curved portion of the shaft passed the bellows.
7. Note there is a spring washer (18) sitting on the top bearing that takes up any backlash which will come out once the shaft is removed. Make sure this is refitted.

Assembly in reverse



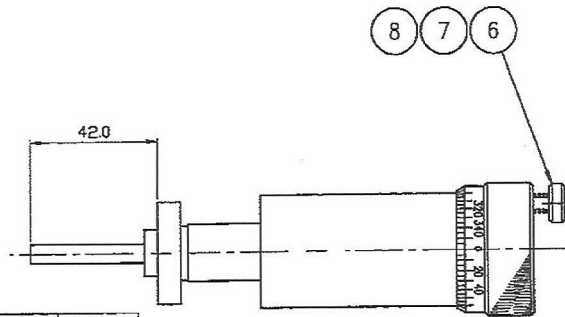
DRAWINGS



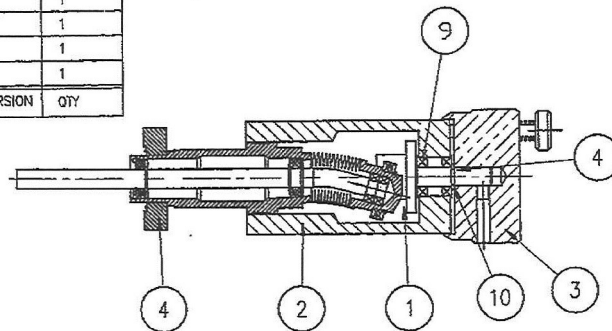
17		2
16		
15		
14		
12	RETAINING RING WH145	1
11	LEE SPRING LC-022BC-0-SS	
10		
9		
8	PAD	1
7	THUMB SCREW	1
6	INDEX RING ENGRAVING	1
5	TOP CAP ENGRAVING	1
3	BEARING ASSY	1
2		
1	IN VAC SHAFT,SUB-ASSY	1
ITEM NO	DESCRIPTION	QTY

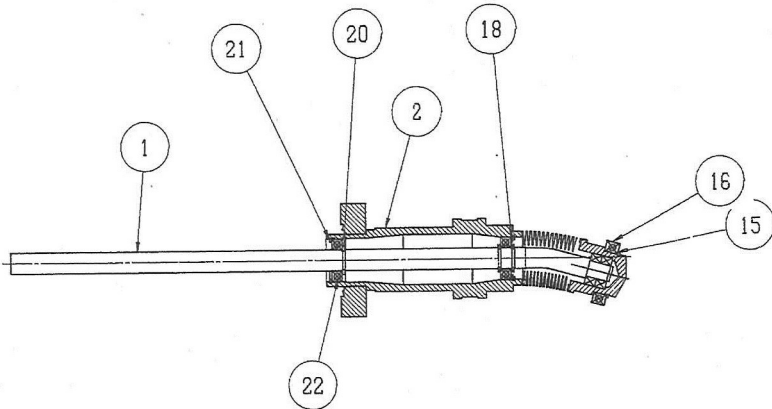
RD91

RD94

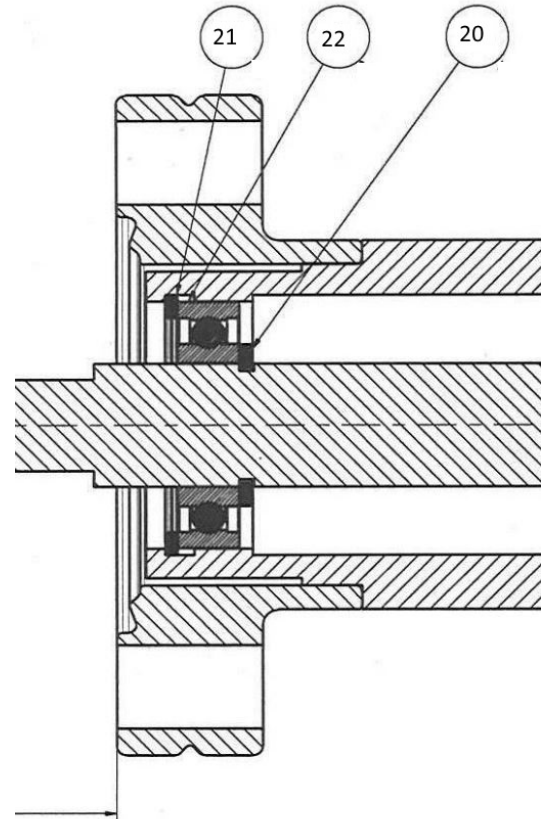


10	CIRCLIP D51030060	1	
9	BEARING NMB SSRIF814H/M	2	
8	PAD	1	
7	THUMB SCREW	1	
6	SPRING	1	
5			
4	IN VAC SUB-ASSY	1	
3	THIMBLE ENGRAVING	1	
2	CASE	1	
1	SHAFT	1	
ITEM NO	DESCRIPTION	VERSION	QTY





16	LBEA36A	SSRI1212		1	
22	LBEA31C			2	
21	XC1S050	RETAINING RING S/S WH50		1	
20	XCIC025			3	
19					
18	XWAW08			1	
16	LBEA36A	SSRI1212		1	
15	XCIR019	CIRCLIP A3108 0050		1	
2	DH-70-13-3	WELD ASSY		1	
1	DH-70-02-3	SHAFT		1	
ITEM NO	STOCK	DRG No	DESCRIPTION	VERSION	QTY



Revision	Date	Comment	Initials
1			
2			
3			

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