



Screw pump

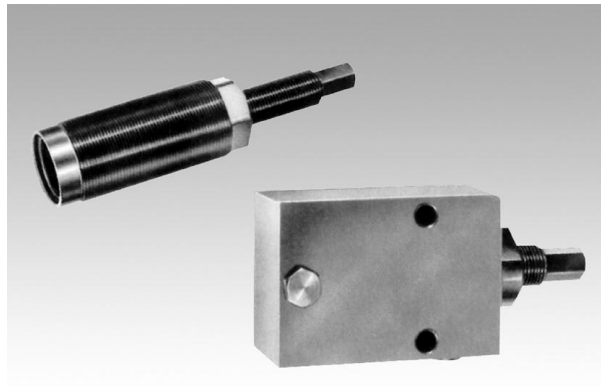


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1 Description of the product

Application

Screw pumps are suitable as pressure source for small clamping fixtures, which must be independent of an external pressure source.

2 Validity of the documentation

This document applies to the following products:

Screw pump of data sheet D8819. The following types or part numbers are concerned:

Screw pump:

- 8819 101, 001

Filling tank with filling valve:

- 0881 976

3 Target group of this document

- Specialists, fitters and set-up men of machines and installations with hydro-mechanical expert knowledge.

Qualification of the personnel

Expert knowledge means that the personnel must

- be in the position to read and completely understand technical specifications such as circuit diagrams and product-specific drawing documents,
- have expert knowledge of function and design of the corresponding components.

A specialist is somebody who has due to its professional education and experiences sufficient knowledge and is familiar with the relevant regulations so that he

- can judge the entrusted works,
- can recognize the possible dangers,
- can take the required measures to eliminate dangers,
- knows the acknowledged standards, rules and guidelines of the technology.
- has the required knowledge for repair and mounting.

4 Symbols and signal words

WARNING

Person damage

Stands for a possibly dangerous situation.

If it is not avoided, death or very severe injuries will result.

CAUTION

Easy injuries / property damage

Stands for a possibly dangerous situation.

If it is not avoided, minor injuries or material damages will result.



Hazardous to the environment

The symbol stands for important information for the proper handling with materials that are hazardous to the environment.

Ignoring these notes can lead to heavy damages to the environment.

Note

This symbol stands for tips for users or especially useful information. This is no signal word for a dangerous or harmful situation.

5 For your safety

5.1 Basic information

The operating instructions serve for information and avoidance of dangers when installing the products into the machine as well as information and references for transport, storage and maintenance.

Only in strict compliance with these operating instructions, accidents and property damages can be avoided as well as trouble-free operation of the products can be guaranteed.

Furthermore, the consideration of the operating instructions will:

- avoid injuries
- reduce down times and repair costs,
- increase the service life of the products.

5.2 Safety instructions

The product was manufactured in accordance with the generally accepted rules of the technology.

Observe the safety instructions and the operating instructions given in this manual, in order to avoid personal damage or material damage.

- Read these operating instructions thoroughly and completely, before you work with the product.
- Keep these operating instructions so that they are accessible to all users at any time.
- Pay attention to the current safety regulations, regulations for accident prevention and environmental protection of the country in which the product will be used.
- Use the ROEMHELD product only in perfect technical condition.
- Observe all notes on the product.
- Use only accessories and spare parts approved by the manufacturer in order to exclude danger to persons because of not suited spare parts.
- Respect the intended use.
- You only may start up the product, when it has been found that the incomplete machine or machine, in which the product shall be mounted, corresponds to the country-specific provisions, safety regulations and standards.
- Perform a risk analysis for the incomplete machine, or the machine.
Due to the interactions between the product and the machine/fixture or the environment, risks may arise that only can be determined and minimized by the user, e.g. :
 - generated forces,
 - generated movements,
 - Influence of hydraulic and electrical control,
 - etc.

6 Application

6.1 Intended use

The products are used in industrial / commercial applications to transform hydraulic pressure into movement and /or force. They must only be operated with hydraulic oil.

Furthermore the following belongs to possible uses:

- Use within the capacity indicated in the technical characteristics.
- Use as per operating instructions.
- Compliance with service intervals.
- Qualified and trained personnel for the corresponding activities.
- Mounting of spare parts only with the same specifications as the original part.

6.2 Misapplication

WARNING

Injuries, material damages or malfunctions!

- The product must never be opened. At the product no changes must be made, except the ones expressly mentioned in the operating instructions!

The use of the products is not authorised:

- For domestic use.
- For use at fairgrounds and amusement parks.
- In food processing or in areas with special hygiene regulations.
- In mines.
- In ATEX areas (in explosive and aggressive environments, e.g. explosive gases and dusts).
- If physical effects (welding currents, vibrations or others) or chemically acting media damage the seals (resistance of the seal material) or components and this can lead to functional failure or premature failure.

For deviating operating and environmental conditions, e.g.:

- Higher operating pressures or flow rates than indicated on the data sheet or installation drawing.
- With hydraulic fluids that do not correspond to the specifications.

Special solutions are available on request!

7 Installation

⚠ WARNING

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

Improper connection can lead to escapes of oil under high pressure at the connections.

- Mounting or dismounting of the element must only be made in depressurised mode of the hydraulic system.
- Connection of the hydraulic line as per DIN 3852/ISO 1179.
- Unused connections have to be locked professionally.
- Use all mounting holes.

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil under high pressure.

- Before using them make a visual control.

Poisoning due to contact with hydraulic oil.

Wear, damage of the seals, aging and incorrect mounting of the seal kit by the operator can lead to escapes of oil.

Incorrect connection can lead to escapes of oil at the ports.

- For handling with hydraulic oil consider the material safety data sheet.
- Wear protection equipment.

Injury by dropping parts!

Some products have a heavy weight and can cause injury when dropping.

- Transport products professionally.
- Wear personal protection equipment!

Weight specifications see chapter "Technical characteristics".

7.1 Design

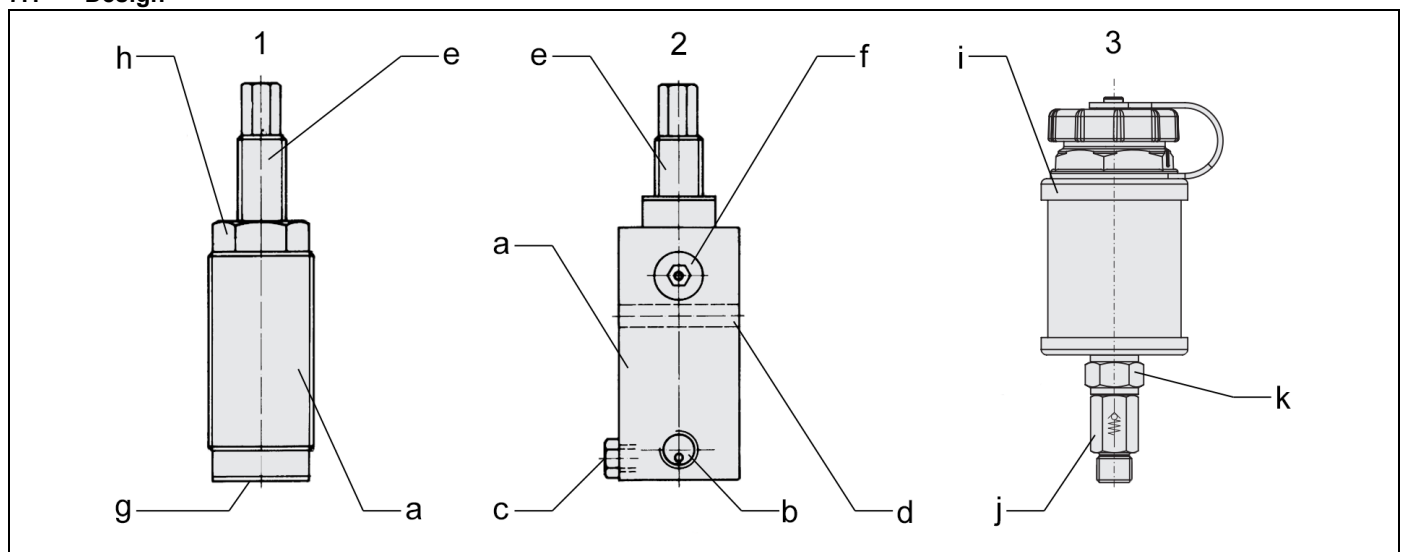


Fig. 1: Overview of block-type

1 Threaded-body version	e Threaded spindle (SW13)
2 Block type	f Bleeding screw
3 Filling tank with filling valve	g Sealing ring
a Housing	h Wrench size SW32
b Hydraulic port	i Filling tank
c Bleeding screw	j Suction valve SW14
d Mounting holes	k Wrench size SW17

⚠ CAUTION

Product not properly tightened

Product can loosen during operation.

- Fix and/or secure with sufficient tightening torque.

7.2 Mounting threaded-body type

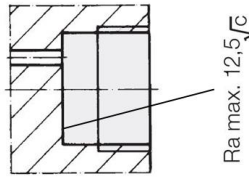


Fig. 2: Horizontal installation position / oil port at the top

NOTICE

Sealing surface

- The sealing surface has to be square to hole axis and flat in order to guarantee the sealing.
- Counterbore **not** circularly milled.

1. Machine the location hole with utmost accuracy; observe the surface details.
2. Provide the threads in the fixture.
3. Drill the holes for hydraulic oil supply in the fixture (see data sheet D8819).
4. Clean the fixture.
5. Screw the screw pump in the fixture.
6. Pay attention to the tightening torque (see technical characteristics)

7.3 Assembly of filling tank with filling valve

NOTICE

Safe operation of cylinders with filling valve

When unclamping, care must be taken to ensure that no vacuum is created in the oil channel. Therefore, the connected single-acting cylinders must either be equipped with a spring return or have a sufficiently large load applied to the cylinder. Otherwise, there is a risk that too much oil will be drawn back in and the cylinders will no longer return completely.

1. Remove screw plug (c) from block-type (2).
2. Screw in the filling tank with filling valve (3). Observe the specified torque (see technical characteristics).

7.4 Installation

CAUTION

Malfunctions!

Chips, coolants and cutting fluids can cause malfunctions.

- Protect the power units against penetration of chips, coolants and cutting fluids!

Install screw pumps horizontally to guarantee venting. Piping and drilled passages are to be arranged such that forming of air pockets is prevented.

7.5 Connection of the hydraulic equipment

1. Connect hydraulic lines to qualifying standards and pay attention to scrupulous cleanness!

NOTE

More details

- See ROEMHELD data sheets A 0.100, F 9.300, F 9.310 and F 9.360.

Screwed Plug

- Use only fittings "screwed plug B and E" as per DIN 3852 (ISO 1179).

Hydraulic connection

- Do not use sealing tape, copper rings or coned fittings.

Pressure fluids

- Use hydraulic oil as per ROEMHELD data sheet A 0.100.

Hydraulic oil

The hydraulic oil must be perfectly filtered with particles not larger than nominally 10 µm. This is the reason why we offer a filter unit (part-no. 3887-060), which can be directly integrated in the tubing of the low-pressure side (see page 2).

NOTE**Completely bled**

After completion of all assembly and installation works, the hydraulic system must be completely bled.

8 Start up**WARNING****Poisoning due to contact with hydraulic oil.**

Wear, damage of the seals, aging and incorrect mounting of the seal kit by the operator can lead to escapes of oil.

Incorrect connection can lead to escapes of oil at the ports.

- For handling with hydraulic oil consider the material safety data sheet.
- Wear protection equipment.

CAUTION**Injury due to bursting or malfunction**

Exceeding the max. operating pressure (see technical data) can cause the product to burst or malfunction.

- The maximum operating pressure must not be exceeded.
- If necessary, avoid overpressure by using suitable valves.

8.1 Filling / bleeding

At the highest point of the system an air bleed screw has to be provided. For the block-body version an additional bleeding possibility has to be provided.

- Remove bleeding screw
- Unscrew screw spindle and fill oil at the bleeding screw.
- In case of the block-body version loosen bleeding screw and retighten, when bubble-free oil comes out, refill oil, if necessary.
- Screw in and retighten bleeding screw
- Operate screw pump and extend and retract cylinders several times.
- Loosen bleeding screw
- Unscrew screw spindle and refill oil
- Screw in and retighten bleeding screw

8.2 Operation**CAUTION****Material damage**

- Do not turn the spindle with high number of revolution to its final position.
- Do not use an impact screw driver
- Use only 60-70% of the oil volume of the screw pump to be in the position to compensate leakages during the motion as well as oil compressibility.

NOTE**Torque**

- When tightening the screw spindle, the torque should be limited by a pneumatic screwdriver.
- Do not tilt when screwing the spindle

Exact measuring of the clamping force is only possible by means of a pressure gauge.

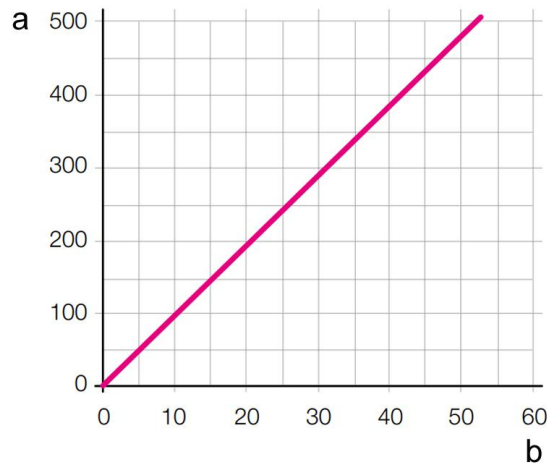


Figure 3: Torque and pressure diagram

a Pressure p in bar	b Torque in Nm
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9 Maintenance

⚠ WARNING

Burning due to hot surface!

During operation, surface temperatures on the product can exceed 70°C.

- Maintenance and repair work should only be performed in a cooled down condition and/or with protective gloves.

⚠ CAUTION

Maintenance and repair work

All maintenance and repair works only to be effected by ROEMHELD service staff.

- Check if the hydraulic ports are tight (visual control).
- The threaded spindle has to be lubricated for frequent operation.

9.1 Cleaning

⚠ CAUTION

Material damage, damage to moving components

Damage to piston rods, plungers, bolts, etc., as well as wipers and seals can lead to leakage or premature failure!

- Do not use cleaning agents (steel wool or similar) that cause scratches, marks or the like.

Material damage, damage or functional failure

Aggressive cleaning agents can cause damage, especially to seals.

The product must not be cleaned with:

- corrosive or caustic substances or
- organic, solvents such as halogenated or aromatic hydrocarbons and ketones (cellulose thinner, acetone, etc.).

The element must be cleaned at regular intervals. Especially the threaded spindle has to be cleaned of swarf and other liquids.

In the case of heavy contamination, the cleaning has to be made in shorter intervals.

9.2 Exchange seal kit

The exchange of the seal kit has to be made in case of external leakages. For high availability we recommend to change the seals at the latest after 500,000 cycles or 2 years.

Due to the complex design a seal exchange must only be effected by ROEMHELD service personnel.

NOTE

Seal Kits

- Do not install seal kits which were exposed to light for a longer time.
- Pay attention to the storage conditions (see chapter "Technical characteristics").
- Only use original seals.

10 Trouble shooting

Trouble	Cause	Remedy
Cylinder extends jerkily	air in the system	bleed system
Threaded spindle moves to its final position	no oil in the system	Refill oil
	air in the system	bleed system

11 Repair

NOTE

Repair works

- Repair works, as e.g. the change of the interior lifting jack may only be effected by the ROEMHELD service technicians.

12 Technical characteristics

Threaded-body and block-body type

	8819 101	8819 001
Piston – Ø [mm]	25	
Stroke [mm]	43	
Displacement [cm³]	21	
Displacement / revolution [cm³]	0.98	
Tightening torque [Nm]	80	-
Weight [kg]	0.80	2.15

Filling tank with filling valve

	0881 976
Max. filling quantity [ccm]	90
Glass material	Polyacrylic
Seal	FKM
Tightening torque suction valve [Nm]	20
Tightening torque filling tank [Nm]	15

13 Storage

CAUTION

Damage due to incorrect storage of components

In case of improper storage, the seals can embrittle and resinification of the anti-corrosive oil or corrosion on/in the element can occur.

- Storage in the packaging and moderate environmental conditions.
- The product must not be exposed to direct sunlight, since UV light may cause serious damage to the seals.

The elements are tested by default with mineral oil. The exterior of the elements is treated with a corrosion inhibitor.

The oil film remaining after the test provides for a six-month interior corrosion protection, if stored in dry and uniformly tempered rooms.

For longer storage times, the element has to be filled with a non-resinifying corrosion inhibitor and the outside surfaces must be treated.

14 Disposal



Hazardous to the environment

Due to possible environmental pollution, the individual components must be disposed only by an authorised expert company.

The individual materials have to be disposed as per the existing regulations and directives as well as the environmental conditions. Special attention has to be drawn to the disposal of components with residual portions of hydraulic fluids. The instructions for the disposal at the material safety data sheet have to be considered.

For the disposal of electrical and electronic components (e.g. stroke measuring systems, proximity switches, etc.) country-specific legal regulations and specifications have to be kept.

15 Declaration of manufacture

Manufacturer

Römheld GmbH Friedrichshütte
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35321 Laubach, Germany
Tel.: +49 (0) 64 05 / 89-0
Fax: +49 (0) 64 05 / 89-211
E-mail: info@roemheld.de
www.roemheld.com

Responsible person for the documentation:

Dipl.-Ing. (FH) Jürgen Niesner, Tel.: +49(0)6405 89-0.

Declaration of manufacture of the products

They are designed and manufactured in line with the relevant versions of the directives **2006/42/EC**(EC MSRL) and in compliance with the valid technical rules and standards.

In accordance with EC-MSRL, these products are components, that are not yet ready for use and are exclusively designed for the installation in a machine, a fixture or a plant.

According to the pressure equipment directives the products are not to be classified as pressure reservoirs but as hydraulic placing devices, since pressure is not the essential factor for the design, but the strength, the inherent stability and solidity with regard to static or dynamic operating stress.

The products may only be put into operation after it was assessed that the incomplete machine / machine, in which the product shall be installed, corresponds to the machinery directives (2006/42/EC).

The manufacturer commits to transmit the special documents of the products to state authorities on request.
The technical documentation as per appendix VII part B was prepared for the products.

Laubach, 09.03.2026