

MODEL 615BP VACUUM BLOWER WITH INTERNAL BYPASS VALVE

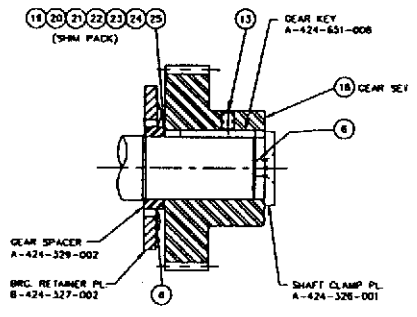
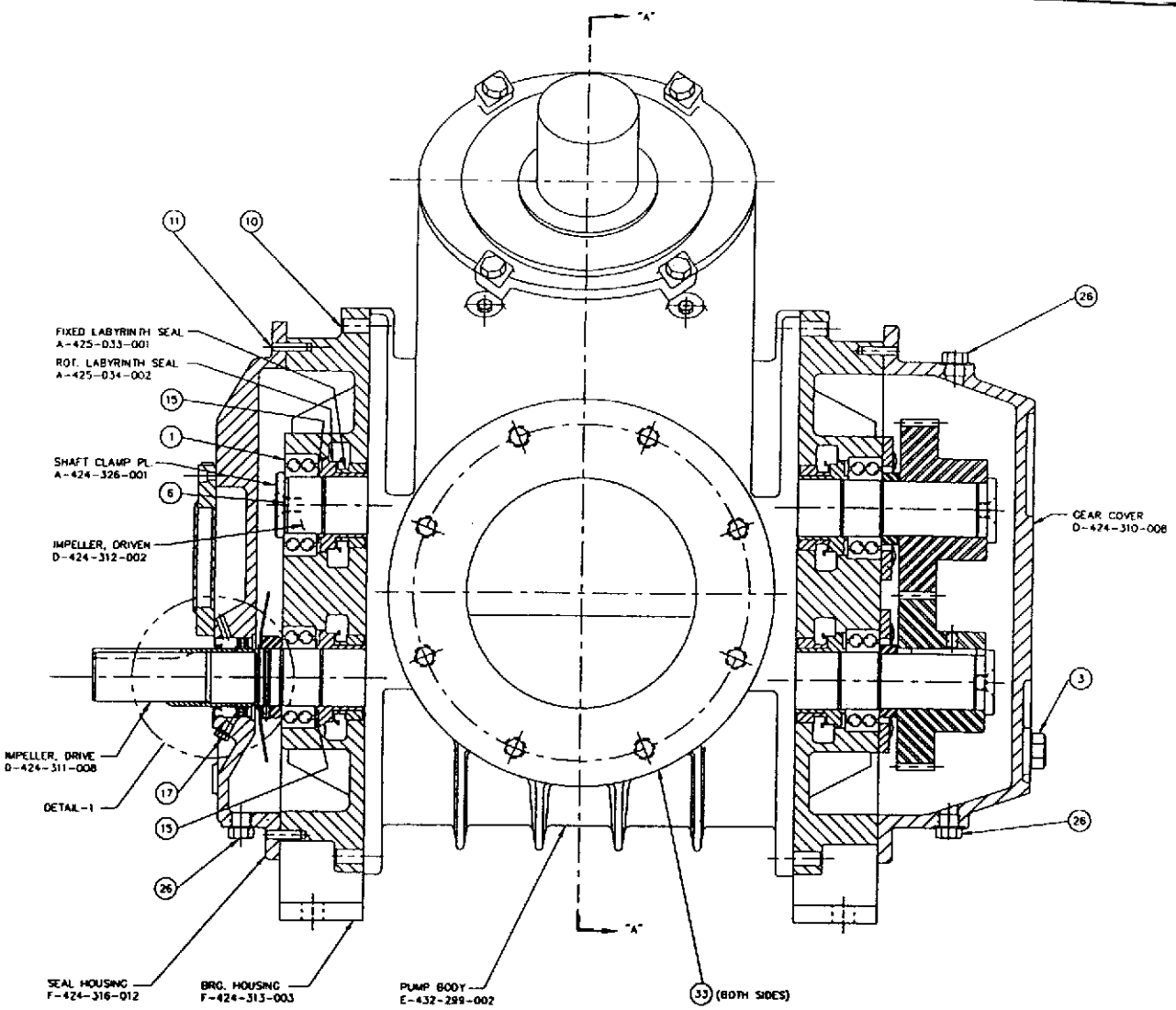
| SYM | PART NO. | DESCRIPTION | REF. DWG/ COMP. LIT. | QTY | UM | RSP | 615-7 | 615-V07 | 615-4V7 | 615-4H7 |
|-----|--------------------|---------------------------------|-------------------------|-----|----|-----|-------|---------|---------|---------|
| | 601-537-009 | LIST, 615-7 BLOWER ARRGT | E-601-537-009 | | | | | | | |
| 1 | 085-044-345 | BRG BALL STL 50MM ID X 90MM OD | | 1 | EA | | x | | x | x |
| 2 | 085-046-942 | SEAL LIP NITRILE STL CASE 2" | | 4 | EA | ✓ | x | | x | x |
| 3 | 085-040-332 | GAUGE SIGHT LEVEL WINDOW TYPE | | 1 | EA | ✓ | x | | x | x |
| 4 | 085-041-999 | CUP OIL 1FL OZ 1/4-18NPT BRASS | | 2 | EA | ✓ | x | | x | x |
| 5 | 001-001-053 | SCR HEX HD CAP 3/8-16 X 4 | | 1 | EA | | x | | x | x |
| 6 | 001-036-018 | SCR SOC HD FL 1/2-13 X 1 1/2 | | 44 | EA | | x | | x | x |
| 7 | 001-002-022 | SCR CAP SOC HD 1/4-20 X 3/4 | | 3 | EA | | x | | x | x |
| 8 | 085-015-684 | SCR BUT HD SOC 3/8-16 X 3/4 | | 9 | EA | | x | | x | x |
| 9 | 001-011-024 | SCR SET CUP 1/4-20 X 1/2 | | 8 | EA | | x | | x | x |
| 10 | 008-002-044 | PIN DOWEL HARD STL 1/2 X 2 | | 2 | EA | | x | | x | x |
| 11 | 008-002-019 | PIN DOWEL STL 1/4 DIA X 1-1/4 | | 4 | EA | | x | | x | x |
| 12 | 085-023-876 | FPS SS PLUG HXO 3/8 NPT | | 3 | EA | | x | | x | x |
| 13 | 001-011-046 | SCR SET HOLLOW 3/8-16 X 5/8 | | 4 | EA | | x | | x | x |
| 14 | 085-040-011 | O RING 1-3/4 ID X .070 SEC | | 2 | EA | | x | | x | x |
| 15 | 085-037-788 | WASHER SPRING 1.988 ID X 2.658 | | 1 | EA | ✓ | x | | x | x |
| 16 | 085-027-094 | RING RETAINER EXT SPRING STL | | 4 | EA | | x | | x | x |
| 17 | 075-040-012 | PLUG TUBE 3/16 PORT SZ #3 | | 1 | EA | | x | | x | x |
| 18 | 085-038-256 | GEAR HELICAL SET 6" PD | | 1 | ST | | x | | x | x |
| 19 | 085-038-833 | SHIM RD ST .062 X 1-3/4 ID | | 4 | EA | | x | | x | x |
| 20 | 085-038-834 | SHIM RD ST .032 X 1-3/4 ID | | 4 | EA | | x | | x | x |
| 21 | 085-038-835 | SHIM RD ST .025 X 1-3/4 ID | | 4 | EA | | x | | x | x |
| 22 | 085-038-836 | SHIM RD ST .008 X 1-3/4 ID | | 4 | EA | | x | | x | x |
| 23 | 085-038-837 | SHIM RD ST .007 X 1-3/4 ID | | 4 | EA | | x | | x | x |
| 24 | 085-038-838 | SHIM ARBOR RD STL 1-3/4 ID X | | 4 | EA | | x | | x | x |
| 25 | 085-038-839 | SHIM RD ST .002 X 1-3/4 ID | | 4 | EA | | x | | x | x |
| 26 | 075-033-472 | PLUG O RING 1/2 X 3/4-16 THD | | 4 | EA | | x | | x | x |
| 27 | 085-043-463 | SHAFT OIL SEAL 2 SHAFT (CW) | | 1 | EA | ✓ | x | | | x |

RSP = RECOMMENDED SPARE PART
UM = UNIT OF MEASURE

MODEL 615BP VACUUM BLOWER WITH INTERNAL BYPASS VALVE

| SYM | PART NO. | DESCRIPTION | REF. DWG/ COMP. LIT. | QTY | UM | RSP | 615-7 | 615-V07 | 615-4V7 | 615-4H7 |
|-----|--------------------|-----------------------------------|-------------------------|----------|-----------|-----|----------|----------|----------|----------|
| 27 | 085-043-469 | SHAFT OIL SEAL 2 SHAFT (CCW) | | 1 | EA | ✓ | | x | x | |
| 28 | 085-042-116 | O-RING VITON 6-1/2 ID X 7 OD | | 1 | EA | | x | | | x |
| 30 | 085-036-358 | O-RING VITON 8 ID X.139 C/S | | 1 | EA | | x | | | x |
| 31 | 001-001-041 | SCR HEX HD 3/8-16 X 1 STL | | 4 | EA | | x | | | x |
| 32 | 007-005-006 | WASHER LOCK SPLIT SP 3/8 STD | | 4 | EA | | x | | | x |
| 33 | 085-008-032 | FLANGE PROTECTOR, 8" PIPE SIZE | | 2 | EA | | x | | | x |
| 34 | 085-044-673 | ADAPTER 1/4 FPT X 9/16-18 STR THD | | 1 | EA | | x | | | x |
| 35 | 026-035-018 | NIPPLE 1/4 NPT X 4 LG | | 1 | EA | | x | | | x |
| 36 | 026-023-002 | EL 45 DEG 1/4 NPT PIPE | | 1 | EA | | x | | | x |
| 37 | 026-010-022 | PLUG SOC HD 1/8 NPT | | 2 | EA | | x | | | x |
| | 432-299-002 | BLOWER BODY | E-432-299-002-B | 1 | EA | | x | x | x | x |
| | 424-310-008 | GEARCOVER CAST IRON | D-424-310-008-C | 1 | EA | | x | | | x |
| | 424-310-007 | GEARCOVER CAST IRON | D-424-310-007-C | 1 | EA | | | x | x | |
| | 424-311-008 | IMPELLER, DRIVE (615) | D-424-311-008-D | 1 | EA | | x | | | x |
| | 424-312-002 | IMPELLER DRIVEN 615 | D-424-312-002-G | 1 | EA | | | x | x | |
| | 424-313-003 | HOUSING BEARING MACH | F-424-313-003-E | 2 | EA | | x | | | x |
| | 424-665-012 | BEARING HOUSING | D-424-665-012-E | 2 | EA | | | x | x | |
| | 425-033-001 | LABYRINTH SEAL FIXED | A-425-033-1C* | 4 | EA | ✓ | | x | x | x |
| | 425-034-002 | LABYRINTH SEAL ROTATING | A-425-034-2G* | 4 | EA | ✓ | | x | x | x |
| | 424-316-012 | SEAL HOUSING | F-424-316-012-F | 1 | EA | | x | | | x |
| | 414-316-011 | SEAL HOUSING | F-424-316-011-E | | | | | x | x | |
| | 604-285-001 | COVER PLATE | B-604-285-001-A | 1 | EA | | x | x | x | x |

RSP = RECOMMENDED SPARE PART
UM = UNIT OF MEASURE



ENLARGED VIEW
OF GEAR END

ACAO FILE No. 60153709 PLOT 1-3.1808

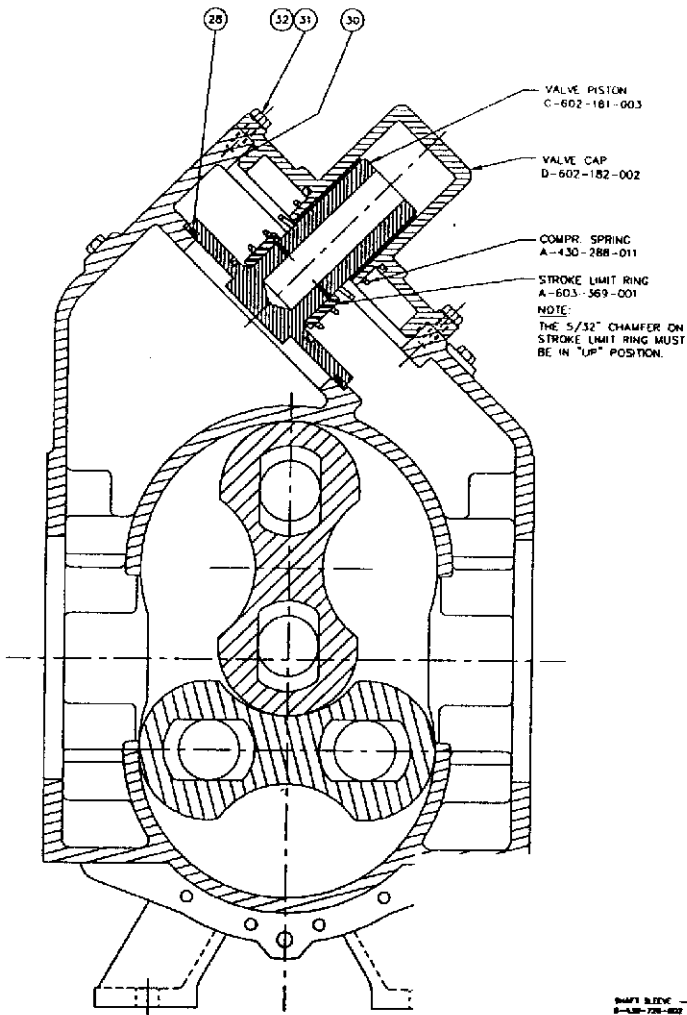
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DESIGNER: _____
FILE: HORIZ. FLOW BLOWER W/INTERNAL BYPASS ARR'T

DRAWN BY: R. GENARO DATE: 10/28/96 SCALE: 1/2" = 1"
CHECKED BY: _____ DATE: _____
APPROVED BY: _____ DATE: _____
APPROVED BY: _____ DATE: _____

PRODUCT CODE NO. 900-615-007

| | | | | |
|---|-----|-----------|--|---|
| | | | | B |
| | | | | A |
| DATE | APP | REVISIONS | | |
| STOKES VACUUM <small>INC.</small> | | | | |
| DWC. NO. F-601-537-009 | | | | |



VALVE PISTON
C-602-181-003

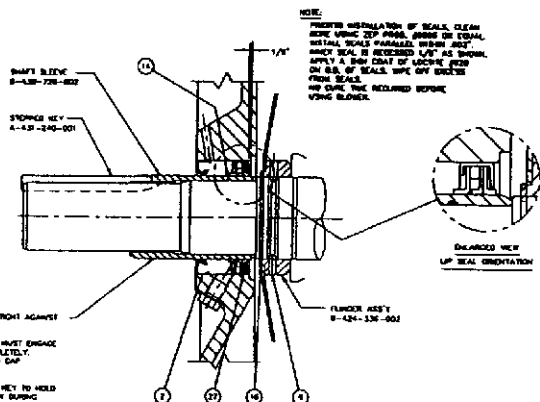
VALVE CAP
D-602-182-002

COMPR. SPRING
A-430-288-011

STROKE LIMIT RING
A-603-569-001

NOTE:
THE 5/32" CHAMFER ON
STROKE LIMIT RING MUST
BE IN "UP" POSITION.

SECTION "A - A"



1. LOCATE "SHAFT SLEEVE" TIGHT AGAINST
SHAFT HOLDER.
2. ENDUS ON STEPPED KEY MUST ENGAGE
GROOVE OF SLEEVE COMPLETELY.
(SHOULDS TO RADIIUS - NO GAP
PERMISSIBLE)
3. USE MARKING TAPE OVER KEY TO HOLD
SLEEVE IN KEY IN POSITION DURING
SUPPORT.

NOTE:
PROPER INSTALLATION OF SEALS. CLEAN
KEYS USING ZIP PROOF BRUSH OR BRUSH
WITH METAL BRUSHES. REMOVE ALL
SANDY SEAL IS NECESSARY 1/16" AS SHOWN.
APPLY A THIN COAT OF LUBRICANT
ON B.S. OF SEALS. Wipe OFF EXCESS
FROM SEALS.
NO OILS ARE REQUIRED BEFORE
VACUUM BLOWERS.



DETAIL No. 1
DILATED VIEW
OF "SHAFT SEAL ASST"

ACAD FILE No. 60153709 PLOT 1=3.1808

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DESCRIBE TITLE: HORIZ. FLOW BLOWER W/INTERNAL BYPASS ARR'T

DRAWN BY: R GENNARD DATE: 10/28/96 SCALE: 1/2" = 1"

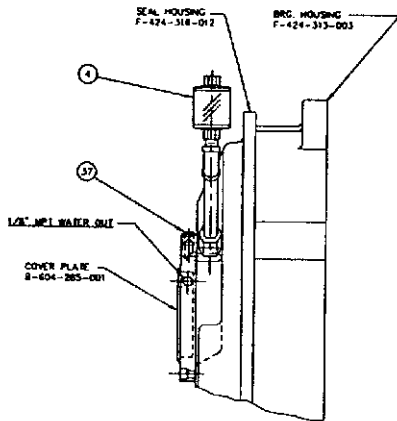
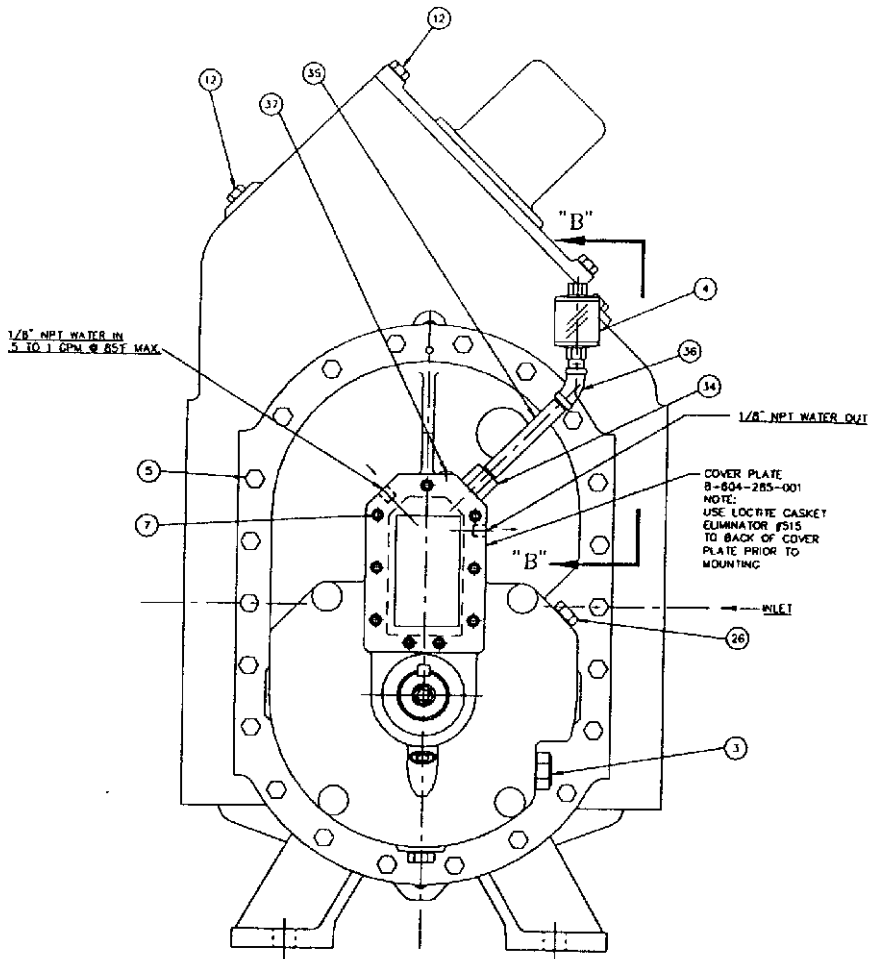
CHECKED BY: DATE:

APPROVED BY: DATE:

DATE: 5.0

PRODUCT CODE NO: 900-615-007

| | | | |
|---|-----------|--|---|
| | | | B |
| | | | A |
| DATE APP | REVISIONS | | |
| STOKES VACUUM Inc. | | | |
| <small>1000 North Main - Philadelphia, Pennsylvania 19107</small> | | | |
| DWG. NO. E-601-537-009 | | | |



SECTION "B-B"

ACAD FILE NO. 60153709 PLOT 1-3.1808

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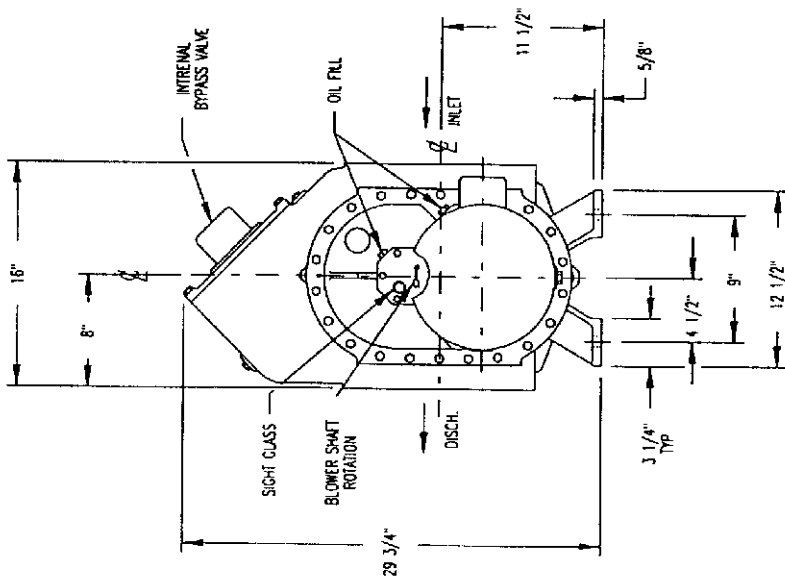
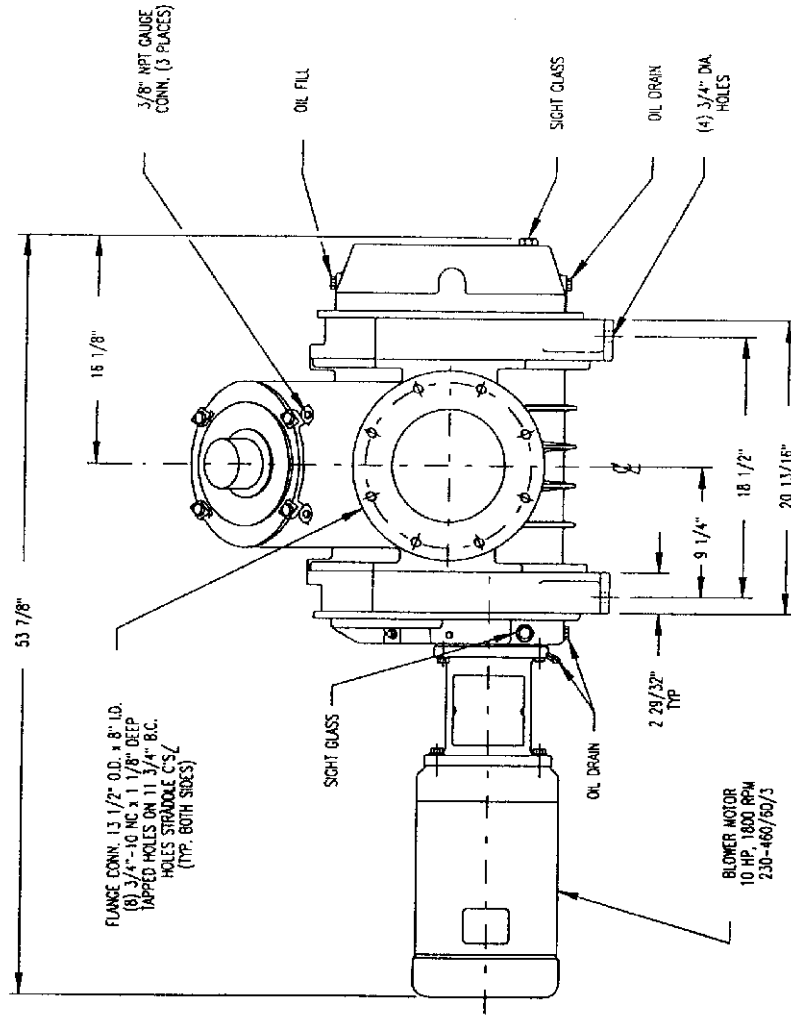
DESCRIPTION
HORIZ. FLOW BLOWER W/INTERNAL BYPASS ARR'Y

DRAWN BY R. GENNARO DATE 10/28/96 SCALE 1/2" = 1"
CHECKED BY DATE
APPROVED BY DATE S.G.
PRODUCT CODE NO 900-815-100Z

| | | | |
|------|-----|-----------|---|
| | | | B |
| DATE | APP | REVISIONS | A |

STOKES VACUUM INC.
1000 Taylor Road / Independence, Pennsylvania 17033

DWG. NO. E-601-537-009



OIL CAPACITY
 4 5/8 PINTS
 APPROX. WEIGHT
 750 LBS

PRODUCT CODE 900-615-4H7

1300 CFM AT 1800 RPM

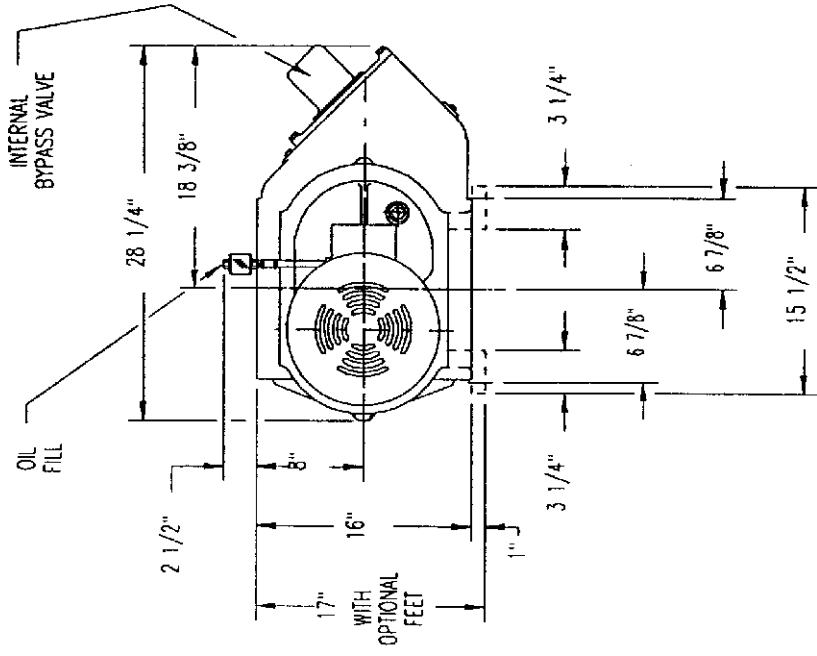
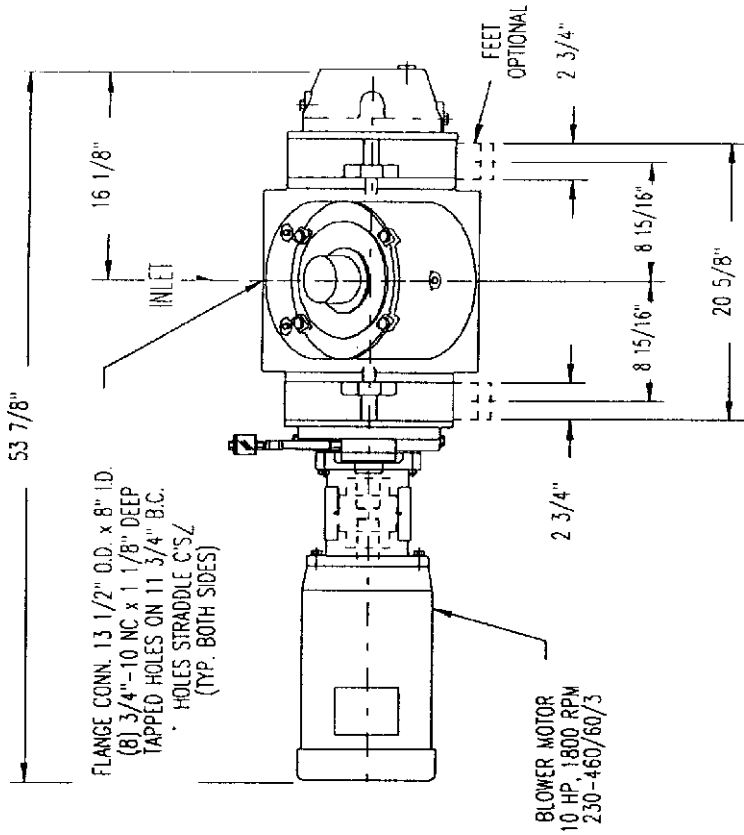
STOKES®
VACUUM Inc.

ACCU NO. 60336601 (1=12)

DWG. NO. A-603-366-001 A

REV. A REISED 1/19/95

RNG 1/26/93

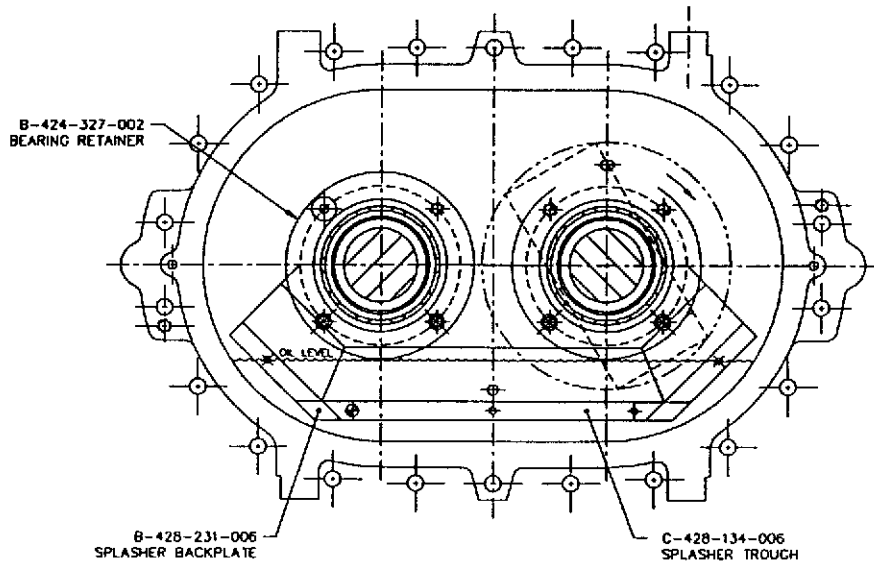
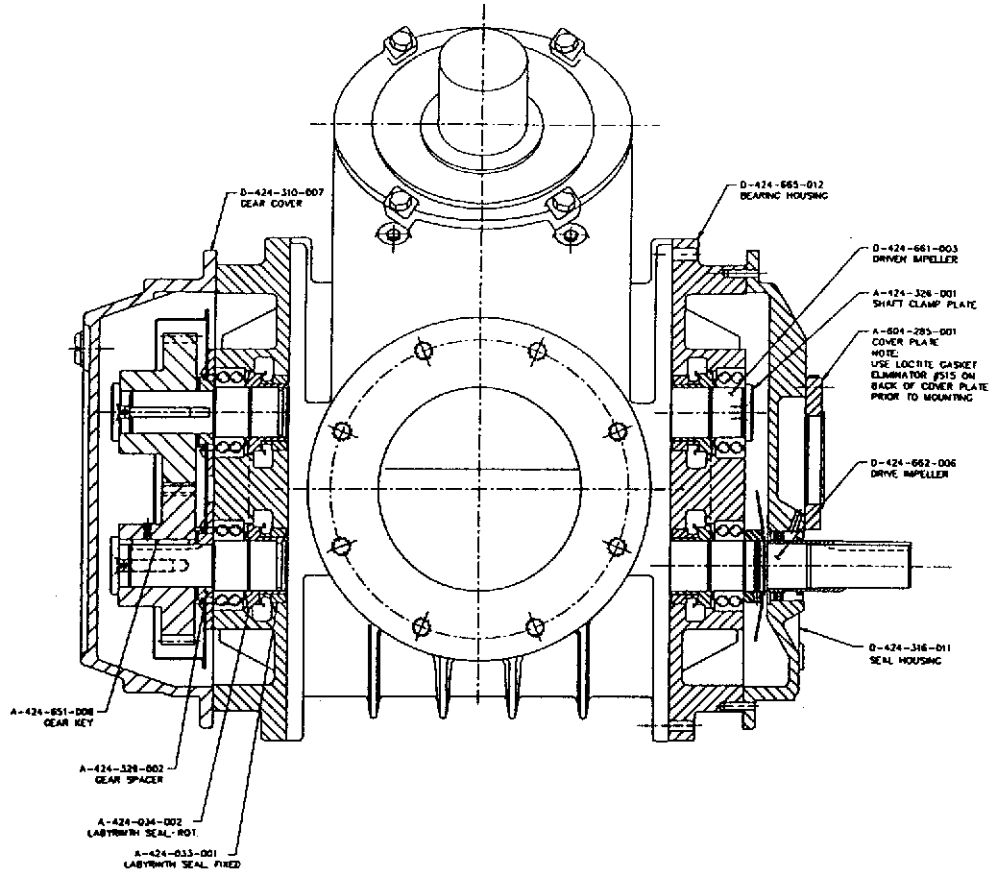


STOKES®
VACUUM Inc.

ACAD NO. 66571501 (1-12)
DWG. NO. A-605-715-001 B
RMC 9/3/96

OIL CAPACITY
9 1/4 PINTS
APPROX. WEIGHT
750 LBS

PRODUCT CODE 900-615-4V7
1300 CFM AT 1800 RPM



SECTION C-C
(GEAR COVER & GEARS NOT SHOWN)

HW-8 FILE NO. 60153710 DRAWN BY: RMC

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| DATE | APP | REVISIONS |
|------|-----|-----------|
| | | B |
| | | A |

REWORK BY: MDD 615-V07 BY-PASS BLOWER (VERT. FLOW)

DRAWN BY: R. GENNARO DATE: 2-3-97 SCALE: HALF

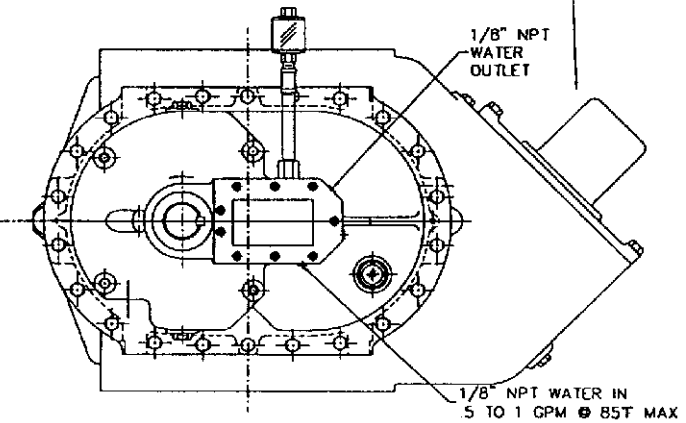
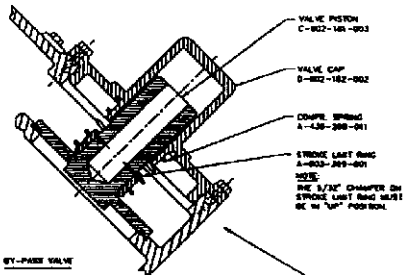
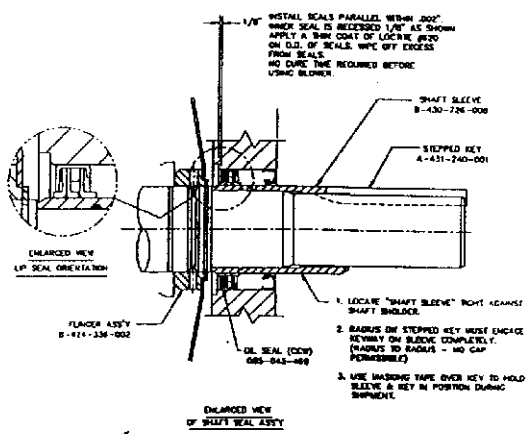
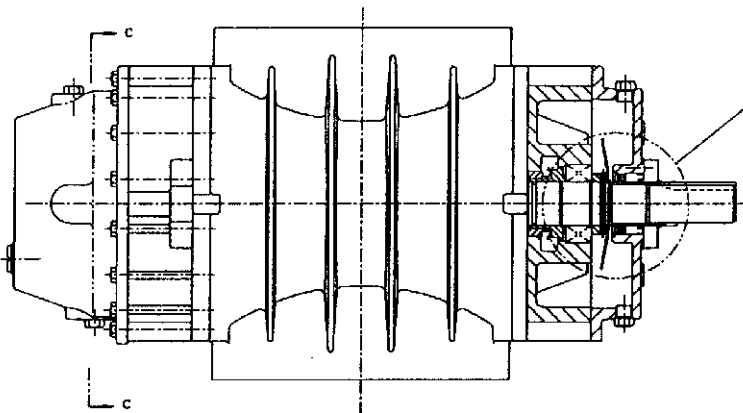
CHECKED BY: DATE: _____

APPROVED BY: DATE: _____ PUN SCALE: 1=2

1 & PRODUCT CODE NO: 390-615-V07

STOKES VACUUM INC.
5280 Tabor Road Philadelphia, Pennsylvania 19128

DWG. NO. E-601-537-010



SCALE FILE NO. 60133710 DRAWN BY: RMC

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| DATE | BY | APP | REVISIONS |
|------|----|-----|-----------|
| | | | B |
| | | | A |

DESCRIPTION: MOD 615-V07 BY-PASS BLOWER (VERT. FLOW)

DESIGN BY: R. GENNAURO DATE: 2-3-97 SCALE: 3/4"=1"

CHECKED BY: DATE: _____

APPROVED BY: DATE: _____

BY: DATE: _____

PRODUCT CODE NO. 300-813-V07

STOKES VACUUM
Stokes Vacuum, Inc. (Philadelphia, Pennsylvania 19126)

DWG. NO. E-601-537-010