

# 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
	<b>601-537-009</b>	<b>LIST, 615-7 BLOWER ARRG'T</b>	<b>E-601-537-009</b>	<b>1</b>	<b>EA</b>		<b>X</b>		<b>X</b>	<b>X</b>
1	085-044-345	BRG BALL STL 50MM ID X 90MM OD		4	EA	✓	X		X	X
2	085-046-942	SEAL LIP NITRILE STL CASE 2"		1	EA	✓	X		X	X
3	085-040-332	GAUGE SIGHT LEVEL WINDOW TYPE		2	EA	✓	X		X	X
4	085-041-999	CUP OIL 1FL OZ 1/4-18NPT BRASS		1	EA		X		X	X
5	001-001-053	SCR HEX HD CAP 3/8-16 X 4		44	EA		X		X	X
6	001-036-018	SCR SOC HD FL 1/2-13 X 1 1/2		3	EA		X		X	X
7	001-002-022	SCR CAP SOC HD 1/4-20 X 3/4		9	EA		X		X	X
8	085-015-684	SCR BUT HD SOC 3/8-16 X 3/4		8	EA		X		X	X
9	001-011-024	SCR SET CUP 1/4-20 X 1/2		2	EA		X		X	X
10	008-002-044	PIN DOWEL HARD STL 1/2 X 2		4	EA		X		X	X
11	008-002-019	PIN DOWEL STL 1/4 DIA X 1-1/4		3	EA		X		X	X
12	085-023-876	FPS SS PLUG HXO 3/8 NPT		4	EA		X		X	X
13	001-011-046	SCR SET HOLLOW 3/8-16 X 5/8		2	EA		X		X	X
14	085-040-011	O RING 1-3/4 ID X .070 SEC		1	EA	✓	X		X	X
15	085-037-788	WASHER SPRING 1.988 ID X 2.658		4	EA		X		X	X
16	085-027-094	RING RETAINER EXT SPRING STL		1	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
	<b>432-299-002</b>	<b>BLOWER BODY</b>	<b>E-432-299-002-B</b>	<b>1</b>	<b>EA</b>		<b>x</b>		<b>x</b>	<b>x</b>
	<b>424-310-008</b>	<b>GEARCOVER CAST IRON</b>	<b>D-424-310-008-C</b>	<b>1</b>	<b>EA</b>		<b>x</b>			<b>x</b>
	<b>424-310-007</b>	<b>GEARCOVER CAST IRON</b>	<b>D-424-310-007-C</b>	<b>1</b>	<b>EA</b>			<b>x</b>	<b>x</b>	
	<b>424-311-008</b>	<b>IMPELLER, DRIVE (615)</b>	<b>D-424-311-008-D</b>	<b>1</b>	<b>EA</b>		<b>x</b>			<b>x</b>
	<b>424-312-002</b>	<b>IMPELLER DRIVEN 615</b>	<b>D-424-312-002-G</b>	<b>1</b>	<b>EA</b>			<b>x</b>	<b>x</b>	
	<b>424-313-003</b>	<b>HOUSING BEARING MACH</b>	<b>F-424-313-003-E</b>	<b>2</b>	<b>EA</b>		<b>x</b>			<b>x</b>
	<b>424-665-012</b>	<b>BEARING HOUSING</b>	<b>D-424-665-012-E</b>	<b>2</b>	<b>EA</b>			<b>x</b>	<b>x</b>	
	<b>425-033-001</b>	<b>LABYRINTH SEAL FIXED</b>	<b>A-425-033-1C*</b>	<b>4</b>	<b>EA</b>	✓		<b>x</b>	<b>x</b>	<b>x</b>
	<b>425-034-002</b>	<b>LABYRINTH SEAL ROTATING</b>	<b>A-425-034-2G*</b>	<b>4</b>	<b>EA</b>	✓		<b>x</b>	<b>x</b>	<b>x</b>
	<b>424-316-012</b>	<b>SEAL HOUSING</b>	<b>F-424-316-012-F</b>	<b>1</b>	<b>EA</b>		<b>x</b>			<b>x</b>
	<b>414-316-011</b>	<b>SEAL HOUSING</b>	<b>F-424-316-011-E</b>					<b>x</b>	<b>x</b>	
	<b>604-285-001</b>	<b>COVER PLATE</b>	<b>B-604-285-001-A</b>	<b>1</b>	<b>EA</b>		<b>x</b>		<b>x</b>	<b>x</b>

RSP = RECOMMENDED SPARE PART  
UM = UNIT OF MEASURE

# MODEL 615BP VACUUM BLOWER WITH INTERNAL BYPASS VALVE

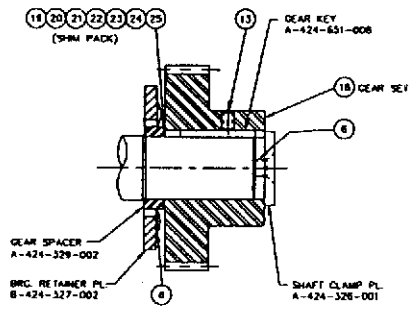
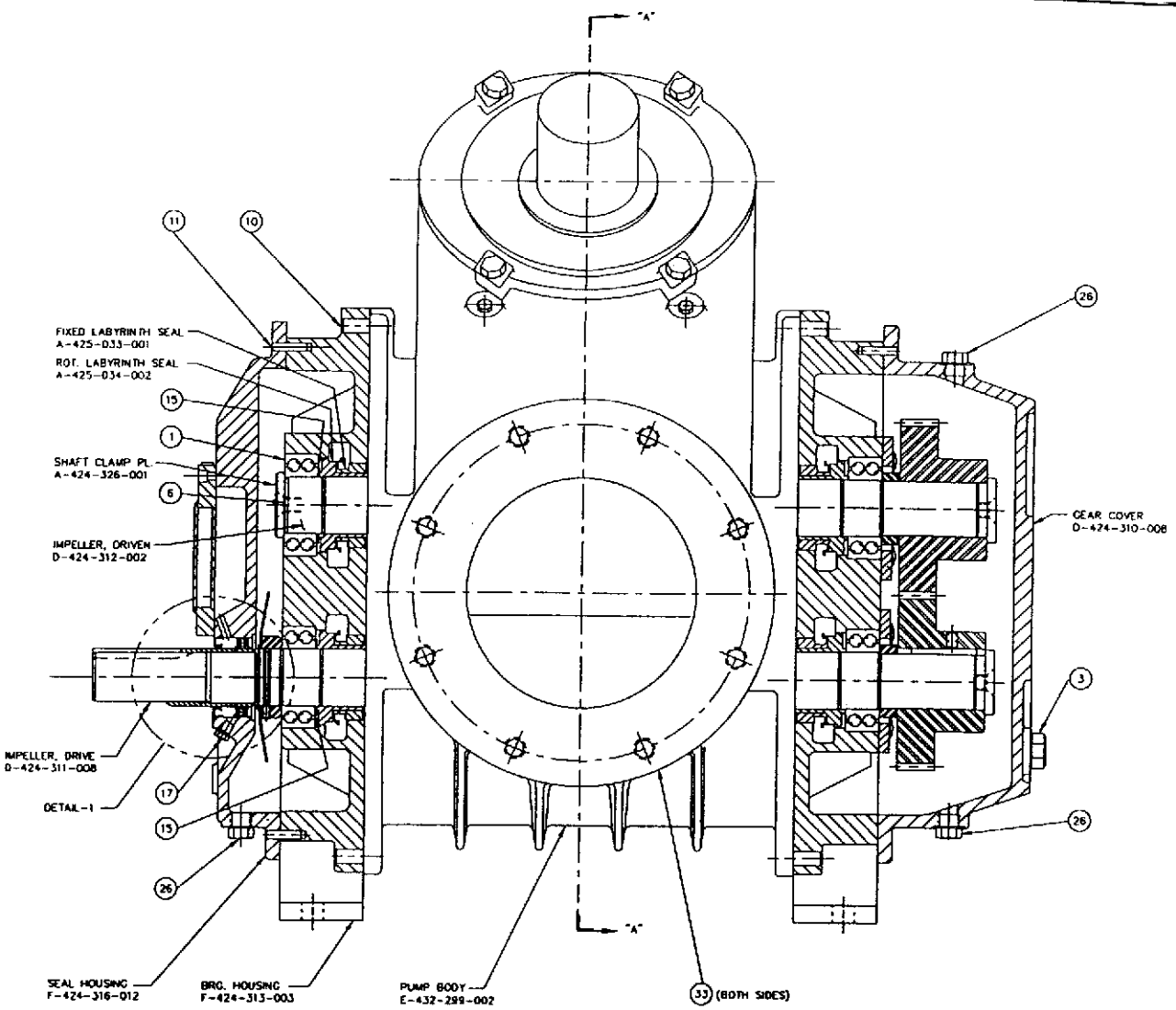
SYM	PART NO.	DESCRIPTION	REF. DWG/ COMP. LIT.	QTY	UM	RSP	615-7	615-V07	615-4V7	615-4H7
	424-651-008	KEY GEAR	A-424-651-8C*	2	EA	✓	X	X	X	X
	424-326-001	SHAFT CLAMP PLATE	A-424-326-001-A	3	EA		X	X	X	X
	424-327-002	BRG RETAINER PLATE	B-424-327-002	2	EA		X	X	X	X
	424-329-002	SPACER GEAR	A-424-329-002-A	2	EA		X	X	X	X
	603-369-001	RING STROKE LIMIT	A-603-369-001	1	EA		X	X	X	X
	424-336-002	FLINGER ASSEM	B-424-336-002-A	1	EA		X	X	X	X
1	424-334-001	FLINGER HUB	A-424-334-001	1	EA		X	X	X	X
2	425-289-001	FLINGER BLADE	B-425-289-001-A	1	EA		X	X	X	X
	430-726-002	SHAFT SLEEVE	B-430-726-2A*	1	EA	✓	X	X	X	X
	602-181-003	VALVE PISTON	C-602-181-003-C	1	EA		X	X	X	X
	602-182-002	VALVE CAP	D-602-182-002	1	EA		X	X	X	X
	430-288-011	COMPRESSION SPRING	A-430-288-011	1	EA		X	X	X	X
	431-240-001	STEPPED KEY	A-431-240-001-A	1	EA		X	X	X	X
	428-231-006	SPLASHING BACK PLATE	B-428-231-006-A	1	EA		X	X	X	X
	428-134-006	SPLASHING TROUGH	C-428-134-006-C	1	EA		X	X	X	X
	429-008-002	SUPPORT MOTOR	C-429-008-002-C	1	EA		X	X	X	X
	429-000-001	COVER PORT	A-429-000-001	2	EA		X	X	X	X
	429-315-008	COUPLING SHAFT	A-429-315-008-A	1	EA	✓	X	X	X	X
	603-369-002	STROKE LIMIT RING	A-603-369-002-A	1	EA		X	X	X	X
										RFE

RSP = RECOMMENDED SPARE PART  
UM = UNIT OF MEASURE









ENLARGED VIEW  
OF GEAR END

ACAO FILE No. 60153709 PLOT 1-3.1808

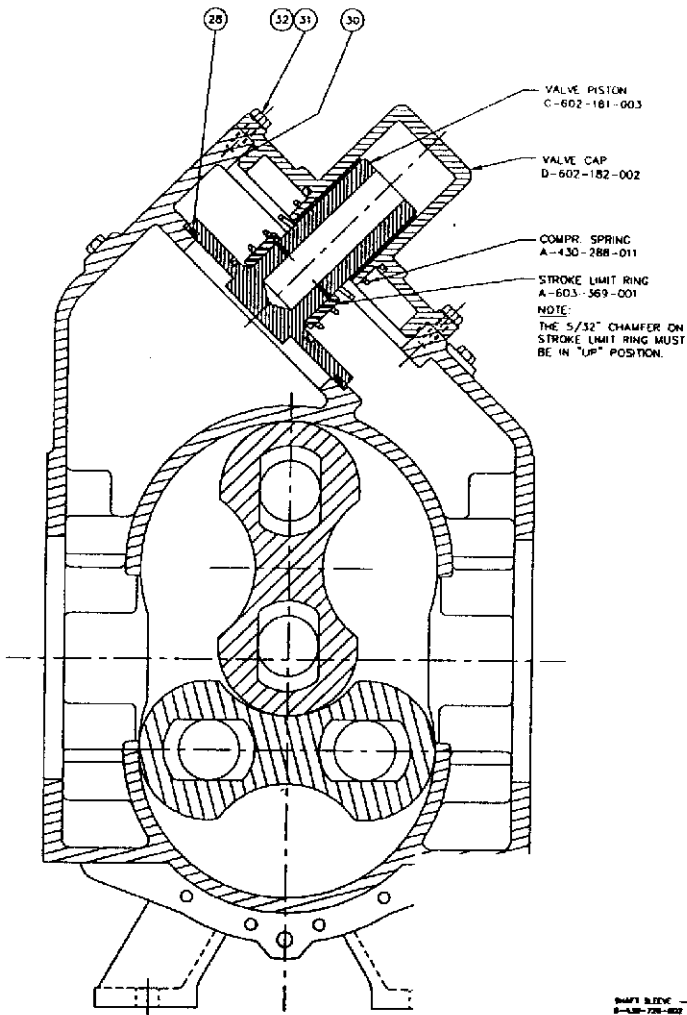
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DESIGNER: \_\_\_\_\_  
FILE: HORIZ. FLOW BLOWER W/INTERNAL BYPASS ARR'T

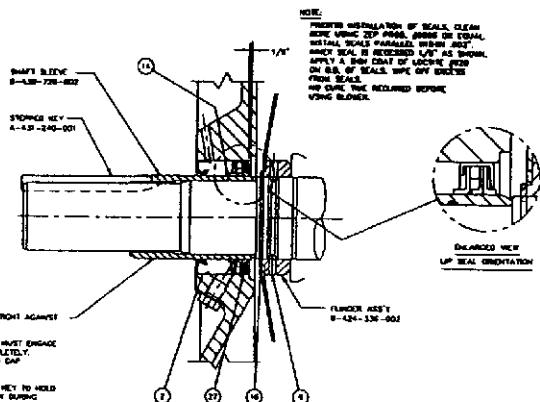
DRAWN BY: R. GENARO DATE: 10/28/96 SCALE: 1/2" = 1"  
CHECKED BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
APPROVED BY: \_\_\_\_\_ DATE: \_\_\_\_\_  
APPROVED BY: \_\_\_\_\_ DATE: \_\_\_\_\_

PRODUCT CODE NO. 900-615-007

			B
			A
DATE	APP	REVISIONS	
<small>© 1996 Stokes Vacuum Corporation</small>			
DWC. NO. F-601-537-009			



SECTION "A - A"



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

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

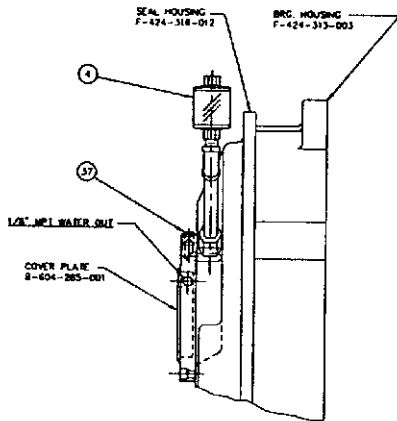
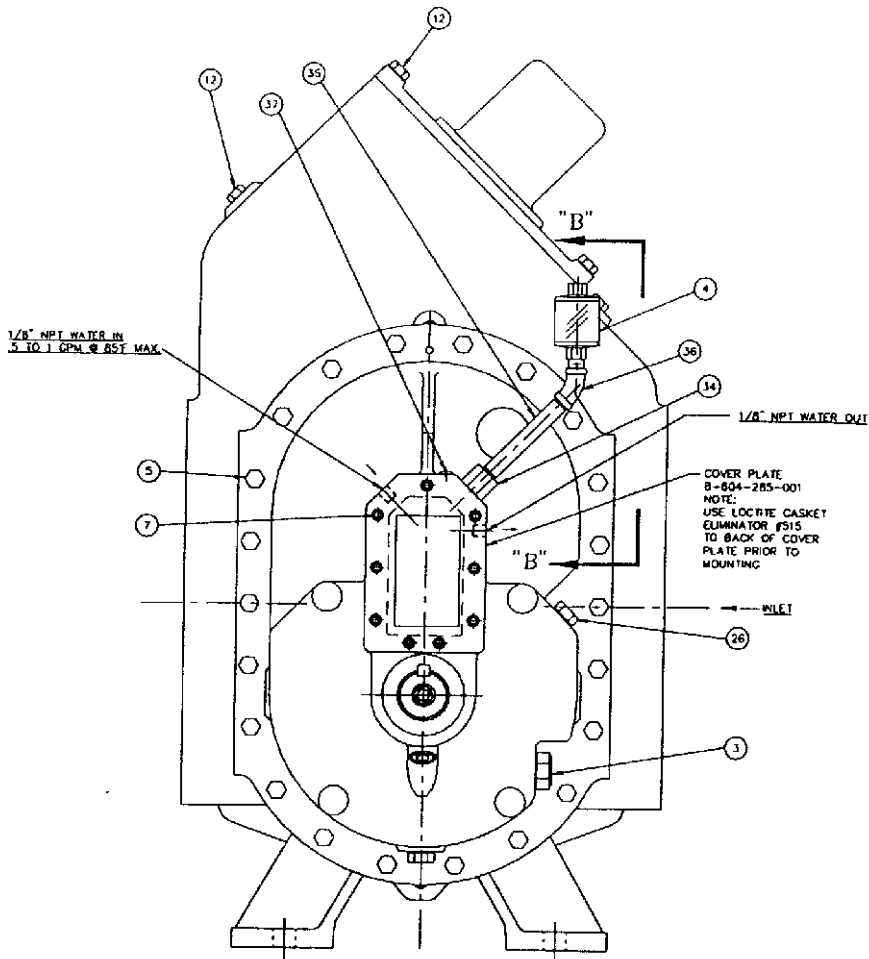
ACAD FILE No. 60153709 PLOT 1=3.1808

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DESCRIPTION: 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: \_\_\_\_\_  
 APPROVED BY: DATE: \_\_\_\_\_ S. O.  
 PRODUCT CODE NO. 900-615-007

			B
			A
DATE APP.	REVISIONS		
<b>STOKES VACUUM Inc.</b>			
<small>10000 Lake Road • Pittsburgh, Pennsylvania 15206</small>			
DWG. NO. E-601-537-009			





SECTION "B-B"

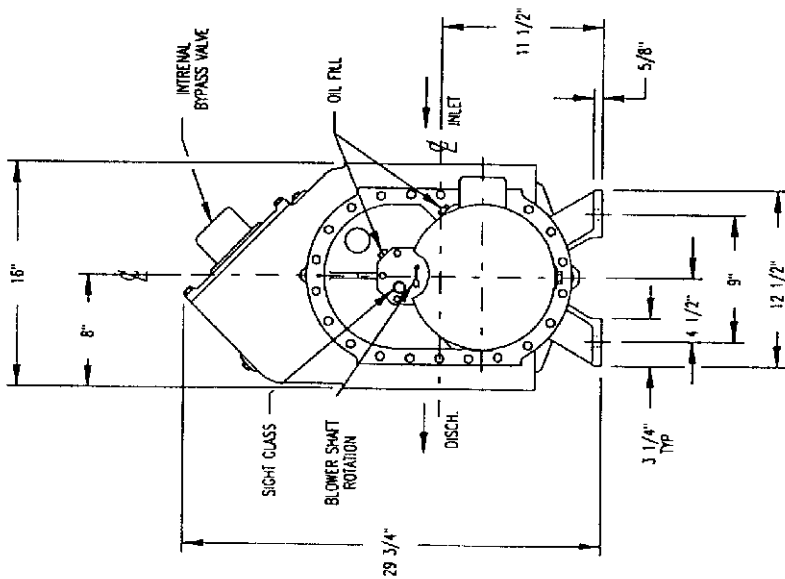
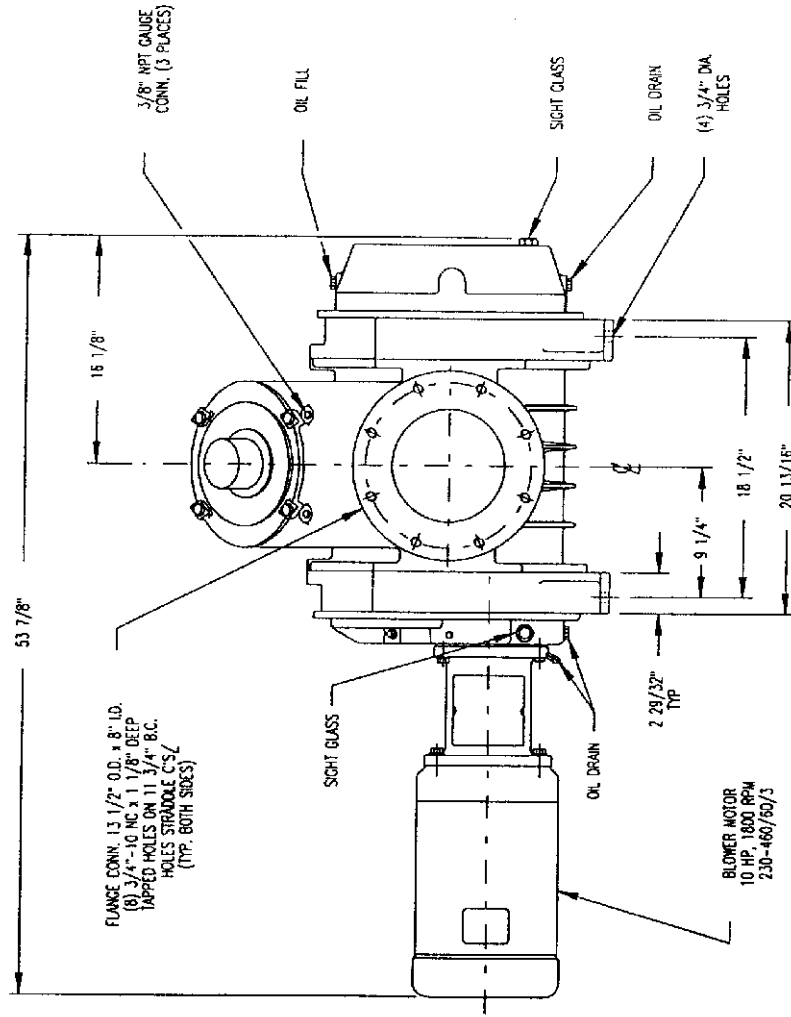
ACAD FILE NO. 60153709 PLOT 1-3.1808

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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. 900-815-1007

			B
			A
DATE	APP	REVISIONS	
<b>STOKES VACUUM</b> <small>INC.</small>			
<small>1995 Year Book / Publications, Performance 174B</small>			
DWC. NO. <u>E-601-537-009</u>			



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

PRODUCT CODE 900-615-4H7

1300 CFM AT 1800 RPM

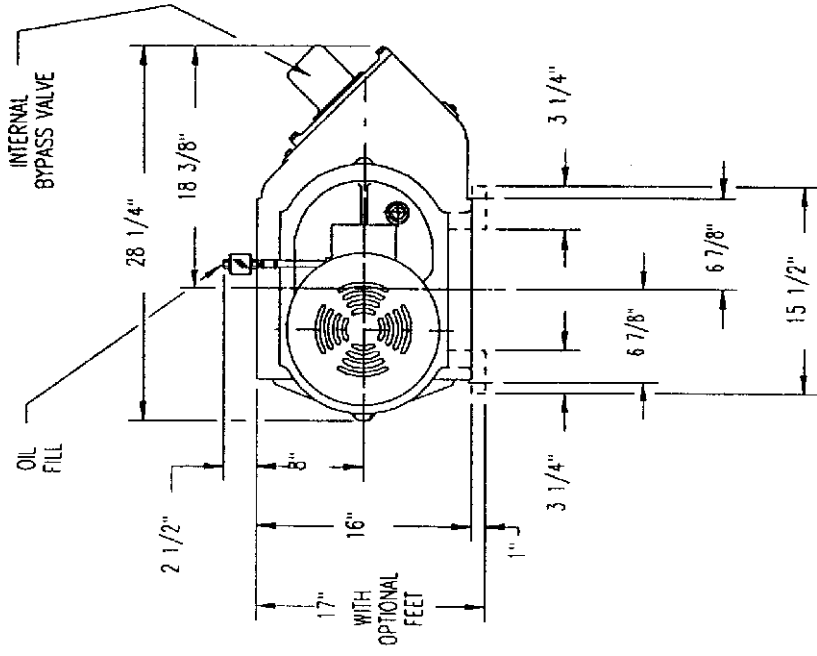
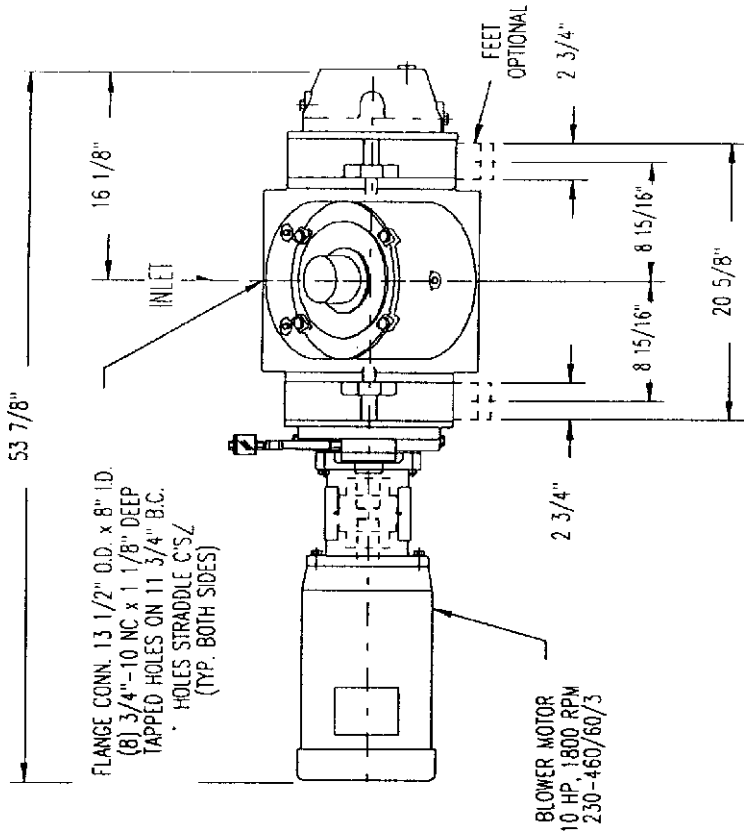
**STOKES®**  
**VACUUM** Inc.

ACCU NO. 60336601 (1=12)

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

REV. A REISED 1/19/95

RNG 1/26/93

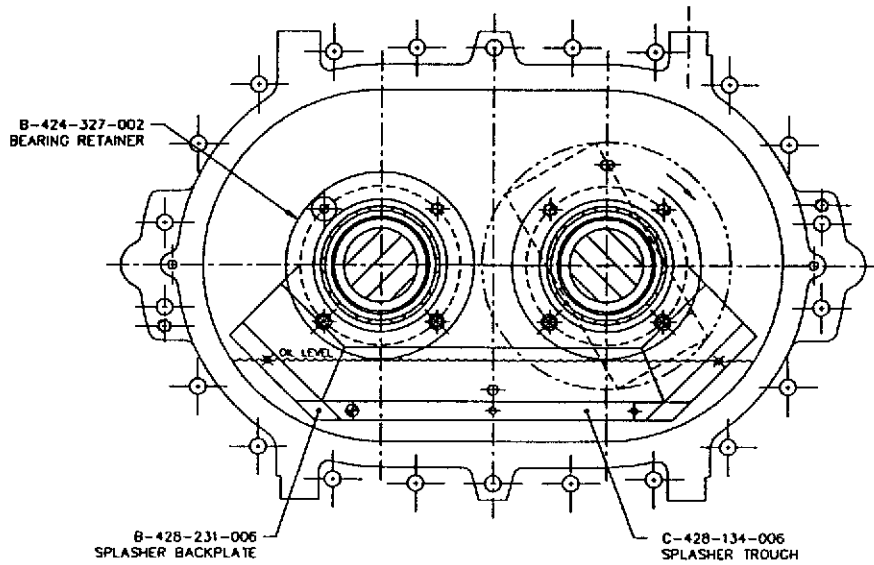
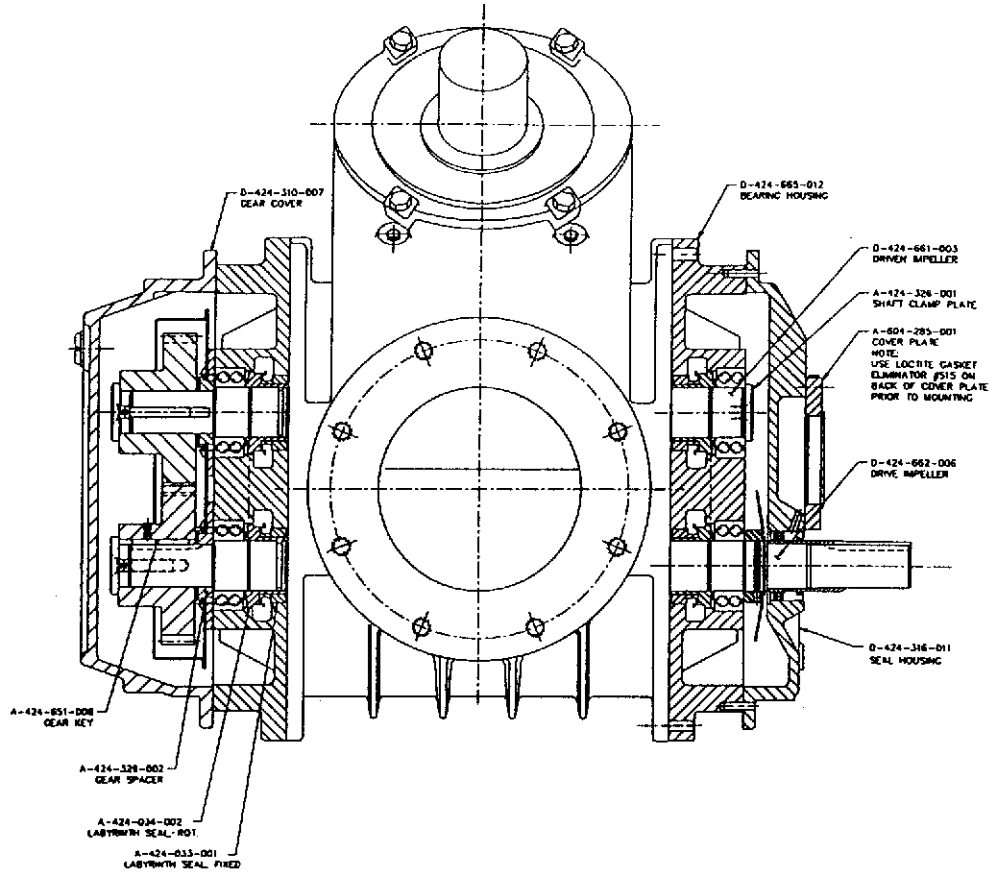


**STOKES®**  
**VACUUM** Inc.

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

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

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



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

HW-8 FILE NO. 60153710 DRAWN BY: RMC

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DATE	APP	REVISIONS
		A
		B

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

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

CHECKED BY: DATE: \_\_\_\_\_

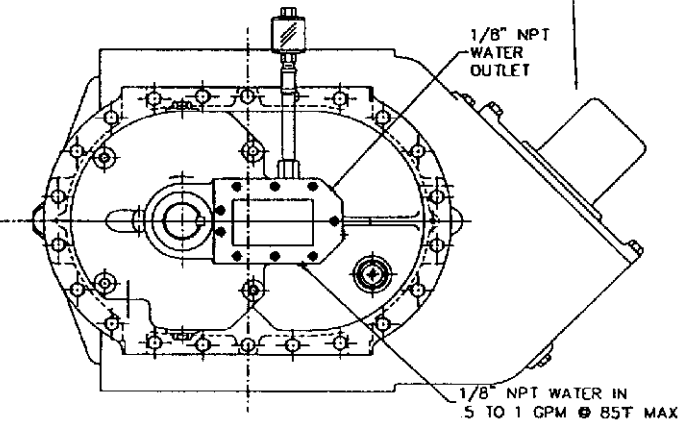
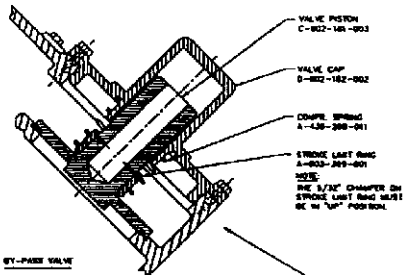
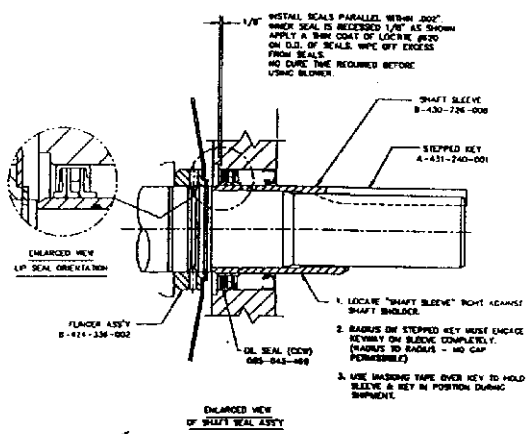
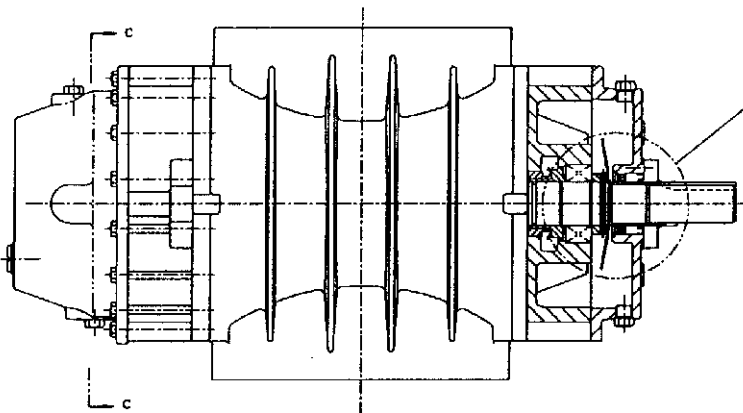
APPROVED BY: DATE: \_\_\_\_\_

PLN SCALE: 1=2

PRODUCT CODE NO: 300-615-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, INC.  
Stokes Vacuum Blvd., Philadelphia, Pennsylvania 19128

DWG. NO. E-601-537-010