



State of the Art:
E-Series
Air-operated Diaphragm Pumps
made of Plastic



AD – VIA A- TO E-SERIES: A STORY OF SETTING THE STATE OF THE ART

Since its foundation in 1984, ALMATEC Maschinenbau GmbH has kept on defining the current state of the art of air operated diaphragm pumps via decent product characteristics.

1984 Series AD (Multicor)

The compact and “closed” design of this pumps has immediately become the ALMATEC trademark. Its massive plastic construction provided the mass an oscillating pump requires. The housing material used for wetted parts have been either abrasion-resistant polyethylene or the chemically almost universally resistant PTFE. The outer surface was completely metal-free. Diaphragms with integrated metal core and without outer pistons as well as the choice of either ball or cylinder valves offered an appropriate choice for any application.

1998 A-Series

After 14 years of successful penetration of the market the Series AD was replaced by the A-Series in 1998. All housing parts (non-wetted as well) were now made from the same material. Fluid connections had been integrated into the center housing and were designed to fit flange connections as well. Various connection patterns could be realised by rotating the center housing. Pump versions with either ball or cylinder valves could easily be switched over due to identical inner structures.

2009 E-Series

The development of the E-Series is based on the extensive experiences with the proven pumps models and offers a large variety of new, market-relevant advantages:

- further increased pump security due to innovative ring-tightening structure
- increased capacity
- decreased air consumption
- reduced noise level
- optimized flow pattern
- pulsation damper suitable for flange connection

As common, the housing parts are tightened to each other via housing bolts. However, instead of single bolts pressing punctually against the housing, all housing bolts are now tightened against a diaphragm-sized ring per side. This structure results in a more even spreading the housing bolt force and in an increased permissible bolt torque – in the end an increased pump safety which is assisted by further improvements of construction details.

The flow resistance is reduced via an optimized flow pattern to increase the efficiency factor of the pump. Compared to the A-Series, the same air flow achieves a higher fluid flow, respectively less air flow is required from the same fluid flow.

The pulsation damper can still be used as an integrated model on top of the pump. However, an additional version with flange connection is available.



1984



1998



2009

THE E-SERIES AT A GLANCE

- air-operated diaphragm pumps in solid design
- housing made of PE or PTFE, both also available in a conductive version
- interchangeability to the A-Series
- seven sizes from DN 8 to DN 80
- max. capacities of 0.9 to 48 m³/h
- increased pump security due to innovative ring-tightening structure
- compared to the A-Series, increased capacity and decreased air consumption thanks to the optimized flow pattern, decreased noise level
- ATEX conformity
- exterior free of metal
- optimized diaphragm fixing
- different possible port configurations
- ball or cylinder check valves with identical interior design
- maintenance and lubrication-free air control system PERSWING P® without dead center
- composite diaphragms with integrated metal core, no diaphragm discs
- proof against dry running and overloading, self-priming, insensitive to solids
- gentle displacement
- can be infinitely controlled via the air volume
- no drives, no rotating parts, no shaft seals
- unattended operation with long service life



- easy to start up
- integrated muffler
- recessed tie rods
- vibration dampers with female thread on the underside for simple direct installation
- low noise levels
- optional features meeting requirements:
 - screw-on or flanged pulsation damper
 - back flushing system
 - barrier chamber system
 - diaphragm monitor
 - stroke counter
 - flange connection
 - transport cart

CERTIFICATIONS

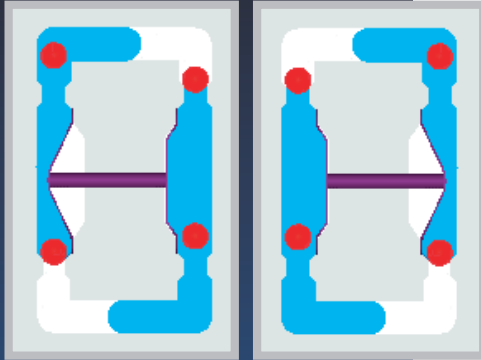
We are certified according to DIN EN ISO 9001:2008 and to DIN ISO 14001:2005. The requirements of the DIN EN ISO 9001 are fixed as minimum standard, with the endeavour to obtain a maximum of internal/external customer and supplier satisfaction by constant improvement, advancement and fault prevention in all phases of the value-added chain. In order to underline the relevance of the environmental policy the certification to DIN ISO 14001:2005 took place in the year 2006. Each enterprise in business world has a special responsibility to preserve the natural bases of life. Conscious usage and consumption of any resources, energy, raw as well as auxiliary and operational materials is a substantial component of our corporate culture. All wetted materials of the E-Series meet the requirements of the FDA and on request the non-conductive versions USP class VI also.



FUNCTIONAL PRINCIPLE

The ALMATEC E-Series is based on the functional principle of double diaphragm pumps. The basic configuration consists of two external side housing with a center housing between them. Each of the side housings contains a product chamber which is separated from the center housing by a diaphragm. The two diaphragms are interconnected by a piston rod. Directed by an air control system, they are alternately subjected to compressed air so that they move back and forth. In the first figure, the compressed air has forced the left-hand diaphragm towards the product chamber and displaced the liquid from that chamber through the open valve at the top to the discharge port. Liquid is simultaneously drawn in by the right-hand diaphragm, thus refilling the second product chamber. When the end of the stroke is reached, it reverses automatically and the cycle is repeated in the opposite direction.

In the second figure, liquid is drawn in by the left-hand diaphragm and displaced by the right-hand diaphragm. The liquid is displaced – and thus conveyed – by the compressed air. The diaphragms merely serve as barriers and are not pressurized. This is a fact of decisive importance for the service life of the diaphragms.



NBR	EPDM	PTFE	PE	summary of chemical resistance
+	+	+	+	water
+	-	+	+	mineral oil
+	-	+	+	veget., anim. fats
-	-	+	+	aliphatic
-	-	+	0	aromatic
-	-	+	-	halogenated
-	-	+	0	chlorinated
0/-	0	+	+	alcohols
-	+	+	+	ketones
-	+	+	+	esters
-	+	+	+	acids, diluted
-	+	+	0	acids, concentrated
-	+	+	+	alkalis, diluted
-	+	+	+	alkalis, concentrated
0	+	+	+	salts

hydrocarbons

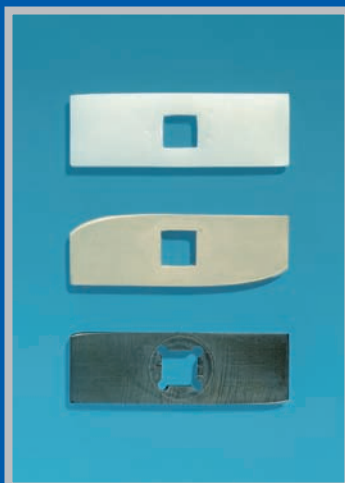
SOLID CONSTRUCTION AND MATERIALS

An important construction element is the solid design. Only a solid plastic body can support the necessary weight for an oscillating pump. The individual components can be designed, so that the required wall thicknesses are arranged where they are needed. The mechanical machining of a solid plastic block is economical thanks to modern CNC technology, enabling tight tolerances to be achieved. The high static mass leads to a smooth operation and external metal parts for reinforcement are not necessary. For ALMATEC pumps only virgin PE and PTFE without additives are used, which are produced in Germany.

The pumps of the E-Series are available in different materials:

- housing: PE, PE conductive, PTFE, PTFE conductive
- diaphragms: EPDM, PTFE/EPDM compound, PTFE modified, NBR, ATEX variations
- ball valves: EPDM, PTFE, NBR, stainless steel
- cylinder valves: PTFE

PE (polyethylene) competes with PP (polypropylene) which is frequently used in the manufacture of pumps. Thermally and chemically speaking, there are virtually no differences between these two. However, the similarity ends where the mechanical properties are concerned. Trials based on the sand-slurry method have shown that the abrasion resistance of the PE (material sample on top) is 7 times higher than that of PP (middle) and even 1.6 times higher than that of steel (bottom). It is certainly also more wear-resistant than, for example, cast iron or aluminum. This high resistance to abrasion plays a vital role in many applications (e. g. pickling baths in the electroplating industry, printing inks, lime slurry for wet desulphurization, ceramic mass and glazes in the ceramics industry).



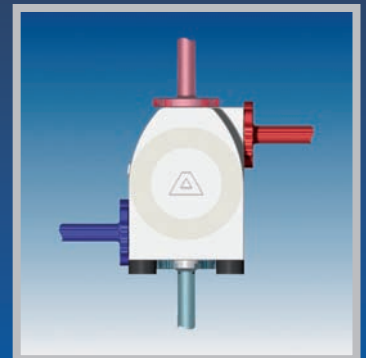
CONDUCTIVE VERSIONS FOR EXPLOSION-PROOF AREAS (ATEX CONFORMITY)

The housings and internals of the conductive versions are made of PE or PTFE filled with conductive pigment which always remains below the limits set by the FDA. The pumps are to be grounded via a connection on the center housing, thus excluding the risk of electrostatic charges. Conductive pumps of the E-Series are ATEX conform. They can consequently be used without difficulty in gas and dust atmospheres and for inflammable liquids.

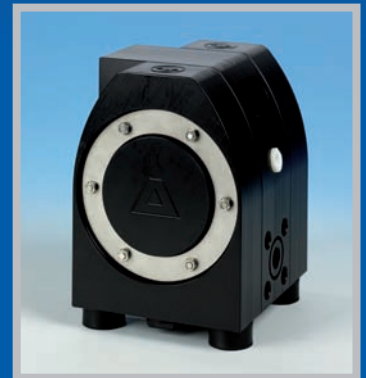


MORE SPECIAL FEATURES

ALMATEC air-operated diaphragm pumps of the E-Series consist of only three solid housing parts, namely center housing and two side housings, all of which are made from the same material (PE or PTFE). The exterior is completely free of metal so that the pumps can also be used in corrosive atmospheres. The product ports prepared for standard flanges are located in the center housing. Different port configurations can be obtained by turning the center housing resp. by re-location of the center housing plug. The standard configuration at delivery is with the suction inlet horizontally at the bottom and the discharge outlet horizontally at the top.



As common, the housing parts are tightened to each other via housing bolts. However, instead of single bolts pressing punctually against the housing, all housing bolts are now tightened against a diaphragm-sized ring per side. This structure results in more evenly spreading the housing bolt force and in an increased permissible bolt torque – in the end an increased pump safety.

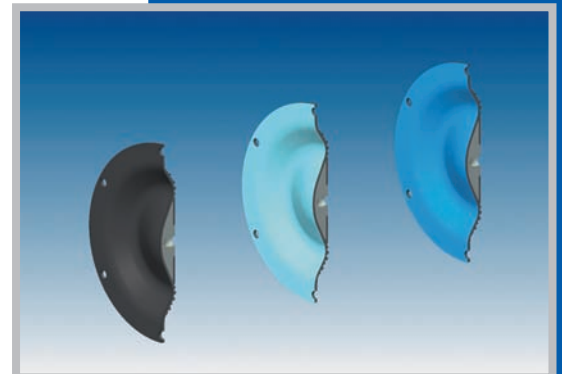


The heavy-duty muffler in the center housing is made of expanded PE (the conductive versions of E 15 – E 50 are equipped with a bronze one). Direct installation of the stationary pumps is facilitated by shock absorbers with female thread on the underside. The positions of the connections are corresponding to those of the predecessor A-Series.

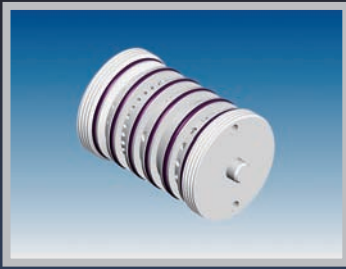
DIAPHRAGMS

The surface of the ALMATEC diaphragms is smooth and not interrupted by any seals whatsoever. Due to the integrated metal core, they do not require diaphragm discs which frequently give rise to leaks. ALMATEC diaphragms have always been designed from the "PTFE" point of view. Result: ALMATEC diaphragms have a large diameter and short stroke with low flexural load. Possible materials for the diaphragms are EPDM, PTFE/EPDM-compound and NBR.

Special diaphragms: For media with increased diffusion tendency (e. g. benzene, solvents) as well as for application with priming out of a vacuum diaphragms made of modified PTFE are available.



AIR CONTROL SYSTEM AND VALVES



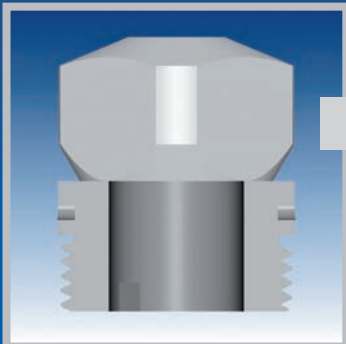
The metal-free, pneumatically pilot-operated PERSWING P® air control system ensures accurate reversal of the main piston and is characterized by low noise levels. Only two moving parts ensure that there is absolutely no dead center. It does not require maintenance, operates without any lubrication whatsoever and is made up of no more than four different parts. The complete cartridge can be replaced easily. The patented PERSWING P® is a precision control system and therefore requires clean, oil-free compressed air to ensure its optimal function.



Ball valves are robust and insensitive to media containing solids since they only form a linear seal with the valve seat. They are available in EPDM, PTFE, NBR and stainless steel. The use of stainless steel ball valves is recommended for high-viscosity media.

PTFE pumps can be equipped with cylinder valves also. The surface sealing shows very good dry priming values. They close gently and uniformly, condition for an accurate delivery.

The interior design of the housings is identical, regardless of the type of valve used. This makes it easier to change over to a different valve type at a later date.



PULSATION DAMPER, ET SERIES

Due to their design, pumps with oscillating action produce a pulsating flow. Although the double-acting design of the E-Series and the direct pneumatic drive have already greatly reduced the pulsation, a pulsation damper must still be installed on the delivery side in order to obtain a virtually uniform flow.



The ALMATEC pulsation damper series ET represents the latest generation of active pulsation dampers. It is simply screwed onto the pump. Additional connecting elements are not required. Alternatively the dampers are available in a flange version, too (ET-F series). Pulsation dampers of appropriate size are available for every pump. The wetted material is PE or PTFE (both also conductive). The damper heads are made of polyamide or PE conductive. As with the pumps the recessed housing bolts are tightened against a ring. The exterior is completely free of metal.

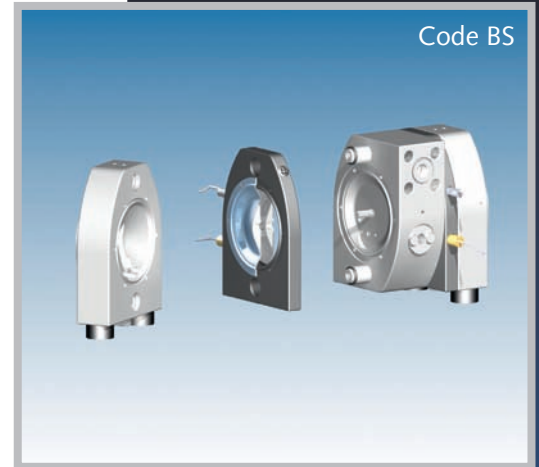


The dampers are self-regulating. They have their own air connection which must be supplied via the pump connection so that pump and damper always operate with the same air pressure. The pulsation can already be damped effectively with a minimum back pressure of only approx. 1 bar. As in the ALMATEC pumps, the diaphragm merely serves as a barrier between product and air chamber and is therefore always without load. If the pressure on the product side drops due to changes in the operating conditions, the pressure on the other side of the diaphragm will decline accordingly. If the pressure on the product side rises, the pressure on the other side will also increase. This automatic adjustment optimizes the diaphragm setting and ensures a consistently good damping effect.

OPTIONAL EQUIPMENT

Barrier chamber system (code BS)

The ALMATEC barrier chamber system for sizes E 10 to E 50 meets high safety requirements. The individual diaphragm is replaced by two diaphragms arranged in tandem with a barrier chamber of conductive PE between them and filled with non-conductive liquid. The barrier chambers must always be filled entirely to transmit the air pressure to the medium. Therefore it is monitored by level sensors. If the diaphragm on the product side breaks, medium merely enters the barrier chamber and the non-conductive liquid flows into the medium. The change in conductivity of the barrier liquid is detected by sensors and signaled to a controller which triggers an alarm or disconnects the pump.

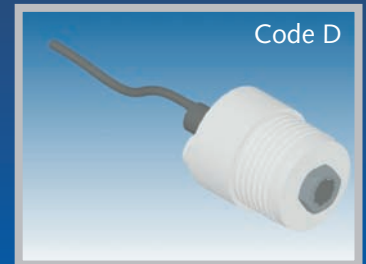


Stroke counter (code C)

A sensor is installed in the center housing to count the strokes. The diaphragm movement is scanned without contact by this sensor. The issued sensor pulses can be output to a detector, which can be used to stop the pump after a preset value. The pneumatic stroke counting registers the changes in pressure within the air chamber behind one of the diaphragms.

Diaphragm monitoring (code D)

A capacitive sensor installed in the pump muffler detects all liquids and in case of a diaphragm rupture it outputs a corresponding signal to a controller which then triggers an alarm or disconnects the pump via a connected solenoid valve.



Flange connection (code F)

According to the safety standard all over the industry the pump sizes E 15 to E 80 can be equipped with thread bushings and flange-O-rings for flange connections to DIN or ANSI / PN 10 (see figure).



Draining system (code R)

The E-series pumps of sizes 15 to 50 are available with the special ALMATEC draining system consisting of a bypass system in the side housings which can be activated easily via hand-operated valves or pneumatically. In this way, the pump and piping can be drained without having to be dismantled. The amount of cleaning agent and solvent required when changing products is reduced considerably and this greatly reduces environmental pollution.



External control (code Z)

Such a pump has neither an air control system nor a muffler, but can be controlled externally via a solenoid valve. The center housing has two separate air connections to ventilate and exhaust both working chambers. The solenoid valve is not part of the delivery.

TRANSPORT CART



A lot of industrial applications need not only stationary air-operated diaphragm pumps but also mobile pumping units (e. g. as emergency pump, as short-dated replacement for a pump to be repaired or for decanting between two containers).

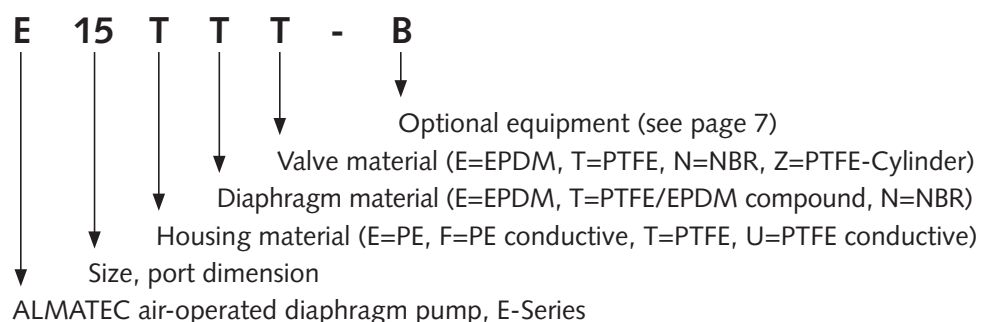
The transport cart consists of a square-pipe frame made of stainless steel and four fixable conductive castors. Room is available for product and air hoses. Possible accessories are: complete air supply with clamp connection, regulator with integrated filter and air-distributor for pump and damper.

TECHNICAL DATA

Pump size		E 08	E 10	E 15	E 25	E 40	E 50
Dimensions, mm (in.):	length	88 (3.5)	110 (4.3)	166 (6.5)	220 (8.7)	304 (12.0)	399 (15.7)
	width	128 (5.0)	147 (5.8)	189 (7.4)	255 (10.0)	353 (13.9)	430 (16.9)
	height	129 (5.1)	169 (6.7)	240 (9.4)	320 (12.6)	432 (17.0)	552 (21.7)
Nominal port size	NPT	1/4"	3/8"	1/2"	1"	1 1/2"	2"
Air connection	BSP	R 1/8	R 1/8	R 1/4	R 1/4	R 1/2	R 1/2
Weight, kg (lb):	PE	-	-	7 (15)	15 (33)	34 (75)	66 (146)
	PTFE	2 (4)	5 (11)	12 (26)	29 (64)	69 (152)	131 (289)
Max. particle size of solids for pumps with ball valves	mm (in.)	2 (0.08)	3 (0.12)	4 (0.16)	6 (0.24)	9 (0.35)	11 (0.43)
Suction lift dry, mWC (ft):	cylinder valves	1 (3.3)	2 (6.6)	3 (9.8)	4 (13.1)	5 (16.4)	5 (16.4)
	ball valves	0,5 (1.6)	1 (3.3)	2 (6.6)	3 (9.8)	4 (13.1)	4 (13.1)
Suction lift wet, mWC (ft)		9 (29.5)	9 (29.5)	9,5 (31.2)	9,5 (31.2)	9,5 (31.2)	9,5 (31.2)
Max. driving and operating pressure, bar (psig)		7 (100)	7 (100)	7 (100)	7 (100)	7 (100)	7 (100)
Max. operating temperature, °C (F):	PE	-	-	70 (158)	70 (158)	70 (158)	70 (158)
	PTFE	100 (212)	100 (212)	120 (248)	120 (248)	120 (248)	120 (248)

These technical data apply to ALMATEC E-Series standard pumps without optional equipment and dampers.

CODE SYSTEM

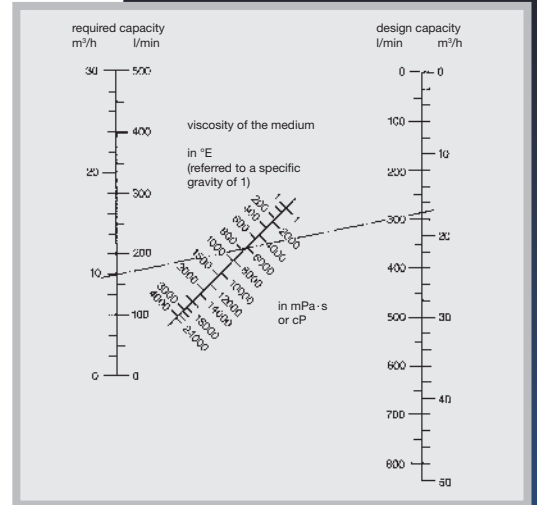


VISCOSITY AND PUMP CAPACITY

The capacity specified in the pump performance charts generally refers to water (1 mPa·s). The value must be reduced correspondingly when pumping media with higher viscosity. The design capacity can be read off directly from the graph and the corresponding pump size selected.

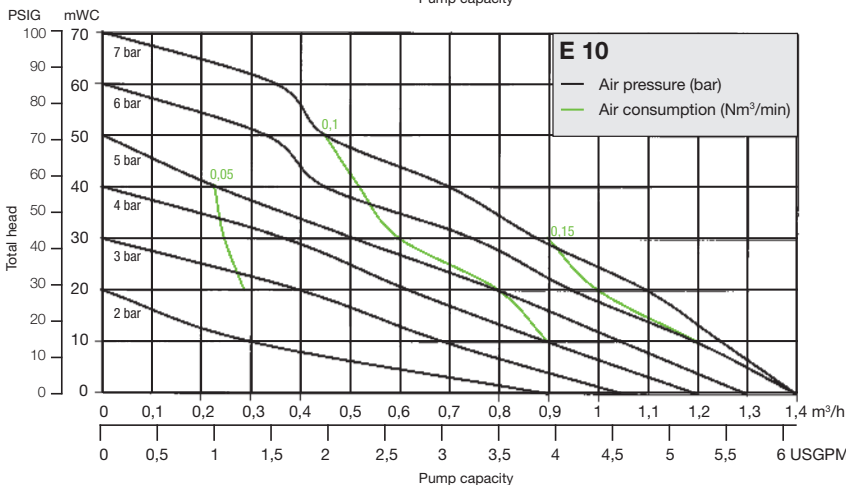
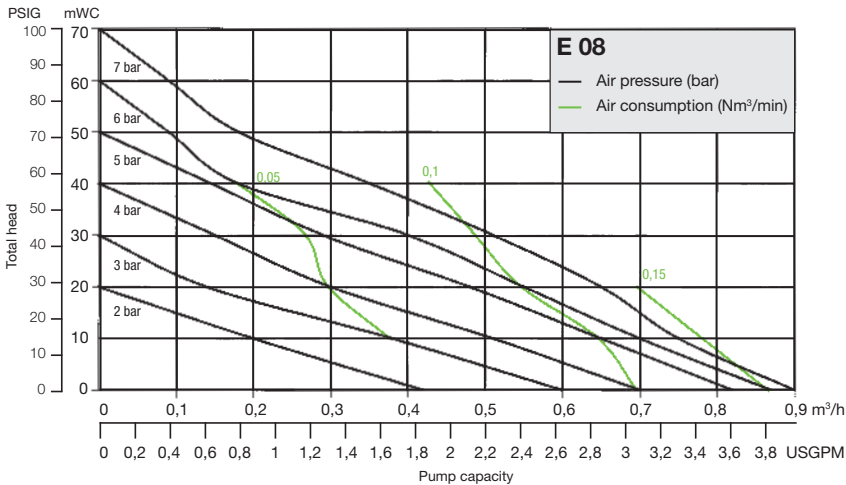
The example shown here is based on a required capacity of 10 m³/h with a product viscosity of 6000 mPa·s. The dash-dotted line intersects the design capacity scale at 17 m³/h.

When handling viscous media, the highly increased necessary suction capacity has to be taken into consideration also. A sufficient size of cross-sections in the suction piping helps to avoid gasing as well as capillary effects. For media with high viscosity a mild positive suction pressure is to recommended.



PERFORMANCE RANGE

The data refer to water (20 °C), under using of different variations (e. g. ball valve model, damper preparation etc.), a compressor Atlas Copco VSG30 and calibrated measuring equipment. The specified performance data are warranted by ALMATEC in accordance with DIN EN ISO 9906.

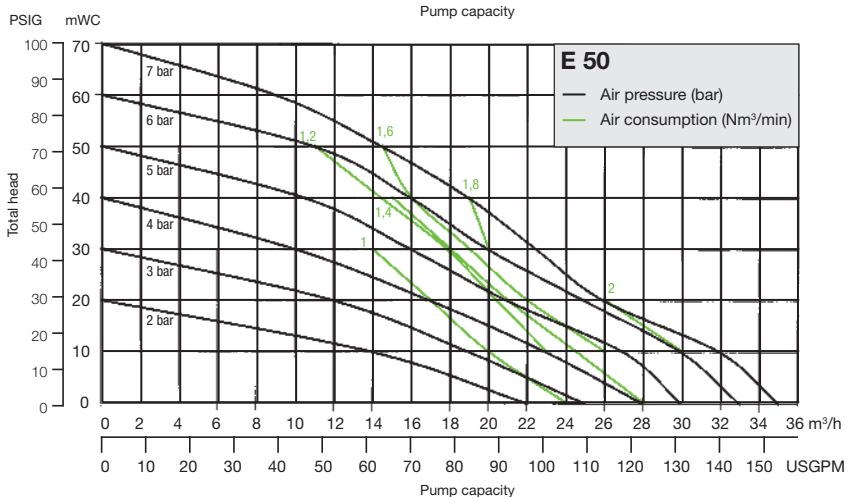
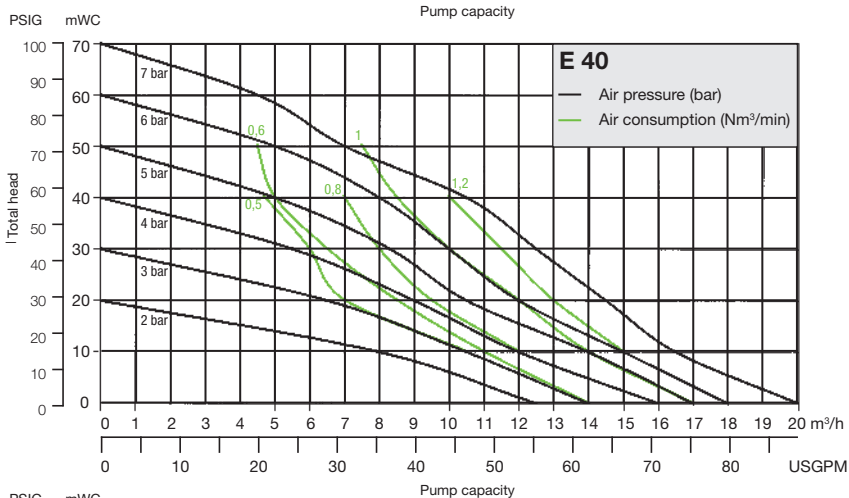
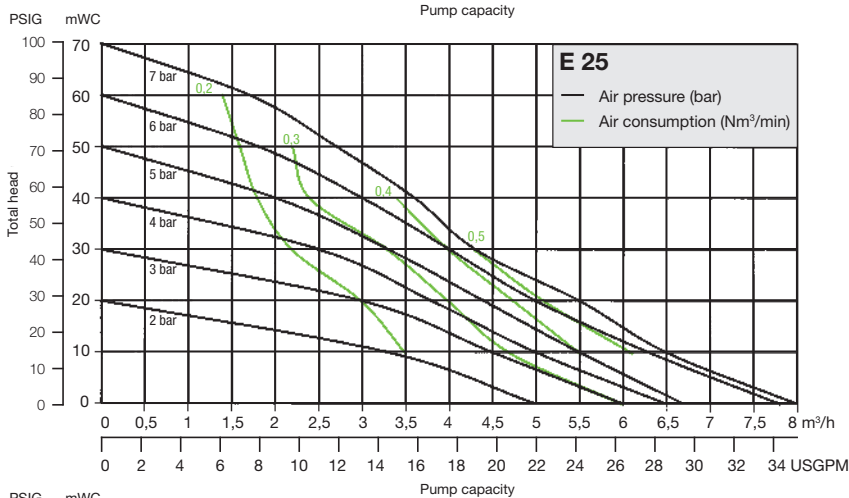
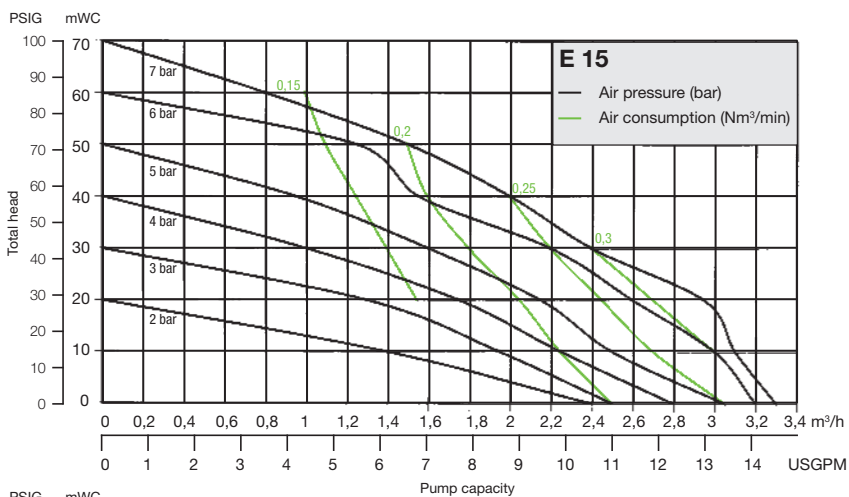




Compatible **media** include
sludges, acids, alkalis,
solvents, slurries, emulsions,
mixtures of liquids and
solids, resins, powders,
aqueous solutions

These **media** may be of
high or low viscosity,
abrasive, thixotropic,
hazardous, toxic, non-
lubricating, hot, cold,
coagulating, shear sensitive,
pasty, solids containing,
corrosive

The **fields of application**
include
chemical industry,
pharmaceuticals, cosmetics,
ceramics, surface treatment,
emergency services,
power plants, refineries,
mechanical engineering,
textile industry, water
processing, waste disposal,
paper industry, electronics,
solar industry



PUMP SIZE E 80

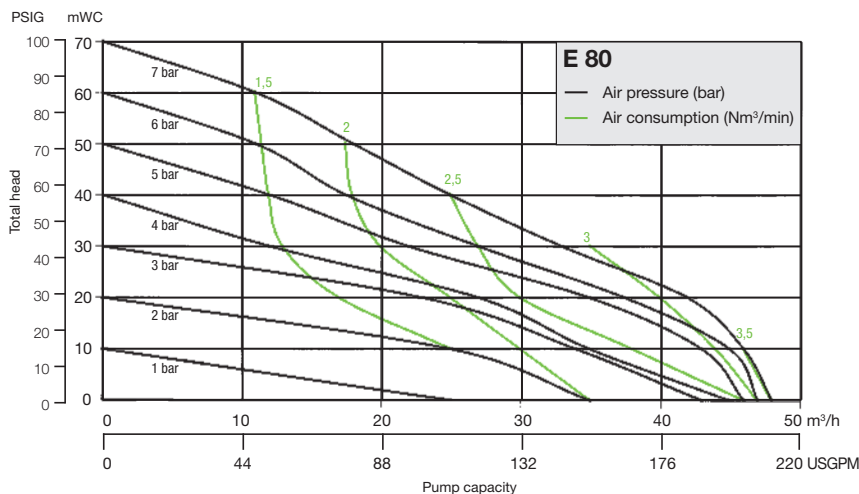
The pump size E 80 extends the E-Series range to seven sizes. With a maximum capacity of 48 m³/h the E 80 is proper for an efficient circulation of great quantities. Housing material is PE. The housing bolts are not tighten against a ring. The using of spring washers allows a high security and less leakage liability.

Further features of the E 80 at a glance:

- air control system: in spite of high performance one piece only
→ less spare parts and low noise level
- icing: big muffler for reduced risk of icing
- product connections: flange connection DN 80
→ high stability and leakage safeness
- flanged pulsation damper as option



Technical data	E 80	
Dimensions (mm)	length	700
	width	627
	height	844
Nominal port size	DN 80 / PN 10	
Air connection	R 3/4"	
Weight (kg): PE	200	
Max. particle size of solids (mm)	15	
Suction lift, dry (mWC)	4	
Suction lift, wet (mWC)	9,5	
Max. driving and operating pressure (bar)	7	
Max. operating temperature (°C)	70	





The Specialists for Air Operated Diaphragm Pumps

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