

## Gast Motor Mounted Rotary Vane Product Family Recommended Service Intervals

### Intake air filter and muffler element assembly for both non-lubricated and lubricated

Intake filter elements should be replaced annually for maximum performance and protection of the compressor. The intake filter should be changed more often when the compressor is operating in extreme conditions with high levels of contaminants in the air. Muffler elements should be replaced every 6 months under normal operating conditions and more often when operating under extreme conditions. The most common cause for broken vanes and scoring of the unit is due to poor filtration and exhaust restriction of back pressure.

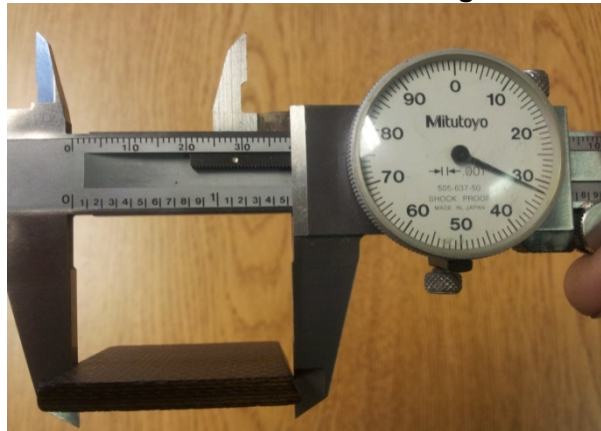
Motor Mounted Non-Lubricated			
Motor Mounted Oilless	Internal Filter & Muffler Elements	External Jar Filter & Muffler Elements	Bronze Pre Filter / Muffler
0323 / 0523	AK524	AC393 (Qty 2)	AK840A
0823 / 1023	AK254	AC393 (Qty 2)	AK840
0531/ 1031 / 1531	N/A	AA928 (Qty 4)	VG2016
0532 / 1032 / 1532	AK646	N/A	VG2016
2032 / 3032	AK646A	N/A	AK840A
1033 / 3033	N/A	AA928 (Qty 4)	N/A
1034 / 1534	AK646	N/A	VG2016
0211	N/A	AA683A (Qty 2) AA683B (Qty 4)	N/A
AT03 & AT05	AK524 x 2	B344A (Qty 2)	N/A
Motor Mounted Lubricated			
0211 Standard	N/A	Intake Filter Elements: AA683B (Qty 3) AA698 (Qty 2) Muffler Element: B344A (Qty 2)	N/A
0211 lab unit	N/A	Intake Filter Elements: AA683B (Qty 3) AA698 Muffler Element: AB584	N/A
0323 / 0523 lab & standard series	N/A	AC393 (Qty 2)	N/A
0823 / 1023 lab & standard series	N/A	AC393 (Qty 2)	N/A
0323 / 0523 standard lub unit	N/A	B344A (Qty 4)	N/A

## Vanes

Gast rotary vanes are engineered to have low wear rate, but like all rotary vane compressors, the vanes will eventually require replacement. The vanes should be replaced when any one of vanes in the compressors wears to the point that measures less than the minimum height dimension illustrated in the chart highlighted in yellow below. Vanes should always be replaced as a complete set.

Used On Model (s)	Part No.	Material	No. Required	Replace Vane if size is smaller than below
0333-0332 Oilless	AD447	Carbon	4	1/4"
0211 lubricated	AA345B	Woven	4	35/64"
0211 Oilless	AA348A	Carbon	4	35/64"
1031-1032-1033-1034	AD979	Carbon	4	23/64"
1531-1532-1533-1534	AD979	Carbon	4	3/8"
0322 lubricated	AF110A	Woven	4	19/32"
0522 lubricated	AF110A	Woven	4	5/8"
0322 Oilless	AF109C	Carbon	4	19/32"
0522 Oilless	AF109C	Carbon	4	5/8"
0323 Oilless	AH850A	Carbon	4	5/8"
<b>0523 Oilless</b>	<b>AH850A</b>	<b>Carbon</b>	<b>4</b>	<b>25/32"</b>
0323 lubricated	AK731	Woven	4	5/8"
0523 lubricated	AK731	Woven	4	25/32"
2031-2032-2033 Oilless	AJ652A	Carbon	4	7/16"
2035-3031-3032-3033 Oilless	AJ958	Carbon	4	29/64"
0822-1022 lubricated	AB980A	Woven	4	1 1/32"
0821-0822-0870-1022-1040 Oilless	AB992B	Carbon	4	1 1/32"
0823 Oilless	AK513	Carbon	4	7/8"
<b>1023 Oilless</b>	<b>AK513</b>	<b>Carbon</b>	<b>4</b>	<b>1"</b>
0823 lubricated	AK741	Woven	4	7/8"
1023 lubricated	AK741	Woven	4	1"
1423 Oilless	AL284	Carbon	4	1"

## How to measure vane height:



## 23Q Series Oil-Less

1. Make sure unit is unplugged or is disconnected from power.
2. Remove the bronze filter/muffler, end caps, O-rings & felt filters from the unit and inspect for brittleness, cuts, rips and cleanliness then set aside.
3. Remove the 5 bolts from the muffler box.
4. Tap on the muffler box with a rubber hammer to remove the muffler box clean as needed. Do not use a screwdriver.
5. Discard gasket.
6. Remove the 6 bolts from the endplate.
7. Do not take apart any further, you do not want to remove the body, rotor, or motor bolts as this will change your clearances.
8. Inspect the vanes noting the direction of the beveled edge and remove.
9. Clean rotor and inside of the body using Gast AH255D flushing solvent to remove any carbon dust buildup from on the rotor.
10. Measure height of vanes to determine if they should be replaced.
11. Replace vanes, making sure the beveled edge is facing the correct way.
12. Replace endplate and torque bolts to 110 in-lbs.
13. Install new gasket.
14. Replace muffler box, making sure the gasket lines up with the edge of the muffler box.
15. Remove old felt filters from end caps and replace.
16. Remove old O-ring from end caps and replace.
17. Re-install end caps into unit. Be sure not to over tighten, but make sure they do not leak.
18. Reinstall muffler box bolts and torque bolts to 110 in-lbs.
19. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
20. Reconnect power and test unit performance.

## 23 Series Oil-Less with Jars

1. Make sure unit is unplugged or is disconnected from power.
2. Remove filters and muffler jars from the front of the unit and set aside.
3. Remove the 6 bolts from the end plate.
4. Tap on the end plate to remove it with the rubber hammer.
5. Do not take apart any further, you do not want to remove the body, rotor, or motor bolts as this will change the internal clearances.
6. Inspect the vanes noting the position of the beveled edge and remove from the rotor.
7. Clean the rotor and inside of the body using Gast AH255D flushing solvent to remove any carbon buildup from the rotor and end plate.
8. Place a coating of oil on the vanes and install the vanes making sure that the bevel on the vane matches the contour of the body.
9. Replace the endplate and tighten bolts 110 in-lbs.
10. Remove old filter, muffler elements and oiler wick and replace with new filters, elements and wicks.
11. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
12. Reconnect power and test unit performance.

## 0211 Oil-Less Series

1. Make sure unit is unplugged or is disconnected from power.
2. Remove filters and muffler from the front of the unit and set aside.
3. Remove the 6 bolts from the end plate with the Philips screwdriver.
4. Tap on the end plate to remove it with the rubber hammer.
5. Do not take apart any further, you do not want to remove the body, rotor, or motor bolts as this will change the internal clearances.
6. Inspect the vanes, noting that there is a colored dot on the bottom edge of the vane. The dot faces the center of the rotor.
7. Clean the rotor and inside of the body using Gast AH255D flushing solvent to remove any carbon buildup from the rotor and end plate.
8. Replace vanes making sure that the colored dot faces the center of the rotor.
9. Replace endplate and tighten bolts to 28-36 in-lbs.
10. Remove the old felt elements and replace with new felt elements.
11. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
12. Reconnect power and test unit performance.

## 0211 Lubricated Series

1. Make sure unit is unplugged or is disconnected from power.
2. Remove filter and muffler jars from the front of the unit and set aside.
3. Remove the 6 bolts from the end plate with the Philips screwdriver.
4. Tap on the end plate to remove it with the rubber hammer.
5. Do not take apart any further, you do not want to remove the body, rotor, or motor bolts as this will change the internal clearances.
6. Inspect the vanes, noting that the notch on the bottom edge faces the center of the rotor.
7. Clean the rotor and inside of the body using Gast AH255D flushing solvent to remove any carbon buildup from the rotor and end plate.
8. Place a coating of oil on the new vanes and install the vanes.
9. Replace endplate and tighten bolts to 28-36 in-lbs.
10. Remove the old felt filters and muffler elements and oiler wick and replace with new filters, elements and wicks.
11. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
12. Reconnect power and test unit performance.

## 31/ 32 Series Oil-Less

1. Make sure unit is unplugged or is disconnected from power.
2. Remove filters and muffler jars if mounted on front of the unit and set aside.
3. Remove the 6 bolts from the end plate with a Philips screwdriver or Allen wrench.
4. Tap on the end plate with a rubber hammer to remove the end plate.
5. Do not take apart any further, you do not want to remove the body, rotor, or motor bolts as this will change the internal clearances.
6. Remove the internal filters in the 32 series.
7. Remove and inspect the vanes, noting that the colored dot on the bottom edge faces the center of the rotor.
8. Clean the rotor and inside of the body using Gast AH255D flushing solvent to remove any carbon buildup from the rotor and end plate.
9. Replace the vanes and depending on your model the internal filter elements or the glass jar filter elements.
10. Replace endplate and torque bolts to 28-36 in-lbs.
11. Check that all external accessories such as relief valves and gauges are attached and are in good operating condition before operating the product.
12. Reconnect power and test unit performance.