

# Repair/Parts List



## Verder HI-CLEAN Diaphragm

### Pump, Model VA-2H25

812.0063  
Rev.A  
EN

For transfer of fluids in sanitary applications. Not approved for use in explosive atmospheres or hazardous (classified) locations unless otherwise stated. See Approvals page for more information. For professional use only.



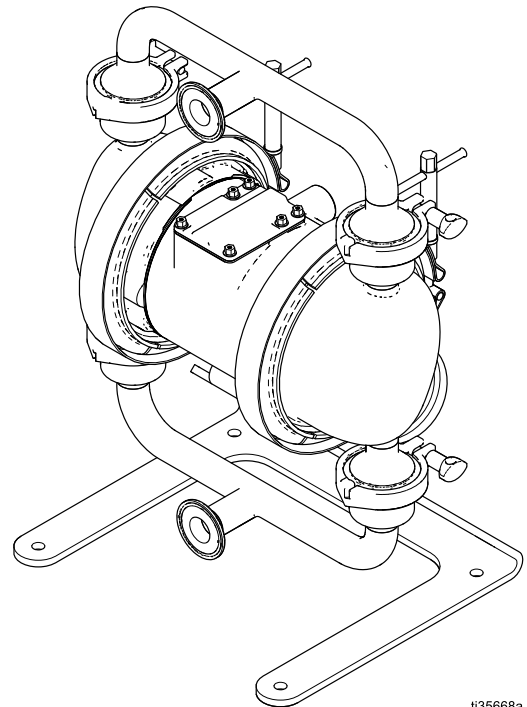
#### Important Safety Instructions

Read all warnings and instructions in this manual and related manuals before using the equipment. **Save all instructions.**

*8 bar (0.8 MPa, 120 psi) Maximum Fluid Working Pressure*

*8 bar (0.8 MPa, 120 psi) Maximum Air Input Pressure*

*See page 6 for approvals.*



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# Related Manuals

Manual Number	Title
812.0061	Verder HI-CLEAN Diaphragm Pumps, Operation

# Warnings

The following warnings are for the setup, use, grounding, maintenance, and repair of this equipment. The exclamation point symbol alerts you to a general warning and the hazard symbols refer to procedure-specific risks. When these symbols appear in the body of this manual or on warning labels, refer back to these Warnings. Product-specific hazard symbols and warnings not covered in this section may appear throughout the body of this manual where applicable.

 <h1 style="margin: 0;">WARNING</h1>	
   	<p><b>FIRE AND EXPLOSION HAZARD</b></p> <p>Flammable fumes, such as solvent, in <b>work area</b> can ignite or explode. Solvent flowing through the equipment can cause static sparking. To help prevent fire and explosion:</p> <ul style="list-style-type: none"> <li>• Use equipment only in well ventilated area.</li> <li>• Eliminate all ignition sources; such as pilot lights, cigarettes, portable electric lamps, and plastic drop cloths (potential static arc).</li> <li>• Ground all equipment in the work area. See <b>Grounding</b> instructions.</li> <li>• Keep work area free of debris, including solvent, rags and gasoline.</li> <li>• Do not plug or unplug power cords, or turn power or light switches on or off when flammable fumes are present.</li> <li>• Use only grounded fluid lines.</li> <li>• <b>Stop operation immediately</b> if static sparking occurs or you feel a shock. Do not use equipment until you identify and correct the problem.</li> <li>• Keep a working fire extinguisher in the work area.</li> <li>• Route exhaust away from all ignition sources. If diaphragm ruptures, fluid may be exhausted with air.</li> </ul>
  	<p><b>PRESSURIZED EQUIPMENT HAZARD</b></p> <p>Fluid from the equipment, leaks, or ruptured components can splash in the eyes or on skin and cause serious injury.</p> <ul style="list-style-type: none"> <li>• Follow the <b>Pressure Relief Procedure</b> when you stop spraying/dispensing and before cleaning, checking, or servicing equipment.</li> <li>• Tighten all fluid connections before operating the equipment.</li> <li>• Check fluid lines, tubes, and couplings daily. Replace worn or damaged parts immediately.</li> </ul>

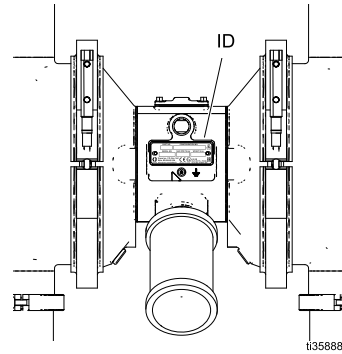
 <h1 style="margin: 0;">WARNING</h1>	
 	<p><b>EQUIPMENT MISUSE HAZARD</b></p> <p>Misuse can cause death or serious injury.</p> <ul style="list-style-type: none"> <li>• Do not operate the unit when fatigued or under the influence of drugs or alcohol.</li> <li>• Do not exceed the maximum working pressure or temperature rating of the lowest rated system component. See <b>Technical Data</b> in all equipment manuals.</li> <li>• Use fluids and solvents that are compatible with equipment wetted parts. See <b>Technical Data</b> in all equipment manuals. Read fluid and solvent manufacturer's warnings. For complete information about your material, request Safety Data Sheet (SDS) from distributor or retailer.</li> <li>• Turn off all equipment and follow the <b>Pressure Relief Procedure</b> when equipment is not in use.</li> <li>• Check equipment daily. Repair or replace worn or damaged parts immediately with genuine manufacturer's replacement parts only.</li> <li>• Do not alter or modify equipment. Alterations or modifications may void agency approvals and create safety hazards.</li> <li>• Make sure all equipment is rated and approved for the environment in which you are using it.</li> <li>• Use equipment only for its intended purpose. Call your distributor for information.</li> <li>• Route fluid lines and cables away from traffic areas, sharp edges, moving parts, and hot surfaces.</li> <li>• Do not kink or over bend fluid lines or use fluid lines to pull equipment.</li> <li>• Keep children and animals away from work area.</li> <li>• Comply with all applicable safety regulations.</li> </ul>
	<p><b>TOXIC FLUID OR FUMES HAZARD</b></p> <p>Toxic fluids or fumes can cause serious injury or death if splashed in the eyes or on skin, inhaled, or swallowed.</p> <ul style="list-style-type: none"> <li>• Read Safety Data Sheet (SDS) to know the specific hazards of the fluids you are using.</li> <li>• Route exhaust away from work area. If diaphragm ruptures, fluid may be exhausted into the air.</li> <li>• Store hazardous fluid in approved containers, and dispose of it according to applicable guidelines.</li> </ul>
	<p><b>BURN HAZARD</b></p> <p>Equipment surfaces and fluid that's heated can become very hot during operation. To avoid severe burns:</p> <ul style="list-style-type: none"> <li>• Do not touch hot fluid or equipment.</li> </ul>
	<p><b>PERSONAL PROTECTIVE EQUIPMENT</b></p> <p>Wear appropriate protective equipment when in the work area to help prevent serious injury, including eye injury, hearing loss, inhalation of toxic fumes, and burns. This protective equipment includes but is not limited to:</p> <ul style="list-style-type: none"> <li>• Protective eyewear, and hearing protection.</li> <li>• Respirators, protective clothing, and gloves as recommended by the fluid and solvent manufacturer.</li> </ul>

# Configuration Number Matrix

Check the identification plate (ID) for the Configuration Number of your pump. Use the following matrix to define the components of your pump.

When you receive your pump, record the 8 character part number found on the shipping box (e.g., 811.0018):

Also record the configuration number on the pump ID plate to assist you when ordering replacement parts:



Sample Configuration Number: **VA-2H25XS-STTFTSD25B21**





<b>VA-2H</b>	<b>25</b>	<b>X</b>	<b>S</b>	<b>ST</b>	<b>TF</b>	<b>TS</b>	<b>D2</b>	<b>SB</b>	<b>21</b>
Pump Model	Pump Size	Wetted Parts	Air Section	Seats	Balls	Diaphragms	Connections	Options	Certifications

**NOTE:** Some combinations are not possible. Please check with your local supplier.

Pump	Pump Size		Wetted Parts		Air Section		Seat Material	
<b>VA-2H</b>	<b>25</b>	25 mm	<b>X</b>	High Sanitation, 3-A 0.8 µm	<b>E</b>	Polished Stainless Steel	<b>SB</b>	Stainless Steel, Buna-N gasket
			<b>Y</b>	Pharmaceutical, 0.5 µm	<b>S</b>	Stainless Steel	<b>SE</b>	Stainless Steel, EPDM gasket
							<b>ST</b>	Stainless Steel, EP-TF gasket
							<b>SV</b>	Stainless Steel, FKM gasket

Ball Material		Diaphragm Material		Connections		Options		Certification	
<b>BN</b>	Buna-N	<b>BN</b>	Buna-N	<b>D2</b>	DIN 11851 (DN25)	<b>SB</b>	Sanitary ball	<b>21</b>	EN 10204 type 2.1
<b>NW</b>	Polychloroprene weighted	<b>SP</b>	Santoprene	<b>T2</b>	TRI-CLAMP 1"			<b>31</b>	EN 10204 type 3.1
<b>SP</b>	Santoprene	<b>TO</b>	PTFE Overmolded						
<b>TF</b>	PTFE	<b>TS</b>	PTFE/Santoprene, 2-piece						
<b>VT</b>	FKM	<b>VT</b>	FKM						

Configuration Number Matrix

Approvals		
All pumps are approved to:		II 2 GD Ex h IIA T6...T3 Gb Ex h IIIB T160°C Db
Models which use diaphragm materials coded <b>TO</b> or <b>TS</b> combined with <b>TF</b> ball checks comply with:		EC 1935/2004
Diaphragm materials coded <b>TS</b> combined with <b>TF</b> ball checks comply with:		Class VI
All models are approved to:		
All fluid contact materials are FDA compliant and meet the United States Code of Federal Regulations (CFR)		

ATEX T-code rating is dependent on the temperature of the fluid being pumped. Fluid temperature is limited by the materials of the pump interior wetted parts. See [Technical Data, page 24](#), for the maximum fluid operating temperature for your specific pump model.

# Troubleshooting



- Follow the [Pressure Relief Procedure, page 9](#) , before checking or servicing the equipment.
- Check all possible problems and causes before disassembly.

Problem	Cause	Solution
Pump cycles at stall or fails to hold pressure at stall.	Worn checks or seating surfaces.	Replace.
Pump will not cycle, or cycles once and stops.	Air valve is stuck or dirty.	Disassemble and clean air valve. Use filtered air.
	Check ball is severely worn and wedged in seat or manifold.	Replace ball and seat.
	Check valve ball is severely wedged into seat due to overpressurization.	Follow <a href="#">Pressure Relief Procedure, page 9</a> . Disassemble ball check assembly and inspect for damage.
	Clogged dispensing valve .	Follow <a href="#">Pressure Relief Procedure, page 9</a> . Clear valve.
	Leak detector has activated a shut-down solenoid.	Investigate failure and reset leak detector.
Reduced pump performance	Clogged suction line.	Inspect; clear.
	Sticky or leaking check balls.	Clean or replace.
	Ruptured diaphragm.	Replace. See standard or overmolded diaphragm repair procedure.
	Restricted exhaust.	Remove restriction.
Air bubbles in fluid.	Loose suction line.	Tighten.
	Ruptured diaphragm.	Replace. See standard or overmolded diaphragm repair procedure.
	Loose inlet manifold, damaged seal between manifold and fluid cover, or damaged gaskets.	Tighten manifold clamps or replace gaskets or seating surfaces.
Leak in inlet or outlet sanitary fitting.	Loose sanitary clamp.	Tighten clamp.
	Damaged or worn gasket.	Replace gasket.
	Misalignment of inlet/outlet fluid line or pipe.	Use flexible fluid lines at pump inlet and outlet.
Manifolds do not fit for installation onto fluid covers.	Use of incorrect air cover gaskets results in misalignment.	Install correct air cover gaskets for the type of diaphragms in use. See Parts list for correct gasket.

Troubleshooting

<b>Problem</b>	<b>Cause</b>	<b>Solution</b>
Fluid in exhaust air.	Diaphragm ruptured.	Replace. See standard or overmolded diaphragm repair procedure.
	Loose diaphragm plate.	Tighten or replace. See standard or overmolded diaphragm repair procedure.
Pump exhausts excessive air at stall.	Worn air valve block, plate, pilot block, u-cups, or pilot pin o-rings.	Repair or replace.
	Worn shaft seals.	Replace. See standard or overmolded diaphragm repair procedure.
Pump leaks air externally.	Air valve cover is loose.	Tighten screws.
	Air valve gasket or air cover gasket is damaged.	Inspect; replace.
	Air cover clamps are loose	Tighten clamps.
Pump leaks fluid externally from ball check valves.	Loose manifolds, damaged seal between manifold and fluid cover, or damaged gaskets.	Tighten manifold clamps or replace seats or clamps.
Chattering.	Check valve balls not seating properly/cleanly due to imbalance between fluid inlet and outlet line sizing. Noise is accentuated with light viscosity fluids.	Reduce size/diameter of inlet line relative to outlet line. Outlet line size should not exceed pump size.



# Repair

## Pressure Relief Procedure



Follow the Pressure Relief Procedure whenever you see this symbol.



This equipment stays pressurized until pressure is manually relieved. To help prevent serious injury from pressurized fluid, such as splashing fluid, follow the **Pressure Relief Procedure** when you stop dispensing and before cleaning, checking, or servicing the equipment.

1. Close the master air valve (A) to shut off the air to the pump.
2. Open outbound fluid valve to relieve fluid pressure from the pump.
3. If fluid is still in the outbound fluid lines, isolate this fluid as follows:
  - a. **For simple transfer applications**, open either the fluid shutoff valve (J) or the fluid drain valve (K).
  - b. **For circulating applications**, ensure that the fluid shutoff valve (J) is closed and open the fluid drain valve (K).

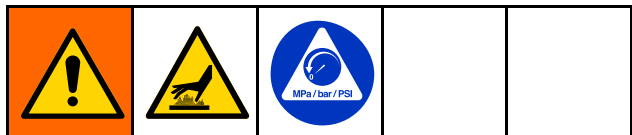
## Air Valve Repair

### Tools Required:

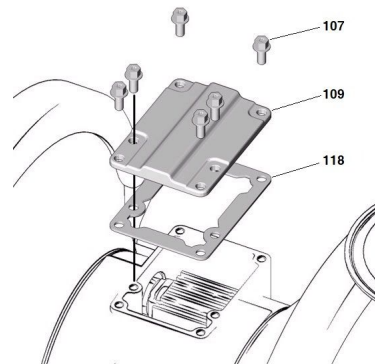
- Torque wrench
- Torx (T20) screwdriver or 7 mm (9/32 in.) socket wrench
- Needle-nose pliers
- O-ring pick
- Lithium base grease

Air valve repair kit 819.0664 is available. Use all parts in the kit for best results.

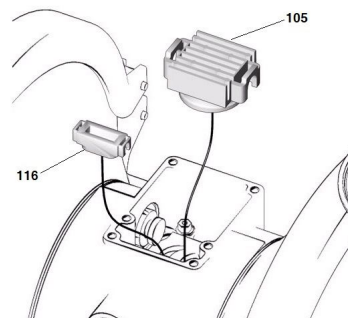
### Disassemble Air Valve



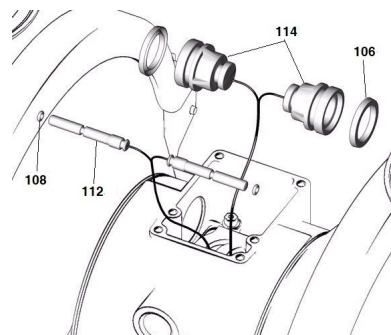
1. Follow the [Pressure Relief Procedure, page 9](#).
2. With a Torx (T20) screwdriver or 7 mm (9/32 in.) socket wrench, remove the six screws (107), air valve cover (109), and gasket (118).



3. Move the valve carriage (105) to the center position and pull it out of the cavity. Using a needle-nose pliers, pull the pilot block (116) straight up and out of the cavity.

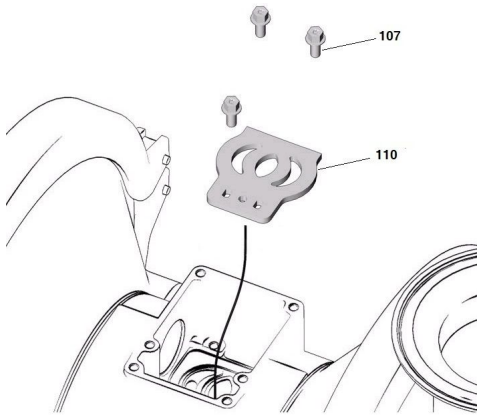


4. Pull the two actuator pistons (114). Remove the u-cups (106) from the pistons. Pull the pilot pins (112). Remove the o-rings (108) from the pilot pins.



## Repair

5. Inspect the valve plate (110) in place. If damaged, use a Torx (T20) screwdriver or 7 mm (9/32 in.) socket wrench to remove the three screws (107). Remove the valve plate (110).

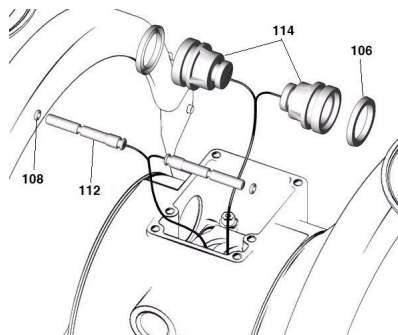


6. Inspect the bearings (113, 115) in place. See [Parts, page 20](#). The bearings are tapered and, if damaged, must be removed from the outside. This requires disassembly of the fluid section. See [Center Section Repair, page 18](#).
7. Clean all parts and inspect for wear or damage. Replace as needed.

## Reassemble Air Valve

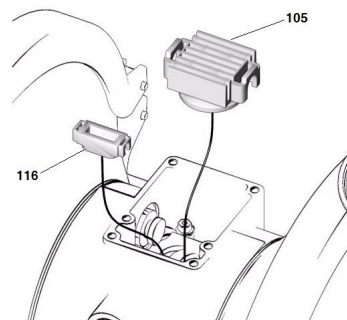
**NOTE:** If repairs involve removing fluid covers, perform the steps in [Reassemble the Overmolded Diaphragms, page 16](#), prior to reassembly of the air valve. The air valve configuration will be modified to aid fluid cover installation.

1. If the center section was disassembled to replace the bearings (113, 115), complete the [Center Section Repair, page 18](#), before continuing with the air valve reassembly.
2. Install the valve plate (110) in the cavity, seal down. Install the three screws (107), using a Torx (T20) screwdriver or 7 mm (9/32 in.) socket wrench. Tighten until the screws bottom out on the housing.
3. Install an o-ring (108) on each pilot pin (112). Grease the pins and o-rings. Insert the pins into the bearings, **narrow** end first.

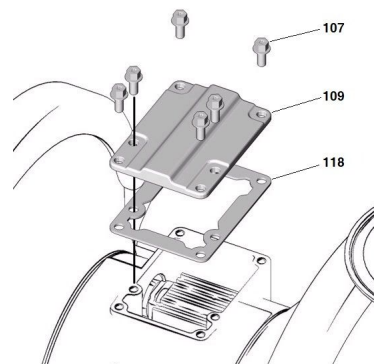


4. Install u-cups (106) on each actuator piston (114), so the lips of the packings face the **narrow** end of the pistons.
5. Lubricate the u-cups (106) and actuator pistons (114). Insert the actuator pistons in the bearings (115), **wide** end first. Leave the narrow end of the pistons exposed.

6. Grease the lower face of the pilot block (116) and install so its tabs snap into the grooves on the ends of the pilot pins (112).



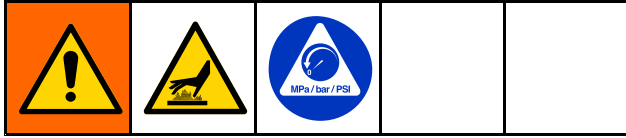
7. Grease the lower face of the valve carriage (105).
8. Install the valve carriage (105) so its tabs slip into the grooves on the narrow end of the actuator pistons (114).
9. Align the valve gasket (118) and cover (109) with the six holes in the center housing (101). Secure with six screws (107), using a Torx (T20) screwdriver or 7 mm (9/32 in.) socket wrench. Torque to 5.7-6.8 N•m (50-60 in-lb).



## Check Valve Repair

**NOTE:** Kits are available for new check valve balls in a range of materials. Gasket kits also are available.

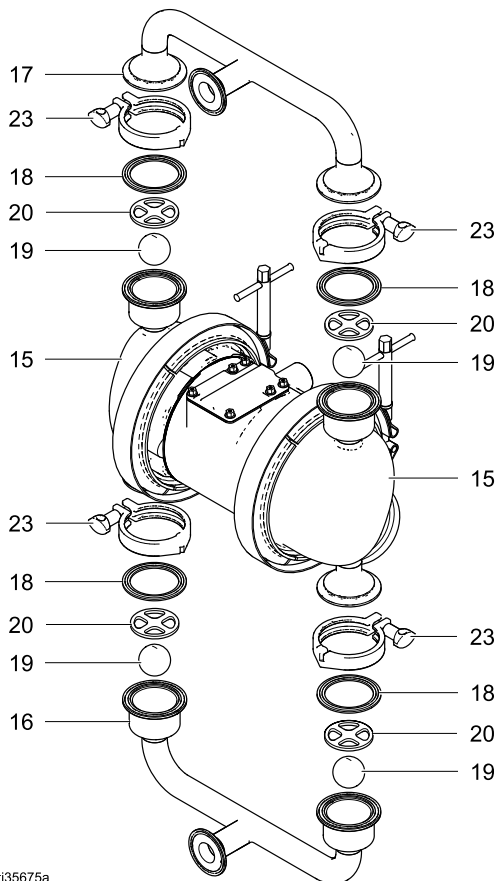
### Disassemble the Check Valve



1. Follow the [Pressure Relief Procedure, page 9](#) . Disconnect all fluid and air lines.
2. To drain the pump, partially disassemble the fluid section as noted below.
3. Remove the clamps (23) on the outlet manifold (17) and remove the manifold.

**NOTE:** Use care while removing manifolds to safely remove check valve components.

4. Remove remaining clamps (23), manifolds (16, 17) gaskets (18), and check valves (19, 20).



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5. Clean and inspect gaskets, balls, ball stops, and seating surfaces for any damage and replace as necessary.

6. To continue with diaphragm disassembly, see [Disassemble the Standard Diaphragms, page 13](#).

### Reassemble the Check Valves

**NOTE:** Lubricate clamps and clamping surfaces with waterproof, sanitary lubricant.

1. Reassemble ball check assembly in reverse order.
2. Attach the manifolds to the fluid covers. Tighten clamps hand tight.

## Standard Diaphragm Repair

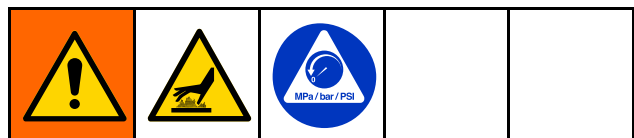
**NOTE:** Overmolded diaphragms are covered in [Overmolded Diaphragm Repair, page 15](#).

### Tools Required:

- Torque wrench
- 5/8 in. wrench
- 19 mm open end wrench
- O-ring pick
- Lithium base grease

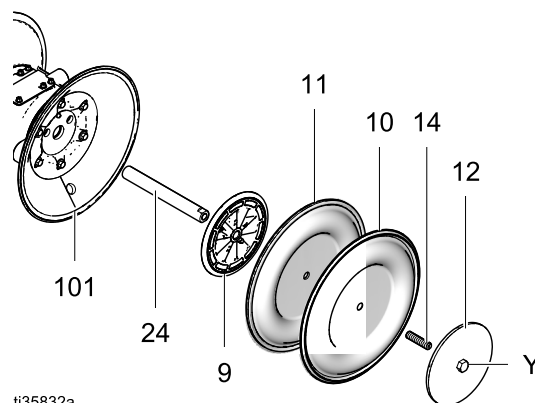
**NOTE:** Center section gasket is dependent on diaphragm material. If changing diaphragm material, it may be necessary to also replace the center section air cover gaskets. See [Diaphragms, page 23](#), for affected air cover gaskets.

### Disassemble the Standard Diaphragms



**NOTE:** Diaphragm kits are available in a range of materials and styles. See Parts section.

1. Follow the [Pressure Relief Procedure, page 9](#).
2. Remove the manifolds and disassemble the check valves as explained in [Check Valve Repair, page 12](#).
3. Remove the clamps (21) from the fluid covers (15), then pull the fluid covers off of the pump.
4. With both fluid covers removed, using two 5/8 in. wrenches, hold the wrench flats on the plates (Y) of each diaphragm assembly and loosen. One diaphragm assembly will come free and the other will remain attached to the shaft.
5. Disassemble the free diaphragm assembly.
6. Remove plate (12) with bolt (14) installed, diaphragm (10), backer (11) if present, and plate (9).
7. Pull the other diaphragm assembly and the diaphragm shaft (24) out of the center housing (101). Hold the shaft flats with a 19 mm open end wrench, and remove the diaphragm assembly from the shaft. Disassemble the remaining diaphragm assembly.
8. Inspect the diaphragm shaft (24) for wear or scratches. If it is damaged, inspect the bearings (111) in place. If the bearings are damaged, refer to [Center Section Repair, page 18](#).
9. Clean all parts and inspect for wear or damage. Replace parts as needed.



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## Reassemble the Standard Diaphragms

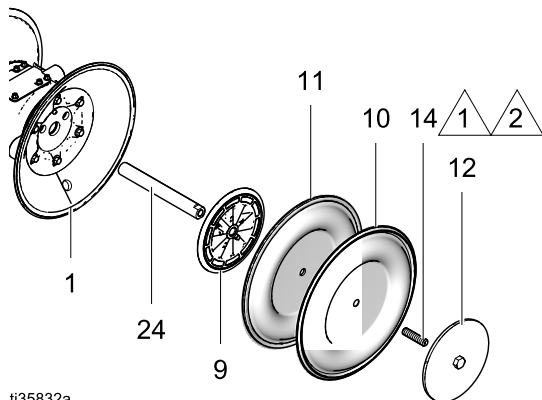
### NOTICE

After reassembly, allow the thread locker to cure for 12 hours, or per manufacturer's instructions, prior to operating the pump. Damage to the pump will occur if the diaphragm shaft bolt loosens.

**TIP:** If you are also repairing or servicing the center section, follow [Center Section Repair, page 18](#), before replacing diaphragms.

1. Lubricate and install the shaft u-cups (106) so the lips face **out** of the housing (101).
2. Assemble diaphragm (10), backer (11) if present, and plate (9) onto plate (12) with screw (14). Rounded side of plate (9) should face diaphragm. Make sure the side marked AIR SIDE faces the center housing.

**NOTE:** Thread locker must be applied to screw (14) as shown for all diaphragm assemblies.



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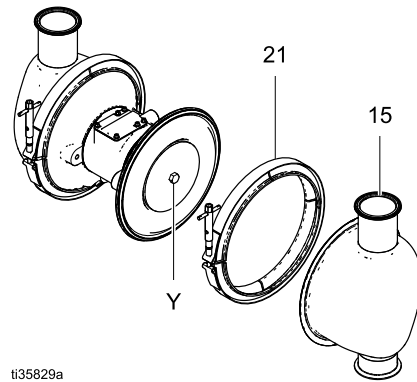
1. Apply a high-strength thread locker to attach the screw to the diaphragm plate, if needed.
2. Apply a medium-strength thread locker to the shaft side of the screw.

3. Screw assembled diaphragm assembly into shaft (24) and hand tighten.
4. Grease the length of the diaphragm shaft (24), and slide it through the housing (101).
5. Assemble the other diaphragm assembly to the shaft as explained in step 2.
6. Using a 5/8 in. wrench, hold the wrench flats of one diaphragm assembly and torque the other diaphragm to 81-94 N•m (60-70 ft-lb).

**NOTE:** Apply waterproof, sanitary lubricant to the clamp (21) and clamping surface of the cover (4, 15) to ease assembly.

7. Align the fluid covers (15) and the center housing. Secure the covers with the clamps (21) and hand tighten.

**NOTE:** Use a food grade anti-seize lubricant on the clamp threads to aid assembly.



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8. Reassemble the ball check valves and manifolds as explained in [Check Valve Repair, page 12](#).

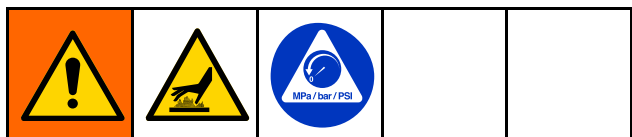
## Overmolded Diaphragm Repair

### Tools Required

- Torque wrench
- 19 mm open end wrench
- O-ring pick
- Lithium base grease

**NOTE:** Center section gasket is dependent on diaphragm material. If changing diaphragm material, it may be necessary to also replace the center section air cover gaskets. See [Diaphragms, page 23](#), for affected air cover gaskets.

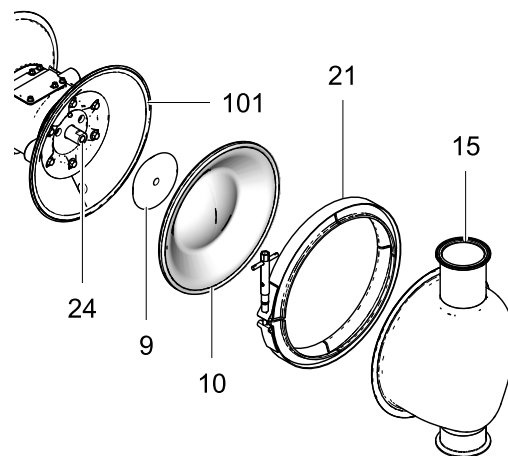
### Disassemble the Overmolded Diaphragms



**NOTE:** Diaphragm kits are available in a range of materials and styles. See Parts section.

1. Follow the [Pressure Relief Procedure, page 9](#).
2. Remove the manifolds and disassemble the check valves as explained in [Check Valve Repair, page 12](#).
3. Remove the clamps (21) from the fluid covers (15), then pull the fluid covers off of the pump.
4. Once the fluid covers are removed, the diaphragm on the side of the pump which was last pressurized with air will be separated from the center section/air cover. This allows you to grip the diaphragms.

5. To loosen, grip both diaphragms securely around the outer edge and rotate counterclockwise. One diaphragm assembly will come free and the other will remain attached to the shaft. Remove the freed diaphragm (10), screw (14) if it remains in the shaft, and air side plate (9).
6. Pull the opposite diaphragm assembly and shaft (24) out of the center housing (101). Hold the shaft flats with a 19 mm open end wrench and remove the diaphragm and air side plate from the shaft.
7. Inspect the diaphragm shaft (24) for wear or scratches. If it is damaged, inspect the bearings (111) in place. If the bearings are damaged, refer to [Center Section Repair, page 18](#).
8. Clean all parts and inspect for wear or damage. Replace parts as needed.



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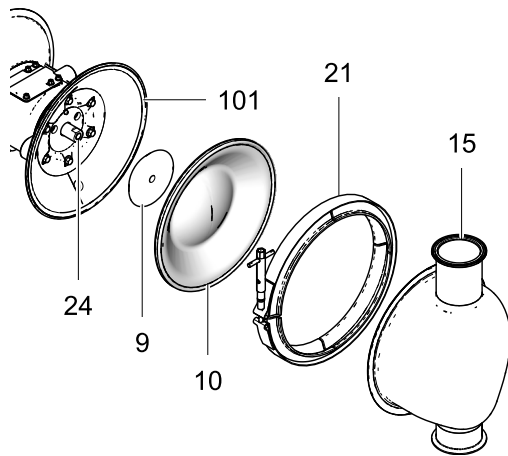
## Reassemble the Overmolded Diaphragms

### NOTICE

After reassembly, allow the thread locker to cure for 12 hours, or per manufacturer's instructions, prior to operating the pump. Damage to the pump will occur if the diaphragm shaft bolt loosens.

**TIP:** If you are also repairing or servicing the center section, follow [Center Section Repair, page 18](#), before replacing diaphragms.

1. Lubricate and install the shaft u-cups (106) so the lips face **out** of the housing (101).
2. Assemble plate (9) onto diaphragm (10) with screw (14). Rounded side of plate (9) should face diaphragm. Make sure the side marked AIR SIDE faces the center housing.



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1. Apply a high-strength thread locker to attach the screw to the diaphragm.
2. Apply a medium-strength thread locker to the shaft side of the screw (14).
3. Screw assembled diaphragm assembly into shaft (24) and hand tighten.
4. Grease the length of the diaphragm shaft (24), and slide it through the housing (101).
5. Assemble the other diaphragm assembly to the shaft as explained in step 2.

6. Grip both diaphragms securely around the outer edge and rotate clockwise until bottomed on the shaft.

**NOTE:** Apply waterproof, sanitary lubricant to the clamp (21) and clamping surface of the cover (4, 15) to ease assembly.

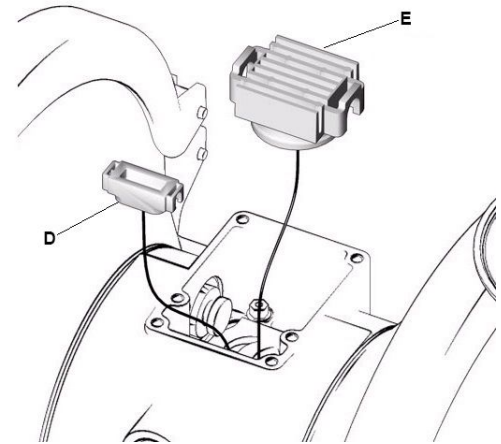
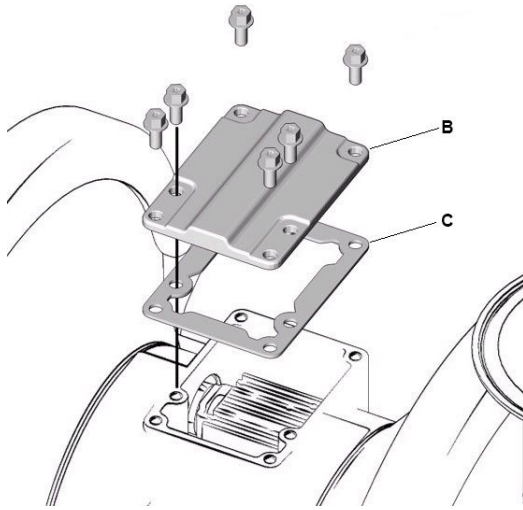
**NOTE:** Use a food grade anti-seize lubricant on the clamp threads to aid assembly.

7. Align the fluid covers (15) and the center housing. Secure the covers with the clamps (21) and hand tighten. If, after installing the first fluid cover, the opposing diaphragm protrudes away from the center housing, leaving a gap between the center housing and the second fluid cover, do not try to force the diaphragm into position. Instead, complete the following procedures in steps 7a–7i to attach the second fluid cover.
  - a. Remove the air valve cover (B), the gasket (C), and the pilot cup (D). See the image in step i.
  - b. Within the drive, shift the main air valve carriage (E) away from the installed fluid cover. This will expose the air passage that feeds the assembled side.
  - c. Reinstall the gasket (C) and the air valve cover (B). Torque all bolts according to instructions in your pump manual.
  - d. Supply the pump with 0.7–1.4 bar (0.07–0.14 MPa, 10–20 psi) air pressure, just enough to move the diaphragm. The diaphragm will shift so the second fluid cover will seat properly. Keep the air pressure on while air flows out of the exhaust.
 

**NOTE:** Too much air pressure may cause the diaphragm to deform and seat incorrectly.
  - e. Install the remaining fluid cover.
  - f. Follow the [Pressure Relief Procedure, page 9](#). Disconnect the air supply from the pump.
  - g. Remove the air valve cover (B) and the gasket (C).
  - h. Lubricate and reinstall the pilot cup (D).



- i. Reinstall the gasket (C) and the air valve cover (B). Torque all bolts according to instructions in your pump manual.



8. Reassemble the ball check valves and manifolds as explained in [Check Valve Repair, page 12](#).

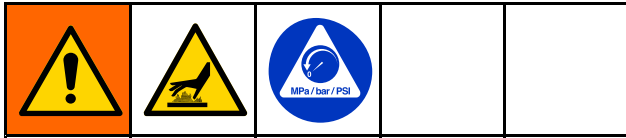
## Center Section Repair

### Tools Required:

- Torque wrench
- 10 mm socket wrench
- 9/16 in. socket wrench
- Bearing puller
- O-ring pick
- Press, or block and mallet

### Disassemble the Center Section

**NOTE:** Do not remove undamaged bearings.

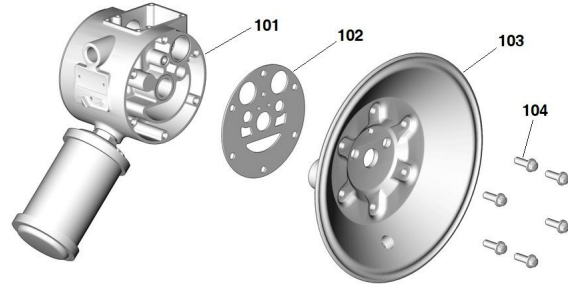


1. Follow the [Pressure Relief Procedure, page 9](#) . Disconnect all fluid and air lines.
2. Remove the manifolds and check valve parts as directed in [Disassemble the Check Valve, page 12](#).
3. Remove the fluid covers and diaphragms as directed in [Disassemble the Standard Diaphragms, page 13](#) or [Disassemble the Overmolded Diaphragms, page 15](#).

**NOTE:** If you are removing only the diaphragm shaft bearing (111), skip step 4.

4. Disassemble the air valve as explained in [Air Valve Repair, page 9](#) .

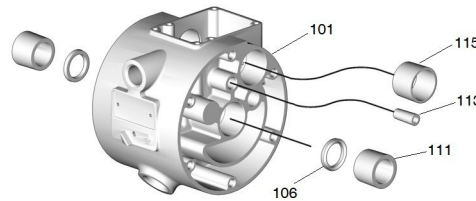
5. Use a 10 mm socket wrench to remove the screws (104) holding the air covers (103) to the center housing (101).



6. Remove the air cover gaskets (102). Always replace the gaskets with new ones. The gasket part number depends on the diaphragm material and will affect assembly of manifolds. Refer to the parts list to verify which gasket to use.

**NOTE:** If removing the diaphragm shaft bearings (111), use an o-ring pick to remove the u-cups (106) first.

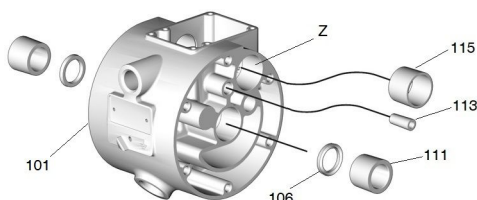
7. Use a bearing puller to remove the diaphragm shaft bearings (111), air valve bearings (115) or pilot pin bearings (113). Do not remove undamaged bearings.



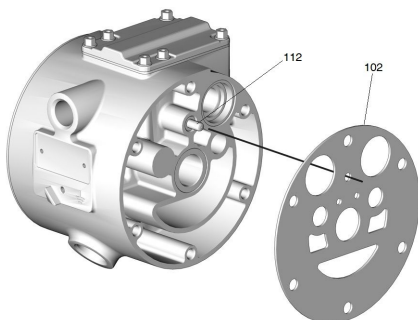
8. Inspect the u-cups. Replace as needed.

## Reassemble the Center Section

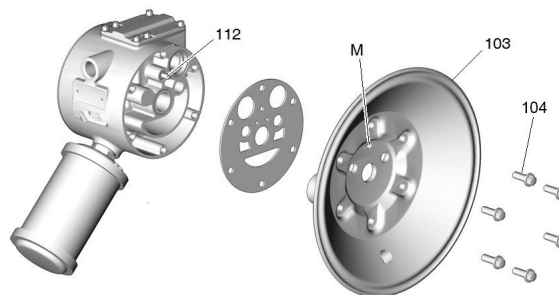
1. Install the shaft u-cups (106) so the lips face **out** of the housing.
2. Insert new bearings (111, 113, and 115) into the center housing (101), **tapered end first**. Using a press or a block and rubber mallet, press-fit the bearing so it is flush with the surface of the center housing.



3. Reassemble the air valve as explained in [Reassemble Air Valve, page 11](#).
4. Align the new air cover gasket (102) so the pilot pin (112) protruding from the center housing (101) fits through the proper hole in the gasket. The gasket part number depends on the diaphragm material and will affect assembly of manifolds. Refer to the parts list to verify which gasket to use.

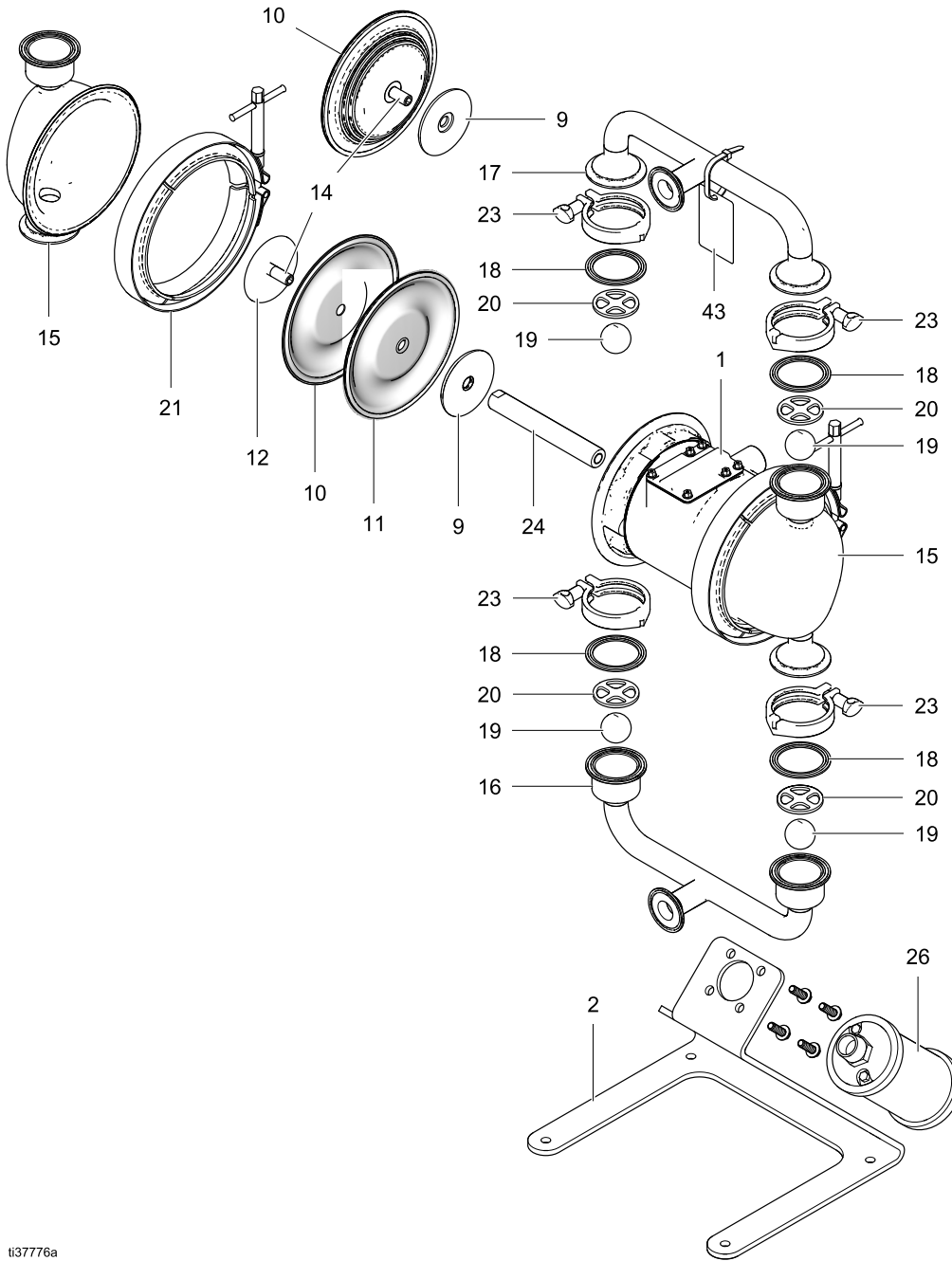


5. Align the air cover (103) so the pilot pin (112) fits in the middle hole (M) of the three small holes near the center of the cover.



6. Apply a medium-strength thread locker to the threads of the screws (104). Install the screws (104), hand tight. Using a 10 mm socket wrench, torque the screws oppositely and evenly to 15-17 N•m (130-150 in-lb). Install the diaphragm assemblies and fluid covers as explained in [Diaphragms, page 23](#).
7. See [Reassemble the Check Valves, page 12](#).

# Parts



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## Parts/Kits Quick Reference

Use this table as a quick reference for parts/kits. Go to the pages indicated in the table for a full description of kit contents.

Ref.	Part/Kit	Description	Qty.
1	— — — —	MODULE, motor; <i>See pages 20-21</i>	1
2	812.0000	FRAME	1
3	— — — —	BOLT, frame attachment, <i>included with Ref. 2</i>	4
9	819.4373 819.0534	PLATE, air side VT, TS, SP, BN TO	2
10	— — — —	DIAPHRAGM, kit; <i>See page 27.</i>	1 kit
11	— — — —	DIAPHRAGM, backup, <i>included with Ref. 10 where needed</i>	2
12	812.0112	PLATE, fluid side, BN, VT, TS, SP only	2
14	812.0132	SCREW, diaphragm	2
15	812.0014 812.0023	COVER, fluid X Y	2
16	812.0034 812.0099 812.0170	MANIFOLD, inlet; T2 X Y MANIFOLD, inlet; D2 X	1
17	812.0027 812.0100 812.0171	MANIFOLD, outlet; T2 X Y MANIFOLD, outlet; D2 X	1

Ref.	Part/Kit	Description	Qty.
18	812.0007 812.0150 812.0157 812.0243	GASKET; pkg of 4 EPDM (SE seats) VT (SV seats) EP-TF (ST seats) BN (SB seats)	1
19	812.0251 819.0426 819.0427 812.0250 819.0545	BALLS, check valve; pkg of 4 BN TF SP VT NW	1
20	812.0119	STOP, ball	4
21	819.0522	CLAMP, fluid cover	2
22	— — — —	HANDLE, tee, <i>included with Ref. 21</i>	2
23	819.0503	CLAMP, sanitary, 2 inch	4
24	819.0447	SHAFT, diaphragm	1
26	819.0519	MUFFLER	1
43	812.0136†	LABEL, kit, <i>included with Ref. 44 &amp; 45</i>	1
44	— — — —	TAG	1
45	— — — —	TIE	1

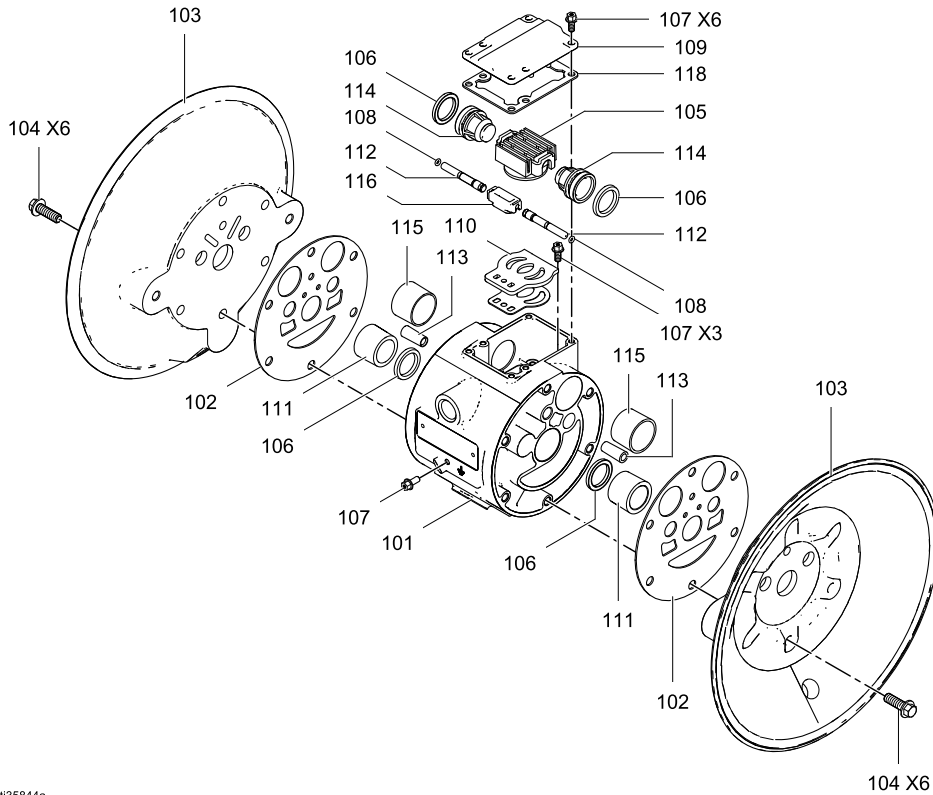
— — — — *Not sold separately.*

† *Replacement safety labels, tags, and cards are available at no cost.*

## Center Section

Sample Configuration Number:

Pump Model	Pump Size	Wetted Parts	Air Section	Seats	Balls	Diaphragms	Connections	Options	Certifications
VA-2H	25	X	<b>S</b>	ST	TF	TS	D2	SB	21



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Ref	Part	Description	Qty
101	812.0113 812.0114	HOUSING, air motor S E	1
102	819.0444 812.0135	GASKET, air cover kit; pkg of 2 use with TS diaphragms use with all diaphragms except TS diaphragms	1
103	819.0520 812.0116	COVER, air S E	2
104	819.4297	SCREW	12
105†	---	CARRIAGE assembly	1
106†	---	U-CUP	4
107	819.0439	SCREW, pkg of 9	10

Ref	Part	Description	Qty
108†	---	O-RING	2
109	819.0259 819.0557	COVER S E	1
110†	---	PLATE, valve	1
111	819.0452	BEARING, shaft, pkg of 2	1
112	819.4288	PIN, pin	2
113	819.4287	BEARING, push	2
114	819.0451	PISTON, pkg of 2	1
115	819.0452	BEARING, piston, pkg of 2	1
116†	---	BLOCK, pilot	1
118†	---	GASKET, cover	1

--- Not sold separately.

† Included in Air Valve Repair Kit 819.0664.

# Diaphragms

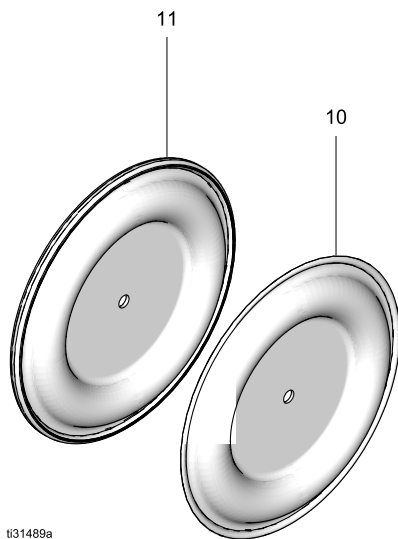
Sample Configuration Number:

Pump Model	Pump Size	Wetted Parts	Air Section	Seats	Balls	Diaphragms	Connections	Options	Certifications
VA-2H	25	X	S	ST	TF	<b>TS</b>	D2	SB	21

Bolt-Through Diaphragm Kits		
Material	Kit	Qty.
<b>BN</b>	812.0258	1
<b>SP</b>	859.0480	1
<b>TS</b>	812.0123	1
<b>VT</b>	812.0124	1

Kits include:

- 2 diaphragms (10)
- 2 diaphragm backers (11), if applicable
- 1 packet anaerobic adhesive
- 2 o-rings

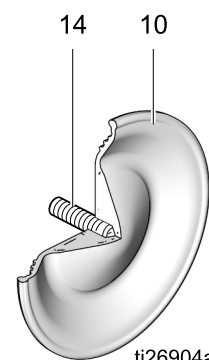


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Overmolded Diaphragm Kit		
Material	Kit	Qty.
<b>TO</b>	819.1409	1

Kits include:

- 2 overmolded diaphragms (10) with set screw (14)



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Fluid Section Repair Kits		
Kit	Description	Qty.
812.0176	VA-2H25X/Y --,BN,BN,BN	1
812.0177	VA-2H25X/Y --,NW,VT,VT	1
812.0178	VA-2H25X/Y --,NW,SP,EP	1
812.0179	VA-2H25X/Y --,VT,VT,VT	1
812.0180	VA-2H25X/Y --,TF,TO,TF	1
812.0181	VA-2H25X/Y --,TF,TS,TF	1
812.0182	VA-2H25X/Y --,TF,SP,EP	1
812.0184	VA-2H25X/Y --,SP,SP,EP	1

Kits include:

- 4 balls
- 2 diaphragms (10)
- 2 diaphragm backers (11), if applicable
- 4 gaskets
- 1 packet anaerobic adhesive
- 2 o-rings

# Technical Data

<b>Verder HI-CLEAN Diaphragm Pump, Model VA-2H25</b>		
	<b>US</b>	<b>Metric</b>
Maximum fluid working pressure	120 psi	0.8 MPa, 8 bar
Air pressure operating range	20 to 120 psi	0.14 to 0.8 MPa, 1.4 to 8 bar
Air inlet size	1/2 in. npt(f)	
Maximum suction lift (reduced if balls don't seat well due to damaged balls or seats, lightweight balls, or extreme speed of cycling)	Wet 30 ft Dry: 10 ft	Wet 9.1 m Dry: 3.0 m
Maximum size pumpable solids	0.42 in.	10.7 mm
Fluid displacement per cycle	0.17 gallons	0.64 liters
Maximum free-flow delivery	41 gpm	155.2 lpm
Maximum pump speed	240 cpm	
Weight	50.5 lb	22.9 kg
<b>Fluid Inlet and Outlet Size</b>		
Stainless Steel	25 mm DIN 11851 or 1.0 in sanitary flange	
<b>Noise Data</b>		
Sound Power (measured per ISO-9614-1)		
at 6.9 bar (100 psi) fluid pressure, full flow	103 dBa	
Sound Pressure		
at 4.8 bar (70 psi) fluid pressure and 50 cpm	85 dBa	
at 6.9 bar (100 psi) fluid pressure, full flow	90 dBa	
<b>Wetted Parts</b>		
Wetted parts include material(s) chosen for seat, ball, and diaphragm options, plus 316 Stainless Steel		
<b>Non-wetted External Parts</b>		
Non-wetted external parts include 300-series SST, Nickel plated aluminum, 17-4 PH SST, Santoprene, LDPE, VHB acrylic		



## Fluid Temperature Range

**NOTICE**

Temperature limits are based on mechanical stress only. Certain chemicals will further limit the fluid temperature range. Stay within the temperature range of the most-restricted wetted component. Operating at a fluid temperature that is too high or too low for the components of your pump may cause equipment damage.

Diaphragm/Ball/Seat Material	Stainless Steel Pump Fluid Temperature Range	
	Fahrenheit	Celsius
FKM Fluoroelastomer (VT)	-40° to 275°F	-40° to 135°C
Polychloroprene check balls (NW)	0° to 180°F	-18° to 82°C
PTFE overmolded diaphragm (TO)	40° to 180°F	4° to 82°C
PTFE check balls	40° to 220°F	4° to 104°C
2-piece PTFE/Santoprene diaphragms (TS)	40° to 180°F	4° to 82°C
Santoprene (SP)	-40° to 180°F	-40° to 82°C
Buna-N (BN)	10° to 180°F	-12° to 82°C

*The maximum temperature listed is based on the ATEX standard for T4 temperature classification.*

# Notes


# Customer Services/Guarantee

## CUSTOMER SERVICES

If you require spare parts, please contact your local distributor, providing the following details:

- Pump Model
- Type
- Serial Number, and
- Date of First Order.

## GUARANTEE

All VERDER pumps are warranted to the original user against defects in workmanship or materials under normal use (rental use excluded) for two years after purchase date. This warranty does not cover failure of parts or components due to normal wear, damage or failure which in the judgement of VERDER arises from misuse.

Parts determined by VERDER to be defective in material or workmanship will be repaired or replaced.

## LIMITATION OF LIABILITY

To the extent allowable under applicable law, VERDER's liability for consequential damages is expressly disclaimed. VERDER's liability in all events is limited and shall not exceed the purchase price.

## WARRANTY DISCLAIMER

VERDER has made an effort to illustrate and describe the products in the enclosed brochure accurately; however, such illustrations and descriptions are for the sole purpose of identification and do not express or imply a warranty that the products are merchantable, or fit for a particular purpose, or that the products will necessarily conform to the illustration or descriptions.

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Many regions, states and localities have codes and regulations governing the sale, construction, installation and/or use of products for certain purposes, which may vary from those in neighboring areas. While VERDER attempts to assure that its products comply with such codes, it cannot guarantee compliance, and cannot be responsible for how the product is installed or used. Before purchasing and using a product, please review the product application as well as the national and local codes and regulations, and be sure that product, installation, and use complies with them.

Original instructions. This manual contains English.

Revision A, September 2020

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