



86R & 87R Series  
Single Cylinder Model Shown



86R & 87R Series  
Twin Cylinder Model Shown



87R BLDC Series  
Twin Cylinder Model Shown

Operation and Maintenance Manual

# 86R, 87R, & 87R BLDC Rocking Piston Oil-less Pumps

# **GAST**

A UNIT OF IDEX CORPORATION

Dear Customer:

Thank you for purchasing this Gast product. It is manufactured to the highest standards using quality materials. Please follow all recommended maintenance, operational, and safety instructions and you will receive years of trouble free service.

**! WARNING**



PLEASE READ THIS MANUAL COMPLETELY BEFORE INSTALLING AND USING THIS PRODUCT.  
SAVE THIS MANUAL FOR FUTURE REFERENCE AND KEEP IN THE VICINITY OF THE PRODUCT.

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## PRODUCT USE CRITERIA, AND PURPOSE

- Pump only clean, dry air.
- Operate at 32°F - 104°F [0°C - 40°C].
- Protect unit from dirt and moisture.
- Do not pump flammable or explosive gases or use in an atmosphere that contains such gases.
- Protect all surrounding items from exhaust air. This exhaust air can become very hot.
- Corrosive gases and particulate material will damage unit. Water vapor, oil-based contaminants, or other liquids must be filtered out.
- Consult your Gast Distributor/Representative before using at high altitudes.
- This pump is oil-less and requires NO lubrication.

**Your safety and the safety of others is extremely important.**

We have provided many important safety messages in this manual and on your product. Always read and obey all safety messages.



This is the safety alert symbol. This symbol alerts you to hazards that can kill or hurt you and others. The safety alert symbol and the words “DANGER” and “WARNING” will precede all safety messages. These words mean:

**! DANGER**

You will be killed or seriously injured if you don't follow instructions.

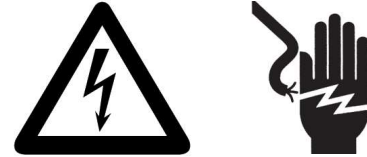
**! WARNING**

You can be killed or seriously injured if you don't follow instructions.

All safety messages will identify the hazard, tell you how to reduce the chance of injury, and tell you what can happen if the safety instructions are not followed.

## INSTALLATION

**! WARNING**



### Electrical Shock Hazard

**Disconnect electrical power at the circuit breaker or fuse box before installing this product.**

**Install this product where it will not come into contact with water or other liquids.**

**Install this product where it will be weather protected.**

**Electrically ground this product.**

**Failure to follow these instructions can result in death, fire, or electrical shock.**

Correct installation is your responsibility. Make sure you have the proper installation conditions and that installation clearances do not block air flow.

**! WARNING**

**Blocking air flow over the product in any way can cause the product to overheat.**

### Mounting

This product can be installed in any orientation. Mounting the product to a stable, rigid operating surface and using shock mounts will reduce noise and vibration.

### Plumbing

Remove plugs from the IN and OUT ports. Connect with pipe and fittings that are the same size or larger than the product's threaded ports. Be sure to connect the intake and exhaust plumbing to the correct inlet and outlet ports. Ports will not support plumbing.

## Accessories

The product's external intake and exhaust muffler will provide adequate filtration in most applications. Check filters periodically and replace when necessary. Consult your Gast Distributor/Representative for additional filter recommendations.

Install relief valves and gauges at inlet or outlet or both, to monitor performance. Check valves may be required to prevent back streaming through the pump.


## Motor Control


**It is your responsibility to contact a qualified electrician and assure that the electrical installation is adequate and in conformance with all national and local codes and ordinances. The metal capacitor must be grounded. (N/A on the BLDC version)**

Determine the correct overload setting required to protect the motor (see motor starter manufacturer's recommendations). Select fuses, motor protective switches or thermal protective switches to provide protection. Fuses act as short circuit protection for the motor, not as protection against overload. Incoming line fuses must be able to withstand the motor's starting current. Motor starters with thermal magnetic overload or circuit breakers protect motor from overload or reduced voltage conditions.

The wiring diagram supplied with the product provides required electrical information. Check that power source is correct to properly operate the dual-voltage motors.

## Electrical Connection


WARNING



**Electrical Shock Hazard**

**This product must be properly grounded.**

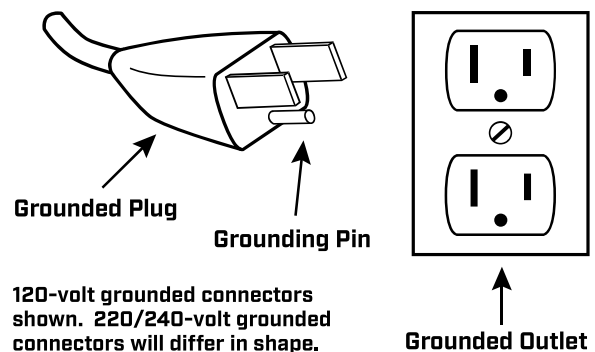
**Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.**

**If repair or replacement of the cord or plug is necessary, do not connect the grounding wire to either flat blade terminal. The wire with insulation that is green or green with yellow stripes is the grounding wire.**

**Check the condition of the power supply wiring.**

**Do not permanently connect this product to wiring that is not in good condition or is inadequate for the requirements of this product.**

**Failure to follow these instructions can result in death, fire, or electrical shock.**



### Model with a power supply cord:

This product must be grounded. For either 120-volt or 220/240-volt circuits connect power supply cord grounding plug to a matching grounded outlet. Do not use an adapter. [See above diagram.]

In the event of an electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current. This product may be equipped with a power supply cord having a grounding wire with an appropriate grounding plug.

The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances

**Check with a qualified electrician or serviceman if the grounding instructions are not completely understood, or if you are not sure whether the product is properly grounded. Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.**

**Model that is permanently wired:**

This product must be connected to a grounded, metallic, permanent wiring system, or an equipment grounding terminal or lead on the product.

Power supply wiring must conform to all required safety codes and be installed by a qualified person. Check that supply voltage agrees with that listed on product nameplate.

**Extension Cords**

Use only a 3-wire extension cord that has a 3-blade grounding plug. Connect extension cord plug to a matching 3-slot receptacle. Do not use an adapter. Make sure your extension cord is in good condition. Check that the gage wire of the extension cord is the correct size wire to carry the current this product will draw.

An undersized cord is a potential fire hazard, and will cause a drop in line voltage resulting in loss of power causing the product to overheat. The following table indicates the correct size cord for length required and the ampere rating listed on the product nameplate. **If in doubt, use the next heavier gage cord. The smaller the gage number, the heavier the wire gage.**

**Minimum gage for extension cords**

Amps	Volts	Length of cord in feet								
		25	50	100	150	200	250	300	400	500
		120v	50	100	200	300	400	500	600	800
0-2		18	18	18	16	16	14	14	12	12
2-3		18	18	16	14	14	12	12	10	10
3-4		18	18	16	14	12	12	10	10	8
4-5		18	18	14	12	12	10	10	8	8
5-6		18	16	14	12	10	10	8	8	8
6-8		18	16	12	10	10	8	6	6	6
8-10		18	14	12	10	8	8	6	6	4
10-12		16	14	10	8	8	6	6	4	4
12-14		16	12	10	8	6	6	6	4	2
14-16		16	12	10	8	6	6	4	4	2
16-18		14	12	8	8	6	4	4	2	2
18-20		14	12	8	6	6	4	4	2	2

**OPERATION**



**Injury Hazard**

**Install proper safety guards as needed.**

**Keep fingers and objects away from openings and rotating parts.**

**When provided, motor terminal covers must be in place for safe operation.**

**Product surfaces become very hot during operation, allow product surfaces to cool before handling.**

**Air stream from the product may contain solid or liquid material that can result in eye or skin damage, wear proper eye protection.**

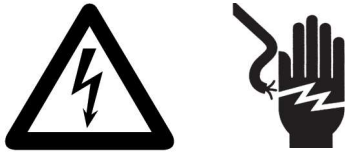
**Wear hearing protection. Sound level from motor may exceed 70 dBA.**

**Failure to follow these instructions can result in burns, eye injury, or other serious injury.**

It is your responsibility to operate this product at recommended pressures or vacuum duties and room ambient temperatures. **Do not start against a vacuum or pressure load.**

**Start Up**

If motor fails to start or slows down significantly under load, shut off and disconnect from power supply. Check that the voltage is correct for motor and that motor is turning in the proper direction. Check the plug, cord and switch for damage. If so equipped, the thermal protection switch has tripped, the motor can restart after cooling.

**MAINTENANCE****! WARNING****Electrical Shock Hazard**

**Disconnect electrical power supply before performing maintenance on this product.**

**If product is hard-wired into system, disconnect electrical power at the circuit breaker or fuse box before performing maintenance on this product.**

**Failure to follow these instructions can result in death, fire, or electrical shock.**

**! WARNING****Injury Hazard**

**Product surfaces become very hot during operation, allow product surfaces to cool before handling.**

**Air stream from the product may contain solid or liquid material that can result in eye or skin damage, wear proper eye protection.**

**Clean this product in a well-ventilated area.**

**Failure to follow these instructions can result in burns, eye injury, or other serious injury.**

**It is your responsibility to:**

- **Regularly inspect and make necessary repairs to product in order to maintain proper operation.**
- **Make sure that pressure is released from product before starting maintenance.**

Check intake and exhaust filters after first 500 hours of operation. Clean filters and determine how frequently filters should be checked during future operation. This one procedure will help to assure the product's performance and service life.

1. Disconnect electrical power supply to unit.
2. Vent all air lines.
3. Remove filter cover.
4. Check filter felt. Replace felt if it is covered with contamination or shows signs of increasing differential pressure.
5. Reinstall felt and filter cover.

Check that all external accessories such as relief valves and gauges are attached to cover and are not damaged before re-operating product.

**SHUTDOWN PROCEDURES**

**It is your responsibility to follow proper shutdown procedures to prevent product damage. NEVER ADD OIL TO THIS OIL-LESS PUMP.**

Proper shutdown procedures must be followed to prevent pump damage. Failure to do so may result in premature pump failure. Gast Manufacturing Rocking Piston Oil-Less Pumps are constructed of ferrous metals or aluminum which are subject to rust and corrosion when pumping condensable vapors such as water. Follow the steps below to assure correct storage and shutdown between operating periods.

1. Disconnect plumbing.
2. Operate product for at least 5 minutes without plumbing.
3. Run at maximum vacuum for 10 to 15 minutes.
4. Repeat step 2.
5. Disconnect power supply.
6. Plug open ports to prevent dirt or other contaminants from entering product.

**SERVICE KIT INSTALLATION****! WARNING****Electrical Shock Hazard**

**Disconnect electrical power supply before installing Service Kit.**

**If product is hard-wired into system, disconnect electrical power at the circuit breaker or fuse box before installing Service Kit.**

**Vent all air lines to release pressure or vacuum.**

**Failure to follow these instructions can result in death, fire, or electrical shock.**

13. Apply a thread locking compound (Loctite 222) to retainer screws. Torque screws to 10-13 in. lbs.
14. Install cylinder O-ring(s) in the bottom of valve plate(s).
15. Check that the orientation of valve plate(s) with the ports is correct.
16. Install head O-rings in the O-ring grooves on top of valve plate.
17. Reinstall head over valve plate(s) checking that orientation with ports is correct.
18. Torque screws to 50 in. lbs

**Check that all external accessories such as relief valves and gauges are not damaged before re-operating product.**

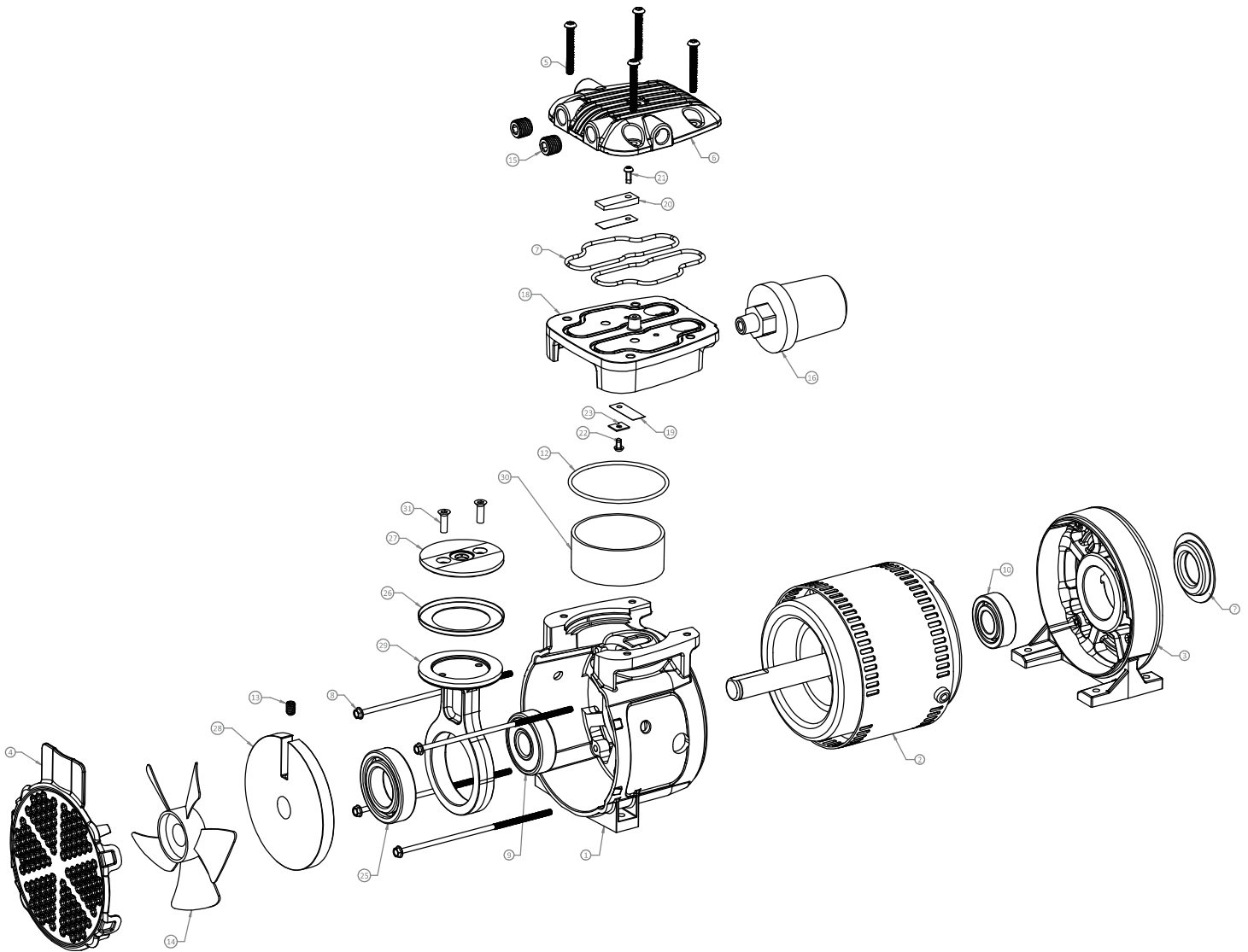
If pump still does not produce proper vacuum or pressure, send unit to a Gast Authorized Service Facility for repair.

**Gast will NOT guarantee field-rebuilt product performance. For performance guarantee, the product must be returned to a Gast Authorized Service Facility.**

Service Kit contents vary. Most contain gasket and filter parts.

1. Disconnect electrical power to pump.
2. Disconnect air supply and vent all air lines to release pressure or vacuum.
3. Mark the orientation of the ports so cover will be reinstalled correctly.
4. Remove screws from the head of the pump. Remove the head of the pump.
5. Mark orientation of valve plate(s). Remove valve plate(s).
6. Remove and discard old cups(s), retainer screws, cylinder O-ring(s), head O-ring(s), valves, and valve retainers.
7. Install new cup(s) on rod(s) facing up.
8. Reinstall retainer plates.
9. Apply a thread locking compound (Loctite 222) to retainer screws. Torque screws to 34-38 in. lbs.
10. Carefully install cylinder(s) over cup(s) at an angle to avoid damaging cup(s).
11. Clean valve plates with water based solvent. Take care to not scratch valve seats.
12. Install valves and valve retainers. Check that the orientation with the ports is correct.

# EXPLODED PRODUCT VIEW, PARTS, AND ORDERING INFORMATION: SINGLE



**EXPLODED PRODUCT VIEW, PARTS, AND ORDERING INFORMATION: TWIN**

Ref	Description	Qty	86R1	87R1
1	Body***	1	***	***
2	Motor***	1	***	***
3	End belt***	1	***	***
4	Fan cover***	1	***	***
5	Head screws	4	AP136	AP136
6	Head	1	AP704A	AP704A
7 Δ	O-ring	1	<b>K961</b>	<b>K962</b>
8	Motor bolt***	1	***	***
9	Bearing***	1	***	***
10	Bearing***	1	***	***
11	End bell cap	1	AP710	AP710
12 Δ	Head o-ring	2	<b>K961</b>	<b>K962</b>
13	Screw	1	BB602C	BB602C
14 Δ	Fan clockwise	1	AP108A	AP108A
15	Pipe plug	2	BA503	BA503
16	Filter	1	B300A	B300A
<b>Valve Plate Assembly [18-23]: varies, consult the factory</b>				
18	Valve plate	1	Varies: consult factory	Varies: consult factory
19 Δ	Leaf valve	2	<b>K961</b>	<b>K962</b>
20	Valve limiter	1	AP110A	AP110A
21	Valve screw	1	AP305	AP304
22	Valve screw	1	AP304	AP305
23 Δ	Valve retainer	1	<b>K961</b>	<b>K962</b>
<b>Rod Assembly [25-29 &amp; 31]: varies, consult the factory</b>				
25	Bearing***	1	Included in rod assembly	Included in rod assembly
26 Δ	Cup	1	Included in rod assembly or <b>K961</b>	Included in rod assembly or <b>K962</b>
27	Retainer plate***	1	Included in rod assembly	Included in rod assembly
28	Eccentric***	1	Included in rod assembly	Included in rod assembly
29	Rod***	1	Included in rod assembly	Included in rod assembly
30 Δ	Cylinder	1	<b>K961</b>	<b>K962</b>
31 Δ	Cup screw	2	Included in rod assembly or <b>K961</b>	<b>K962</b>

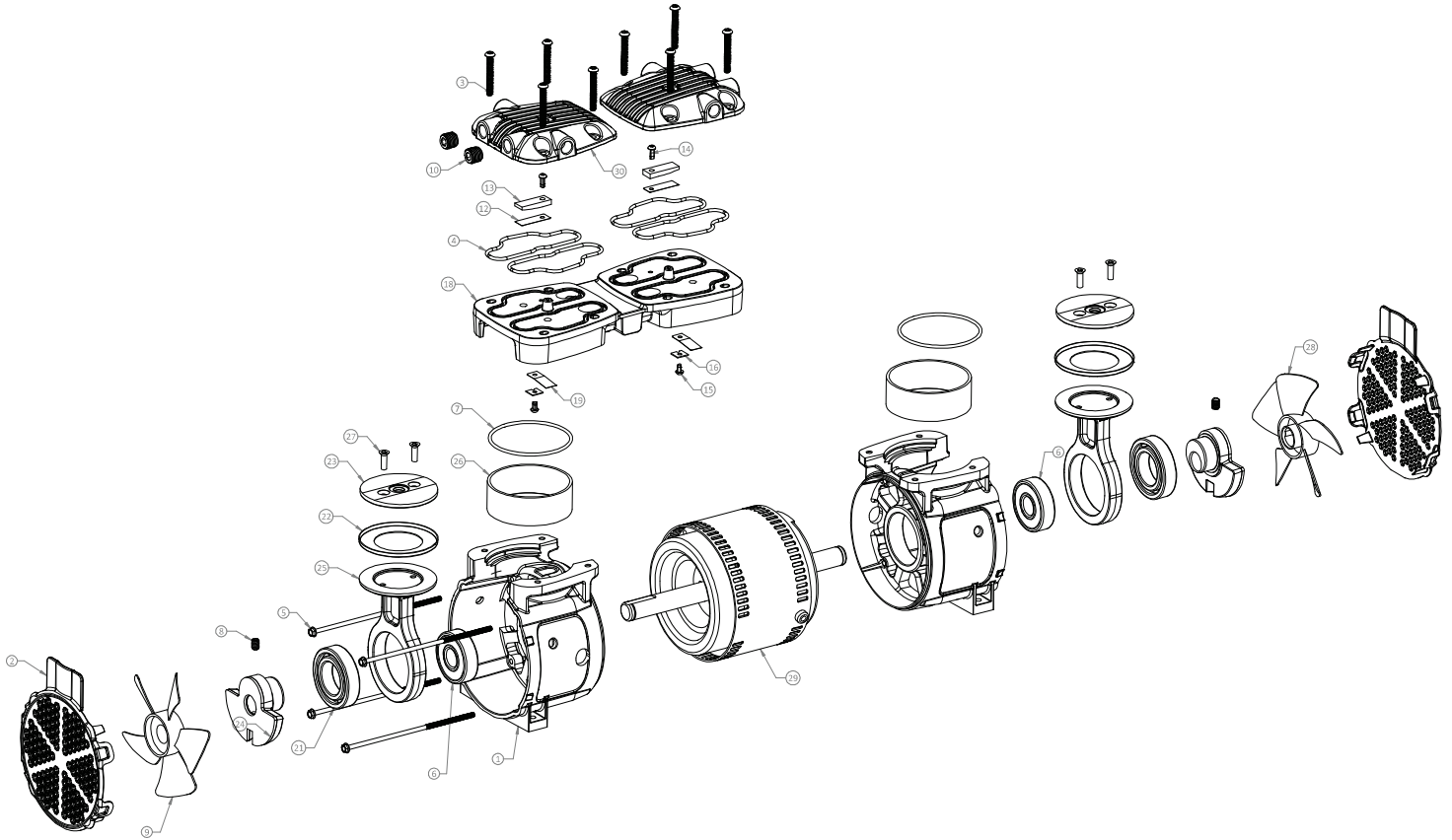
\*\*\* Part not available for purchase

Δ Parts included in the service kit

NOTE: Parts listed are for stock models. **For specific OEM models, please consult the factory.**

**When corresponding or ordering parts, please give complete model and serial numbers.**

**EXPLODED PRODUCT VIEW, PARTS, AND ORDERING INFORMATION: TWIN**



\*\*\* Denotes part not available.

Δ Denotes parts included in the Service Kit.

Parts listed are for stock models. For specific OEM models, please consult the factory. When corresponding or ordering parts, please give complete model and serial numbers.

Ref	Description	Qty	86R6	87R6
1	Body***	2	***	***
2	Fan cover	2	AP709	AP709
3	Head screws	8	AP136	AP136
4	Head	2	AP704A	AP704A
5 Δ	Head o-ring	4	<b>K963</b>	<b>K964</b>
6	Motor bolts***	1	***	***
7	Bearing***	2	***	***
8 Δ	Cylinder o-ring	2	<b>K963</b>	<b>K964</b>
9	Set screw	2	BB602C	BB602C
10	Fan	1	AP108A	AP108A
11	Pipe plug	2	BA503	BA503
<b>Valve Plate Assembly [13-19]: varies, consult the factory</b>				
13	Valve plate	1	Varies: consult factory	Varies: consult factory
14 Δ	Leaf valve	2	<b>K963</b>	<b>K964</b>
15	Valve limiter	2	AP110A	AP110A
16	Valve screw	2	AP305	AP305
17 Δ	Leaf valve	2	<b>K963</b>	<b>K964</b>
18	Valve screw	2	AP304	AP304
19	Retainer valve	2	AF819A	AF819A
20	Plug	1	AP711	AP711
<b>Rod Assembly [22-26 &amp; 28]: varies, consult the factory</b>				
22	Bearing 6006***	1	Included in rod assembly	Included in rod assembly
23 Δ	Cup	1	Included in rod assembly or <b>K963</b>	Included in rod assembly or <b>K964</b>
24	Retainer plate***	1	Included in rod assembly	Included in rod assembly
25	Eccentric	1	Included in rod assembly	Included in rod assembly
26	Rod	1	Included in rod assembly	Included in rod assembly
27 Δ	Cylinder	2	<b>K963</b>	<b>K964</b>
28 Δ	Retainer screw	4	Included in rod assembly or <b>K963</b>	Included in rod assembly or <b>K964</b>
29	Motor****	1	***	***
30	Fan	1	AP108	AP108

\*\*\* Part not available for purchase

Δ Parts included in the service kit

NOTE: Parts listed are for stock models. **For specific OEM models, please consult the factory.**

**When corresponding or ordering parts, please give complete model and serial numbers.**

## WARRANTY POLICY

Gast finished products, when properly installed and operated under normal conditions of use, are warranted by Gast to be free from defects in material and workmanship for a period of twelve (12) months from the date of purchase from Gast or an authorized Gast Representative or Distributor. In order to obtain performance under this warranty, the buyer must promptly (in no event later than thirty (30) days after discovery of the defect) give written notice of the defect to Gast Manufacturing Incorporated, PO Box 97, Benton Harbor Michigan USA 49023-0097 or an authorized Service Center (unless specifically agreed upon in writing signed by both parties or specified in writing as part of a Gast OEM Quotation). Buyer is responsible for freight charges both to and from Gast in all cases.

This warranty does not apply to electric motors, electrical controls, and gasoline engines not supplied by Gast. Gast's warranties also do not extend to any goods or parts which have been subjected to misuse, lack of maintenance, neglect, damage by accident or transit damage.

THIS EXPRESS WARRANTY EXCLUDES ALL OTHER WARRANTIES OR REPRESENTATIONS EXPRESSED OR IMPLIED BY ANY LITERATURE, DATA, OR PERSON. GAST'S MAXIMUM LIABILITY UNDER THIS EXCLUSIVE REMEDY SHALL NEVER EXCEED THE COST OF THE SUBJECT PRODUCT AND GAST RESERVES THE RIGHT, AT ITS SOLE DISCRETION, TO REFUND THE PURCHASE PRICE IN LIEU OF REPAIR OR REPLACEMENT.

GAST WILL NOT BE RESPONSIBLE OR LIABLE FOR INDIRECT OR CONSEQUENTIAL DAMAGES OF ANY KIND, however arising, including but not limited to those for use of any products, loss of time, inconvenience, lost profit, labor charges, or other incidental or consequential damages with respect to persons, business, or property, whether as a result of breach of warranty, negligence or otherwise. Notwithstanding any other provision of this warranty, BUYER'S REMEDY AGAINST GAST FOR GOODS SUPPLIED OR FOR NON-DELIVERED GOODS OR FAILURE TO FURNISH GOODS, WHETHER OR NOT BASED ON NEGLIGENCE, STRICT LIABILITY OR BREACH OF EXPRESS OR IMPLIED WARRANTY IS LIMITED SOLELY, AT GAST'S OPTION, TO REPLACEMENT OF OR CURE OF SUCH NONCONFORMING OR NON-DELIVERED GOODS OR RETURN OF THE PURCHASE PRICE FOR SUCH GOODS AND IN NO EVENTS SHALL EXCEED THE PRICE OR CHARGE FOR SUCH GOODS. GAST EXPRESSLY DISCLAIMS ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR PURPOSE WITH RESPECT TO THE GOODS SOLD. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTIONS SET FORTH IN THIS WARRANTY, notwithstanding any knowledge of Gast regarding the use or uses intended to be made of goods, proposed changes or additions to goods, or any assistance or suggestions that may have been made by Gast personnel.

Unauthorized extensions of warranties by the customer shall remain the customer's responsibility.

CUSTOMER IS RESPONSIBLE FOR DETERMINING THE SUITABILITY OF GAST PRODUCTS FOR CUSTOMER'S USE OR RESALE, OR FOR INCORPORATING THEM INTO OBJECTS OR APPLICATIONS WHICH CUSTOMER DESIGNS, ASSEMBLES, CONSTRUCTS OR MANUFACTURES.

This warranty can be modified only by authorized Gast personnel by signing a specific, written description of any modifications.

## TROUBLESHOOTING CHART

Pressure						Possible reason
Low	High	Low vacuum	Excessive noise	Over-heating	Won't start	
x						Dirty filter.
		x				Dirty muffler.
x		x				Dirty valves. Clean or replace.
x		x				Bent/damaged valves. Replace.
x		x	x			Damaged/worn cup. Replace
x		x	x			Leaky hose.
x					x	Leaky check valve.
	x	x		x	x	Plugged vacuum or pressure line.
				x	x	Low voltage.
x						Leaky relief valve.
				x	x	Motor not wired correctly – check wiring diagram/line voltage.



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