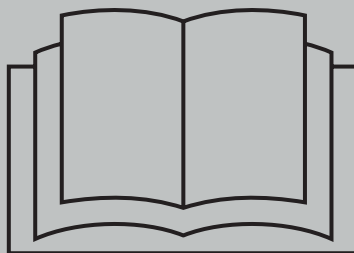


REPAIR MANUAL

H-200/4 UAP



INDEX

HEAD ASSEMBLY	5
SHELL ASSEMBLY	9
TRASMISSION PARTS	14
CONNECTING RODS	18
SELF CENTERING	19
SEAL CAGE	20
HEAD UAP	21
PISTON KIT (P-16)	23
PISTON KIT (P-18)	25
PISTON KIT (P-20)	27

HEAD ASSEMBLY



Head assembly H200/4 SAP.

Fig. 01



Mounting kit repair

Fig. 02



Put O-Ring in Basket Cap.

Fig. 03



Put Bak ring, making sure that it is to the outside as well as the chamfer Bak Ring (indicated with the pen).

Fig. 04



First side.

Fig. 05



Perform the same process on the other hand, stressing attention on the chamfer bak ring.

Fig. 06



Mounted.

Fig. 07



Fit the pressure spring (Pos. 15) in the Pressure Valve.

Fig. 08



Set mounted.

Fig. 09



Place the set in Basket Cap.

Fig. 10



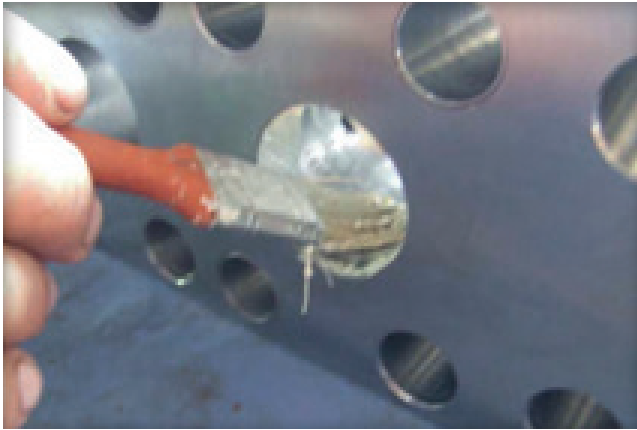
Attach the spring in Basket Cap, with the help of a key to attach it securely.

Fig. 11



Set mounted.

Fig. 12



Skip desingripante grease on the head with a brush.

Fig. 13



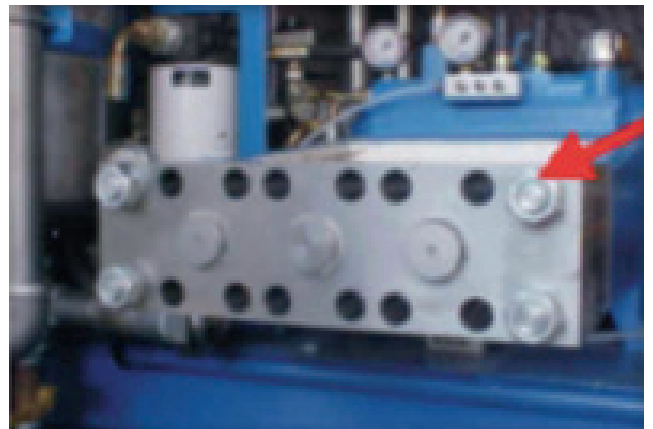
Pass desingripante grease also in Basket cap and place it on the head.

Fig. 14



Place the Basket cap on the head with the help of Nylon beater.

Fig. 15



Fix using the nuts with a torque of 320 Nm.

Fig. 16



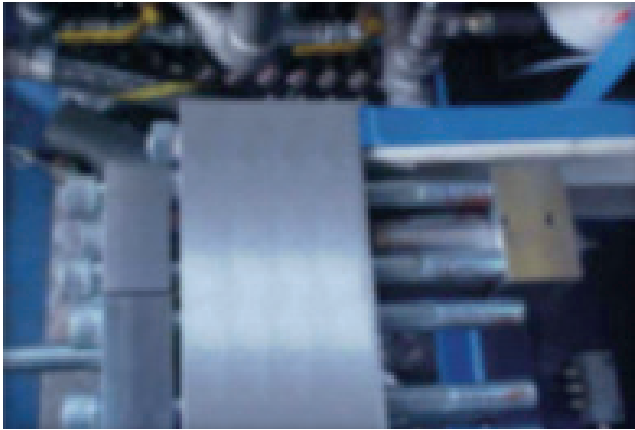
Position the flanges.

Fig. 17



Fit the flange to the head.

Fig. 18



Auto Centering mount and Piston Kit.

Fig. 19



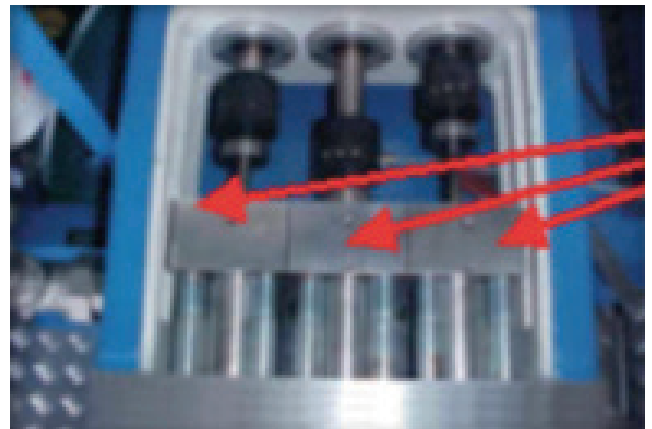
With the Assistance of an allen key, pull the screws, pressing the "X".

Fig. 20



a) With the aid of a torque wrench, tighten the screws "X", with torque of 320 Nm.
b) With the Assistance of an allen Wrench, pull the grub screws in "X".

Fig. 21



Chek alignment

M24x375 screws have capacity of 20 torques, after this amount may lose their mechanical characteristics.

Fig. 22

SHELL ASSEMBLY

For fitting shirt SAP separate the following items:

1. Piston - 2. Allen screws (12 pcs) - 3. Disk Support - 4. Vedaseal - 5. Straight Connection
6. Flange - 7. Seal Metallic - 8. O-ring - 9. Sliding Sleeve - 10. O-ring - 11. Shirt - 12. Support ring infer.
13. Scraper ring - 14. Lamela Kevlar - 15. Lamela Rami - 16. Super support ring - 17. Spring
18. Support sleeve - 19. Seal top Metallic



1° - Piston SAP dismantled.

Fig. 23



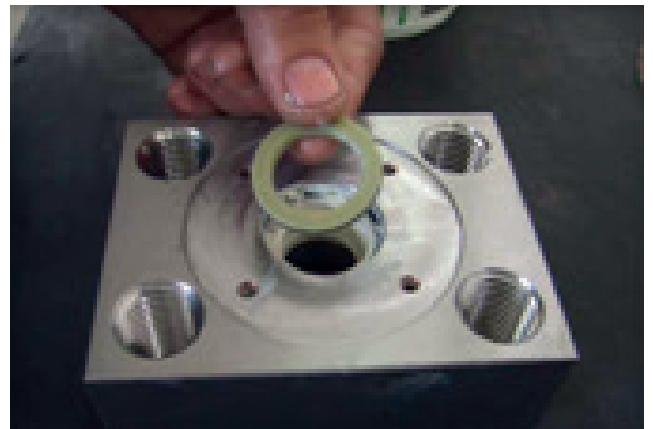
2° - Insert the Sliding Sleeve in Flange.

Fig. 24



3° - Overlap with the O-ring.

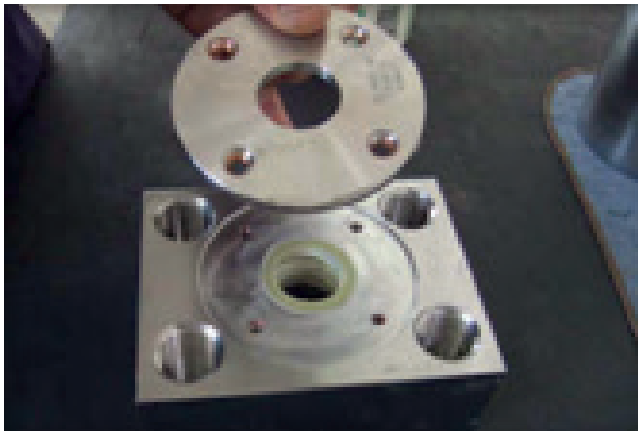
Fig. 25



4° - Enter the Vedaseal with the opening facing shirt use grease "Rocol" type for better sealing.

Fig. 26

(continues on the next page)



5° - Cover the pool using the Disk Support.

Fig. 27



6° - Screw Disk Support "X".

Fig. 28



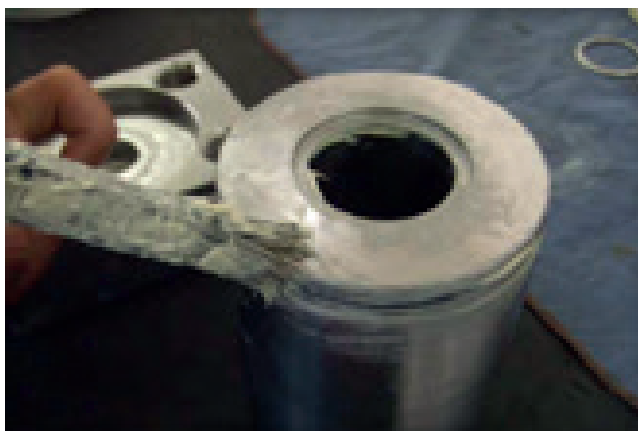
7° - Enter the O-Ring on tear shirt.

Fig. 29



8° - When installing the shirt with the flange, the O-ring will be placed in recess.

Fig. 30



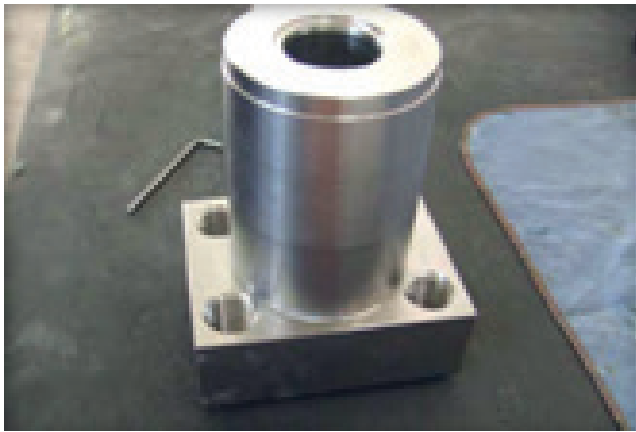
9° - Use grease type "Rocol" for better sealing.

Fig. 31



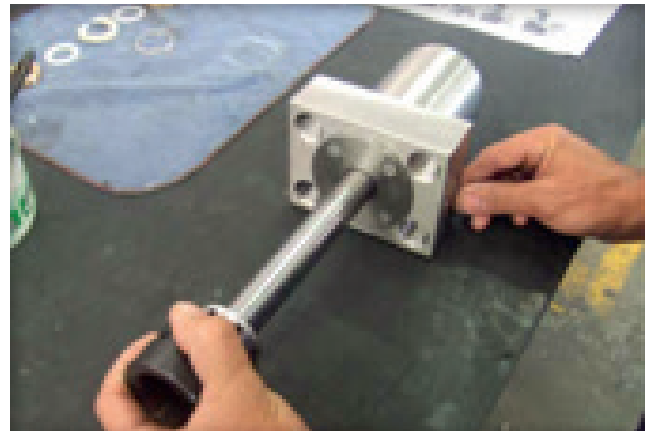
10° - Mount the shirt on SAP Flange.

Fig. 32



11°

Fig. 33



12° - Insert the piston in the set.

Fig. 34



13° - Turn the complete unit and enter the Lower support ring with the bevel facing down.

Fig. 35



14° - Use a Nylon beater to pull the components.

Fig. 36



15° - Insert the first scraper ring.

Fig. 37



16° - Use a Nylon beater to pull the components.

Fig. 38



17° - Enter Lamela Klever.

Fig. 39



18° - Use a Nylon beater to pull the components.

Fig. 40



19° - Enter Rami slide, taking care to leave 180° away from the rip and tear this the anterior lamella.

Fig. 41



20° - Use a Nylon beater to pull the components.

Fig. 42



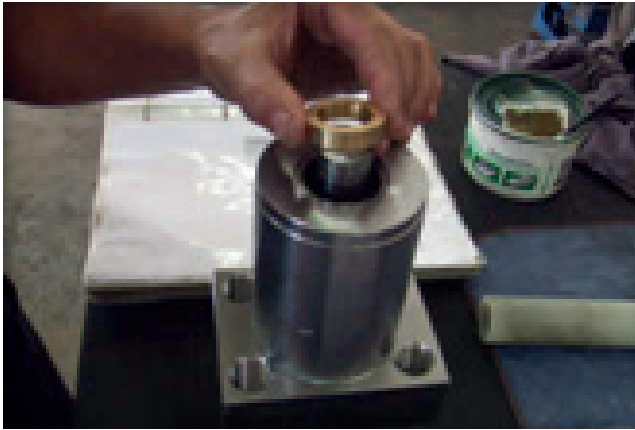
21° - Insert the other scraper ring.

Fig. 43



22° - Use a Nylon beater to pull the components.

Fig. 44



23° - Place the upper support ring (no bevel).

Fig. 45



24° - Use a Nylon beater to pull the components.

Fig. 46



25° - Insert the spring.

Fig. 47



26° - Insert the bushing Support.

Fig. 48



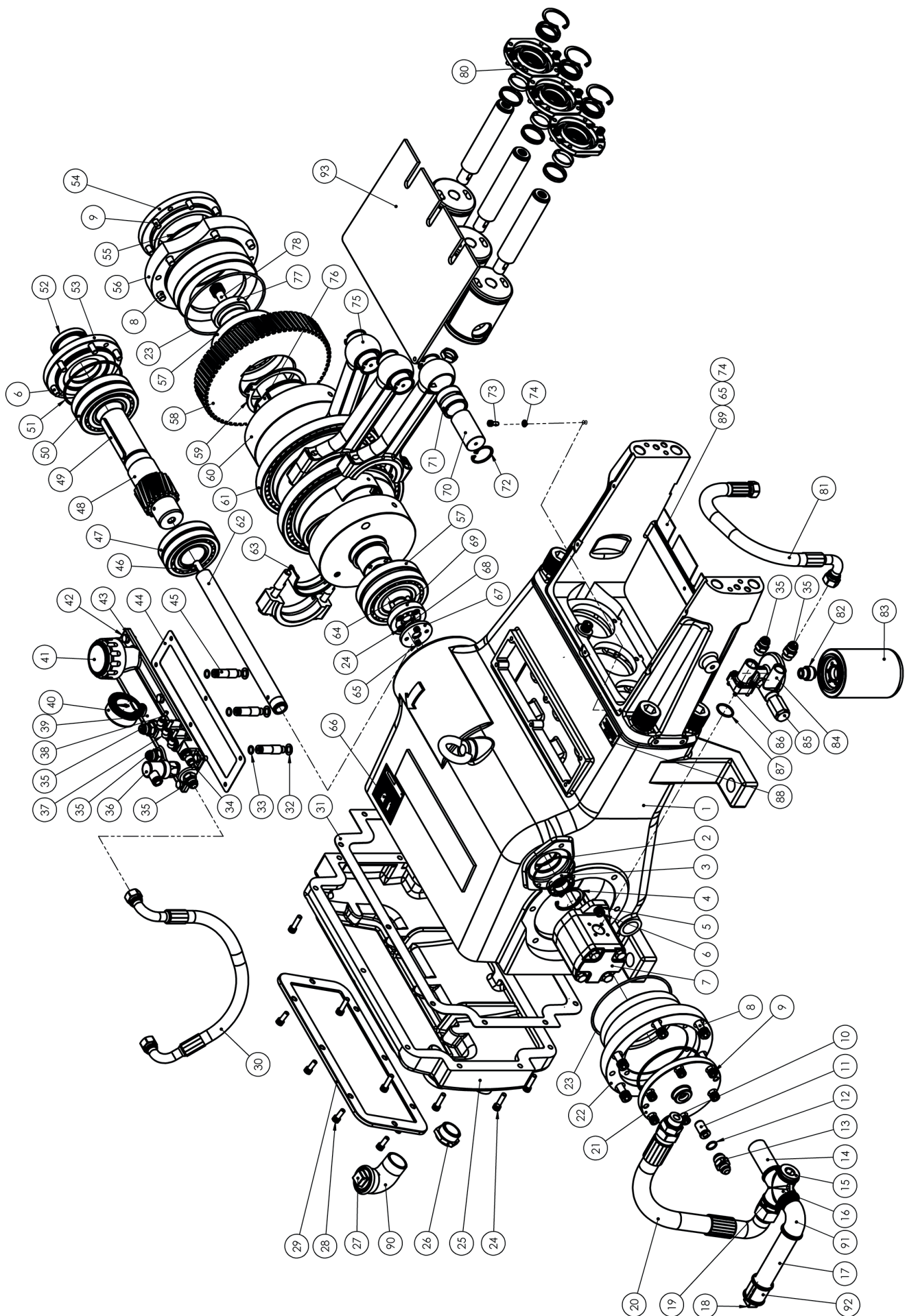
27° - Insert the upper metal seal.

Fig. 49



28° - Mounted piston.

Fig. 50

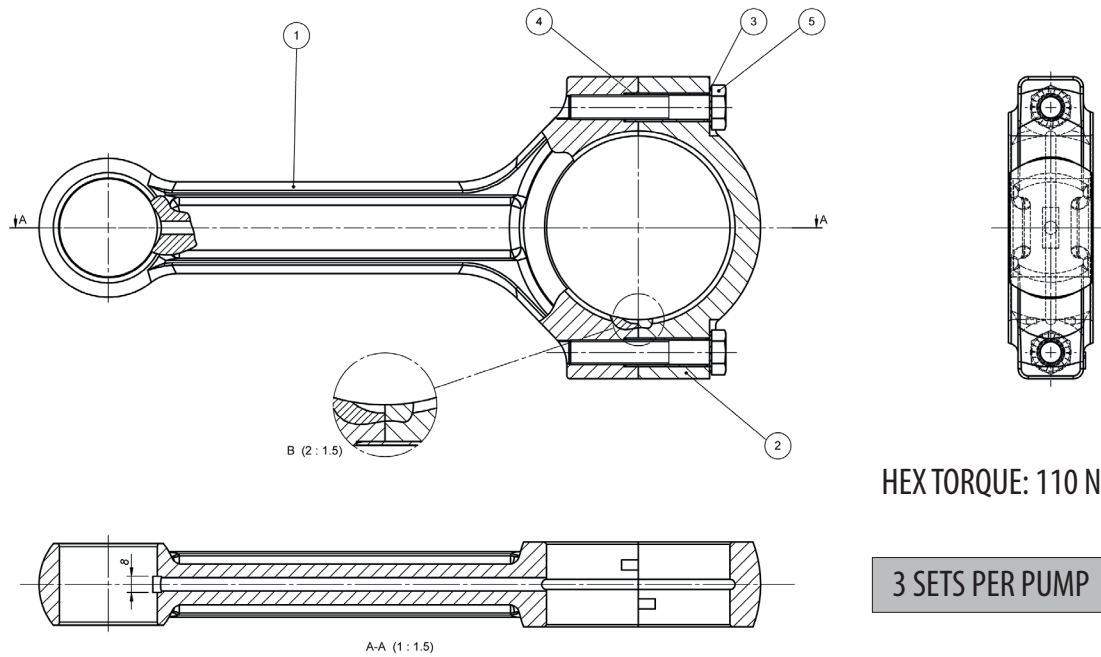


TRANSMISSION PARTS LIST H 200-4 - CODE 1010.01025.1			
ITEM	CODE	DESCRIPTION	QTY.
1	1010.01201.0	HULL H200-4	1
2	1300.00582.0	O-RING	1
3	1700.00195.0	RIGID BALL BEARING	1
4	1200.00826.0	ELASTIC RING	1
5	1200.00103.0	PRESSURE WASHER M10	2
6	1200.00140.0	ALLEN BOLT M10X25mm	8
7	3000.01773.0	LUBRICATION PUMP	1
8	1200.00184.0	ALLEN SCREW M12x30mm	12
9	1200.00229.0	ALLEN SCREW M10x20mm	12
10	2320.00992.0	NETWORK NIPPLE 1.5/16" UNF JIC X 1/16" VNF PL	1
11	1110.02304.0	GLYD ROTOR SHAFT	1
12	1300.00848.0	O-RING	1
13	2320.00778.0	M22 X 1.5 PL X 3/4" UNF JIC REDUCING NIPPLE	1
14	2370.00501.0	SCH 40 150mm PIPE	1
15	2320.01677.0	BMA 1" BSP MAGNETIC PLUG	1
16	2320.00237.0	1" BSP YOKE	1
17	2370.00501.0	SCH 40 150mm PIPE	1
18	2320.00214.0	1" BSP PLUG	1
19	2320.00667.0	1" BSP X 1.5/16" UNF NIPPLE	1
20	1010.00792.0	PUMP-OIL PUMP CONNECTION HOSE	1
21	1110.02263.0	CRANKSHAFT COVER	1
22	1110.00722.0	BEARING BOX RG L200/4	1
23	1300.00382.0	O-RING	2
24	1200.00268.0	ALLEN SCREW M8X30mm	14
25	1110.02616.0	COVER L200-4	1
26	3000.00208.0	OIL LEVEL SIGHT GLASS	1
27	2320.01611.0	1.1/4" BSP PLUG	1
28	1200.00550.0	ALLEN SCREW M8X20mm	8
29	1110.00717.0	INSPECTION HOLE COVER	1
30	1010.00731.0	DUCT-CRANKSHAFT CONNECTION HOSE	1
31	1300.00819.0	JUNTA COVER L200-4	1
32	1300.00176.0	COPPER RING	3
33	1300.00213.0	O-RING	3
34	2320.00563.0	STRAIGHT CONNECTION 1/4"x10mm	1
35	2320.00283.0	NIPPLE 3/4" UNF PI x 3/4" UNF JIC	5
36	1010.01074.0	PRESSURE SWITCH	1
37	2320.00309.0	ADJUSTABLE L CONNECTION 1/4"x6mm	3
38	2370.00605.0	HOSE PU Ø6mm	1
39	1110.03092.0	LUBRICATION DUCT	1
40	3000.00321.0	PRESSURE GAUGE	1
41	3000.00119.0	BREATHER 1" BSP	1
42	1200.00828.0	HEX SCREW M8x20mm	6

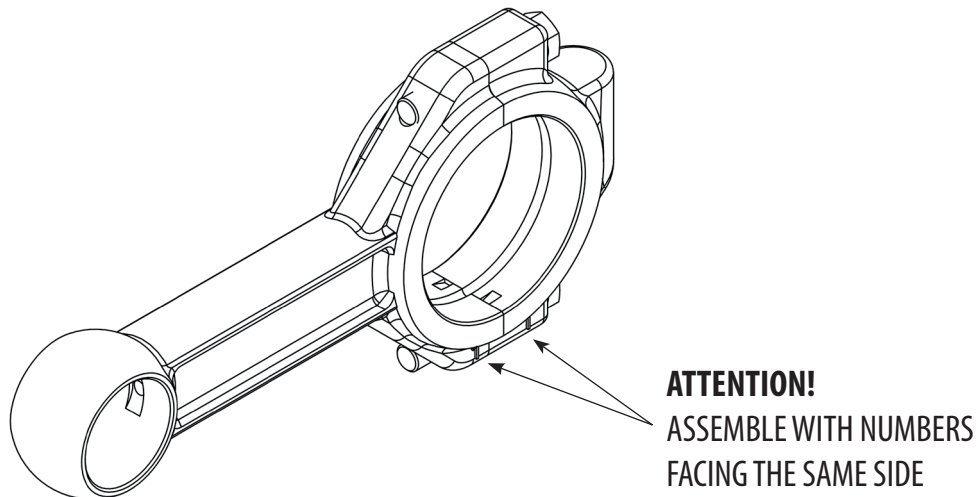
TRANSMISSION PARTS LIST H 200-4 - CODE 1010.01025.1			
ITEM	CODE	DESCRIPTION	QTY.
43	1200.00402.0	FLAT WASHER M8	6
44	1300.00224.0	OIL DUCT GASKET	1
45	1110.02620.0	DUCT CONNECTING PIPE	3
46	1200.00300.0	WOODRUFF KEY	1
47	1700.00138.0	BEARING	1
48	1110.02433.0	PINION H200-4	1
49	1200.00853.0	COAT HANGER	1
50	1700.00131.0	ROTO GLYD BACKBOARD BEARING	1
51	1300.00820.0	O-RING	1
52	1300.00336.0	BEARING	1
53	1110.02630.0	TRANSMISSION AXIS	1
54	1110.00697.0	CRANKSHAFT COVER	1
55	1300.00381.0	O-RING	2
56	1110.00917.0	BEARING BOX H200/4	1
57	1700.00115.0	ROTO GLYD BACKBOARD BEARING	2
58	1110.02214.0	CRANKSHAFT GEAR H200-4	1
59	1200.00181.0	ELASTIC RING E-110	1
60	1010.00772.0	CRANKSHAFT H200-4	1
61	1700.00128.0	BEARING	2
62	1110.02621.0	EXPANDER	1
63	1700.00125.0	BEARING SHELL	3
64	1300.00254.0	O-RING	1
65	1200.00161.0	ALLEN SCREW M6X12mm	5
66	3000.00120.0	NAMEPLATE	1
67	1110.01104.0	ROTO GLYD COVER	1
68	1300.00502.0	ROTO GLYD	1
69	1110.02270.0	BEARING SUPPORT H200-4	1
70	1100.00196.0	ROD PIN	3
71	1700.00135.0	ROD BUSHING	3
72	1200.00278.0	ELASTIC RING 1-39	6
73	1200.00265.0	ALLEN SCREW M6X15mm	1
74	1200.00191.0	FLAT WASHER M6	4
75	1010.01098.0	ROD H200-4	3
76	1200.00178.0	LINCHPIN	1
77	1110.00368.0	BEARING RING	1
78	1200.00186.0	ALLEN SCREW M16X40mm	1
79	1010.00885.0	GUIDE PISTON	3
80	1010.01097.0	SEAL CAGE	3
81	1010.01489.0	MANIFOLD-DUCT CONNECTION HOSE	1
82	2320.01708.0	3/4" BSP X 3/4" UNF REDUCING NIPPLE	1
83	3000.02147.0	OIL FILTER	1

TRANSMISSION PARTS LIST H 200-4 - CODE 1010.01025.1			
ITEM	CODE	DESCRIPTION	QTY.
84	1110.03036.0	LUBRICATION MANIFOLD	1
85	3000.01020.0	RELIEF VALVE	1
86	1200.00222.0	ALLEN SCREW M6X25mm	4
87	1300.00256.0	O-RING	1
88	3000.01794.0	TORQUE NAMEPLATE	1
89	1110.03223.0	PISTON COVER	1
90	2320.01610.0	1.1/4" BSP ELBOW	1
91	2320.00229.0	MF 1" BSP ELBOW	1
92	2320.00924.0	1" BSP SLEEVE	1
93	1110.00840.0	PISTION COVER	1

CONNECTING RODS - CODE 1010.01098.0



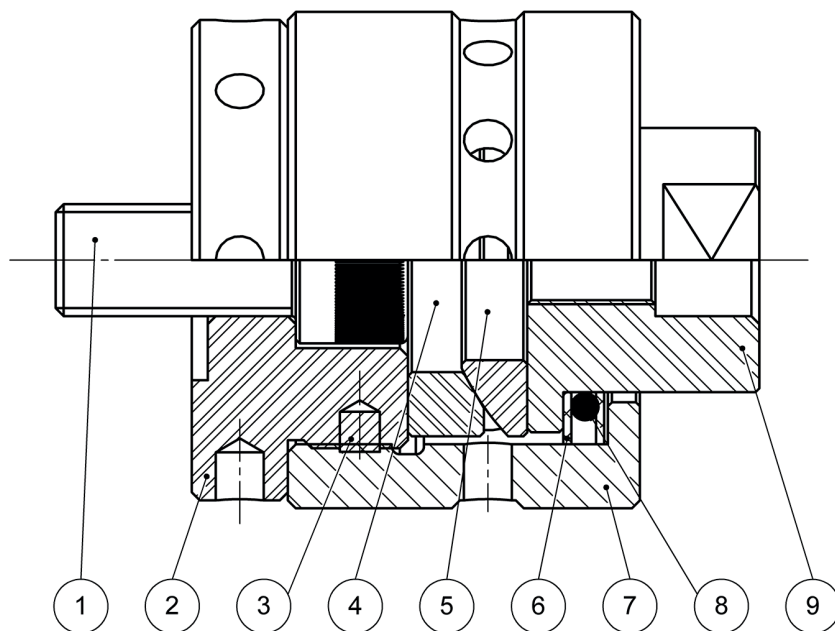
ITEM	CODE	DESCRIPTION	QTY.
1	1110.02212.0	ARM OF CONNECTING ROD + ROD CAP	1
2			
3	1200.00190.0	TOOTHED WASHER M12	2
4	1200.00881.0	ELASTIC GUIDE BUSHING	2
5	1200.00187.0	HEX BOLT M12X70	2



⚠ Attention!

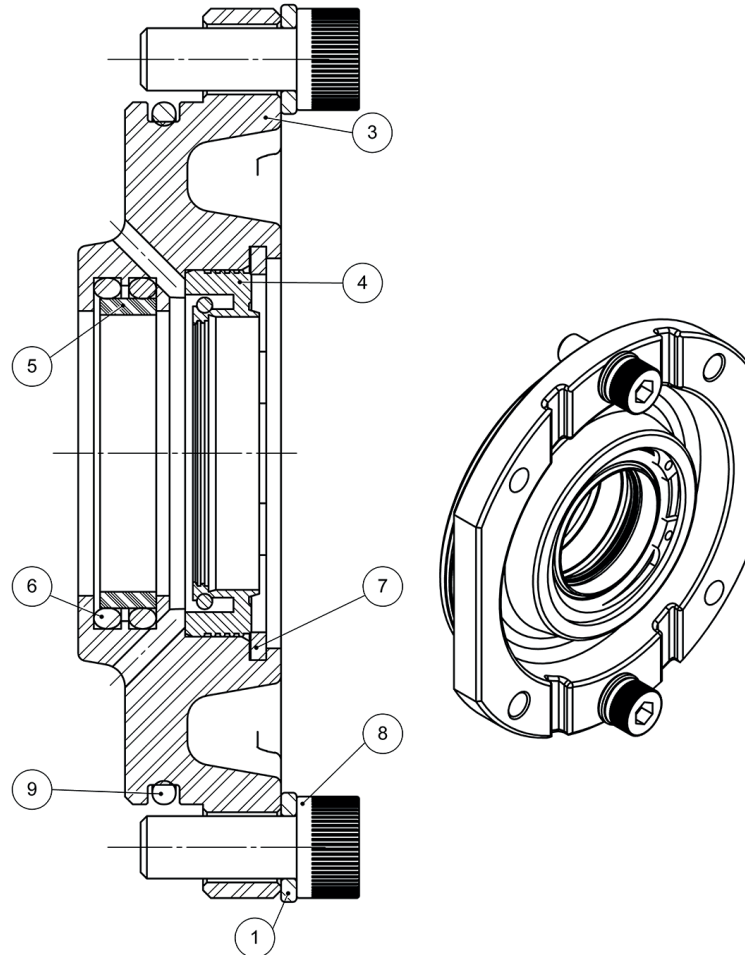
- ▶ All connecting rods are numbered.
- ▶ Always assemble arm and bearing of the connecting rod so that the unsequenced number is shown.
- ▶ Never replace arms and bearing by a connecting rod from a different set.

SELF CENTERING - CODE 1010.00268.0

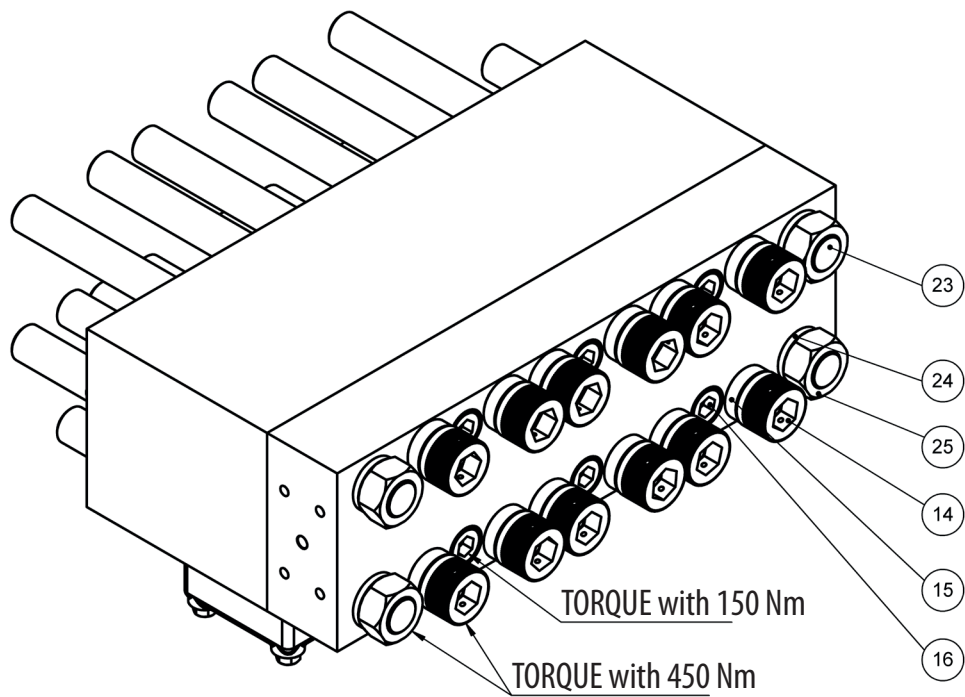
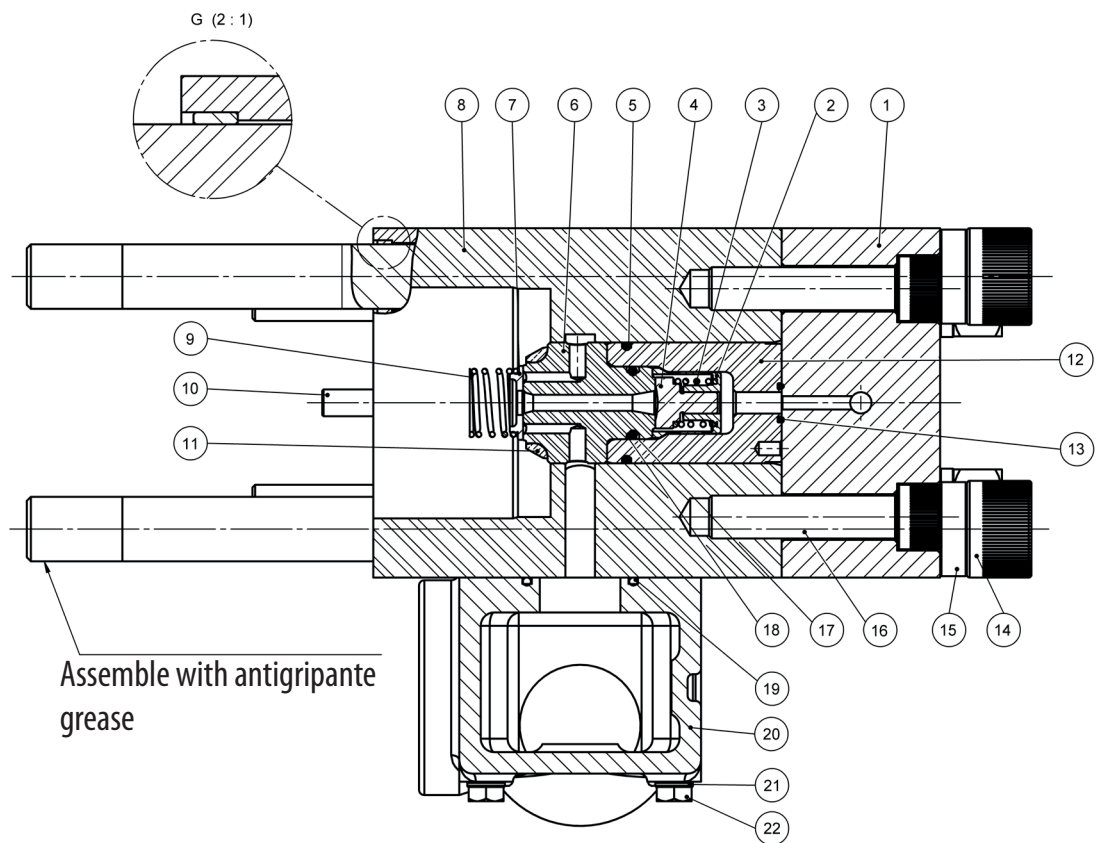


ITEM	CODE	DESCRIPTION	QTY.
1	1200.00297.0	ALLEN SCREW M14x30 DIN 919	1
2	1110.00719.0	SELF CENTERING P-14 / P-30	1
3	2380.01467.0	SPIGOT	1
4	1110.00631.0	SPHERICAL RING	1
5	1110.00630.0	SPHERICAL RING	1
6	1110.00724.0	BACK UP RING	2
7	1110.00721.0	SELF CENTERING SCREW	1
8	1300.00361.0	O-RING	1
9	1110.00820.0	CONECT BUSHING	1

SEAL CAGE - CODE 1010.01097.0



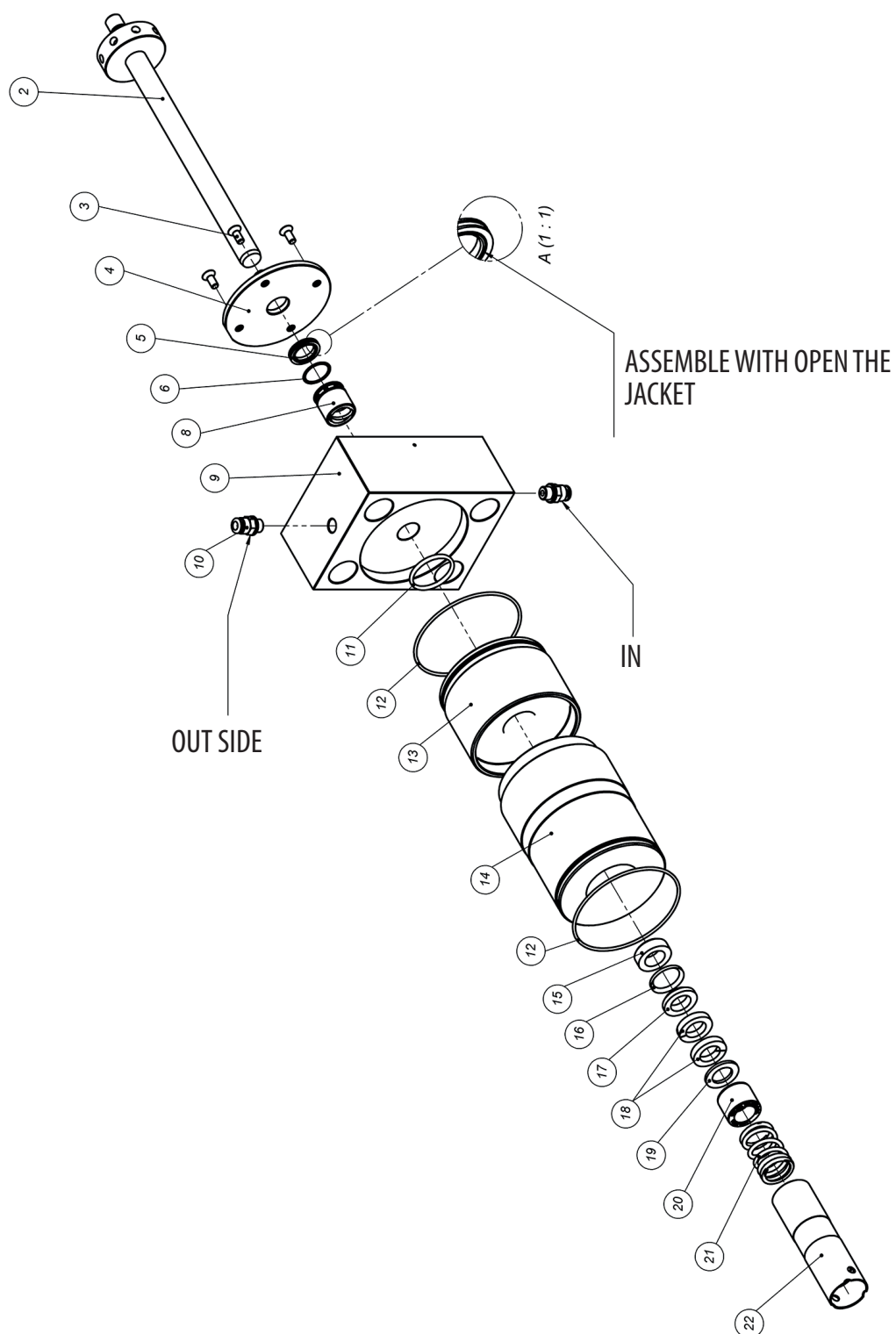
*	ITEM	CODE	DESCRIPTION	QTY.
	1	1200.00107.0	PRESSURE WASHER	2
* Note: Common wear parts or disposable				
	3	1110.02618.0	SEAL CAGE	1
	4	1300.00750.0	SEAL	1
	5	1300.00751.0	SLIDING RING	1
	6	1300.00191.0	O-RING	2
	7	1200.00154.0	ELASTIC RING	1
	8	1200.00550.0	ALLEN SCREW M8X20mm	2
	9	1300.00117.0	O-RING	1



HEAD UAP PARTS LIST - CODE 1010.01485.0				
NOTE	ITEM	CODE	DESCRIPTION	QTY.
	1	1110.01186.0	MANIFOLD	1
	2	1110.01195.0	GUIDE SPRING UAP	3
*	3	1500.00145.0	SPRING	3
*	4	1100.00179.0	PRESSURE VALVE UAP	3
	5	1300.00601.0	O-RING	3
*	6	1100.00224.0	DOUBLE SEAT UAP	3
*	7	1100.00180.0	SUCTION VALVE UAP	3
	8	1010.01120.0	HEAD UAP III	1
*	9	1500.00144.0	SPRING	3
	10	1200.00369.0	GUIDE PIN	2
*	11	1300.00576.0	SUCTION SEAL UAP-III 40K	3
*	12	1110.01279.0	COVER	3
	13	1300.00146.0	O-RING	3
	14	1200.00384.0	ALLEN SCREW M24x350mm	12
	15	1110.01309.0	DISTANCE BUSHING	12
	16	1200.00186.0	ALLEN SCREW M16X40mm	6
	17	1300.00443.0	O-RING	3
	18	1300.00406.0	BACK RING	3
	19	1300.00193.0	O-RING	3
	20	1110.01677.0	SUCTION DUTE	1
	21	1200.00107.0	PRESSURE WASHER	8
	22	1200.00726.0	SCREW M8x90mm	8
	23	1200.00375.0	PRISIONER M24x280mm	4
	24	1200.00363.0	PRESSURE WASHER	4
	25	1200.00149.0	NUT	4
		1020.00133.1	REPAIR KIT	1

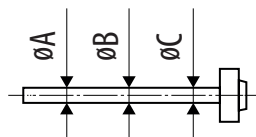
Note: * Common wear parts.

REPAIR KIT – CODE 1020.00133.1				
NOTE	ITEM	CODE	DESCRIPTION	QTY.
	5	1300.00601.0	O-RING	3
	12	1110.01279.0	COVER	3
	18	1300.00406.0	BACK RING	3
	19	1300.00193.0	O-RING	3



REPLACE SEAL KIT EVERY 500 HOURS TO ENSURE SMOOTH EQUIPMENT OPERATION

NOTE: THE WATER QUALITY DIRECTLY INFLUENCES SEAL LIFECYCLE AND CHANGING TIME MUST BE REDUCED.



Ø Nominal	Appropriate	Critical	Change
16 mm	-0,01	-0,07	-0,1
	-0,06	-0,09	

ANALYSE PISTON DIMENSIONS WHEN CHANGING THE SEALS OR EVERY 500 HOURS RESPECT THE WEAR LIMIT.

PISTON KIT P-16 UAP PARTS LIST - CODE 1010.01286.1

NOTE	ITEM	CODE	DESCRIPTION	QTY.
	1	1010.00274.0	PISTON P-16	3
	2	1200.00327.0	ALLEN SCREW	12
	3	1110.00823.0	SUPPORT DISC	3
***	6	1010.00444.0	BUSHING	3
	7	1110.01360.0	FLANGE P-16	3
	8	2320.003030.	STRAIGHT CONNECTION	6
	10	1300.00242.0	O-RING	6
	11	1110.03266.0	FLANGE	3
	12	1110.03160.0	JACKET UAP	3
**	19	1500.00193.0	PISTON KIT SPRING	3
	20	1010.01285.0	SUCTION SPRING GUIDE	3
		1020.00216.2	SEAL KIT P-16 UAP	1

Note: * Common wear parts.

Note: ** Replace with 1000h.

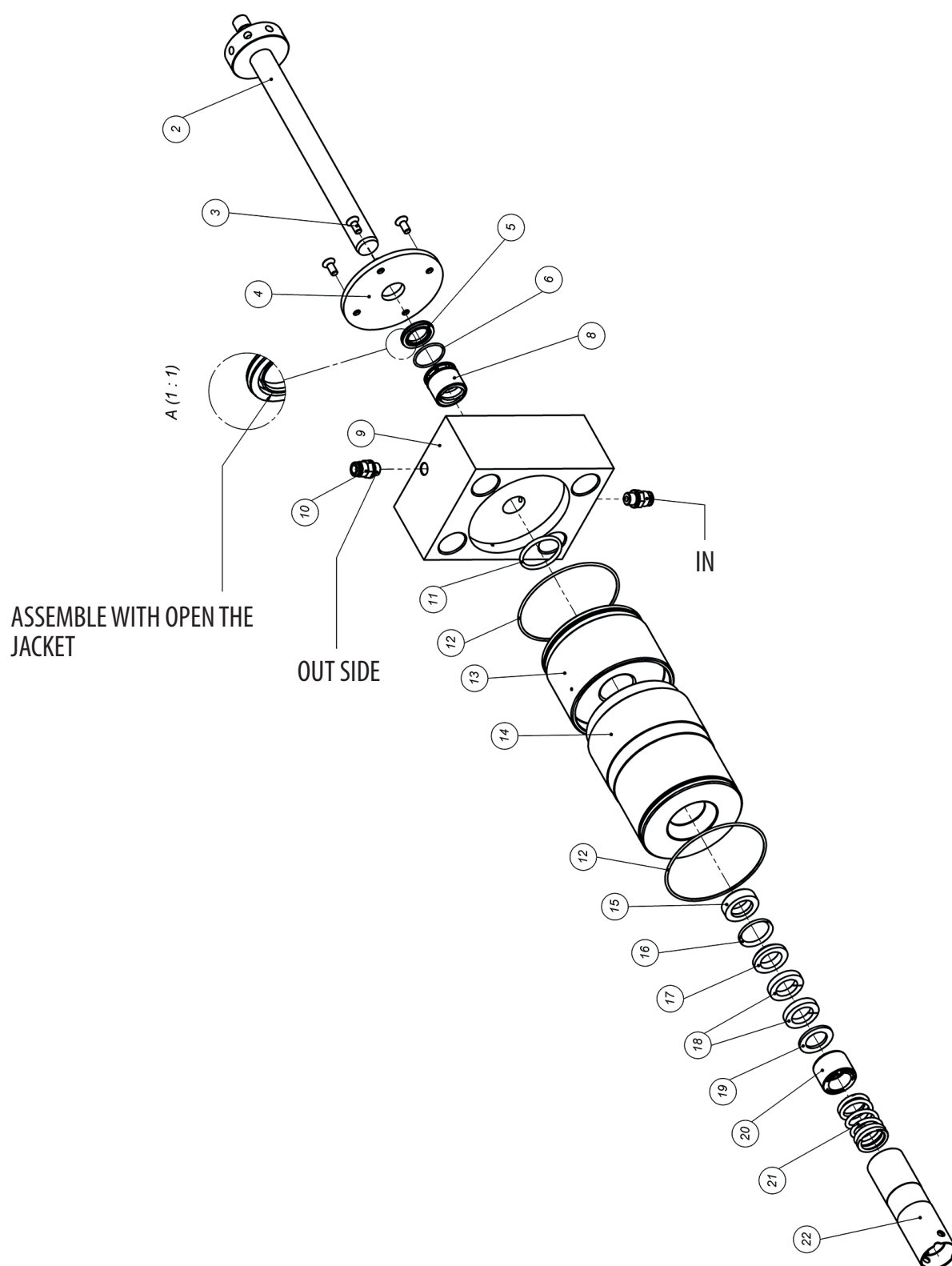
Note: *** Replace with 500h, or with wear parts.

SEAL KIT P-16 UAP PARTS LIST - CODE 1020.00216.2

NOTE	ITEM	DESCRIPTION	QTY.
*	4	VEDASEAL P-16	3
*	5	O-RING	3
*	9	O-RING	3
*	13	LOWER SUPPORT RING P-16	3
*	14	BACKUP RING	3
*	15	UAP SEAL P-16	3
*	16	BLACK LAMELA	6
*	17	SCRAPER RING P-16	3
*	18	UPPER SUPPORT RING P-16	3

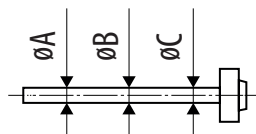
CAUTION!

ALL SEAL KITS INCLUDE VEDASEAL HOWEVER; MAY BE PURCHASED SEPARATELY.



REPLACE SEAL KIT EVERY 500 HOURS TO ENSURE SMOOTH EQUIPMENT OPERATION

NOTE: THE WATER QUALITY DIRECTLY INFLUENCES SEAL LIFECYCLE AND CHANGING TIME MUST BE REDUCED.



Ø Nominal	Appropriate	Critical	Change
18 mm	-0,01	-0,07	-0,1
	-0,06	-0,09	

ANALYSE PISTON DIMENSIONS WHEN CHANGING THE SEALS OR EVERY 500 HOURS RESPECT THE WEAR LIMIT.

PISTON KIT P-18 UAP PARTS LIST - CODE 1010.01412.1

NOTE	ITEM	CODE	DESCRIPTION	QTY.
	1	1010.00275.0	PISTON P-18	3
	2	1200.000327.0	ALLEN SCREW	12
	3	1110.00824.0	SUPPORT DISC	3
***	6	1010.00471.0	BUSHING	3
	7	1110.01399.0	FLANGE P-18	3
	8	2320.00303.0	STRAIGHT CONNECT	6
	10	1300.00242.0	O-RING	6
	11	1110.03159.0	SEAL FLANGE	3
	12	1110.03160.0	JACKET UAP	3
**	19	1500.00193.0	PISTON KIT SPRING	3
	20	1010.01285.0	SUCTION SPRING GUIDE	3
		1020.00218.5	SEAL KIT P-18 UAP	1

Note: * Common wear parts.

Note: ** Replace with 1000h.

Note: *** Replace with 500h, or with wear parts.

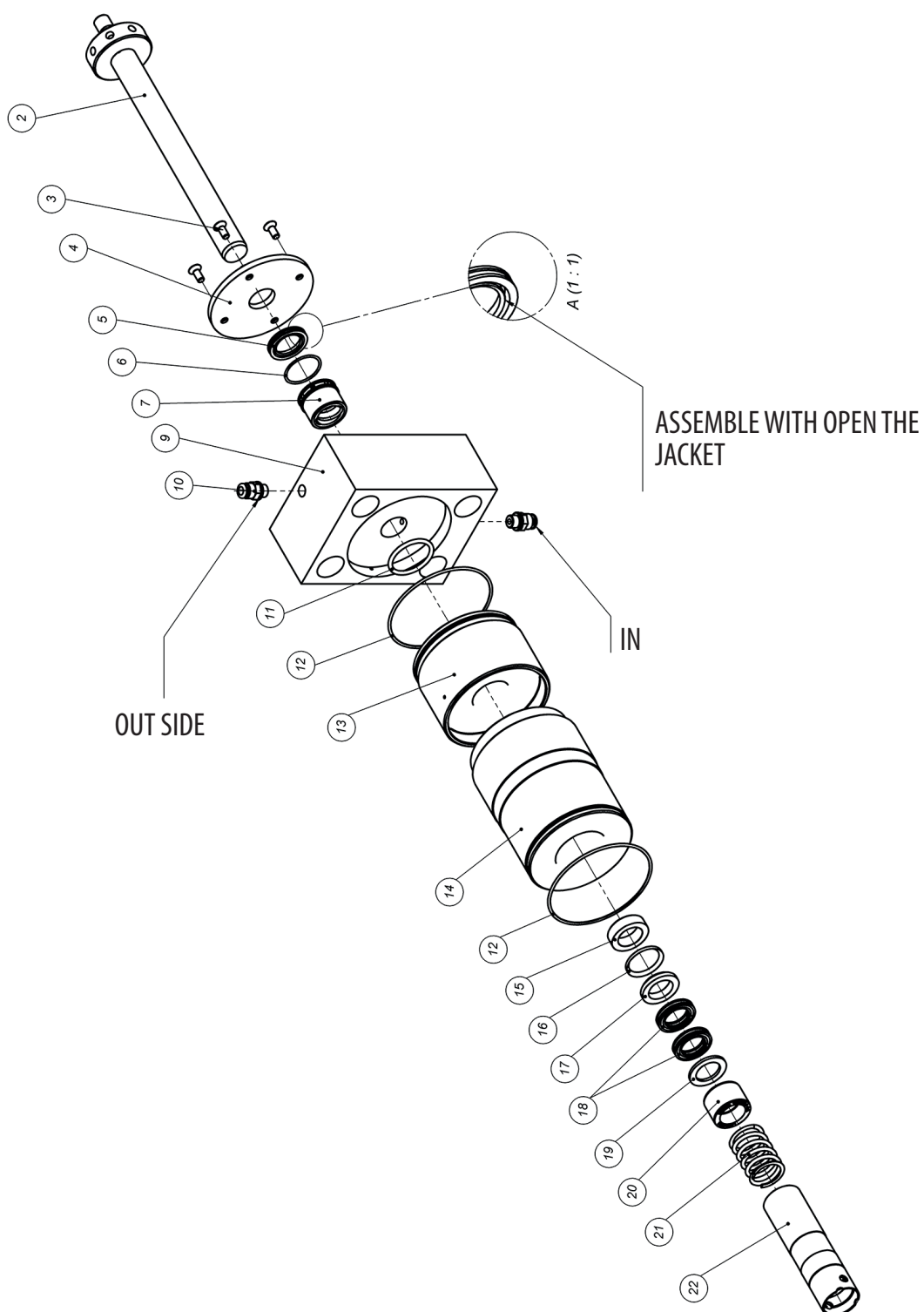
SEAL KIT P-18 UAP PARTS LIST - CODE 1020.00218.5

NOTE	ITEM	DESCRIPTION	QTY.
*	4	VEDASEAL P-18	3
*	5	O-RING	3
*	9	O-RING	3
*	13	LOWER SUPPORT RING P-18	3
*	14	BACKUP RING	3
*	15	UAP SEAL P-18	3
*	16	BLACK LAMELA	6
*	17	SCRAPER RING P-18	3
*	18	UPPER SUPPORT RING P-18	3

CAUTION!

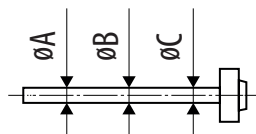
ALL SEAL KITS INCLUDE VEDASEAL HOWEVER; MAY BE PURCHASED SEPARATELY.

PISTON KIT (P-20) - CODE 1010.01115.1



REPLACE SEAL KIT EVERY 500 HOURS TO ENSURE SMOOTH EQUIPMENT OPERATION

NOTE: THE WATER QUALITY DIRECTLY INFLUENCES SEAL LIFECYCLE AND CHANGING TIME MUST BE REDUCED.



Ø Nominal	Appropriate	Critical	Change
20 mm	-0,01	-0,07	-0,1
	-0,06	-0,09	

ANALYSE PISTON DIMENSIONS WHEN CHANGING THE SEALS OR EVERY 500 HOURS RESPECT THE WEAR LIMIT.

PISTON KIT P-20 UAP PARTS LIST - CODE 1010.01115.1

NOTE	ITEM	CODE	DESCRIPTION	QTY.
	1	1010.01038.0	PISTON P-20	3
	2	1200.000327.0	ALLEN SCREW	12
	3	1110.00855.0	SUPPORT DISC P-20	3
***	6	1010.01036.0	BUSHING	3
	7	1110.02546.0	FLANGE P-20	3
	8	2320.00303.0	STRAIGHT CONNECT	6
	10	1300.00242.0	O-RING	6
	11	1110.03253.0	SEAL FLANGE	3
	12	1110.03160.0	JACKET UAP	3
**	19	1500.00206.0	PISTON KIT SPRING	3
	20	1110.03037.0	SUCTION SPRING GUIDE	3
		1020.00220.1	SEAL KIT P-20 UAP	1

Note: * Common wear parts.

Note: ** Replace with 1000h.

Note: *** Replace with 500h, or with wear parts.

SEAL KIT P-20 UAP PARTS LIST - CODE 1020.00220.1

NOTE	ITEM	DESCRIPTION	QTY.
*	4	VEDASEAL P-20	3
*	5	O-RING	3
*	9	O-RING	3
*	13	LOWER SUPPORT RING P-20	3
*	14	BACKUP RING	3
*	15	UAP SEAL P-20	3
*	16	BLACK LAMELA	6
*	17	SCRAPER RING P-20	3
*	18	UPPER SUPPORT RING P-20	3

CAUTION!

ALL SEAL KITS INCLUDE VEDASEAL HOWEVER; MAY BE PURCHASED SEPARATELY.

NOTE: _____

[illegible]



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