

TABLE 1: ROTOR CLEARANCE FOR U1 & U2 PUMPS

U1 & U2 Model	A - Back Face in (mm)		B - Rotor to Body in (mm)		C - Front Face in (mm)	
	Std & FF	Hot	Std & FF	Hot	Std	FF & Hot
006	0.0015 - 0.002 (0.04 - 0.05)	0.0015 - 0.002 (0.04 - 0.05)	0.001 - 0.004 (0.03 - 0.10)	0.0025 - 0.0055 (0.06 - 0.14)	0.004 - 0.006 (0.10 - 0.15)	0.0055 - 0.0075 (0.14 - 0.19)
014, 015, 018, 024 (U1 only)	0.0015 - 0.002 (0.04 - 0.05)	0.0015 - 0.002 (0.04 - 0.05)	0.001 - 0.004 (0.03 - 0.10)	0.0025 - 0.0055 (0.06 - 0.14)	0.004 - 0.0065 (0.10 - 0.17)	0.006 - 0.0085 (0.15 - 0.22)
030, 033A (U1 only), 034, 040	0.002 - 0.0025 (0.05 - 0.06)	0.002 - 0.0025 (0.05 - 0.06)	0.001 - 0.005 (0.03 - 0.13)	0.0025 - 0.006 (0.06 - 0.15)	0.0035 - 0.006 (0.09 - 0.15)	0.0065 - 0.009 (0.17 - 0.23)
045 (U2 only), 060, 064	0.003 - 0.0035 (0.08 - 0.09)	0.003 - 0.0035 (0.08 - 0.09)	0.003 - 0.0075 (0.08 - 0.19)	0.005 - 0.010 (0.13 - 0.25)	0.0045 - 0.009 (0.11 - 0.23)	0.0085 - 0.014 (0.22 - 0.36)
133A (U1 only), 130, 134	0.003 - 0.0035 (0.08 - 0.09)	0.003 - 0.0035 (0.08 - 0.09)	0.0035 - 0.0075 (0.09 - 0.19)	0.0055 - 0.0095 (0.14 - 0.24)	0.0045 - 0.009 (0.11 - 0.23)	0.009 - 0.015 (0.23 - 0.38)
180 (U2 only), 184 (U2 only), 220, 223A (U1 only), 224	0.004 - 0.005 (0.10 - 0.13)	0.004 - 0.005 (0.10 - 0.13)	0.0055 - 0.0095 (0.14 - 0.24)	0.009 - 0.015 (0.23 - 0.38)	0.005 - 0.010 (0.13 - 0.25)	0.010 - 0.015 (0.25 - 0.38)
210 (U2 only), 213 (U2 only), 214 (U2 only), 320, 323 (U2 only), 323A (U1 only), 324	0.005 - 0.006 (0.13 - 0.15)	0.005 - 0.006 (0.13 - 0.15)	0.008 - 0.012 (0.20 - 0.30)	0.010 - 0.014 (0.25 - 0.36)	0.007 - 0.012 (0.18 - 0.30)	0.013 - 0.018 (0.33 - 0.46)

FIGURE 1: FOR U1 & U2 PUMPS

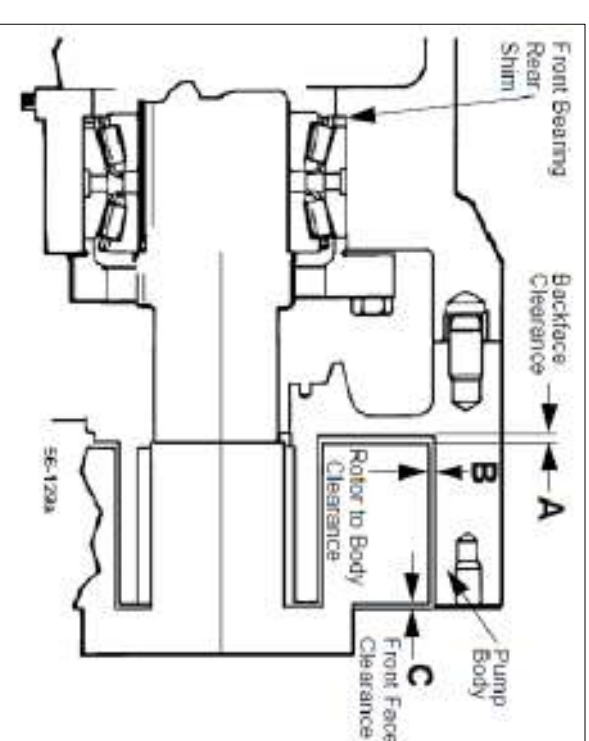


TABLE 2: ROTOR CLEARANCE FOR U3 PUMPS

U3 Model	A - Back Face in (mm)		B - Rotor to Body in (mm)		C - Front Face in (mm)	
	Low Viscosity	Standard	Low Viscosity	Standard	Low Viscosity	Standard
006	0.0025 - 0.004 (0.06 - 0.10)	0.0035 - 0.005 (0.09 - 0.13)	0.001 - 0.004 (0.03 - 0.10)	0.0025 - 0.0055 (0.06 - 0.14)	0.004 - 0.005 (0.10 - 0.13)	0.0045 - 0.0055 (0.11 - 0.14)
015, 018	0.0025 - 0.0045 (0.06 - 0.11)	0.003 - 0.005 (0.08 - 0.13)	0.001 - 0.004 (0.03 - 0.10)	0.0025 - 0.0055 (0.06 - 0.14)	0.004 - 0.005 (0.10 - 0.13)	0.0055 - 0.0065 (0.14 - 0.17)
030, 040	0.002 - 0.004 (0.05 - 0.10)	0.0035 - 0.0055 (0.09 - 0.14)	0.001 - 0.005 (0.03 - 0.13)	0.0025 - 0.006 (0.06 - 0.15)	0.0045 - 0.0055 (0.11 - 0.14)	0.006 - 0.007 (0.15 - 0.18)
045, 060	0.003 - 0.007 (0.08 - 0.18)	0.004 - 0.008 (0.10 - 0.20)	0.003 - 0.0075 (0.08 - 0.19)	0.005 - 0.010 (0.13 - 0.25)	0.0055 - 0.0075 (0.14 - 0.19)	0.0085 - 0.0105 (0.22 - 0.27)
130	0.003 - 0.007 (0.08 - 0.18)	0.004 - 0.008 (0.10 - 0.20)	0.0035 - 0.0075 (0.09 - 0.19)	0.0055 - 0.0095 (0.14 - 0.24)	0.006 - 0.007 (0.15 - 0.18)	0.009 - 0.0115 (0.23 - 0.29)
180, 220	0.004 - 0.008 (0.10 - 0.20)	0.005 - 0.009 (0.13 - 0.23)	0.0055 - 0.0095 (0.14 - 0.24)	0.009 - 0.013 (0.23 - 0.33)	0.006 - 0.008 (0.15 - 0.20)	0.010 - 0.012 (0.25 - 0.30)
210, 320	0.005 - 0.009 (0.13 - 0.23)	0.007 - 0.011 (0.18 - 0.28)	0.008 - 0.012 (0.20 - 0.30)	0.010 - 0.014 (0.25 - 0.36)	0.008 - 0.010 (0.20 - 0.25)	0.012 - 0.014 (0.30 - 0.36)

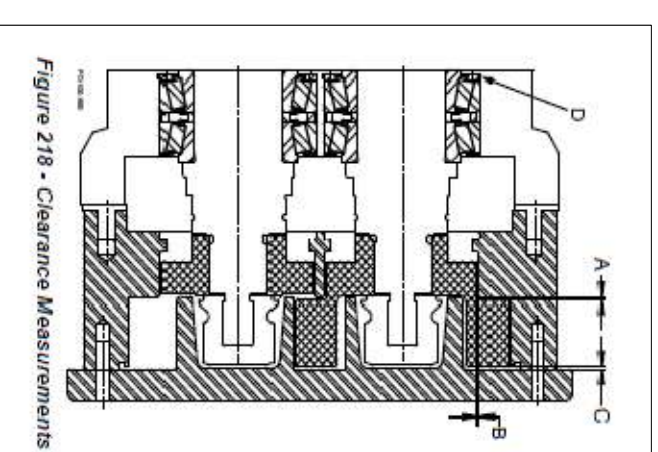
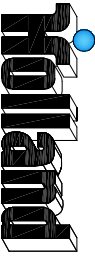


FIGURE 2: FOR U3 PUMPS



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P.O. NO. PROJECT LOCATION DOCUMENT CODE

**COMMON SURFACE FINISHES  
ROTOR CLEARANCES**

W.O. NUMBER: DUE DATE: QUANTITY: MATERIAL: 316L

INTERIOR FINISH: 32 Ra (150 GRIT) EXTERIOR FINISH: 32 Ra (150 GRIT)

DRAWING NUMBER: **13975 - 001** REVISION: A

SCALE: NTS TITLE: - PAGE: (1) OF (1)

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