



ROLEC DH45 Series

Operation and Maintenance Manual



Introduction..... 3
 Introduction 3
 General Information 3
 Shipping Damage or Loss 3
 Pump Receiving 3
 Safety 3

Operation..... 4
 Unit Overview 4
 Specifications 4
 Parts Overview 5
 Suggested Use 6
 Unit Configuration 7
 Electrical 8
 VFD Manual 8
 Operation 9

Maintenance 11
 Maintenance 11

Troubleshooting 12

Ampco Pumps Terms and Conditions 13

Return Policy..... 16

Introduction

To ensure the best results and service, please read and fully understand this manual prior to putting the unit into service. For any questions regarding operation or maintenance please contact your local distributor or Ampco Pumps Company:

*Ampco Pumps Company
2045 W. Mill Road
Glendale, WI 53209
Phone: (800) 737-8671 or (414) 643-1852
Fax: (414) 643-4452
Email: ampcoocs@ampcopumps.com*

General Information

Ampco's ROLEC DH utilizes a SBI shear pump to recirculate a fermenter and simultaneously induce hop pellets into the stream of beer. The hop pellets remain dry until they meet the stream of beer. The DH45 utilizes an open top hopper with a CO₂ buffer.

Shipping Damage or Loss

Upon receiving equipment that is damaged or if your shipment is lost in transit, immediately file a claim with the carrier. At time of pick-up, the carrier signed the bill of lading, acknowledging that they have received the product from Ampco in good condition.

Pump Receiving

When applicable, Ampco covers the pump inlet and discharge ports prior to shipping, ensuring that foreign matter does not enter the pump during shipment. If the protective covers are missing upon arrival, remove the pump cover and inspect to ensure it is free from contaminate before turning the shafts. Please make note of the serial number; this will assist in the process of ordering replacement parts and/or a warranty claim. For more information regarding shipment damage or warranty, please refer to Terms and Conditions (page 13).

Safety

IMPORTANT: ALWAYS WEAR SAEFTY GLASSES WHEN OPERATING THIS UNIT. Read and understand this manual BEFORE operation or maintenance of the unit. Improper operation or maintenance may result in severe injury or death. Equipment damage caused by user neglect will invalidate the warranty.

There are safety symbols used throughout this manual identifying safety concerns.



WARNING: Hazards or unsafe practices that COULD result in severe personal injury or death, and how to avoid them.

CAUTION: Hazards or unsafe practices that COULD result in minor personal injury or damage to product or property.

Unit Overview

- The SBI shear pump allows recirculation of the fermenter and induction/chopping of hop pellets and any other ingredients that are induced.
- Once recirculation is established, pellets can be drawn into the tee and then introduced into the stream of beer.
- The pellets are chopped in the SBI shear pump and introduced into the fermenter.
- Recirculation continues as desired after pellets are induced.

Specifications

- The DH45 has a pellet capacity of 45 lbs and uses an SBI– R10 shear blender with a 5HP motor. It recirculates up to 2.0 BBLs per minute and has 1.5” x 1.5” ports
- All models come with a NEMA4X VFD with an integrated on/off breaker.
- The DH45 can only CIP itself with the additional sprayball kit. Otherwise components need to be cleaned out of place.
- All units come standard with a 50’ input power cord.
- The DH45 comes with a flexible cleanable stick for use if hops happen to bridge in the hopper during induction.
- All units can be operated at 208V, 230V, or 460V. Voltage must be specified at time of order (VFD must match desired voltage)

IMPORTANT: Ball valve should be disassembled and cleaned out of place regularly regardless of sprayball or COP practices for regular cleaning

Parts Overview DH45

Table 2: Parts Functionality (DH45)		
Item	Description	Function
A	Motor	Drives the SBI shear pump
B	SBI Shear Pump	Recirculates beer, induces pellets, and chops pellets
C	Sight Glass	User can confirm flooding, flow, and pellet intake
D	Tank Ball Valve	Controls flow of pellets into the stream of beer
E	Pressure Gauge	User can monitor differential pressure to ensure good induction
F	Inlet Butterfly Valve	User can throttle to adjust differential pressure
G	CO ₂ Port	Allows CO ₂ into the hop chamber
H	Hop Chamber	Holds dose of hop pellets for induction
I	VFD	Electrical control for the motor
J	Hopper Lid	Keeps foreign objects out of hopper and used for CIP

Figure 2



Suggested Use:

Crashed beer – Induce the pellets and recirculate for three to four full volume turnovers. Sample from the sampling port periodically to get an idea of hop particle exposure.

Un-crashed beer - Induce the pellets and recirculate for three to four full volume turnovers. Sample from the sampling port periodically to get an idea of hop particle exposure.

Fermenting beer - Induce the pellets and STOP. No shearing of the yeast occurs as observed under a microscope, although it is still suggested not to recirculate longer than necessary. Beer may finish early as a result of agitation.

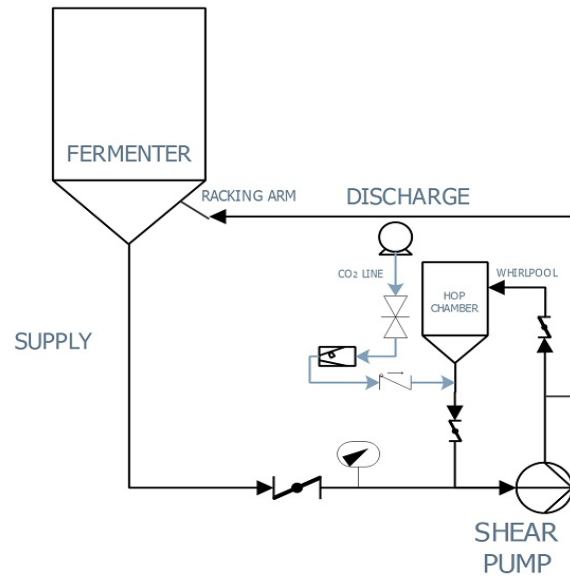
Unit Configuration

The Ampco ROLEC DH Series should be placed as close to the fermenter as possible. Please reference Figures 3-5 for suggested configurations.

*It is highly recommended that a tee with valves on all ends be installed at the end of the discharge hose back to the fermenter. At the perpendicular tee end, add a CO2 connection after the valve. This is utilized later in case of clogs.

Figure 3: Supply From Bottom Port / Discharge Into Racking Arm

This configuration is ideal for breweries that do not have top ports without spray balls. It ensures partial contact, but will rely on recirculation time of the fermenter to ensure full-contact. Three to four full volume turnovers are suggested.



Unit Configuration

Figure 4: Supply From Bottom or Racking Arm / Discharge Into Top Port

This configuration is ideal to ensure maximum exposure. The majority of breweries do not have top ports, so this configuration is not common.

RECOMMENDED SET UP WHEN TOP PORT IS AVAILABLE

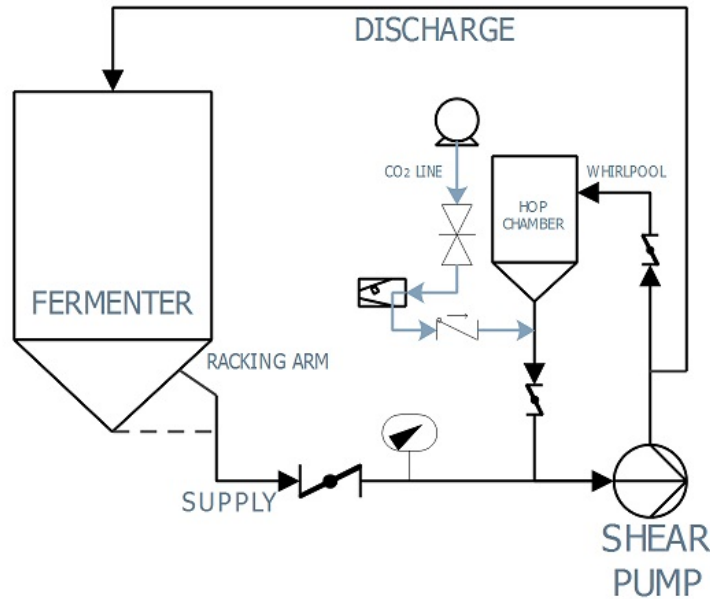
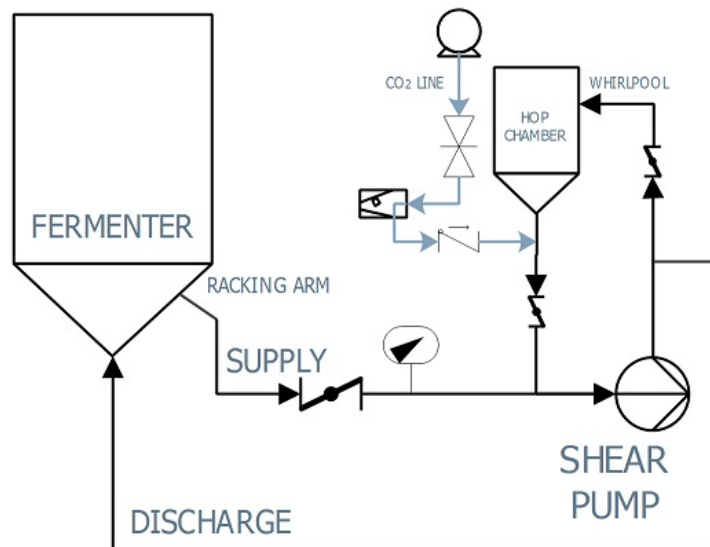


Figure 5: Supply From Racking Arm / Discharge Into Bottom Port

This configuration is necessary for large dry hops where the cone becomes filled with hop sediment. This is normally only a problem on 100+ BBL fermenters. The pump simply cannot pull through the hop sediment once it is too thick. Three to four full volume turnovers are suggest-



Try to use hoses that match the fermenter port size. The longer the hose, the more line loss will occur. This slows the induction and recirculation of the unit.

Electrical

The Ampco ROLEC DH is supplied with an input power cord. The ratings for input are referenced in Table 3.

Table 3: VFD Model Specifications			
VFD Model	HP, Voltage	Max output	Rated input
Movitrac LTEB – MCLTEB0040-2A3-4-40	5 HP, 208-230V	18.0A	20.7A
Movitrac LTEB – MCLTEB0040-5A3-4-40	5 HP, 460V	9.5A	12.4A

The VFD parameters must be checked prior to use. The most important parameters are:

- **Full load current of the motor:** The VFD must know the full load current (amps) of the motor it is paired with. This allows the VFD to protect the motor if it is overloaded. This current is listed on the motor nameplate.
- **Max frequency:** The suggested setting is 60Hz. This allows the user to ramp up quickly without worrying about overshooting.
- **Acceleration time:** This allows the user to program a time in which the motor will reach the set current.
- **Deceleration mode:** Ampco suggests a “coast” or immediate stop. This is okay when the pump is filled with liquid as the motor will stop quickly from hydraulic drag.
- **Direction:** Ensure the pump is rotating the correct direction. Start at a low frequency and watch the shaft rotation. It should be clockwise when looking at the fan (back of the motor). If it is desired to switch the direction of the motor, but not on the VFD, two of the three motor leads can be switched.

The VFD manual should be carefully read to determine if additional parameters are applicable.

VFD Manuals

<http://download.sew-eurodrive.com/download/pdf/20265743.pdf>

http://download.lenze.com/TD/ESV__SMV%20frequency%20inverter__v18-0__EN.pdf

Operating DH45

CIP with sprayball kit:

REFERENCE PAGE 5 FOR LETTER CORRELATION

Step 1: Filling hop chamber with hot water

For CIPing, (see figure 2 page 5) the hop chamber (H) and hopper lid (J) should be slightly opened to allow liquid to be poured inside. The tank ball valve (D) should be opened. A cross (provided with the sprayball kit) should be attached to the discharge of the pump. Attach sprayball (provided with sprayball kit) through center of hopper lid (J). Attach the beverage hose from the sprayball to the straight section of the cross. Attach a butterfly valve (not provided) to the cross. Connect the inlet hose to the inlet butterfly valve (F) and the other end to the discharge butterfly valve. Connect CO₂ valve and cross with second beverage hose (provided). Fill the unit to slightly above half way in the hop chamber (H).

Step 2: Adding caustic and establishing recirculation loop

USING PROTECTIVE EQUIPMENT, add caustic, sanitizing, or passivating solution to the hot water through the hop chamber (H). Close the hopper lid (J) over the hop chamber (H). Turn on the SBI shear pump (B) using VFD (I) until the sprayball rotates and sprays vigorously. Allow the pump to recirculate through its piping and spray the hop chamber (H) for 15-60 minutes or as suggested by the operator.

Step 3: Rinse and sanitize

Drain the hop chamber (H) through the cross and perform a rinse (from pump outlet). Repeat steps 1 and 2 with sanitizer instead of caustic. After the final rinse or sanitizing cycle allow the hop chamber (H) to dry before proceeding.

Ampco Pumps suggests that new equipment be passivated. Repeat step 1 and 2 with acid solution.

NOTE: CIP without sprayball kit - hopper, valve, reducer will need to be cleaned out of place.

IMPORTANT: Ball valve should be disassembled and cleaned out of place regularly regardless of sprayball or COP practices for regular cleaning.

Hop Induction:

Step 1: Connecting the unit to the fermenter

Attach the inlet hose and discharge hose according to figures 3-5 on pages 7 and 8. Attach a tee (not provided) and pressure gauge (not provided) to the fermenter, to read the internal pressure during induction. Remove the spray ball from the hopper lid (J) and close the butterfly valve on the discharge tee.



WARNING: Hot water may cause burns. Caustic/Sanitizing solutions may cause chemical burns. Wear proper protective gear when handling hot water and chemicals.

Operating DH45**Step 2: Bringing the fermenter up to pressure**

Flood the pump (B) with beer and take note of the pressure reading on the pressure gauge (E). Pressure must be above 4.3psi and below 14 psi on DH45 pressure gauge. Above 14 psi contact factory.

Step 3: Establishing recirculation

Ensure the inlet butterfly valve (F) is open fully, the tank ball valve (D) is closed and the discharge valve (not provided) is closed. Operate the VFD (I) and ensure motor (A) is spinning in the correct direction. Increase the frequency to 60Hz. Also take note of the reading on the pressure gauge on the fermenter (not provided).

Step 4: Hop Induction

Allow the pump (B) to recirculate and ensure it does not lose prime with this amount of vacuum. Set CO2 (not provided) to 15 psi and connect to the check valve (G). Slide hopper lid (J) to the side, to allow room for pouring hop pellets. After 15 seconds of the CO2 running, add hops to hop chamber (H). Ensure that pressure gauge (E) still shows a negative reading. Open the tank ball valve (D) for hop induction to begin.

Depending on hop varieties, hops may bridge in hopper. If vacuum does not overcome bridge in 30-45 seconds use supplied stick to break bridge as needed. Make sure to properly sanitize the stick before and after use.

Step 5: End of Hop Induction

Once the pellets have induced, close the tank ball valve (D). Turn off the CO2 (not provided).

Recirculation Guidelines

Ampco recommends a recirculation of 3.5 fermenter turnovers. Please reference the chart below. Times can vary by system and hop style, these are general guidelines only.

DH45 Recirculates up to 2BBL/ Minute		
< 10 ft	10 BBL Fermenter	18 minutes
10 ft	20 BBL Fermenter	35 Minutes
12 ft	30 BBL Fermenter	53 Minutes
14 ft	50 BBL Fermenter	1.5 Hours
15-20 ft	100 BBL Fermenter	3 Hours

Maintenance

The Ampco ROLEC DH should be hot rinsed after use. This is done by performing a rinse cycle; Refill the hop chamber with water and recirculate for a time specified by the user. After the rinse cycle allow the hop chamber to dry completely. This ensures the seal faces are free of particles and product, which can cause damage when used the next time. It also protects the elastomers and seals in the valves and other components from having product adhere to them.

See the [SB/SBH/SBI series shear blenders manual](#) for further maintenance instructions.

See the [Baldor Maintenance Manual](#) for motor lubrication and other information.

NOTE: CIP without sprayball kit - hopper, valve, reducer will need to be cleaned out of place.

IMPORTANT: Ball valve should be disassembled and cleaned out of place regularly regardless of sprayball or COP practices for regular cleaning

Spare Parts

13MHHM100-150	1" - 1-1/2" - SINGLE PIN HEAVY DUTY CLAMP
13MHHM200	2" - SINGLE PIN HEAVY DUTY CLAMP
40MPF-U100	1" - CLAMP GASKET BUNA-N (BLACK), FLANGED
40MPF-U150	1-1/2" - CLAMP GASKET BUNA-N (BLACK), FLANGED
40MPF-U200	2" - CLAMP GASKET BUNA-N (BLACK), FLANGED
40MPF-U50	1/2"-CLAMP GASKET BUNA-N (BLACK), FLANGED
B5101E150CC-C	1.5" BUTTERFLY VALVE WITH TRICLAMP INOX
B5101E200CC-C	2" BUTTERFLY VALVE WITH TRICLAMP INOX
S1100-200-EP	SANITARY SIGHT FLOW - 2" CLAMP CONNECTION
13MHHM50-75	0.50"-0.75" SINGLE PIN CLAMP 304
13MHHM300	3" SINGLE PIN HEAVY DUTY CLAMP
40MPF-U300	3" CLAMP GASKET BUNA-N(BLACK), FLANGED
RDH04520013	TEE SUPPORT
N70331	O-RING FOR LID ATTACHMENT
RDH04510061	1 1/2" PRESSURE GAUGE - 30"Hg to 30PSI
RDH04510091	STICK

Troubleshooting

Problems may occur over the life of the unit due to system variations, standard wear, or user error. The following table has information that may help identify and solve a problem. For additional technical assistance, please contact Ampco with the pump's serial number.

Symptom	Cause	Solution
Pump will not flood when fermenter's beer is introduced	Air-lock	Ensure the inlet butterfly valve is open
	Too much cone sediment in fermenter	Switch hoses (Figure 4/5 page 7)
No flow	Direction of pump is incorrect	Switch direction in VFD (page 8)
	Too much cone sediment in fermenter	Switch hoses (Figure 4/5 page 7)
	Speed of pump too low	Increase speed on the VFD (Not above 70Hz)
	Discharge valve closed/ not open enough	Open discharge valve
	The inlet butterfly valve is throttled too far	Open the inlet butterfly valve slightly
Hops will not flow down hop chamber funnel	Not enough vacuum present (DH45)	<ul style="list-style-type: none"> - Open/Close tank ball valve to "jump start" induction - Use provided hop agitator to stir up hops and force down hop chamber
VFD stops and displays error	High amps detected	Check current setting in parameters (page 8). If parameters are correct, run pump slower or at a higher backpressure on discharge
	Other	Reference VFD manual (page 8)

AMPCO PUMPS

Made of SELECTED corrosion-resistant alloys

TERMS AND CONDITIONS OF SALE

1. ENTIRE AGREEMENT. This document contains all of the terms and conditions of the agreement (“the agreement”) between Ampco Pumps Company, Inc. (“Seller”) and the purchaser (“Purchaser”) of the Products (“Products”) to be sold to Purchaser, to the exclusion of any other statements and agreements, and to the exclusion of any terms and conditions incorporated in Purchaser’s order or other documents of Purchaser. Seller’s acceptance of Purchaser’s order is expressly conditioned on Purchaser’s acceptance of the terms and conditions contained herein, and Purchaser, upon placing an order, is presumed to have accepted all the terms and conditions without modification. No alteration, waiver, modification of or addition to the terms and conditions herein shall be binding on Seller unless set forth in writing and specifically agreed to by an officer of Seller. No course of dealing, usage of trade or course of performance will be relevant to supplement or explain any terms used in the agreement. All offers to purchase, quotations and contracts of sale are subject to final acceptance by Seller at its home office at Milwaukee, Wisconsin.

2. PRICES. Prices for Products manufactured by Seller pursuant to written accepted orders will remain firm for thirty (30) days from the date of any subsequent price change.

3. TERMS OF PAYMENT. Standard terms are ½% 10 days, 30 days net, from date of invoice unless otherwise stated. If, in the judgment of Seller, the financial condition of Purchaser at any time does not justify continuance of production or shipment on the terms of payment specified, Seller may require full or partial payment in advance. In cases of delays in payment, Seller reserves the right to charge interest on delinquent balances at the rate of 1 ½% per month.

4. DELIVERY. Except as otherwise provided expressly stated in the agreement, Products are sold F.O.B. Milwaukee. Seller will use reasonable commercial efforts to fill orders within the time stated, but the stated delivery date is approximate only, and Seller reserves the right to readjust shipment schedules without liability. Acceptance by Purchaser of the Products waives any claim for loss or damage resulting from a delay, regardless of the cause of the delay. Except as otherwise provided herein, Seller will not be responsible for freight, transportation, insurance, shipping, storage, handling, demurrage or similar charges. Claims by Purchaser for shortages in the Products must be made to Seller in writing within ten (10) days after date of receipt of the Products. No such shortage shall entitle Purchaser to withhold payment for Products which were received by Purchaser. Each such claim shall set forth in detail the basis and amount of such claim.

5. TAXES AND FEES. Seller shall pay all present and future sales, excise, privilege, use or other taxes, customs duties, and all other fees or other costs, imposed by any federal, state, foreign, or local authorities arising from the sale, purchase, transportation, delivery, storage, use or consumption of the Products or will, if applicable, provide Seller with an appropriate exemption certificate. Seller shall be under no obligation to contest the validity of any such taxes or to prosecute any claims for refunds or returns.

6. INSTALLATION. The Products shall be installed by and at the expense of Purchaser.

7. LOSS, DAMAGE OR DELAY. Seller will not be liable for loss, damage or delay resulting from causes beyond its reasonable control, including, without limitation, strikes or labor difficulties, lockouts, acts or omissions of any governmental authority or Seller, insurrection or riot, war, fires, floods, Acts of God, breakdown of essential machinery, accidents, embargoes, cargo or material shortages, delays in transportation, lack of production capacity or inability to obtain labor, materials or parts from usual sources. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay. In the event performance by Seller under the agreement cannot be accomplished by Seller due to any of the foregoing causes within a reasonable period of time, Seller may, at its option, terminate the agreement without liability.

8. RETURNS. No Products or parts may be returned by Purchaser without the prior written consent of Seller.

9. WARRANTY. Seller warrants that the Products manufactured by Seller will be free from defects, material and workmanship under normal use and service for a period of one (1) year from date of shipment. In addition, the specified rating of each pump is warranted; however, the characteristic shape of the performance curves may vary from the published standards, and the capacity, head and efficiency guarantees are based on actual shop tests using clear cold water, and therefore the rating is specified in equivalent units of clear cold water. The sole obligation of Seller and the exclusive remedy of Purchaser for breach of this warranty shall be the repair (at Seller’s facility) or replacement by Seller (F.O.B. Milwaukee, Wisconsin), at Seller’s option, of any parts found to be defective, without charge and shall be conditioned upon Seller receiving written notice of any alleged breach of this warranty within a reasonable time after discovery of the defects, but in no event later than the end of the warranty period. The parts alleged to be defective shall be returned to Seller upon its request, freight prepaid. This warranty does not cover ordinary wear and tear, abuse, misuse, overloading, alteration or Products or parts which have not been installed, operated or maintained in accordance with Seller’s written instructions. Seller shall not be liable for any expenses for repairs, additions or modifications to the Products outside of Seller’s factory without its prior written consent, and any such repairs without such consent shall void this warranty. THIS WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ALL OTHER EXPRESS AND IMPLIED WARRANTIES WHATSOEVER, INCLUDING BUT NOT LIMITED TO IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. Seller may from time to time provide its facilities, personnel and experience to assist customers in the selection of materials, design, installation and operation of Products for maximum resistance to corrosion and abrasion with due consideration to the economy of the installation. This service is provided in an advisory capacity only and the final selection and operation of the Products and ancillary equipment shall be the sole responsibility of Purchaser or any user thereof. Accessories and parts manufactured by third parties are warranted only to the extent of such third party’s warranty. IN NO EVENT SHALL SELLER BE LIABLE UNDER ANY CIRCUMSTANCES FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, ANY LOST PROFITS OR LABOR COSTS) ARISING FROM THE BREACH OF THIS WARRANTY OR OTHERWISE ARISING FROM OR RELATING TO THE PRODUCTS OR THEIR SALE, USE OR INSTALLATION.

Terms and Conditions

Ampco Pumps Company

10. CHANGES. Changes in any work to be performed hereunder may be made only upon Purchaser's written instructions and acceptance by Seller in its discretion. Any change in drawings, materials or design of the Products, or to tools, fixtures or other items used to produce the Products, which affects Seller's cost to produce the Products will entitle Seller to adjust the price to take into account any additional costs. If work has been started, Seller shall be properly reimbursed for work already performed; if Products already produced are not accepted by Purchaser, Seller has the right to adjust the price to take into account any additional costs caused by an increase or decrease in quantities or in the time required for performance under the agreement.

11. TERMINATION. After Seller has commenced work, ordered any materials or made any other commitments pursuant to the agreement, it may be terminated only with the prior written agreement of Seller providing for equitable cancellation charges. Such charges shall reimburse Seller for any completed items at the contract price, and for any work-in-process items at the contract price less the cost to complete. Termination on any other basis must be specifically agreed on in writing in advance between Purchaser and Seller.

12. DEFERRED DELIVERIES. Orders or deliveries will be deferred only upon the prior written agreement of Seller in its discretion, and then only upon the following conditions:

(a) The deferral period may not exceed sixty (60) days. At the end of the deferral period, if no release is provided by Purchaser, Seller reserves the right to render an invoice for and ship the completed portion of the order to the destination specified in Purchaser's order, or to store such material at Purchaser's expense at Seller's standard storage charges then in effect.

(b) For the portion of the order that is not completed, if no release is provided by Purchaser at the expiration of the deferral period, Seller reserves the right to render an invoice for any completed items at the contract price, and for any work-in-process items at the contract price less the cost to complete.

(c) Purchaser shall bear the risk of loss or damage to materials held at Purchaser's request.

13. LIMITATION OF LIABILITY. IN NO EVENT SHALL SELLER BE LIABLE UNDER ANY CIRCUMSTANCES: (a) FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, ANY LOST PROFITS OR LABOR COSTS) ARISING FROM OR RELATING TO THE PRODUCTS OR THEIR SALE, USE OR INSTALLATION; (b) FOR DAMAGES TO PROPERTY (OTHER THAN THE PRODUCTS PURCHASED FROM SELLER); (c) FROM ANY BREACH OF ITS WARRANTY OR ANY OTHER OBLIGATIONS TO BUYER; OR (d) FOR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON WARRANTY (EXPRESSED OR IMPLIED) OR OTHERWISE BASED ON CONTRACT, OR ON TORT OR OTHER THEORY OF LIABILITY, AND REGARDLESS OF ANY ADVICE OR REPRESENTATIONS (WHETHER OR NOT IN WRITING) THAT MAY HAVE BEEN RENDERED BY SELLER CONCERNING THE DESIGN, MANUFACTURE, SALE, USE OR INSTALLATION OF THE PRODUCTS.

14. INFRINGEMENT. Seller at its expense will defend and hold Purchaser harmless from and against all damages, costs and expenses arising from any valid claim of infringement by a third party with respect to any patent or other intellectual property rights (collectively, the "Intellectual Property Rights") caused by Products originally manufactured by Seller, provided Purchaser (a) has not modified such Products, (b) gives Seller immediate notice in writing of any claim or commencement or threat of suit, and (c) permits Seller to defend or settle the same, and gives all immediate information, assistance and authority to enable Seller to do so. In the event any such originally manufactured Products are held to infringe an Intellectual Property Right and if Purchaser's use thereof is enjoined, Seller will, at its expense and option: (1) obtain for Purchaser the right to continue using the Products, (2) supply non-infringing Products, (3) modify the Products so that they become non-infringing, or (4) refund the then market value of such Products. In no event shall Seller's liability exceed the sale price of the infringing Products. THE FOREGOING REPRESENTS SELLER'S ENTIRE AND EXCLUSIVE OBLIGATION WITH RESPECT TO ANY CHARGE OF INFRINGEMENT OF ANY INTELLECTUAL PROPERTY RIGHT AND IS IN LIEU OF ANY STATUTORY WARRANTY RELATING TO INFRINGEMENT. Notwithstanding the foregoing, Seller shall have no liability as to any Products or parts thereof that are manufactured or modified by Purchaser or a third party, or that are manufactured or modified by Seller in accordance with Purchaser's specifications. Purchaser will defend and hold Seller harmless from and against all damages, costs and expenses whatsoever arising from any claim for infringement of any Intellectual Property Rights relating to Products that have been manufactured or modified by Seller according to specifications provided by Purchaser.

15. CERTAIN LAWS. Seller will comply with the applicable requirements of the Fair Labor Standards Act of 1938, as amended, Executive Order 11246, and THE rules, regulations and orders of the Secretary of Labor relating thereto.

16. PERIOD FOR ACCEPTING QUOTATIONS. Unless accepted without modification within thirty (30) days of issuance, or prior to withdrawal by Seller if earlier, all quotations automatically expire at the end of such thirty (30) day period.

Terms and Conditions

Ampco Pumps Company

17. PROVISIONS FOR INTERNATIONAL TRANSACTIONS. The following provisions shall apply if the Products are to be shipped to Purchaser at a location outside the United States, and apply regardless of other provisions set forth in these Terms and Conditions:

(a) The 1980 United Nations Convention on Contracts for the International Sale of Products shall not apply.

(b) Except as otherwise provided expressly stated in the agreement, terms of delivery are Ex-Works (within the meaning of INCOTERMS 2000) and all customs fees, import duties, cargo insurance, taxes and other charges imposed on or relating to the purchase or sale of the Products shall be paid by Purchaser in addition to the stated price.

(c) Except as otherwise provided expressly stated elsewhere in the agreement, payment shall be made by issuance to Seller of an irrevocable letter of credit which (i) is issued and confirmed by a U.S. bank acceptable to Seller, (ii) is governed by the Uniform Customs and Practice for Documentary Credits (UCP 600) and otherwise acceptable in form and substance to Seller, and (iii) provides for payment to Seller of the purchase price in U.S. dollars upon presentation by Seller of Seller's certification and/or such other documents as shall be required by the letter of credit. All banking and other charges for such letter of credit shall be for the account of Purchaser.

(d) Prices include Seller's standard commercial export packaging which may vary depending on whether shipment is made by air, land or sea. Except as otherwise provided expressly stated in the agreement, Purchaser will bear any additional expenses required to satisfy Purchaser's packaging requirements. Packages will be marked in accordance with Purchaser's instructions, if any. Seller shall furnish packing lists and such other information as may be necessary to enable Purchaser's agent to prepare documents required for export shipment.

(e) All shipments hereunder are subject to compliance with the U.S. Export Administration Act, as amended, regulations thereunder and all other U.S. laws and regulations concerning exports. Purchaser shall comply with all such laws and regulations concerning the use, disposition, re-export and sale of the Products provided hereunder.

18. GENERAL. No modification or waiver of the agreement or any of its provisions is valid unless expressly agreed to by Seller in writing, and no waiver by Seller of any default under the agreement is a waiver of any other or subsequent default. The unenforceability or invalidity of one or more of the provisions of the agreement will not affect the enforceability or validity of any other provision of the agreement. Purchaser may not assign any of its rights, duties or obligations under the agreement without Seller's prior written consent and any attempted assignment without such consent, even if by operation of law, will be void. The agreement is governed by and shall be construed in accordance with the laws of the State of Wisconsin, including the Uniform Commercial Code as enacted by such state, without giving effect to its conflict of laws principles.

Return Policy

Ampco Pumps Company

This policy is intended for returns that are not covered by product warranty, i.e. wrong pump or part was ordered, customer canceled order, etc. Before returning any product, contact us for a Returned Material Authorization Number (RMA#). This will eliminate confusion when the parts are received and facilitate processing the return. No action will be taken on returned parts without an RMA.

<u>Type of Return</u>	<u>Restocking Charge</u>
Standard pump with a replacement order	10%
Standard pump without a replacement order	20%
Standard parts with a replacement order	5%
Standard parts without a replacement order	10%

Additional restocking charges may be assessed for any of the following circumstances.

1. Special order motors and seals are not returnable unless we have a use for them. Credit will be determined on a case-by-case basis.
2. Impellers that are trimmed to a diameter that we don't regularly use are not returnable. Credit will be determined on a case-by-case basis.
3. Used seals and motors are not returnable.
4. For any pumps and/or parts purchased over (1) year ago, credit will be determined on a case-by-case basis.

Credits

Credit will be issued only after parts are returned and inspected. Customer is responsible for packaging parts so they are returned in "as new" condition. Any labor required by Ampco to return the parts to "as new" condition will be deducted from the credit.

Notes

Notes

Notes



Ampco Pumps Company
2045 W. Mill Road
Glendale, WI 53209
Phone: (800) 737-8671 or (414) 643-1852
Fax: (414) 643-4452
Email: ampcoocs@ampcopumps.com

For additional information on the ROLEC DH series and other Ampco Pumps products, please visit our website: **www.ampcopumps.com**