



## ▶ Sanitary Turbine Flow Meter - TA3

### Installation, Operating & Maintenance Manual

# Mechanical Specifications

## Measuring Accuracy

± 1.0% of reading or better

## Repeatability

± 0.1%

## Flow Measuring Range

0.6 to 400 GPM (gal/min)

## Turn Down Ratio

10:1

## Maximum Operating Pressure\*\*

Working pressure up to 1,000 psi

## Temperature Range\*

Fluid temperature up to 300°F

## Electrical Connection

NEMA 6 Connector

## Port Connection

Tri-clamp

\*Sensor & seal dependent. \*\* Depends on connection size & clamp. Note: .COP (Clean-Out-of-Place)

## Materials of Construction

<b>Body &amp; Rotor Support</b>	316L Stainless Steel
<b>Rotor</b>	Nickel Plated Stainless Steel
<b>Bearings</b>	Nickel Bindery Tungsten Carbide

## Electronics

Model	Sensor Type	Temp (°F)
RT-10R	Battery-Powered Monitor	0 to 140
RT-30SD	15-24 VDC Powered Monitor	0 to 140
MAG-INVA	Amplified Pulse Output	0 to 140
MG-300	Non-Amplified (external amplifier needed)	0 to 300
MG-450	Non-Amplified (external amplifier needed)	0 to 450

\*Contact factory for additional sensor options.

## Meter Specifications

Part Number	Range (gal/min)	K-Factor * (Pulses/ gal)	Meter Size	Clamp Size	Weight (lbs)
TA3-75-375	0.6 to 3	20,000	3/8"	3/4"	1
TA3-75-500	0.75 to 7.5	13,000	1/2"	3/4"	1
TA3-75-750	2 to 15	2,750	1/2"	3/4"	1
TA3-150-500	0.75 to 7.5	13,000	1/2"	1-1/2"	3
TA3-150-750	2 to 15	2,750	1/2"	1-1/2"	3
TA3-150-875	3 to 30	2,600	7/8"	1-1/2"	3
TA3-150-100	5 to 50	870	1"	1-1/2"	3
TA3-150-150	15 to 180	330	1-1/2"	1-1/2"	5.5
TA3-250-200	40 to 400	50	2"	2-1/2"	8.5

\* K-Factors given are averaged. A calibration sheet accompanies every meter sold.

# Introduction

The TA-3 Sanitary turbine flow meter is designed with wear resistant moving parts to provide trouble-free operation and long service life. The durable 316L stainless steel construction provides a cost efficient flow measurement system that offers excellent accuracy and repeatability. The TA-3 Sanitary turbine meter repair kit is designed for easy field service of a damaged flow meter, rather than replacing the entire flow meter. See Repair Kits on page 8 for information.

## Theory of Operation

Fluid entering the meter passes through the inlet flow straightener which reduces its turbulent flow pattern and improves the fluid's velocity profile. Fluid then passes through the turbine, causing the rotor to rotate at a speed proportional to the fluid velocity. As each turbine blade passes through the magnetic field, the blade generates an AC voltage pulse in the pickup coil at the base of the magnetic pickup (see Figure 1). These pulses produce an output frequency proportional to the volumetric flow through the meter. The output frequency represents flow rate and/or totalization of fluid passing through the turbine flow meter.

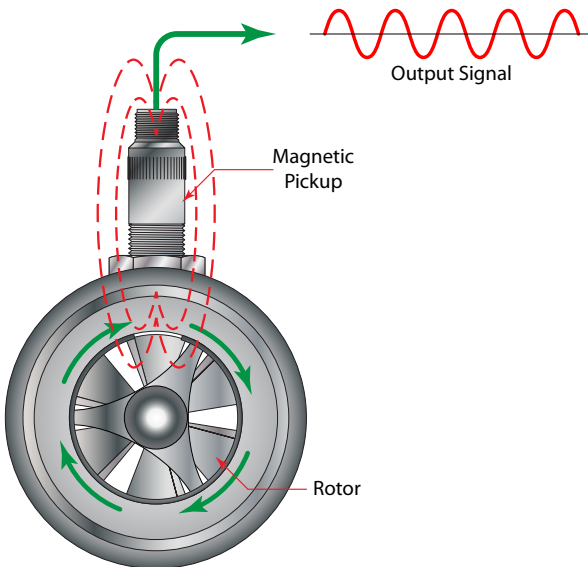


Figure 1. Theory of Operation

# Installation

**WARNING: The meter should not be subjected to temperatures above 300° F (149° C), below -150° F (-101°C) or the freezing point of the metered liquid. High temperatures will damage the magnetic pickup, while lower temperatures will limit the rotation of the rotor.**

**WARNING: Incompatible fluids could deteriorate internal parts and cause the meter to read inaccurately.**

## Plumbing

Install the flow meter with the flow arrow, which is etched on the exterior of the meter body, pointing in the direction of fluid flow. Install the meter horizontally with the magnetic pickup facing upward.

The liquid being measured must be free of any large particles that may obstruct spinning of the rotor. If particles are present, install a mesh strainer.

If small particles are present in the fluid, install a strainer upstream of the meter. See Table 1 for filtration recommendations.

Table 1

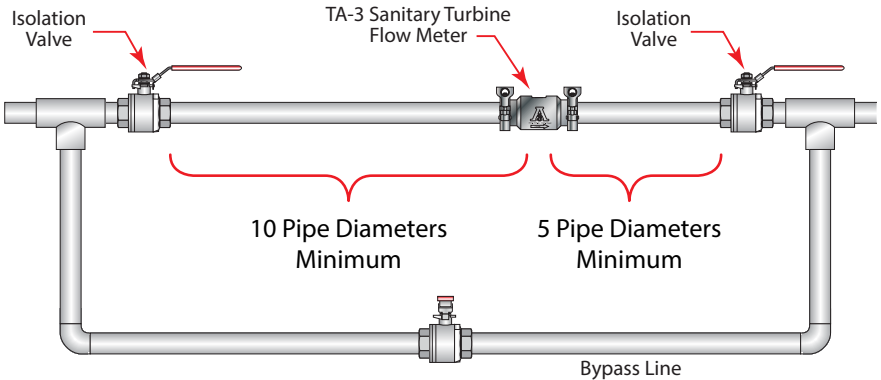
Bore Size	Ferrule Size	Strainer Size	Clearance
3/8 in. (9.53 mm)	0.984 in. (24.99 mm)	60 × 60	0.0092 in. (0.23 mm)
1/2 in. (12.7 mm)	0.984 in. (24.99 mm)	60 × 60	0.0092 in. (0.23 mm)
3/4 in. (19.05 mm)	0.984 in. (24.99 mm)	60 × 60	0.0092 in. (0.23 mm)
1/2 in. (12.7 mm)	1.984 in. (50.39 mm)	60 × 60	0.0092 in. (0.23 mm)
3/4 in. (19.05 mm)	1.984 in. (50.39 mm)	60 × 60	0.0092 in. (0.23 mm)
7/8 in. (22.23 mm)	1.984 in. (50.39 mm)	60 × 60	0.0092 in. (0.23 mm)
1 in. (25.4 mm)	1.984 in. (50.39 mm)	60 × 60	0.0092 in. (0.23 mm)
1-1/2 in. (38.1 mm)	1.984 in. (50.39 mm)	20 × 20	0.034 in. (0.86 mm)
2 in. (50.8 mm)	3.047 in. (77.39 mm)	10 × 10	0.065 in. (16.51 mm)

Severe pulsation and mechanical vibration affects accuracy and shortens the life of the meter.

The preferred plumbing setup is one containing a bypass line that allows meter inspection and repair without interrupting flow. See Figure 2. If a bypass line is not utilized, it is important that all control valves be located downstream of the flow meter. See Figure 3.

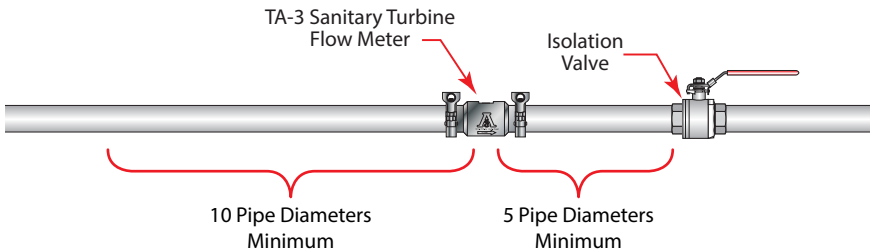
This is true with any restriction in the flow line that may cause the liquid to flash. If necessary, air eliminators should be installed to ensure that the meter is not incorrectly measuring entrained air or gas.

Figure 2: Installation with bypass line



It is recommended that a minimum length, equal to ten (10) pipe diameters of straight pipe, be installed on the upstream side and five (5) diameters on the downstream side of the flow meter. Otherwise, meter accuracy may be affected. Piping should be the same size as the meter bore or threaded port size.

Figure 3: Installation without a bypass line



Do not locate the flow meter or connection cable close to electric motors, transformers, sparking devices, high voltage lines, or place connecting cable in conduit with wires furnishing power for such devices. These devices can induce false signals in the flow meter coil or cable causing the meter to read inaccurately.

**WARNING: Damage can be caused by striking an empty meter with a high velocity flow stream.**

If problems arise with the flow meter and monitor, consult the “Troubleshooting Guide” on page 13. If further problems arise, consult the factory. If the internal components of the turbine flow meter are damaged, order a turbine meter repair kit. See “Repair Kits” on page 10.

## Operational Startup

The following steps should be followed when installing and starting the meter.

**WARNING: Make sure that fluid flow has been shut off and pressure in the line released before attempting to install the meter in an existing system.**

1. After meter installation, keep the isolation valves closed and the bypass valve open. Flow liquid through the bypass valve for sufficient time to eliminate any air or gas in the flow line.
2. Open upstream isolating valve slowly to eliminate hydraulic shock while charging the meter with the liquid. Open the valve to full open.

**CAUTION: High velocity air or gas may damage the internal components of the meter.**

3. Open downstream isolating valve to permit meter to operate.
4. Close the bypass valve to a full closed position.
5. Adjust the downstream valve to provide the required flow rate through the meter.

*NOTE: The downstream valve may be used as a control valve.*

# Dimensions and Drawings

Figure 5: Dimensions

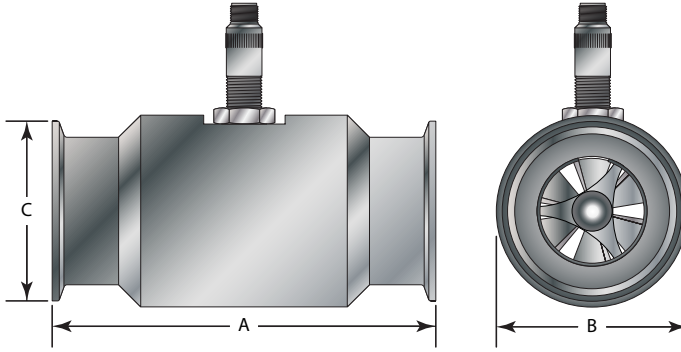
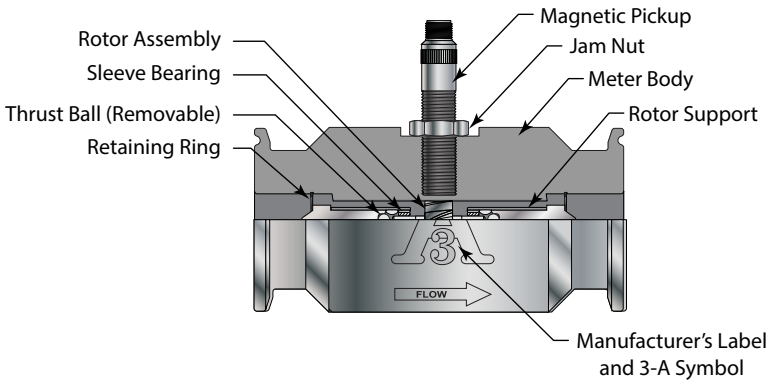


Table 4: Dimensions

Part Number	A	B	C
TA3-75-375	3.00 in. (76 mm)	1.5 in. (38 mm)	1 in. (25 mm)
TA3-75-500	3.00 in. (76 mm)	1.5 in. (38 mm)	1 in. (25 mm)
TA3-75-750	3.00 in. (76 mm)	1.5 in. (38 mm)	1 in. (25 mm)
TA3-150-500	4 in. (101 mm)	2.0 in. (50 mm)	2.0 in. (50 mm)
TA3-150-750	4 in. (101 mm)	2.0 in. (50 mm)	2.0 in. (50 mm)
TA3-150-875	4 in. (101 mm)	2.0 in. (50 mm)	2.0 in. (50 mm)
TA3-150-100	4 in. (101 mm)	2.0 in. (50 mm)	2.0 in. (50 mm)
TA3-150-150	6.25 in. (158 mm)	2.3 in. (59 mm)	2.0 in. (50 mm)
TA3-250-200	6.5 in. (161 mm)	2.3 in. (59 mm)	3 in. (76 mm)



Figure 6: TA-3 Sanitary Meters Cross Sections



## Meter Repair and Cleaning

### Repair Kits

Each TA-3 turbine repair kit is factory-calibrated for accuracy throughout the entire flow range. Each kit is complete and includes a new K factor, which is the calibrated number of pulses generated by each gallon of liquid. This K factor will be used to recalibrate the monitor or other electronics to provide accurate output data. Service Procedures

### Turbine Repair Kits Part Numbers

Table 5: TA-3 Sanitary Meters Repair Kits

Bore Size	Ferrule Size	Repair Kit Fits Meter Part Number	Repair Kit Part Number
3/8 in. (9.53 mm)	1 in. (25 mm)	TA3-75-375	TA3-375
1/2 in. (12.7 mm)	1 in. (25 mm)	TA3-75-500	TA3-500
3/4 in. (19.05 mm)	1 in. (25 mm)	TA3-75-750	TA3-750
1/2 in. (12.7 mm)	2 in. (50 mm)	TA3-150-500	TA3-500
3/4 in. (19.05 mm)	2 in. (50 mm)	TA3-150-750	TA3-750
7/8 in. (22.23 mm)	2 in. (50 mm)	TA3-150-875	TA3-875
1 in. (25.4 mm)	2 in. (50 mm)	TA3-150-100	TA3-100
1-1/2 in. (38.1 mm)	2 in. (50 mm)	TA3-150-150	TA3-150
2 in. (50.8 mm)	3 in. (78 mm)	TA3-250-200	TA3-200

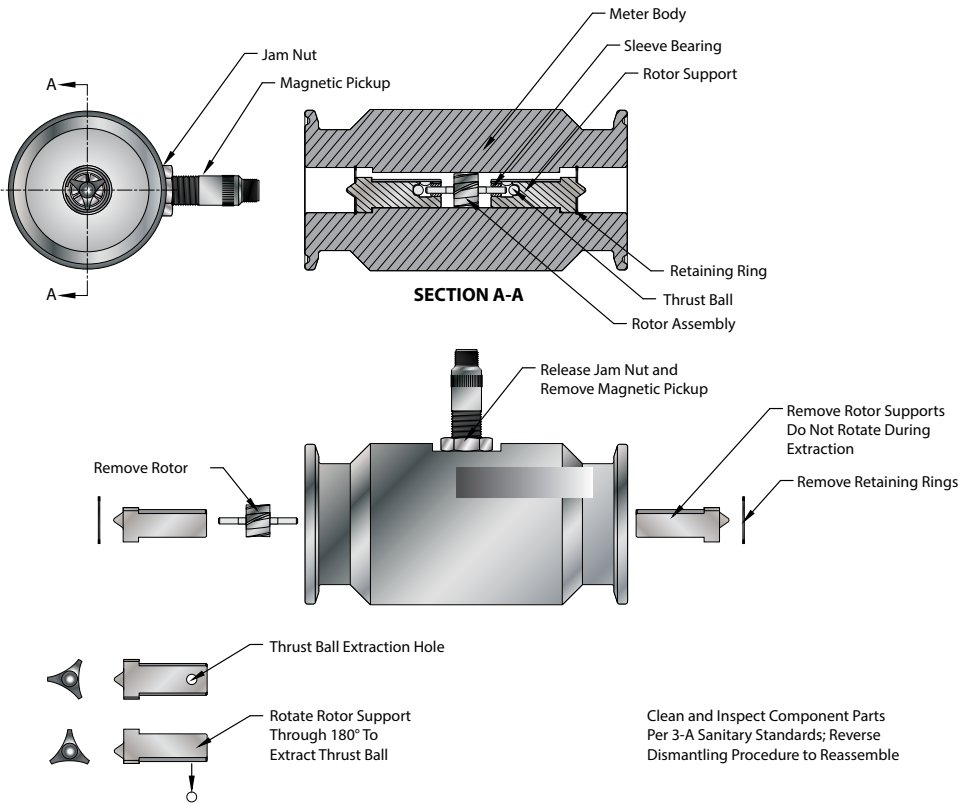
### 3-A Turbine Disassembly and Cleaning Procedure

**WARNING: High-pressure leaks are dangerous and cause personal injury. Make sure that fluid flow had been shut off and pressure in the line released before attempting to remove the meter.**

*NOTE: Refer to Figure 7 for relative positions of repair kit components.*

1. Remove the magnetic pickup from the meter body to avoid damage during procedure.
2. Remove the retaining ring from one end of the meter.
3. Keeping the meter upright (pickup port at the top), remove the rotor support from the body, taking care not to rotate it in the process. If the rotor support is jammed in the body, use a pair of pliers or vice grips to break it free.
4. Hold the rotor support over a suitable container and rotate it through 180°. The thrust ball will drop out. Take care not to lose the ball.
5. Remove the rotor assembly.
6. Remove the second retaining ring from the opposite side of the meter.
7. Repeat steps 3 and 4 for the remaining rotor support.
8. Identify parts and flow direction to match with original meter body.
9. Clean and/or sanitize parts to meet appropriate sanitary standards.

Figure 7: TA-3 Sanitary Turbine Exploded View



### 3-A Turbine Installation

*NOTE: This procedure applies to installation of replacement turbine repair kits and re-installation of cleaned or sanitized turbine.*

**IMPORTANT: Before reassembly, note there are weep holes on each rotor support. These weep holes must be facing down toward the bottom of the meter body when installed.**

The meter must be reassembled with the arrowheads on the rotor pointed in the direction of fluid flow. The magnetic pickup side of the body signifies the up position. This is the position that the repair kit was calibrated, and this is the position to be used to ensure meter accuracy. Due to the polished surfaces, there are no arrows on the rotor support to indicate which rotor support is to be placed

upstream or downstream. Please install the repair kit as it was received in the box, using the arrow on the rotor to determine the placement of the rotor support.

1. If required by process procedures, the meter should be cleaned prior to installation into the piping system.
2. Drop a thrust ball into a rotor support through the hole provided in the side. Insert rotor support into the meter body. Keep the thrust bearing hole pointed upwards to keep the ball in place.
3. Secure a retaining ring in the groove provided. Be sure that the retaining ring is completely installed in the groove.
4. Drop a thrust ball into second rotor support through the hole provided in the side. Locate the rotor in the support sleeve bearing. Insert rotor support and rotor into the meter body and the first support sleeve bearing. Keep the thrust bearing hole pointed upwards to keep the ball in place.
5. Secure the second retaining ring in the groove provided. Be sure that the retaining ring is completely installed in the groove.

**WARNING: Excess air pressure may damage the rotor and bearings by over-spin.**

6. Check the meter by blowing air through the assembly. If the rotor does not turn freely, the meter should be disassembled and checked for anything that would obstruct movement of the rotor.
7. Install the magnetic pickup.

*NOTE: After installing the new repair kit, the electronics will need re-calibration. Refer to the electronics' installation and operation manual. If there are any questions on re-calibration, contact AW-Lake Company at 1.800.850.6110 or contact the manufacturer of the associated electronics.*

# Troubleshooting Guide

Issue	Possible Cause	Remedy
Meter indicates higher than actual flow rate	<ul style="list-style-type: none"> <li>• Cavitation</li> <li>• Debris on rotor support</li> <li>• Build up of foreign material on meter bore</li> <li>• Gas in liquid</li> </ul>	<ul style="list-style-type: none"> <li>• Increase back pressure</li> <li>• Clean meter</li> <li>• Clean meter</li> <li>• Install gas eliminator ahead of meter</li> </ul>
Meter indicates lower than actual flow rate	<ul style="list-style-type: none"> <li>• Debris on rotor</li> <li>• Worn bearing</li> <li>• Viscosity higher than calibrated</li> </ul>	<ul style="list-style-type: none"> <li>• Clean meter and add filter</li> <li>• Install new repair kit</li> <li>• Recalibrate monitor</li> </ul>
Erratic system indication, meter alone works well (remote monitor application only)	Ground loop in shielding	Ground shield one place only. Look for internal electronic instrument ground. Reroute cables away from electrical noise.
Indicator shows flow when shut off	Mechanical vibration causes rotor to oscillate without turning	Isolate meter
No flow indication, full or partial open position	Fluid shock, full flow into dry meter or impact caused bearing separation or broken rotor shaft	Rebuild meter with repair kit and recalibrate monitor. Move to location where meter is full on startup or add downstream flow control valve.
Erratic indication at low flow, good indication at high flow	Rotor has foreign material wrapped around it	Clean meter and add filter
No flow indication	Faulty pickup	Replace pickup
System works perfect, except indicates lower flow over entire range	Bypass flow, leak	Repair or replace bypass valves or faulty solenoid valves
Meter indicating high flow, upstream piping at meter smaller than meter bore	Fluid jet impingement on rotor	Change piping
Opposite effects of above	Viscosity lower than calibrated	Change temperature, change fluid or recalibrate meter







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