**TriScroll™ 600 Series Dry Scroll Vacuum Pump**

**TIP SEAL REPLACEMENT MANUAL**
TriScroll™ 600 Series
Dry Scroll Vacuum Pump

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Loctite and PST are registered trademarks of Loctite Corporation.
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We declare under our sole responsibility that the product,
klären, in alleniniger Verantwortung, daß dieses Produkt,
déclarons sous notre seule responsabilité que le produit,
declaramos, bajo nuestra sola responsabilidad, que el producto,
verklaren onder onze verantwoordelijkheid, dat het product,
dichiariamo sotto nostra unica responsabilità, che il prodotto,

declare under our sole responsibility that the product,
eklären, in alleniniger Verantwortung, daß dieses Produkt,
déclarons sous notre seule responsabilité que le produit,
declaramos, bajo nuestra sola responsabilidad, que el producto,
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declaramos, bajo nuestra sola responsabilidad, que el producto,
verklaren onder onze verantwoordelijkheid, dat het product,
dichiariamo sotto nostra unica responsabilità, che il prodotto,

declare under our sole responsibility that the product,

**TriScroll Series Vacuum Pump**

to which this declaration relates is in conformity with the following standard(s) or other normative documents.
auf das sich diese Erklärung bezieht, mit der/den flogenden Norm(en) oder Richtlinie(n) übereinstimmt.
auquel se réfère cette déclaration est conforme à la (aux) norme(s) ou au(x) document(s) normatif(s).
al que se refiere esta declaración es conforme a la(s) norma(s) u otro(s) documento(s) normativo(s).
waamaar deze verklaring verwijst, aan de volgende norm(en) of richtlijn(en) beantwoordt.
a cui se riferisce questa dichiarazione è conforme alla/e sequente/i norma/o documento/i normativo/i.

**98/37/EEC, Machinery Directive**

- EN 1012-2:1996 Compressors and Vacuum Pumps Safety Requirements; Part 2 Vacuum Pumps
- EN 1050:1996 Safety of machinery - principles for risk assessment
- EN 60204-1 Electrical equipment of industrial machines; general requirements

**73/023/EEC, Low Voltage Directive**

- EN 60034 part 1 Rotating electrical machines - Part 1: Rating and performance

**89/336/EEC, Electromagnetic Compatibility Directive**

- EN 61000-4-2 Testing and Measurement Techniques - Electrostatic Discharge Immunity Test

Frederick C. Campbell
Operations Manager
Vacuum Technologies
Varian, Inc.
Lexington, Massachusetts, USA

March 2003
Preface

This manual provides the information you need to successfully perform tip seal replacement on your Vacuum Technologies TriScroll™ Dry Vacuum Pump. Tip seal replacement is generally recommended when the pump base pressure has risen to an unacceptably high level for your application. If you have questions that are not addressed in this manual, please contact the nearest Vacuum Technologies service facility listed on the rear cover of this manual.

Safety Considerations

READ THE FOLLOWING INSTRUCTIONS. TAKE ALL NECESSARY PRECAUTIONS.

The following format is used in this manual to call attention to hazards:

WARNING

The warning messages are for attracting the attention of the operator to a particular procedure or practice which, if not followed correctly, could lead to serious injury.

CAUTION

The caution messages are displayed before procedures, which if not followed, could cause damage to the equipment.

NOTE

The notes contain important information taken from the text.

Maintenance personnel must be aware of all hazards associated with this equipment. They must know how to recognize hazardous and potentially hazardous conditions, and know how to avoid them. The consequences of work performed by unskilled or improperly trained maintenance personnel, or careless operation of the equipment employed in the specified maintenance procedures can be serious. Every maintenance person must read and thoroughly understand the materials discussed and the instructions provided in this manual, as well as any additional information provided by Vacuum Technologies.
All warnings and cautions must be read carefully, fully understood, and strictly observed. Consult local, state/province, and national agencies regarding specific requirements and regulations. Address any safety, operation, and/or maintenance questions to the nearest Vacuum Technologies location.

**WARNING**
Disconnect power from the TriScroll 600 before performing any maintenance procedure.

Allow the pump to cool before performing any maintenance procedure. Approximate cool-down time is one to two hours.

**CAUTION**
Wipe all O-rings clean with a lint-free cloth before installation to ensure that no foreign matter is present to impair the seal.

Do not use alcohol, methanol or other solvents on O-rings. To do so causes deterioration and reduces their ability to hold a vacuum.

If applicable, apply a small amount of Krytox® GPL 224 grease and wipe the O-rings “shiny” dry.

**NOTE**
Vacuum Technologies recommends replacing all O-rings during routine maintenance or during any maintenance procedure requiring that O-rings be removed.

**WARNING**
The TriScroll 600 weighs 32 kg (70 lbs). To avoid injury, use proper lifting techniques when moving the pump.
Related TriScroll Manuals

Manuals related to the installation and operation, pump module replacement, and major maintenance for the TriScroll 600 series pumps are listed in the following table:

<table>
<thead>
<tr>
<th>Title</th>
<th>Applicable TriScroll Model</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Major Maintenance Manual</td>
<td>All TriScroll 600 Series Models</td>
<td>699904300</td>
</tr>
<tr>
<td>Pump Module Replacement</td>
<td>All TriScroll 600 Series Models</td>
<td>699904305</td>
</tr>
<tr>
<td>Installation and Operation Manual</td>
<td>All TriScroll 600 Series Models</td>
<td>699904290</td>
</tr>
</tbody>
</table>

Maintenance and Tool Kits

Material and tooling required to perform maintenance on TriScroll pumps is provided in kit form. A description of each kit and ordering information is provided in the following table:

<table>
<thead>
<tr>
<th>Description</th>
<th>Contents</th>
<th>Applicable TriScroll Model</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Major Maintenance Tool Kit</td>
<td>All bearings, bearing seals, bearing lubricant, O-rings, and tip seals required to rebuild TriScroll 600 Series pumps.</td>
<td>All TriScroll 600 Series models</td>
<td>PTSS0600MK</td>
</tr>
<tr>
<td>Maintenance Tool Kit</td>
<td>All fixtures and tools required to perform any maintenance on TriScroll 600 Series pumps.</td>
<td>All TriScroll 600 Series models</td>
<td>PTSS0600TK</td>
</tr>
<tr>
<td>Tip Seal Tool Kit</td>
<td>All tools required to change the tip seals on any TriScroll Series pump.</td>
<td>All TriScroll Series pumps</td>
<td>PTSTSTKIT</td>
</tr>
<tr>
<td>Replacement Tip Seal Set</td>
<td>Replacement tip seals and static O-rings for TriScroll 600 Series pumps.</td>
<td>All TriScroll 600 Series models</td>
<td>PTSS0600TS</td>
</tr>
</tbody>
</table>
Factory Service Options

Vacuum Technologies offers factory-rebuild service or advance exchange of complete TriScroll Pumps or TriScroll Pump Modules. Contact your nearest Vacuum Technologies sales office for price and availability information. Select your preferred service option from the table below.

<table>
<thead>
<tr>
<th>Factory Service Options</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Advance Exchange TriScroll 600 Single Phase</td>
<td>EXPPTS06001</td>
</tr>
<tr>
<td>Advance Exchange TriScroll 600 Three Phase</td>
<td>EXPPTS06003</td>
</tr>
<tr>
<td>Advance Exchange TriScroll 610 Single Phase</td>
<td>EXPPTS06101</td>
</tr>
<tr>
<td>Advance Exchange TriScroll 610 Three Phase</td>
<td>EXPPTS06103</td>
</tr>
<tr>
<td>Advance Exchange TriScroll 600 Pump Module Only</td>
<td>EXPTS0600SC</td>
</tr>
<tr>
<td>Advance Exchange TriScroll 610 Pump Module Only</td>
<td>EXPTS0610SC</td>
</tr>
<tr>
<td>Service/Rebuild TriScroll 600 Pump (Single or Three Phase)</td>
<td>PTS0600KMA</td>
</tr>
<tr>
<td>Service/Rebuild TriScroll 610 Pump (Single or Three Phase)</td>
<td>PTS0610KMA</td>
</tr>
<tr>
<td>Service/Rebuild TriScroll 600 Pump Module Only</td>
<td>PTS0600SCRP</td>
</tr>
<tr>
<td>Service/Rebuild TriScroll 610 Pump Module Only</td>
<td>PTS0610SCRP</td>
</tr>
</tbody>
</table>

Contacting Vacuum Technologies

In the United States, you can contact Vacuum Technologies Customer Service at 1-800-8VARIAN. See the back cover of this manual for a listing of our sales and service offices.

Internet users:

- Send email to Customer Service & Technical Support at vpl.customer.support@varianinc.com
- Visit our web site at www.varianinc.com/vacuum
- Order on line at www.evarian.com
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Tip Seal Replacement

General Information
Vacuum Technologies TriScroll 600 series pumps will provide years of trouble-free service if maintenance procedures and intervals are observed. Bearing grease replenishment and tip seal replacement is recommended when the pump base pressure rises to an unacceptably high level for your application. Replace bearings, rotary seals and O-rings if the pump bearings exhibit humming or grinding noises. Main bearing life may be shortened if your application requires the pumping of high quantities of water vapor. Use bearing purge to keep this water from impacting bearing life.

Required Equipment
- **Tip Seal Replacement Kit**: PTSS0600TS (“Tip Seal Replacement Kit” on page 2)
- **Tip Seal Tool Kit**: PTSTSTKIT (“Tip Seal Tool Kit” on page 3; customer can supply metric Allen wrench set and chisel).
- **Vacuum Measuring Gauge**: Capable of measuring pressures of 5 to 20 mTorr with an accuracy of ±1 mTorr. A capacitance manometer or Pirani gauge is recommended.
Tip Seal Replacement Kit

Tip Seal

Krytox GPL 224 Grease
Tip Seal Tool Kit

Chisel

Metric Hex Key Set
TriScroll 600 Disassembly

Remove the Intake Fitting

1. Remove the two M5x16 screws from the intake assembly.

2. Remove the intake assembly from the top of the pump.

3. Remove and discard the O-ring from the groove on the underside of the intake fitting.
Remove the Outboard Housing

1. Remove the three M5x16 screws that attach the cowling to the module.
2. Remove the cowling.
3. Remove the six M6x55 screws that attach the outboard housing to inboard housing.
4. Remove the outboard housing.
5. Remove and discard the O-ring.

6. Remove and discard the tip seals from the outboard housing.
TriScroll 600 Disassembly (Continued)

Remove the Inboard Housing and Orbiting Plate Assembly

1. Remove the four M5x15 screws that attach the inboard housing to the frame.

2. Remove the inboard housing from the frame.
   Locate the rubber spider that mounts between the motor shaft coupling and the inboard housing assembly.

CAUTION
The inboard housing assembly weighs 22 lbs.
Disassemble the Inboard Housing and the Orbiting Plate Assembly

1. Remove the M8x12 screw and washer that attaches the counterweight to the inboard housing.

2. Lift the counterweight off the inboard housing.

   The counterweight is keyed to the crankshaft. Locate the key after removal of the counterweight from the inboard housing.
3. Remove the inboard housing from the crankshaft and orbiting plate.

4. Remove and discard the tip seals from the inboard housing.
5. Remove and discard the tip seals from both sides of the orbiting plate.
Scroll Cleaning

1. Carefully scrape with a chisel to loosen the tip seal dust from the:
   - Orbiting plate
   - Inboard housing
   - Outboard housing

   **CAUTION**  Do not scratch or gouge any surface.

If seal debris is attached to the sides of the scroll walls, use a razor blade or Exacto knife to scrape this debris off.

2. Use dry compressed air to remove the tip seal debris from the scroll parts.

   **CAUTION**  Do not blow compressed air or debris into exposed bearings.

3. Wipe the scroll parts with isopropyl alcohol and a clean lint free cloth to remove any remaining tip seal debris.

TriScroll 600 Disassembly (Continued)
TriScroll 600 Reassembly

1. Insert the new tip seal into the scroll tip grooves on the inboard housing side of the orbiting plate.

2. Cut the seal to the correct length at the end of each groove. Leave a gap of 1/4" (6 mm) from the outer end to allow for thermal growth.

3. Insert the new tip seal into the scroll tip grooves on the inboard housing.

4. Cut the seal to the correct length at the end of each groove. Leave a gap of 1/4" (6 mm) from the outer end to allow for thermal growth.
5. Place the scroll in the vertical position and reinstall the inboard housing onto the crankshaft.

   Placing the scroll in the vertical position keeps the tip seals from falling out of the grooves during reassembly.

6. Ensure that the scroll walls are properly aligned to allow full engagement of the two parts.

7. Reinstall the counterweight onto the crankshaft.

8. Align the keyways in the counterweight and crankshaft and install the key.

9. Secure the counterweight to the crankshaft using the M8x12 screw and washer.
TriScroll 600 Reassembly (Continued)

10. Install the rubber spider into motor shaft coupling.

11. Align the motor coupling to properly mate with the fan hub coupling.

12. Install the inboard housing onto the frame.
TriScroll 600 Reassembly (Continued)

13. Secure the inboard housing assembly to the frame using the four M5x15 screws.

14. Insert the tip seal into the scroll tip grooves on the orbiting plate.

15. Cut the seal to the correct length at the end of each groove. Leave a gap of 1/8" (3mm) from the outer end to allow for thermal growth.
16. Squeeze a dot of Krytox GPL 224 grease into each of the three needle bearings.
17. Smear grease over the needles.
18. Coat the lips of all three seals with grease.
19. Lightly grease the new 2-273 O-ring (large) and install it around the lip on the inboard housing.
20. Insert the tip seals into the grooves on the outboard housing.
21. Cut the seal to the correct length at the end of each groove. Leave a gap of 1/8" (3mm) from the outer end to allow for thermal growth.

22. Install the outboard housing over the orbiting plate and against the inboard housing, engaging the dowel pins and all the sync cranks.

**NOTE**

Orient the sync cranks and the orbiting plate in the downward position before installing the outboard housing.

23. Secure the outboard housing to the inboard housing with the six M6x55 screws.
24. Install the cowling over the pump module.
25. Secure with the three M5x16 screws.
26. Lightly grease the new 2-127 O-ring and insert it into the groove on the intake fitting.
27. Place the intake fitting assembly into the outboard housing.

28. Secure the fitting with the two M5x16 screws.
Put the Pump Back into Service

The TriScroll 600 pump can be placed into service immediately after maintenance is complete. However, 24 hours of run time is required before base pressure of 7 mTorr can be achieved.

**NOTE**

The 24 hour run time does not have to be continuous. If your application requires a low base pressure, it is wise to run the pump for the 24-hour period for optimum performance.
Request for Return
Health and Safety Certification

1. Return authorization numbers (RA#) will not be issued for any product until this Certificate is completed and returned to a Varian, Inc. Customer Service Representative.
2. Pack goods appropriately and drain all oil from rotary vane and diffusion pumps (for exchanges please use the packing material from the replacement unit), making sure shipment documentation and package label clearly shows assigned Return Authorization Number (RA#) VVT cannot accept any return without such reference.
3. Return product(s) to the nearest location:

North and South America
Varian, Inc.
Vacuum Technologies
121 Hartwell Ave.
Lexington, MA 02421
Fax: (781) 860-9252

Europe and Middle East
Varian S.p.A.
Via Flli Varian, 54
10040 Leini (TO) – ITALY
Fax: (39) 011 997 9350

Asia and ROW
Varian Vacuum Technologies
Local Office

For a complete list of phone/fax numbers see www.varianinc.com/vacuum

4. If a product is received at Varian, Inc. in a contaminated condition, the customer is held responsible for all costs incurred to ensure the safe handling of the product, and is liable for any harm or injury to Varian, Inc. employees occurring as a result of exposure to toxic or hazardous materials present in the product.

CUSTOMER INFORMATION
Company name: .................................................................................................................. ....................................................
Contact person: Name: ...................................................................................................... Tel:.................................................................
Fax: ................................................................................................................................. E-mail:.................................................................
Ship method: Shipping Collect #: .................................. P.O.#: ..................................................
Europe only: VAT Reg Number: .......... USA only: ☐Taxable ☐Non-taxable
Customer ship to: ............................................................................................................
Customer bill to: .............................................................................................................

PRODUCT IDENTIFICATION

<table>
<thead>
<tr>
<th>Product Description</th>
<th>Varian, Inc. Part Number</th>
<th>Varian, Inc. Serial Number</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

TYPE OF RETURN (check appropriate box)
☐ Paid Exchange ☐ Paid Repair ☐ Warranty Exchange ☐ Warranty Repair ☐ Loaner Return
☐ Credit ☐ Shipping Error ☐ Evaluation Return ☐ Calibration ☐ Other

HEALTH and SAFETY CERTIFICATION

VARIOUS TECHNOLOGIES CANNOT ACCEPT ANY BIOLOGICAL HAZARDS, RADIOACTIVE MATERIAL, ORGANIC METALS, OR MERCURY AT ITS FACILITY. CHECK ONE OF THE FOLLOWING:

☐ I confirm that the above product(s) has (have) NOT pumped or been exposed to any toxic or dangerous materials in a quantity harmful for human contact.

☐ I declare that the above product(s) has (have) pumped or been exposed to the following toxic or dangerous materials in a quantity harmful for human contact (Must be filled in):

Print Name................................................ Signature ................................................... Date ..........................

PLEASE FILL IN THE FAILURE REPORT SECTION ON THE NEXT PAGE

Do not write below this line
Notification (RA) #: .................................. Customer ID #: .................................. Equipment #: ..................................
FAILURE REPORT
(Please describe in detail the nature of the malfunction to assist us in performing failure analysis):

### TURBO PUMPS AND TURBOCONTROLLERS

<table>
<thead>
<tr>
<th>Claimed Defect</th>
<th>Position</th>
<th>Parameters</th>
</tr>
</thead>
<tbody>
<tr>
<td>❑ Does not start</td>
<td>❑ Noise</td>
<td>❑ Vertical</td>
</tr>
<tr>
<td>❑ Does not spin freely</td>
<td>❑ Vibrations</td>
<td>❑ Horizontal</td>
</tr>
<tr>
<td>❑ Does not reach full speed</td>
<td>❑ Leak</td>
<td>❑ Upside-down</td>
</tr>
<tr>
<td>❑ Mechanical Contact</td>
<td>❑ Overtemperature</td>
<td>❑ Other</td>
</tr>
<tr>
<td>❑ Cooling defective</td>
<td>❑ Clogging</td>
<td></td>
</tr>
</tbody>
</table>

Describe Failure:

Turbocontroller Error Message:

### ION PUMPS/CONTROLLERS

<table>
<thead>
<tr>
<th>Claimed Defect</th>
<th>Position</th>
</tr>
</thead>
<tbody>
<tr>
<td>❑ Bad feedthrough</td>
<td>❑ Poor vacuum</td>
</tr>
<tr>
<td>❑ Vacuum leak</td>
<td>❑ High voltage problem</td>
</tr>
<tr>
<td>❑ Error code on display</td>
<td>❑ Other</td>
</tr>
</tbody>
</table>

Describe failure:

Customer application:

### VALVES/COMPONENTS

<table>
<thead>
<tr>
<th>Claimed Defect</th>
<th>Position</th>
</tr>
</thead>
<tbody>
<tr>
<td>❑ Main seal leak</td>
<td>❑ Bellows leak</td>
</tr>
<tr>
<td>❑ Solenoid failure</td>
<td>❑ Damaged flange</td>
</tr>
<tr>
<td>❑ Damaged sealing area</td>
<td>❑ Other</td>
</tr>
</tbody>
</table>

Describe failure:

Customer application:

### LEAK DETECTORS

<table>
<thead>
<tr>
<th>Claimed Defect</th>
<th>Position</th>
</tr>
</thead>
<tbody>
<tr>
<td>❑ Cannot calibrate</td>
<td>❑ No zero/high background</td>
</tr>
<tr>
<td>❑ Vacuum system unstable</td>
<td>❑ Cannot reach test mode</td>
</tr>
<tr>
<td>❑ Failed to start</td>
<td>❑ Other</td>
</tr>
</tbody>
</table>

Describe failure:

Customer application:

### INSTRUMENTS

<table>
<thead>
<tr>
<th>Claimed Defect</th>
<th>Position</th>
</tr>
</thead>
<tbody>
<tr>
<td>❑ Gauge tube not working</td>
<td>❑ Display problem</td>
</tr>
<tr>
<td>❑ Communication failure</td>
<td>❑ Degas not working</td>
</tr>
<tr>
<td>❑ Error code on display</td>
<td>❑ Other</td>
</tr>
</tbody>
</table>

Describe failure:

Customer application:

### ALL OTHER VARIAN, INC.

<table>
<thead>
<tr>
<th>Claimed Defect</th>
<th>Position</th>
</tr>
</thead>
<tbody>
<tr>
<td>❑ Pump doesn’t start</td>
<td>❑ Noisy pump (describe)</td>
</tr>
<tr>
<td>❑ Doesn’t reach vacuum</td>
<td>❑ Overtemperature</td>
</tr>
<tr>
<td>❑ Pump seized</td>
<td>❑ Other</td>
</tr>
</tbody>
</table>

Describe failure:

Customer application:

### DIFFUSION PUMPS

<table>
<thead>
<tr>
<th>Claimed Defect</th>
<th>Position</th>
</tr>
</thead>
<tbody>
<tr>
<td>❑ Heater failure</td>
<td>❑ Electrical problem</td>
</tr>
<tr>
<td>❑ Doesn’t reach vacuum</td>
<td>❑ Cooling coil damage</td>
</tr>
<tr>
<td>❑ Vacuum leak</td>
<td>❑ Other</td>
</tr>
</tbody>
</table>

Describe failure:

Customer application:
Sales and Service Offices

Canada
Central coordination through:
Varian, Inc.
121 Hartwell Avenue
Lexington, MA 02421
USA
Tel: (781) 861 7200
Fax: (781) 860 5437
Toll Free: (800) 882 7426

China
Varian Technologies - Beijing
Room 1201, Jinyu Mansion
No. 129A, Xuanwumen Xidajie
Xicheng District
Beijing 100031
P.R. China
Tel: (86) 10 6608 1031
Fax: (86) 10 6608 1541

France and Benelux
Varian s.a.
7 avenue des Tropiques
Z.A. de Courtaboeuf – B.P. 12
Les Ulis cedex (Orsay) 91941
France
Tel: (33) 1 69 86 38 13
Fax: (33) 1 69 28 23 08

Germany and Austria
Varian Deutschland GmbH
Alsfelder Strasse 6
Postfach 11 14 35
64289 Darmstadt
Germany
Tel: (49) 6151 703 353
Fax: (49) 6151 703 302

India
Varian India PVT LTD
101-108, 1st Floor
1010 Competent House
7, Nangal Raya Business Centre
New Delhi 110 046
India
Tel: (91) 11 5548444
Fax: (91) 11 5548445

Italy
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Via F.lli Varian, 54
10040 Leini, (Torino)
Italy
Tel: (39) 011 997 9 111
Fax: (39) 011 997 9 350

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Sumitomo Shibaura Building, 8th Floor
4-16-36 Shibaura
Minato-ku, Tokyo 108
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Fax: (81) 3 5232 1263

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Varian Technologies Korea, Ltd.
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966-5 Daechi-dong
Kangnam-gu, Seoul
Korea 135-280
Tel: (82) 2 3452 2452
Fax: (82) 2 3452 2451

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Varian S.A.
Concepcion Beistegui No 109
Col Del Valle
C.P. 03100
Mexico, D.F.
Tel: (52) 5 523 9465
Fax: (52) 5 523 9472

Russia
Central coordination through:
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via F.lli Varian 54
10040 Leini, (Torino)
Italy
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Fax: (39) 011 997 9 316

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18F-13 No.79, Hsin Tai Wu Road
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Fax: (886) 2 2698 9678

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Fax: (44) 1932 22 8769

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Fax: (781) 860 5437

Other Countries
Varian, Inc.
Via F.lli Varian 54
10040 Leini, (Torino)
Italy
Tel: (39) 011 997 9 111
Fax: (39) 011 997 9 350

Customer Support and Service:

North America
Tel: 1 (800) 882-7426 (toll-free)
vrl.technical.support@varianinc.com

Europe
Tel: 00 (800) 234 234 00 (toll-free)
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Japan
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