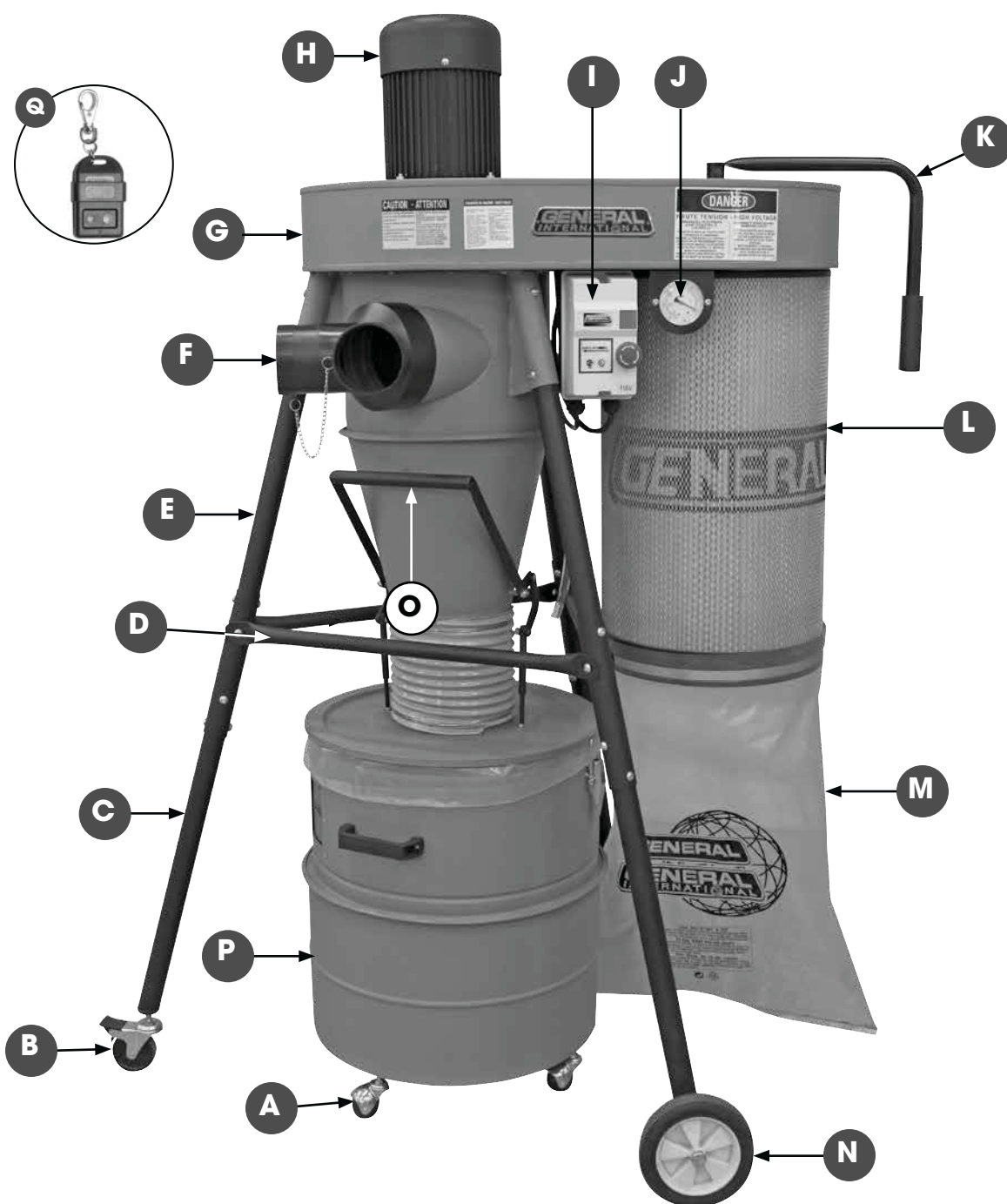


IDENTIFICATION OF MAIN PARTS AND COMPONENTS



- A. SWIVEL CASTER
- B. LOCKABLE SWIVEL CASTER
- C. LOWER LEG
- D. CROSS BRACE
- E. UPPER LEG
- F. 4" & 6" HOSE INLET
- G. IMPELLER/SEPARATOR ASSEMBLY
- H. MOTOR
- I. ON/OFF MAGNETIC SWITCH

- J. PRESSURE GAUGE
- K. CANISTER FILTER HANDLE
- L. CANISTER FILTER
- M. COLLECTOR BAG
- N. WHEEL
- O. QUICK-REMOVE DRUM LID HANDLE
- P. CHIP COLLECTION DRUM ASSEMBLY
- Q. REMOTE CONTROLLER

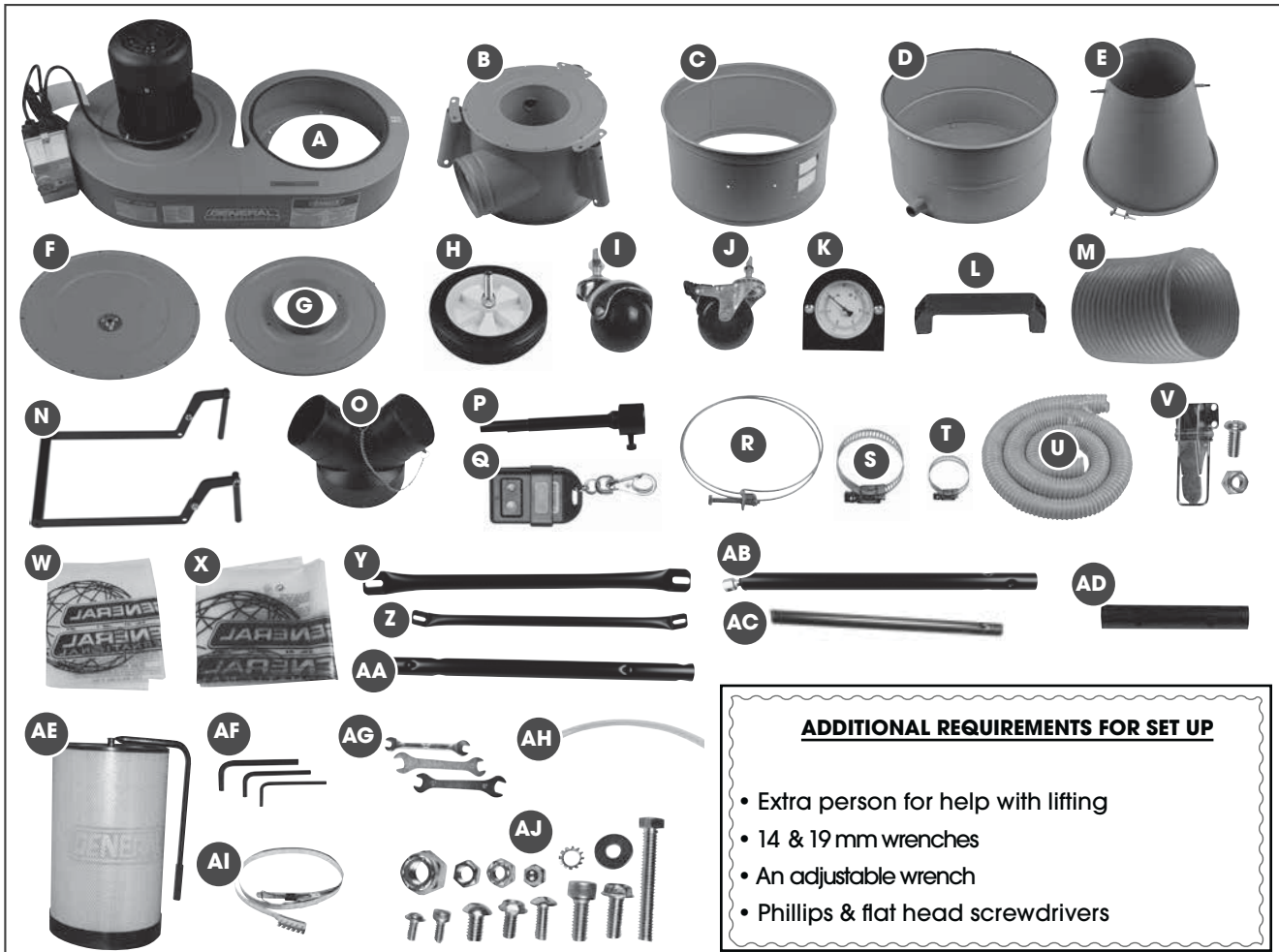
UNPACKING

Carefully unpack and remove the unit and its components from the box and check for missing or damaged items as per the list of contents below.

NOTE: PLEASE REPORT ANY DAMAGED OR MISSING ITEMS TO YOUR GENERAL® INTERNATIONAL DISTRIBUTOR IMMEDIATELY.

LIST OF CONTENTS

	QTY		
A. IMPELLER/SEPARATOR ASSEMBLY	1	S. HOSE CLAMP (LARGE)	2
B. UPPER CYCLONE SEPARATOR	1	T. HOSE CLAMP (SMALL)	2
C. UPPER COLLECTION DRUM	1	U. DUST HOSE	1
D. LOWER COLLECTION DRUM	1	V. LATCH (WITH 8 SCREWS AND NYLOCK NUTS)	2
E. LOWER CYCLONE SEPARATOR	1	W. COLLECTOR BAG	1
F. CANISTER LID	1	X. DRUM LINER BAG	1
G. COLLECTION DRUM LID	1	Y. CROSS BRACE (LONG)	2
H. WHEEL	2	Z. CROSS BRACE (SHORT)	1
I. SWIVEL CASTER (DRUM)	4	AA. UPPER LEG	3
J. LOCKABLE SWIVEL CASTER	1	AB. LOWER LEG (LONG)	2
K. PRESSURE GAUGE	1	AC. LOWER LEG (SHORT)	1
L. COLLECTION DRUM HANDLE	1	AD. CONNECTOR	3
M. JUNCTION HOSE	1	AE. CANISTER FILTER	1
N. QUICK-REMOVE HANDLE	1	AF. 4, 5, 6 MM ALLEN KEY	1
O. HOSE FITTING	1	AG. COMBINATION WRENCHES	3
P. FILTER HANDLE MOUNT ARM	1	AH. PRESSURE GAUGE HOSE	1
Q. REMOTE CONTROLLER	1	AI. BAG CLAMP	1
R. HOSE CLAMP	2	AJ. HARDWARE BAG	1



ADDITIONAL REQUIREMENTS FOR SET UP

- Extra person for help with lifting
- 14 & 19 mm wrenches
- An adjustable wrench
- Phillips & flat head screwdrivers

PLACEMENT WITHIN THE SHOP

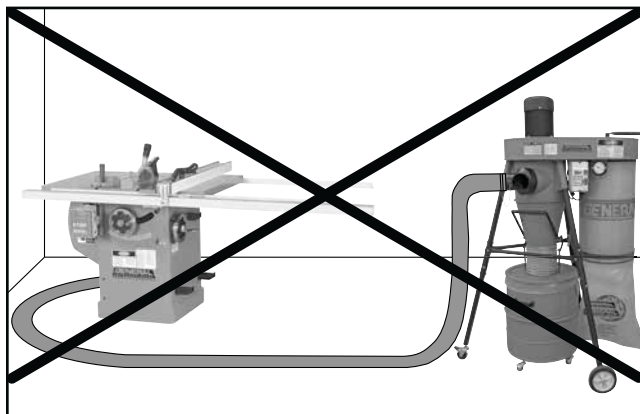
LAYING OUT A PLAN FOR THE PIPING

For permanent installations, it is advisable to map out a rough layout of your planned installation starting from the dust collector out to all the machines that you wish to connect to the system. You may vary your layout to suit your specific shop needs and may choose to use metal or plastic ducting, or flexible hose in any combination as suited to your needs.

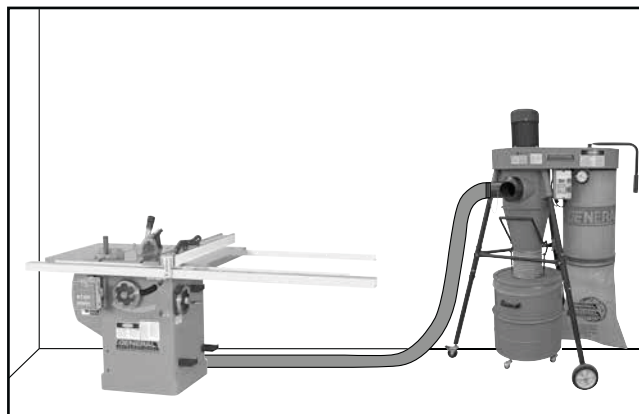
Note: To avoid accidents as well as damage to ducting or hoses, plan your installation with hoses and ducting running along walls or mounted from above wherever possible. See the accompanying examples of non-recommended and recommended installations.



HOSES AND DUCTING RUNNING ALONG THE SHOP FLOOR BETWEEN MACHINERY CAN CAUSE USERS TO TRIP AND LEAD TO SERIOUS INJURY.



Wherever possible avoid running hoses and ducting along the floor.



Keep hoses and ducting safely mounted along the walls.

ASSEMBLY INSTRUCTIONS

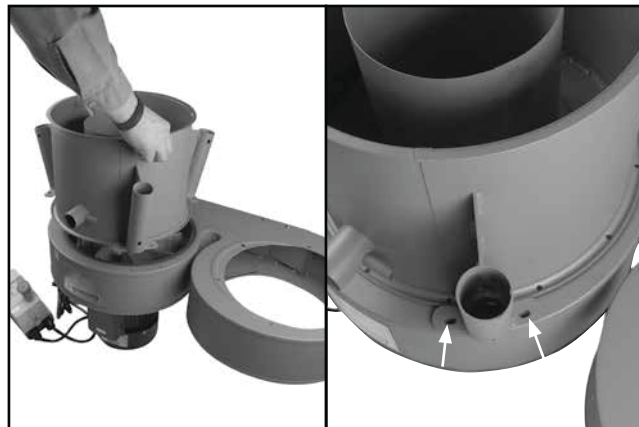


BEFORE ASSEMBLING, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED. DO NOT PLUG IN OR TURN ON THE MACHINE UNTIL YOU HAVE COMPLETED THE ASSEMBLY AND INSTALLATION STEPS DESCRIBED IN THIS SECTION OF THE MANUAL.

INSTALLING THE UPPER CYCLONE SEPARATOR ON THE IMPELLER/SEPARATOR



1. With the help of an assistant, set the impeller/separator upside down on a flat and stable surface.

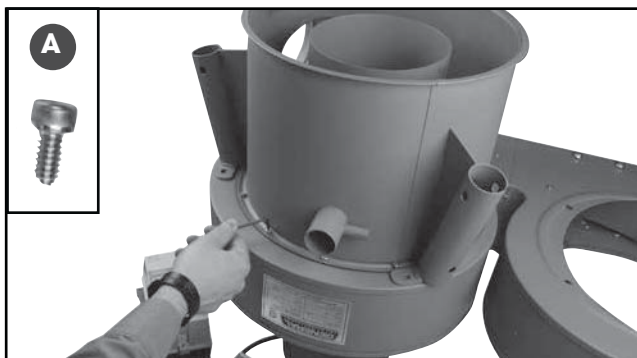


2. Place the upper cyclone on the impeller and align its mounting holes with the corresponding holes in the impeller separator.

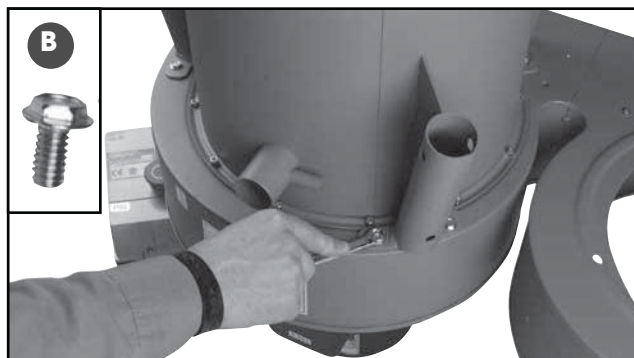


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INSTALLING THE UPPER CYCLONE SEPARATOR ON THE IMPELLER/SEPARATOR (CONTINUED)



- 3.** Attach the cyclone to the impeller using 12 cap screws **A** and a 4 mm Allen key.

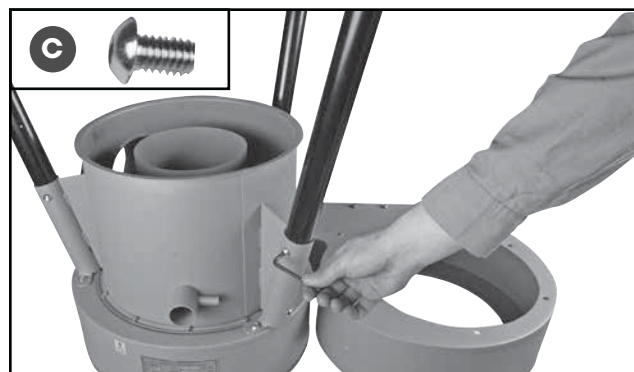


- 4.** Complete the assembly using 6 flange bolts **B** and a 12 mm wrench.

INSTALLING THE LEGS



- 1.** Insert an upper leg into the 3 upper cyclone mounting brackets.



- 2.** Align the leg mounting holes with the corresponding holes in the bracket, then secure each leg with 3 cap screws per leg **C** using a 5 mm Allen key.



- 3.** Slide a connector onto each leg, align its mounting holes with the corresponding holes in the leg, then secure the connector with 3 cap screws **D** per connector using a 5 mm Allen key.

Note: Do not use the hole **E**, this hole is used for the cross braces later.



- 4.** Insert the short lower leg into **F** and the two other legs into the other connectors. Twist the legs to align their mounting holes with the corresponding holes in the leg connectors, making sure the legs are leveled, then secure each leg with 4 cap screws per leg using a 5 mm Allen key.

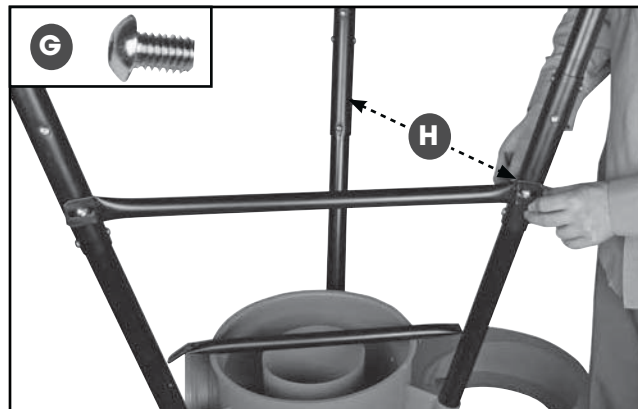


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INSTALLING THE LEGS (CONTINUED)



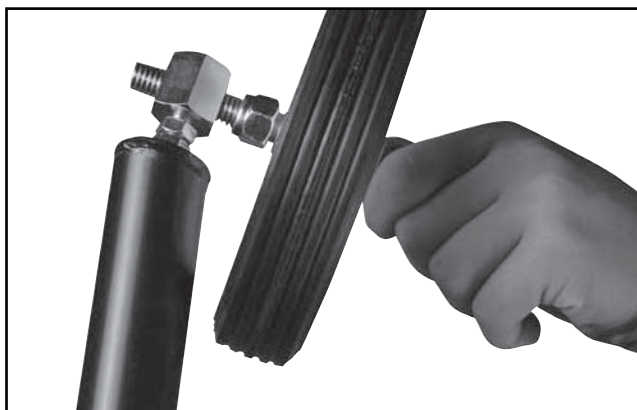
5. Align the cross brace mounting holes with the corresponding holes in the legs connectors.



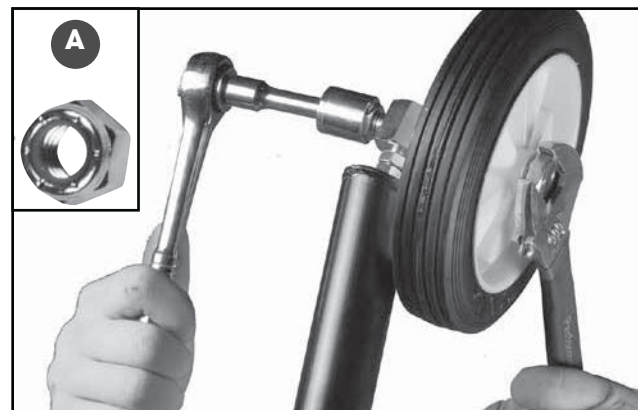
6. Attach a cross brace by hand tightening a screw **G** at each end. Repeat with the other cross braces, then tighten all the screws with a 5 mm Allen key.

Note: The short cross brace can only be installed between the closest two legs **H**.

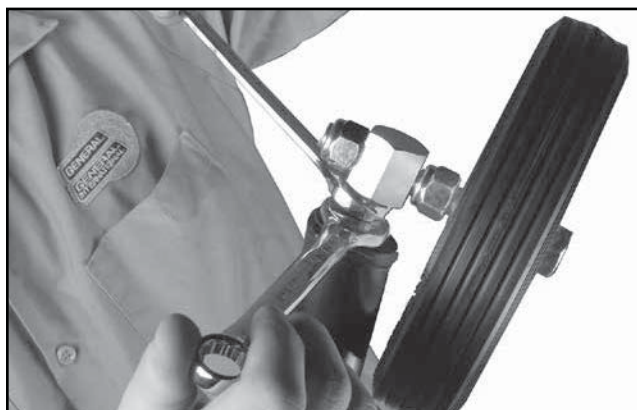
INSTALLING THE WHEELS AND LOCKABLE SWIVEL CASTERS



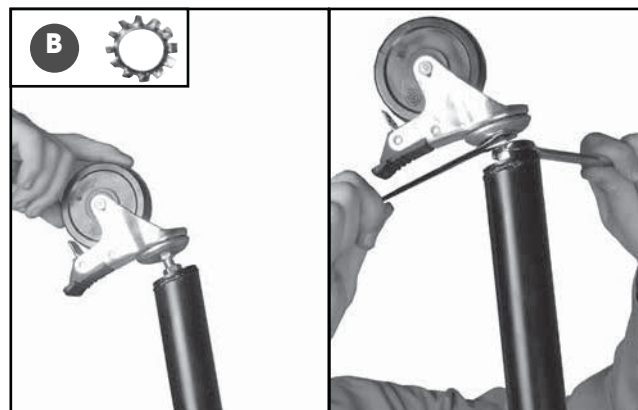
1. Screw the wheel axes into their supports in the end of the long lower legs.



2. Attach the wheels by tightening the nylock nut **A** using a 19 mm wrench and an adjustable wrench.



3. Secure the wheels in the proper position by tightening the jam nuts using two 14 mm wrenches.



4. Screw the lockable swivel caster with a sprocket washer **B** into the short leg, then secure it in position by tightening the two jam nuts using two 14 mm wrenches.

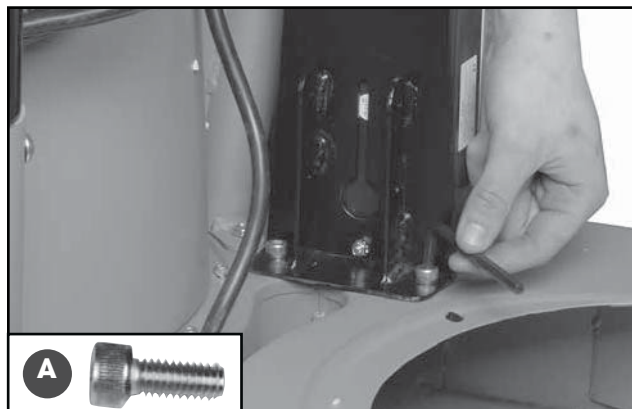


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INSTALLING THE SWITCH BOX

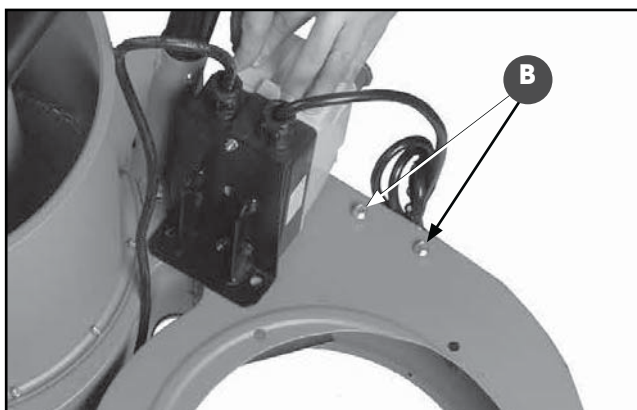


1. Align the switch bracket mounting holes with the corresponding holes in the impeller.

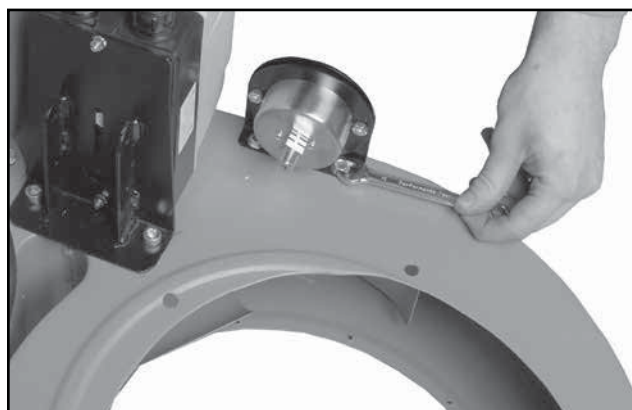


2. Attach the switch box to the impeller with two cap screws **A** using a 6 mm Allen key.

INSTALLING THE PRESSURE GAUGE



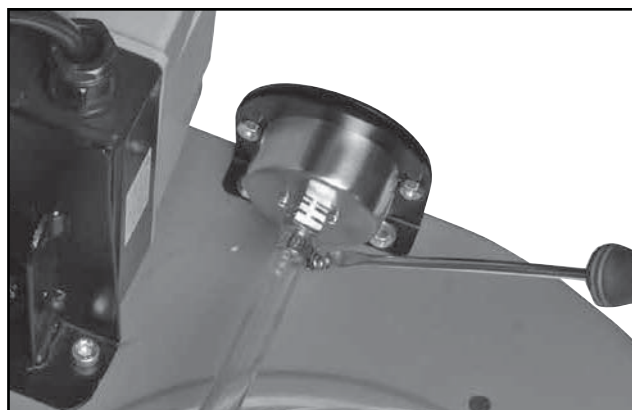
1. Using a 10 mm wrench remove the 2 flange bolts **B**.



2. Attach the pressure gauge to the impeller with the flange bolts you just removed.



3. Slide a small hose clamp onto the end of the hose.



4. Slide the hose onto the gauge inlet, then tighten the hose clamp using a flat screwdriver.

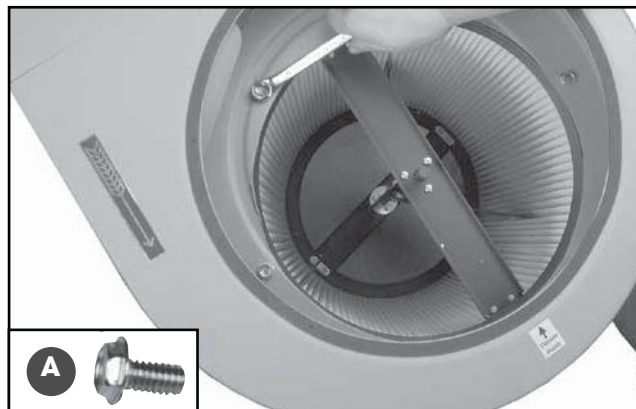


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INSTALLING THE CANISTER FILTER



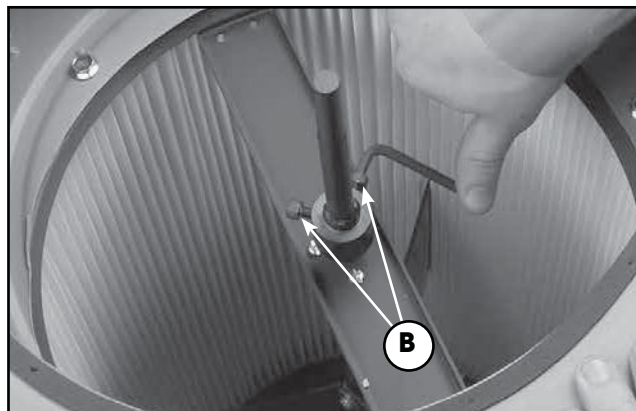
1. With the help of an assistant, turn the machine upright on a flat surface, then fit the canister against the impeller.



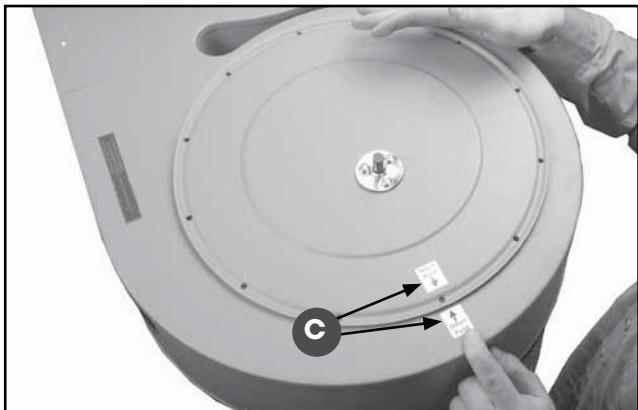
2. Align the canister mounting holes with the corresponding holes in the impeller, then attach the canister with 6 flange bolts **A** using a 12 mm wrench.



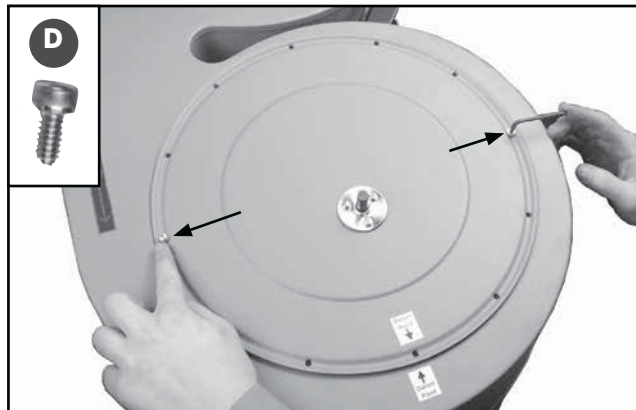
3. Slide the mounting arm onto the canister shaft.



4. Secure the arm by tightening screws **B** using a 5 mm Allen key.



5. Place the canister lid on the impeller with the mounting arm through the center hole. Align the reference marks **C**.



6. Align the lid mounting holes with the corresponding holes in the impeller, then secure the lid by starting with screws **D** on opposite sides.

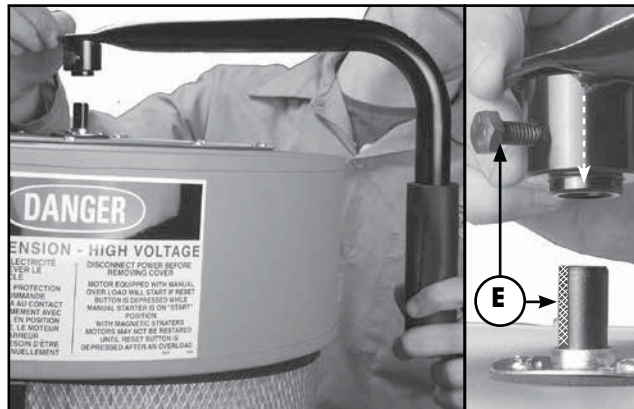


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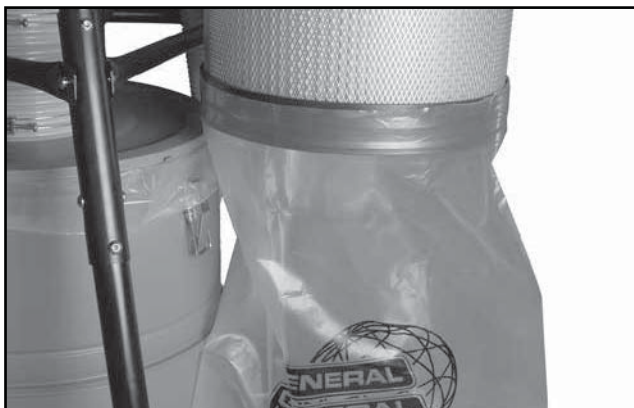
INSTALLING THE CANISTER FILTER (CONTINUED)



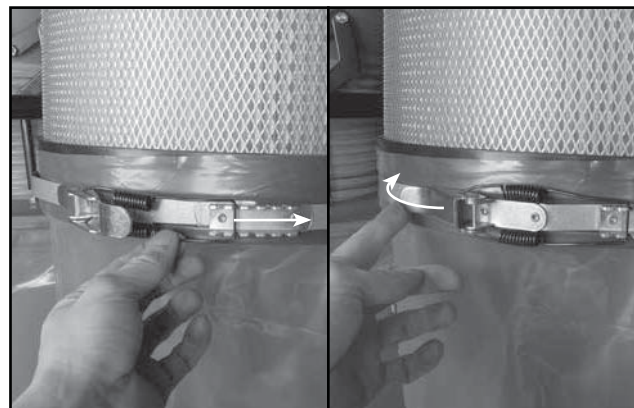
- 7.** Once all the screws are installed, tighten them all the way for an airtight seal.



- 8.** Fit the handle onto the mounting arm, making sure the bolt is aligned with the flat side of the arm. Then secure it in place with the bolt **E** using a 10 mm wrench.



- 9.** Fit the plastic collector bag over the bottom of the canister filter.



- 10.** Use the belt clamp to hold the bag in place, making sure the metal strap is sitting in the groove on the lower portion of the canister.

ASSEMBLING/INSTALLING THE COLLECTION DRUM



- 1.** Set the lower drum upside down on a flat surface.



- 2.** Screw the 4 swivel casters to their mounting holes.



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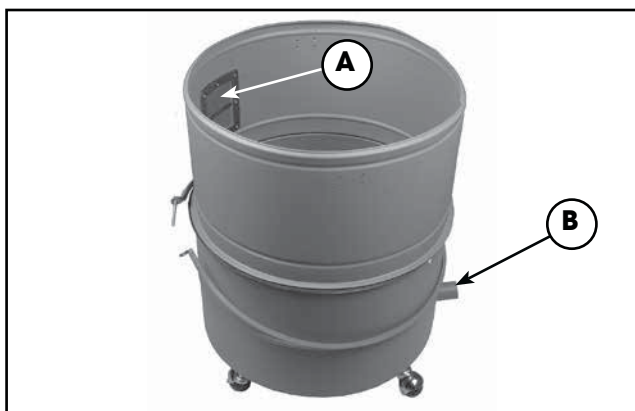
ASSEMBLING/INSTALLING THE COLLECTION DRUM (CONTINUED)



- 3.** Lock each swivel caster by tightening the jam nuts with two 12 mm wrenches.



- 4.** Remove the metal belt using a 10 mm wrench.



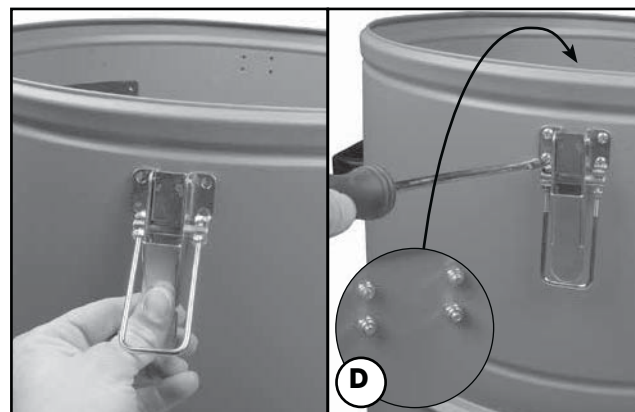
- 5.** Set the upper drum on the lower drum, positioning the window **A** opposite the tube **B**.



- 6.** Slide the metal belt down over the top drum and tighten it over the joint between the 2 drums to hold them together.



- 7.** Install the drum handle with phillips screws and cap nuts **C** using a screwdriver and pliers.



- 8.** Align the latch mounting holes with the holes in the drum. Attach the 2 latches to the drum using phillips screws with and nylock nuts inside the drum **D**.

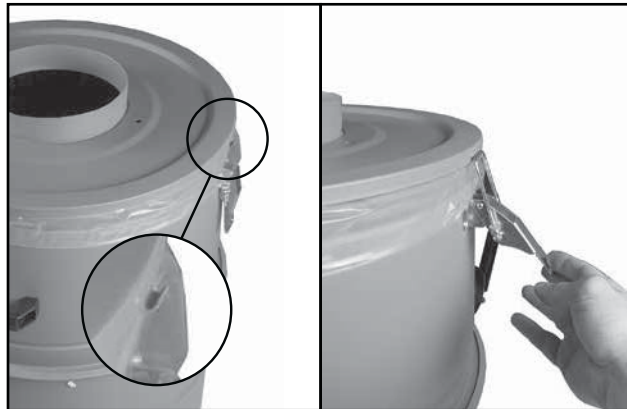


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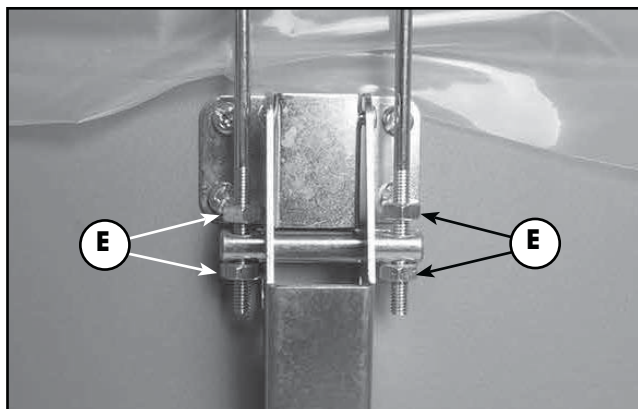
ASSEMBLING/INSTALLING THE COLLECTION DRUM (CONTINUED)



- 9.** Install the liner bag (the bigger of the 2) inside the drum.



- 10.** Place the lid on the drum making sure the hooks are aligned with the latches. Secure the drum lid by clamping the latches.



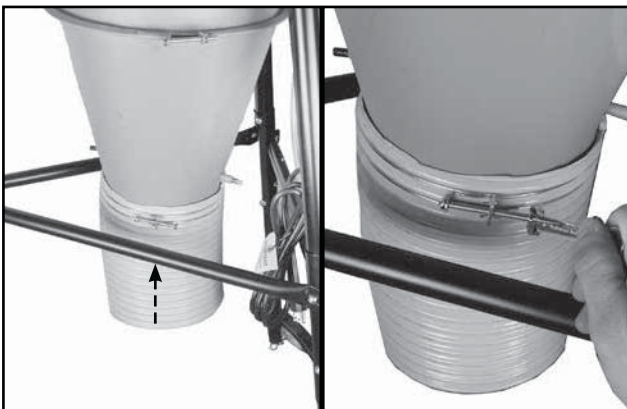
Note: If needed, adjust the nuts and jam nuts E so that the latches firmly close the lid.



- 11.** Remove the lower cyclone separator metal belt using a 10 mm wrench.



- 12.** With the help of an assistant, hold the lower cyclone against the upper cyclone and tighten it over the joint between the 2 sections to hold them together using a 10 mm wrench.



- 13** Fit a hose clamp onto the junction hose, then slide the hose onto the cyclone. Tighten the hose clamp using a 10 mm wrench.

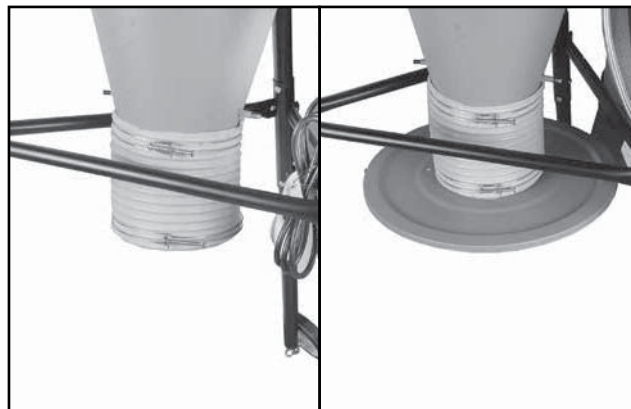


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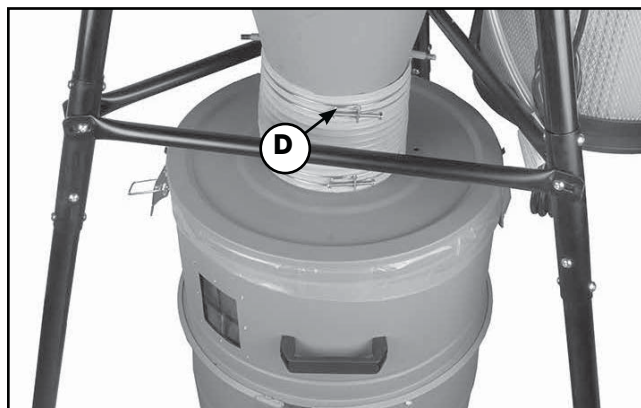
ASSEMBLING/INSTALLING THE COLLECTION DRUM (CONTINUED)



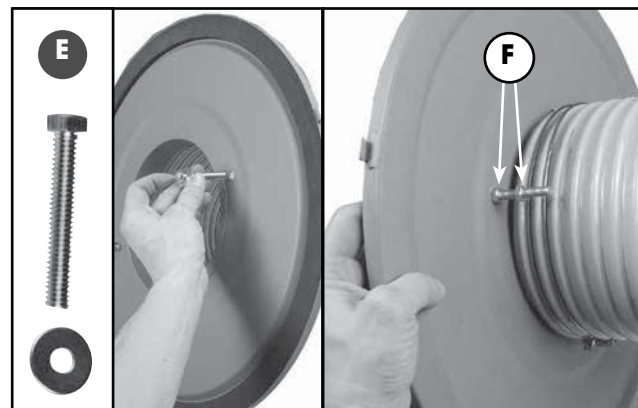
- 14.** Place the drum against the junction hose to evaluate if the hose needs to be cut. Make a reference mark and cut as needed.



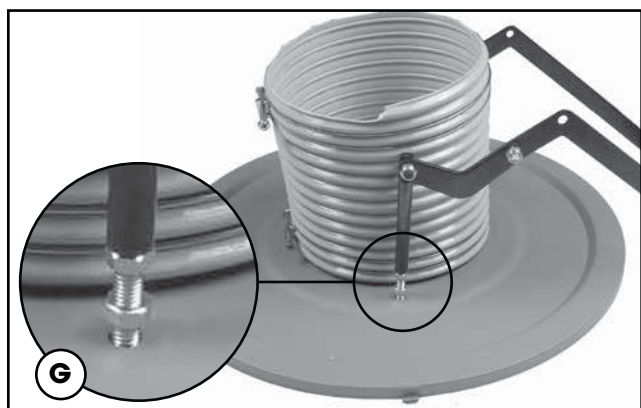
- 15.** Fit the other hose clamp onto the opposite end of junction hose. Slide the fitting on the drum lid into the junction hose, and tighten the hose clamp.



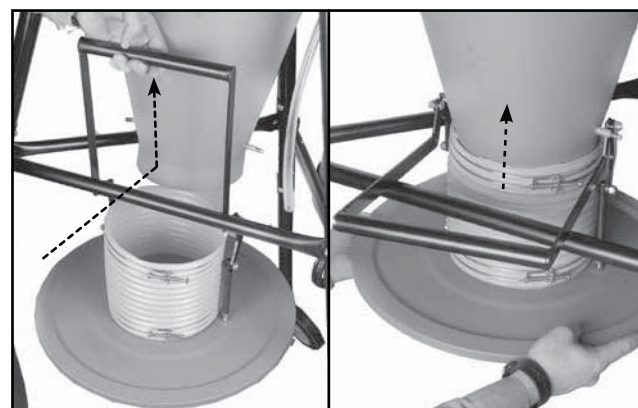
- 16.** Verify that the junction hose has been cut to the correct length by placing the drum under the lid. Then remove the drum and detach the hose with the lid from the cyclone by loosening the hose clamp **D**.



- 17.** Insert a bolt with a washer **E** into the 2 holes in the lid. From the top of the lid install 2 nuts onto each bolt **F**.



- 18.** Hand tighten the bolts in the threaded ends of the quick-remove handle draw bars **G**.

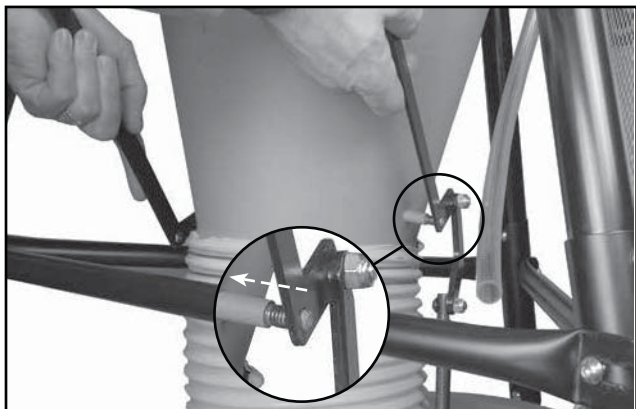


- 19.** Pass the handle under and behind the front cross brace. Slide the hose back onto the cyclone, then tighten the hose clamp.



BEFORE ASSEMBLING, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED. DO NOT PLUG IN OR TURN ON THE MACHINE UNTIL YOU HAVE COMPLETED THE ASSEMBLY AND INSTALLATION STEPS DESCRIBED IN THIS SECTION OF THE MANUAL.

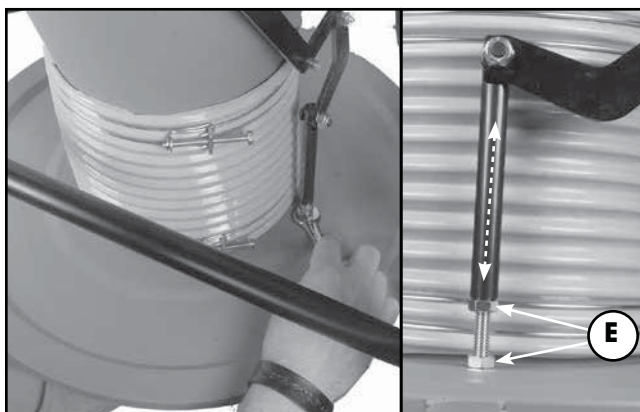
ASSEMBLING/INSTALLING THE DRUM COLLECTION (CONTINUED)



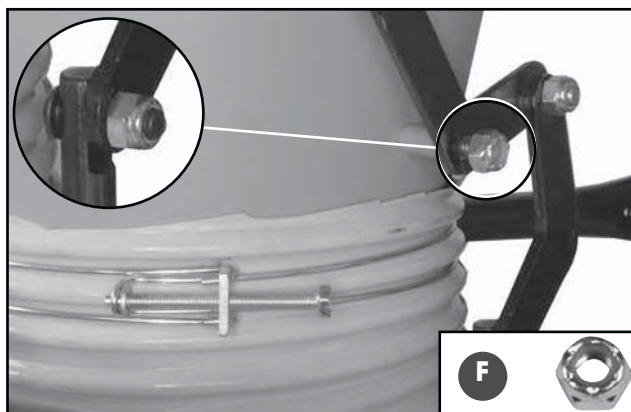
21. Spread the handle arms apart and slide them onto the threaded rods as shown.



22. Lower the handle to lift the lid and confirm that there is enough space between the lid and the drum to remove the drum easily.



23. Adjust the height of the arms as needed, then tighten the nuts **E** as shown: one against the lid and the other against the draw bar.



24. Once the handle is properly adjusted, lock it in place by screwing a nylock nut **F** on each threaded rod.

Note: Do not overtighten the nuts

CONNECTING THE PRESSURE GAUGE TO THE DRUM



1. Slide a small hose clamp onto the pressure gauge, and slide the hose onto the fitting at the rear of the impeller.



2. Using a Phillips screwdriver tighten the hose clamp.

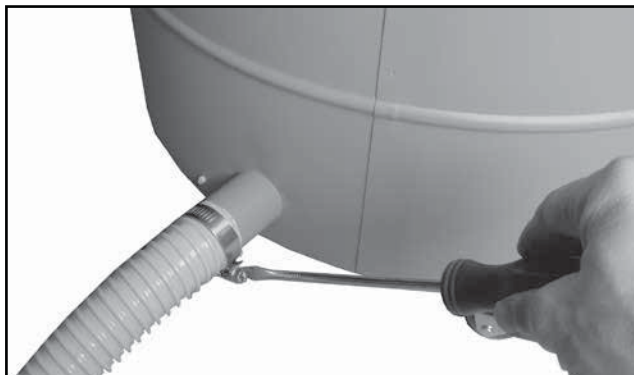


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CONNECTING THE PRESSURE GAUGE TO THE DRUM (CONTINUED)

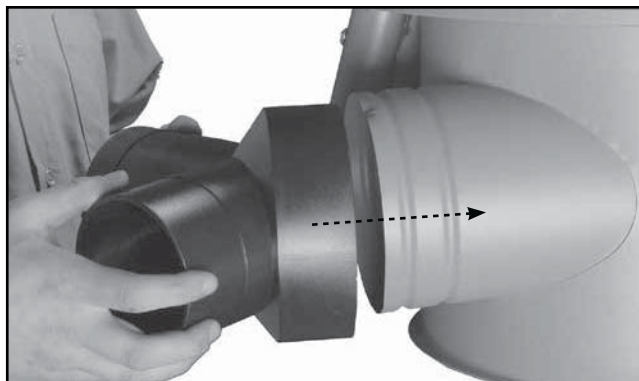


- 3.** Fit a hose clamp onto the dust hose, and slide the hose onto the fitting. Tighten the hose clamp using a Phillips screwdriver.

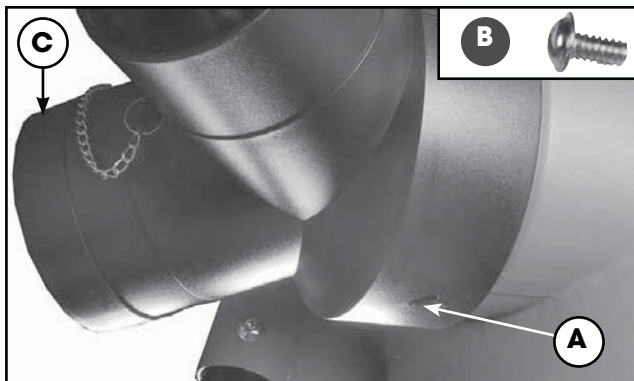


- 4.** Repeat with the other end of the hose at the bottom of the drum.

INSTALLING THE INLET FITTING



- 1.** Slide the hose fitting onto the inlet.



- 2.** Align the holes **A** and attach the fitting using the screw **B**.

Note: For maximum efficiency, a supplied cap should be installed on any unused openings **C**.

BASIC ADJUSTMENTS & CONTROLS



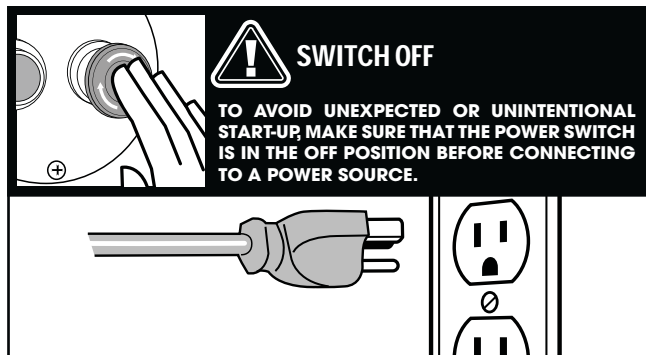
TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY. TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

CONNECTING TO A POWER SOURCE

Once the assembly steps have been completed, plug the power cord into an appropriate outlet.

Refer back to the section entitled "Electrical Requirements" and make sure all requirements and grounding instructions are followed.

When operations have been completed unplug the machine from the power source.



SWITCH OFF

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.



MAKE SURE THE MACHINE HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE OR ADJUSTMENTS.

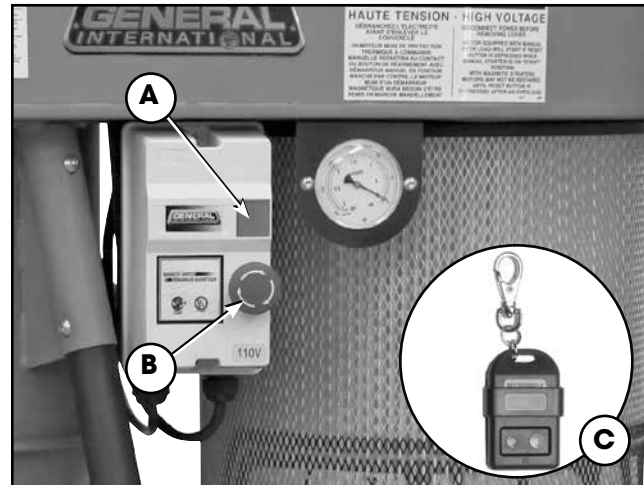
MAGNETIC SWITCH

This machine is equipped with a magnetic safety switch designed to protect the unit and the user from power surges, power outages or unintentional start-up.

The switch assembly is equipped with a green “start” button **A**, and a red “stop” button **B**.

Once the stop button has been pressed, the machine can only be started by turning the button to the right to release it.

The remote control **C** offers the exact same On/Off function as the magnetic switch, from virtually anywhere in the shop within the line of sight of the machine.



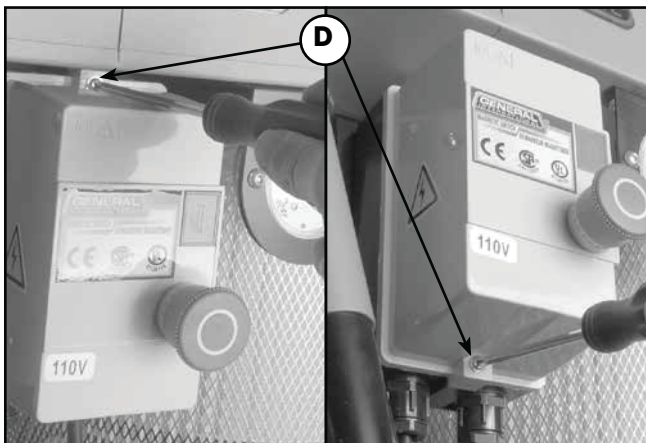
OVERLOAD PROTECTION

The magnetic safety switch on this machine is equipped with an overload protection feature. To prevent an electrical overload from damaging the motor, in the event of a spike in line voltage or amperage draw, the internal overload protector will automatically be tripped, thereby cutting off power to the motor.

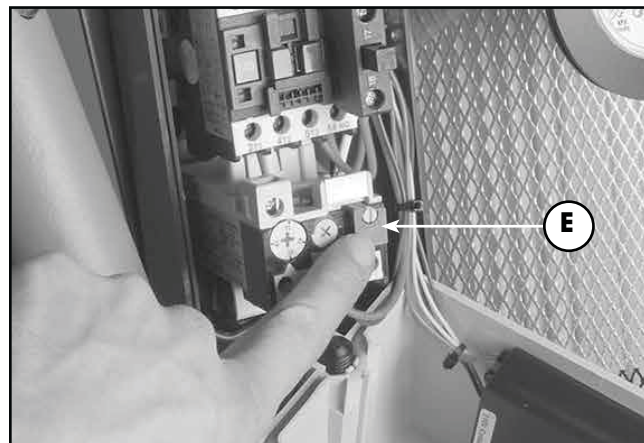
Common causes of such overloads:

- Overworking the motor, thereby causing an increase in power consumption and a spike in amperage draw.
- An electrical extension cord that is too long or not the correct gauge of wire, which can also cause an increase in amperage draw. If an electric extension cord must be used, follow the instructions and refer to the chart in the electrical requirements section at the beginning of this manual.
- Overworked circuit caused by operating on a circuit that is close to its amperage draw capacity. Make sure the circuit being used is capable of handling the amperage draw from this machine as well as any other electrical devices operating on the same circuit. If you are unsure, consult a qualified electrician.

To reset the overload protection switch after it has been tripped proceed as follows:



1. Loosen the two screws **D** with a Phillips screwdriver until you can remove the switch cover.



2. Press on the button **E** to reset the overload protection. Re-install the cover and then retighten the two screws **D** before starting the machine.