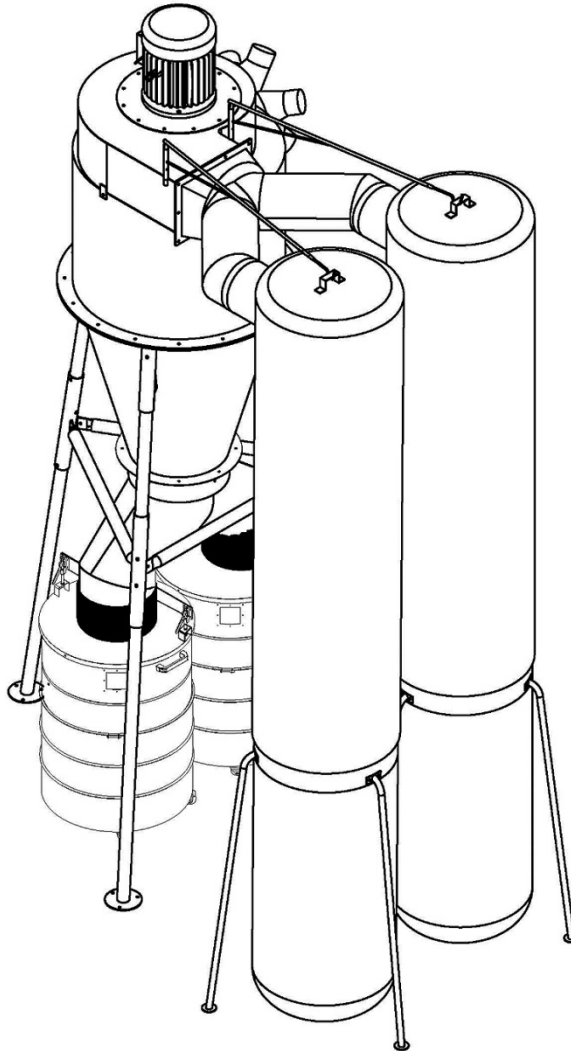




Wood Working

# OPERATOR'S MANUAL



## TWO STAGE CYCLONE DUST COLLECTOR MODEL: DC-6000C

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## Table of Contents

THANK YOU & WARRANTY .....	1
INTRODUCTION.....	3
GENERAL NOTES.....	3
SAFETY INSTRUCTIONS .....	4
SAFETY PRECAUTIONS .....	6
Dear Valued Customer:.....	6
TECHNICAL SUPPORT .....	8
TECHNICAL SPECIFICATIONS .....	9
Fan Curve.....	9
UNPACKING AND CHECKING CONTENTS.....	10
Cleaning .....	10
TRANSPORTING AND LIFTING .....	11
INSTALLATION.....	12
CONTENTS OF PACKAGE .....	13
ASSEMBLY AND SET UP .....	15
ELECTRICAL .....	22
Power cord connection: .....	23
REMOTE RESET AND CLEAR FUNCTION .....	24
LUBRICATION AND MAINTENANCE .....	25
EXPLODED VIEW PARTS DIAGRAM.....	26
Part List .....	27



## THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial Holdings LLC. We hope that you find it productive and useful to you for a long time to come.

**Inspection & Acceptance.** Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without a RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without an RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special-order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

**Specifications.** Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

**Limited Warranty.** Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

**EXCLUSION OF OTHER WARRANTIES.** THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

**Limitation of Liability.** IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



**Force Majeure.** Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. 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.

**Installation.** If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

**Work By Others; Safety Devices.** Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

**Remedies.** Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

**Attorney's Fees.** In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorney fees and costs.

**Governing Law/Venue.** This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

#### **SUMMARY OF RETURN POLICY.**

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial Holdings LLC makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial Holdings LLC reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

#### **For Customer Service & Technical Support:**

Please contact one of our knowledgeable Sales and Service team members at:  
(920) 684-4990 or e-mail us at [sales@baileighindustrial.com](mailto:sales@baileighindustrial.com)



## **INTRODUCTION**

*The quality and reliability of the components assembled on a Baileigh Industrial Holdings LLC machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However, if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.*

*Our technical staff will do their best to help you get your machine back in working order.*

### **In this manual you will find: (when applicable)**

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Setup and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

## **GENERAL NOTES**

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial Holdings LLC and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



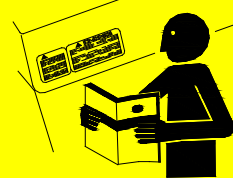
**Note:** This symbol refers to useful information throughout the manual.



## IMPORTANT

### PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



## SAFETY INSTRUCTIONS

### LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

### UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

**DANGER:** Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

**WARNING:** Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

**CAUTION:** Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

**NOTICE:** Indicates a situation which, if not avoided, could result in property damage.

 **DANGER**

 **WARNING**

 **CAUTION**

**NOTICE**



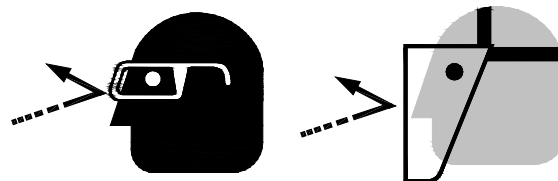


**SAVE THESE INSTRUCTIONS.**  
**Refer to them often and use them to instruct others.**



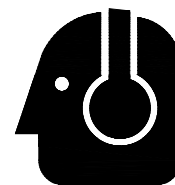
### **PROTECT EYES**

Wear safety glasses or suitable eye protection when working on or around machinery.



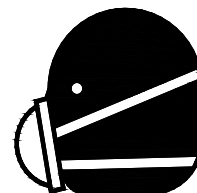
### **PROTECT AGAINST NOISE**

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



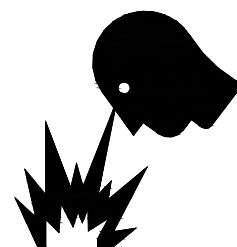
### **DUST HAZARD**

Wear appropriate dust mask. Dust created while using machinery can cause cancer, birth defects, and long term respiratory damage. Be aware of the dust hazards associated with all types of materials.



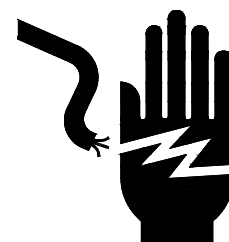
### **DUST PARTICLES AND IGNITION SOURCES**

**DO NOT** operate the table saw in areas where explosion risks are high. Such areas include locations near pilot lights, open flames, or other ignition sources.



### **HIGH VOLTAGE**

**USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT** assume the power to be off.  
**FOLLOW PROPER LOCKOUT PROCEDURES.**

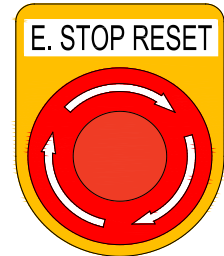




### **EMERGENCY STOP BUTTON**

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button. Twist the emergency stop button clockwise (cw) to reset.

**Note:** Resetting the E-Stop will not start the machine.



### **SAFETY PRECAUTIONS**



Wood working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, push sticks, hold-downs, feather boards, goggles, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

**REMEMBER:** **Your personal safety is your responsibility.**



**WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY**

Dear Valued Customer:

- All Baileigh woodworking machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

**Please enjoy your Baileigh machine! ....Please enjoy it SAFELY!**

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel can operate this machine.**





3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
5. **Keep work area clean.** Cluttered areas invite injuries.
6. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
7. **Dressing material edges.** Before bending sheet metal, always chamfer and deburr all sharp edges.
8. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
9. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.
10. **Respiratory Protection.** Wear an approved dust mask or respirator while using this machine. Continued exposure to dust can cause allergies or long term respiratory problems.
11. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
12. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
13. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
14. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
15. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
16. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
17. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
18. Watch for fire and keep a fire extinguisher close by.
19. **DO NOT** touch live electrical components or parts.
20. Turn off power before checking, cleaning, or replacing any parts.



21. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
22. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
23. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
24. **DO NOT** bypass or defeat any safety interlock systems.
25. Keep visitors a safe distance from the work area.
26. **Warning:** The dust generated by certain woods and wood products can be injurious to your health. Always operate machinery in well ventilated areas and provide for proper dust removal. Use a wood dust collection system whenever possible.

## **TECHNICAL SUPPORT**

Our technical support department can be reached at 920.684.4990 and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: [sales@baileigh.com](mailto:sales@baileigh.com), Phone: 920.684.4990, or Fax: 920.684.3944.



**Note:** *The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.*



**Note:** *The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.*

## **Definition**

**CFM (Cubic Feet per Minute)** provides the amount of air your blower puts out. That amount is decided by the capacity of your blower and how much you restrict the inlet and outlet. Dust collector manufactures rate their blower CFM as the maximum flow with no inlet or outlet restrictions. When normal items such as ducting, fittings, separators, cyclones and filters are added this creates resistance. Resistance is called static pressure that is measured as inches of water. To know how a blower will really perform, the static pressure should be plotted against the fan performance curve showing the CFM at different static pressure levels. CFM levels can be reduced by as much as half the maximum rated CFM depending upon static pressure.

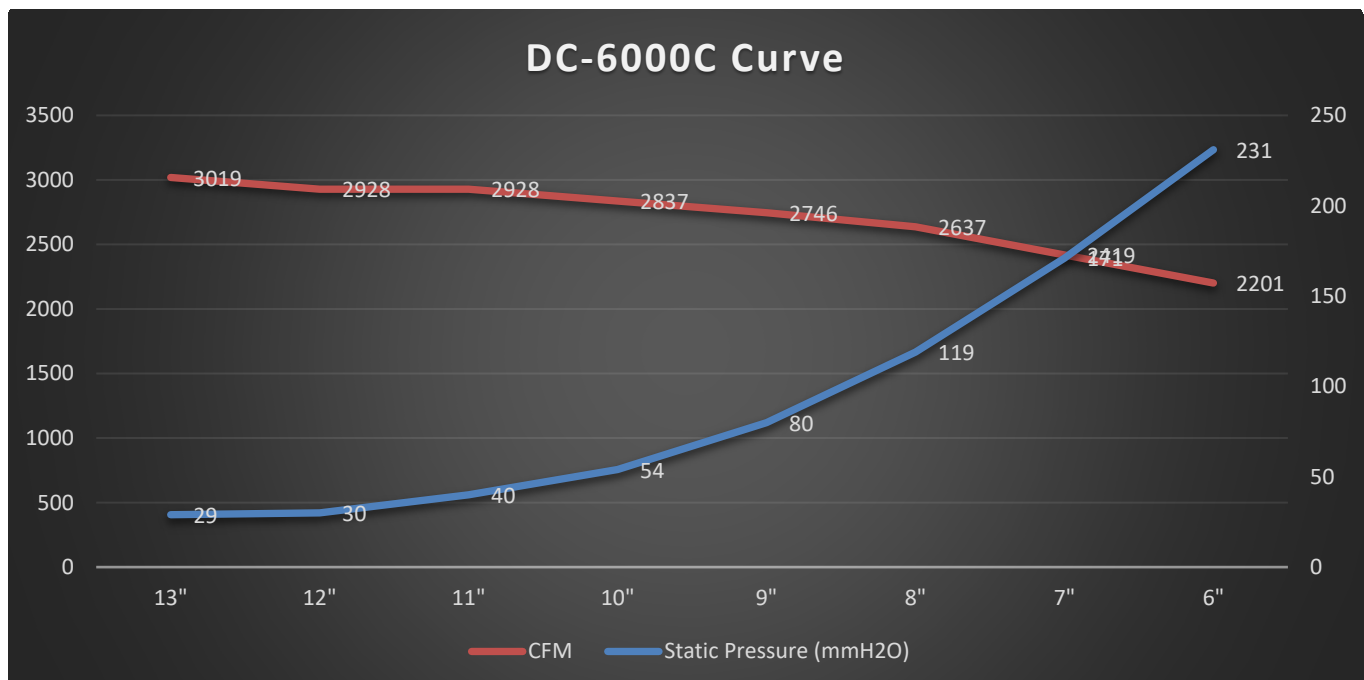


## TECHNICAL SPECIFICATIONS

Motor	10 HP (7.5kw) 440V, 60Hz, 3ph, 15A
Power	440V, 60Hz, 3ph
Motor Speed	3450 RPM
Suction Capacity	6000 CFM
Noise Rating (reference only)	95dBs
Impeller Size	18.5" (470mm)
Inlet Size	13" x 4" x 5" (330 x 102 x 127mm)
Switch	Magnetic
Overall Dimensions of Base	85" x 65.3" x 148.2" (2160 x 1660 x 3765mm)
N.W.	574lbs (260 Kgs)
G.W.	757lbs (343 Kgs)

## Fan Curve

Inlet Diameter of Tube (IN)	13"	12"	11"	10"	9"	8"	7"	6"
Static Pressure (mmH2O)	29	30	40	54	80	119	171	231
CFM	3019	2928	2928	2837	2746	2637	2419	2201





## UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.



**WARNING: SUFFOCATION HAZARD!** Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

## Cleaning



**WARNING: DO NOT USE** gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.



**CAUTION:** When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



**Important:** This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.



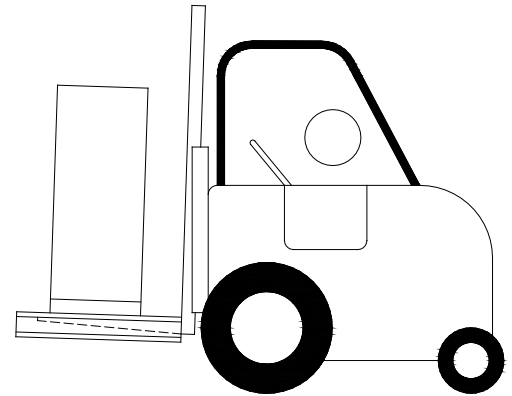


## **TRANSPORTING AND LIFTING**

**NOTICE:** *Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.*

### **Follow these guidelines when lifting with truck or trolley:**

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a fork lift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.



### **Follow these guidelines when lifting crane or hoist:**

- Always lift and carry the machine with the lifting holes provided at the top of the machine.
- Use lift equipment such as straps, chains, capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.
- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, then lower slowly until it touches the floor.



## **INSTALLATION**

### **IMPORTANT:**

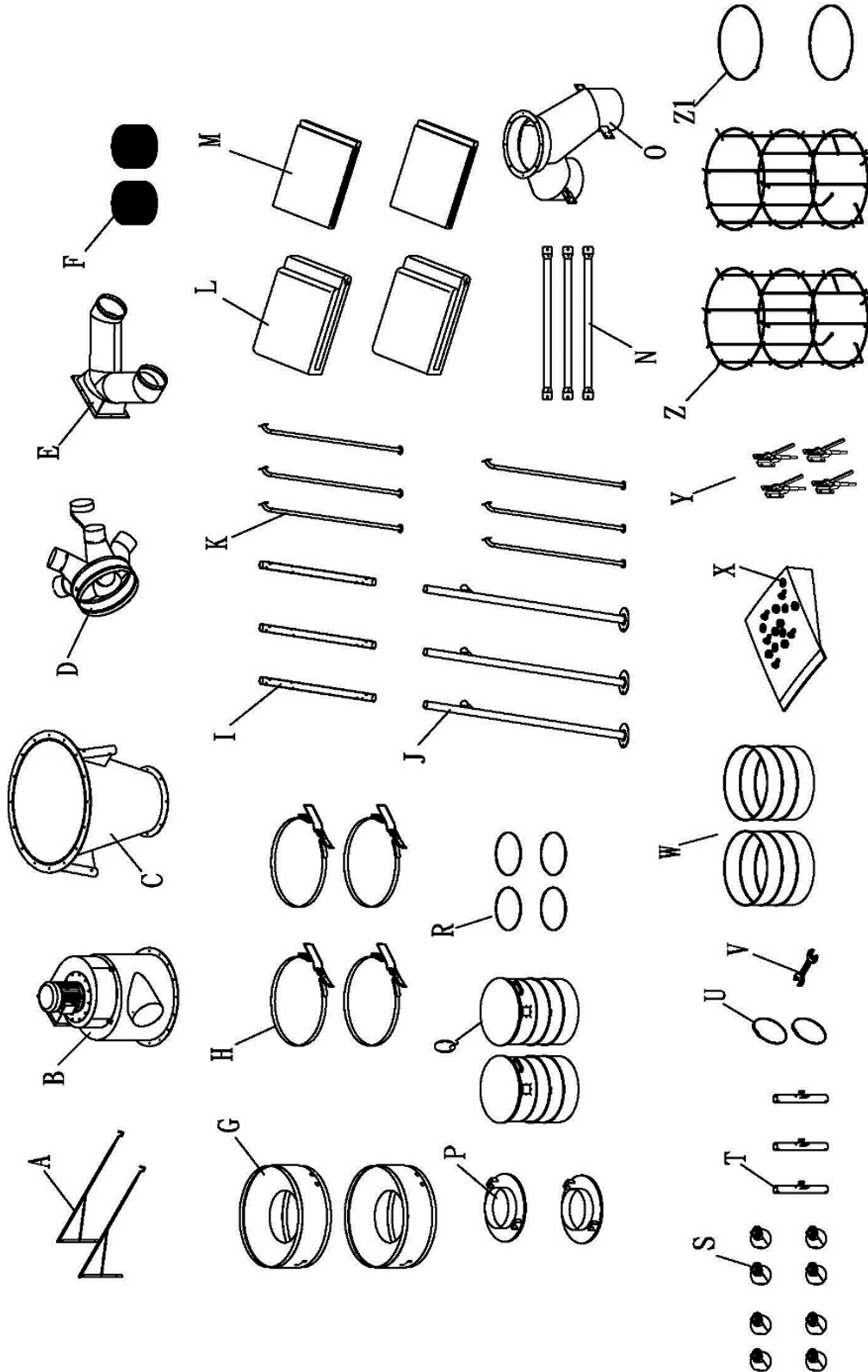
Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- It is important to maintain free area around the machine, which is required for the working place. If any long material is machined, it is necessary to have a sufficient room in front of the machine as well behind it in the places of material input and output.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This machine distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.





## CONTENTS OF PACKAGE





NO.	Description	Qty.	Part List NO.	NO.	Description	Qty.	Part List NO.
A	Hanger	2	NO.62	N	Stiffener	3	NO.53
B	Collector Support frame with motor	1		O	2 Hole Outlet for Reducing Collector	1	NO.34
C	Reducing collector support frame	1	NO.57	p	Drum Inlet Cover	2	NO.41
D	Inlet	1	NO.63	Q	upper Collecting Drum	1	NO.51
E	2 Hole Inlet	1	NO.61	R	Hose Clamp 12-1/2"	4	NO.39
F	Hose 12" x 11-3/4" L	2	NO.40	S	Caster	8	NO.48
G	Collector	2	NO.69	T	Connecting Tube	3	NO.55
H	Belt Clamp	4	NO.68	U	Belt Clamp 9"	2	NO.66
I	Upper supporting Leg	3	NO.56	V	Open End Wrench 10 x 12 mm	1	NO.32
J	Lower supporting Leg	3	NO.54	W	Lower Collecting Drum	2	NO.49
K	Collector supporter	6	NO.72	X	Hardware Bag	1	
L	Filter Bag	2	NO.67	Y	Quick Lever	4	NO.36
M	Collecting Bag	2	NO.71	Z	Inner Frame	2	NO.74~78
				Z1	Drum Clamp	2	NO.50



## ASSEMBLY AND SET UP



**WARNING:** For your own safety, **DO NOT** connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.

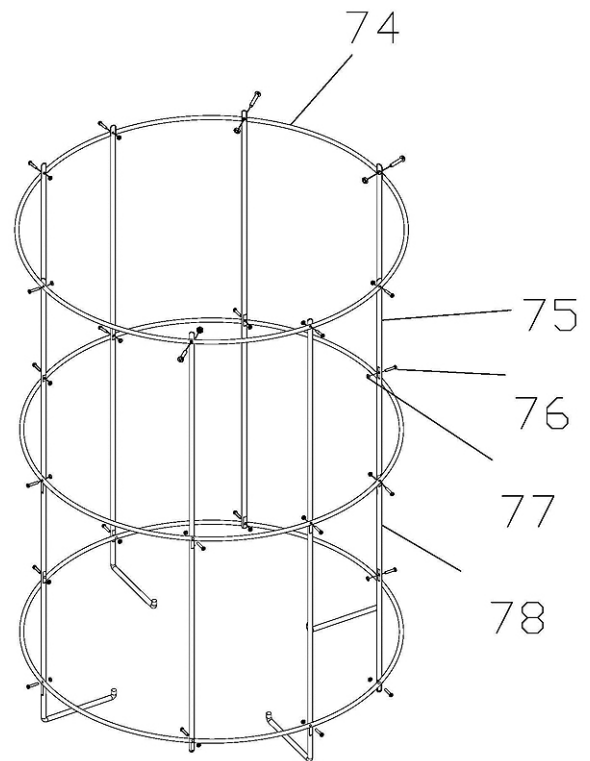


**Note:** Reference the parts diagram as needed for additional assistance during assembly.

1. Screw each Long Side Support Rod (NO.75) & Short Side Support Rod (NO.78) into the Ring (NO.74).
2. Place each around the frame and secure to the Long Side Support Rod (NO.75) & Short Side Support Rod (NO.78) with the 24 Bolts (NO.76) and 24 Nuts (NO.77).



**Note:** This Frame can now be placed inside a plastic bag to keep the bag shape in the negative pressure environment of a cyclone drum. Once the bag is full, remove frame and dispose of waste.



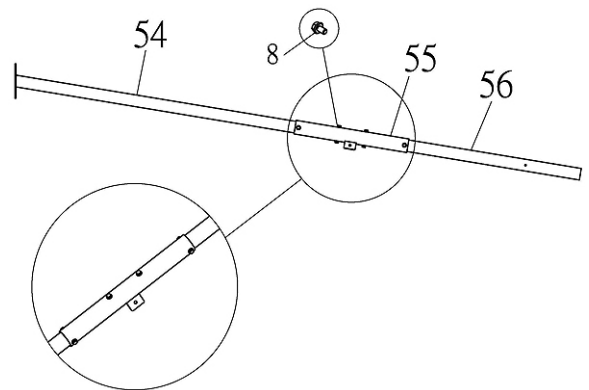
(Fig.1)

### Bag Frame Parts List

NO	Description	Specification	Qty.	NO	Description	Specification	Qty.
74	Ring		3	77	Nut	M3	24
75	Side Support Rod	Long	4	78	Side Support Rod	Short	4
76	Bolt	M3 x 12	24				

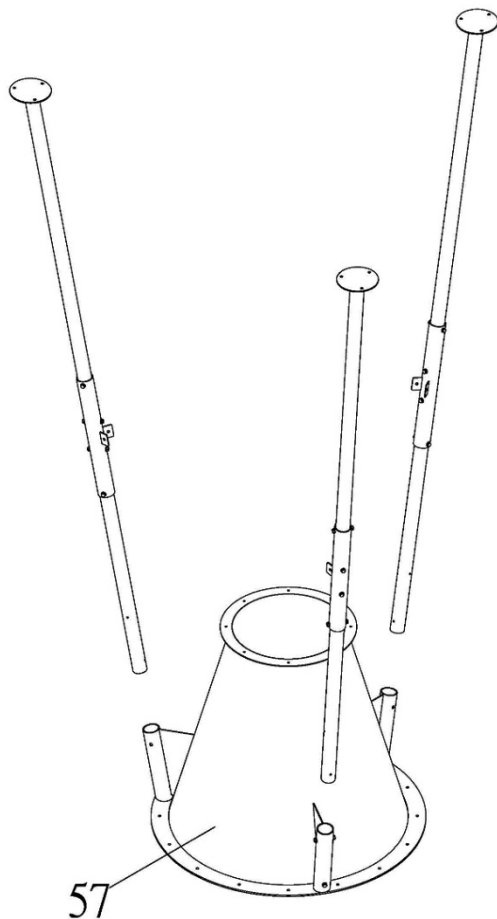


3. Assemble the upper and lower supporting leg with connecting tube by using hex head screw. (NO.8). See (Fig 2)

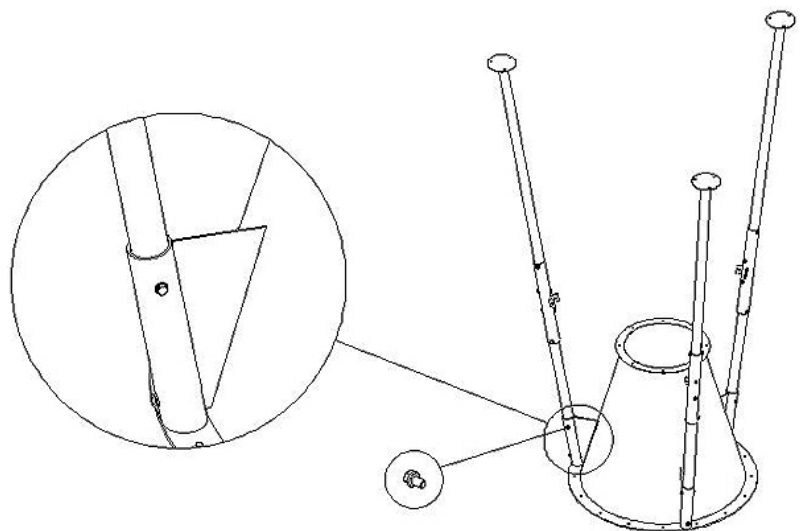


(Fig.2)

4. Place the support frame upside down as illustrated. Insert the 3 supporting leg into the Reducing Collector Support Frame (NO.57) by using hex head screw  $5/16"$  x  $3/4"$ . See (Fig 3 and 4)



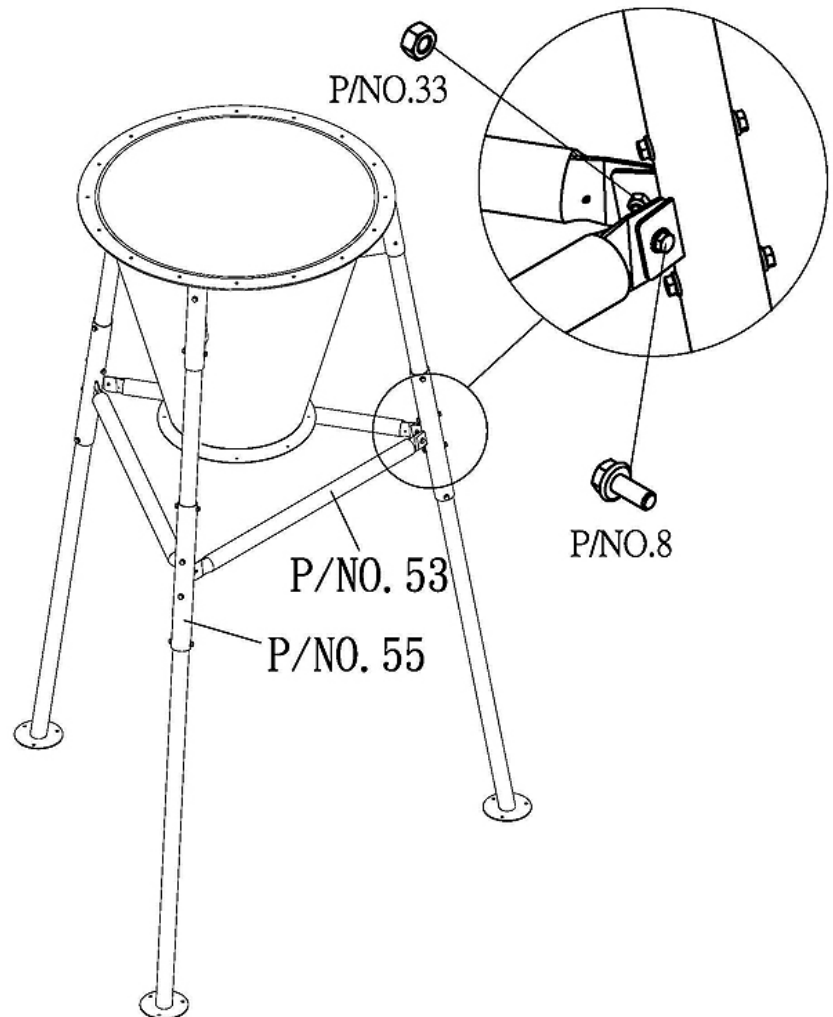
(Fig.3)



(Fig.4)



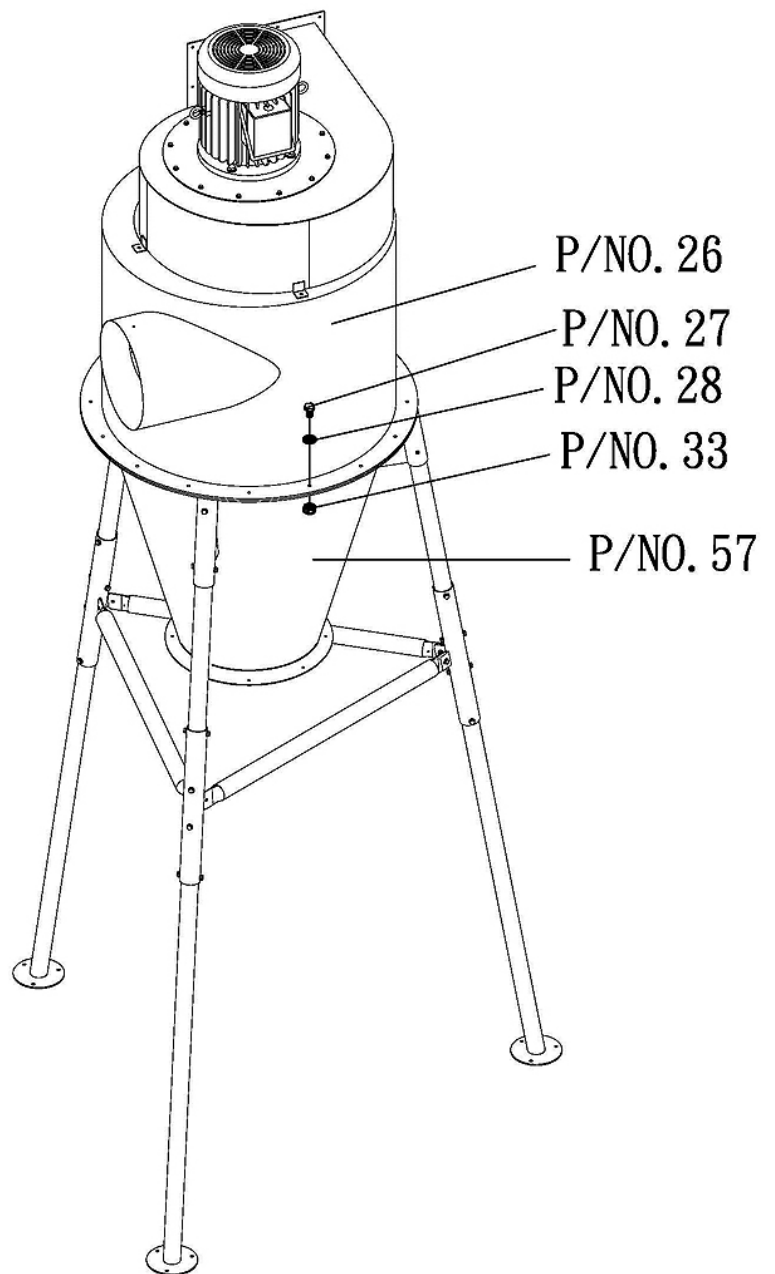
5. Install the Stiffeners (NO.53) between the supporting leg at the Connecting Tube (NO.55) by using hex head screw 5/16"x3/4" (NO.8) and nut 5/16" (NO.33). See (Fig 5)



(Fig.5)



6. Stand the Reducing Collector Support Frame upright.
7. Place the Collector, Main Housing and Motor assembly (NO.26) on the top of the reducing collector support frame (NO.57) and secure using hex head screw 5/16" x 1", washer 5/16" x 18mm, and nut 5/16".
8. Make sure all the screw securely tightened.

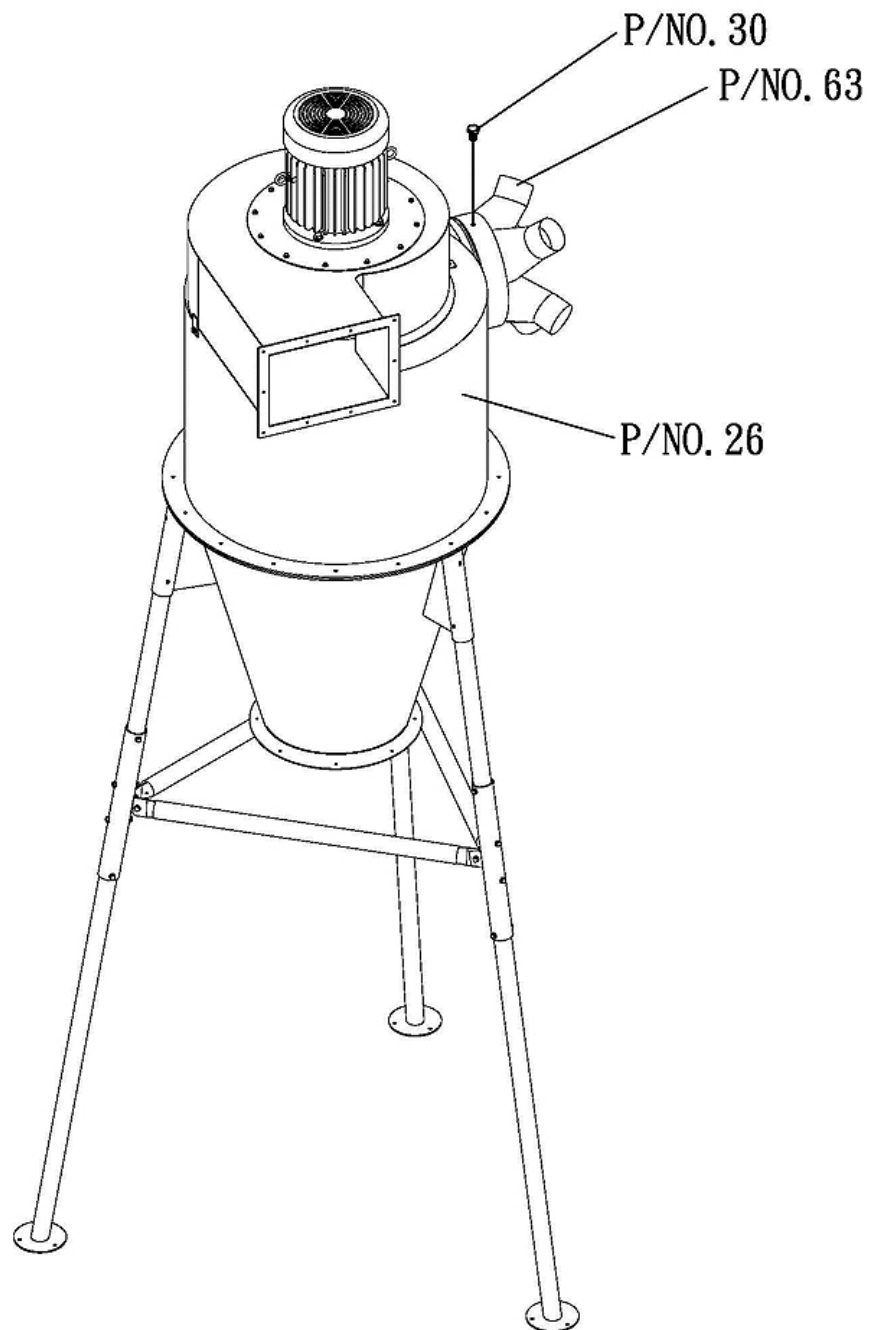


(Fig.6)





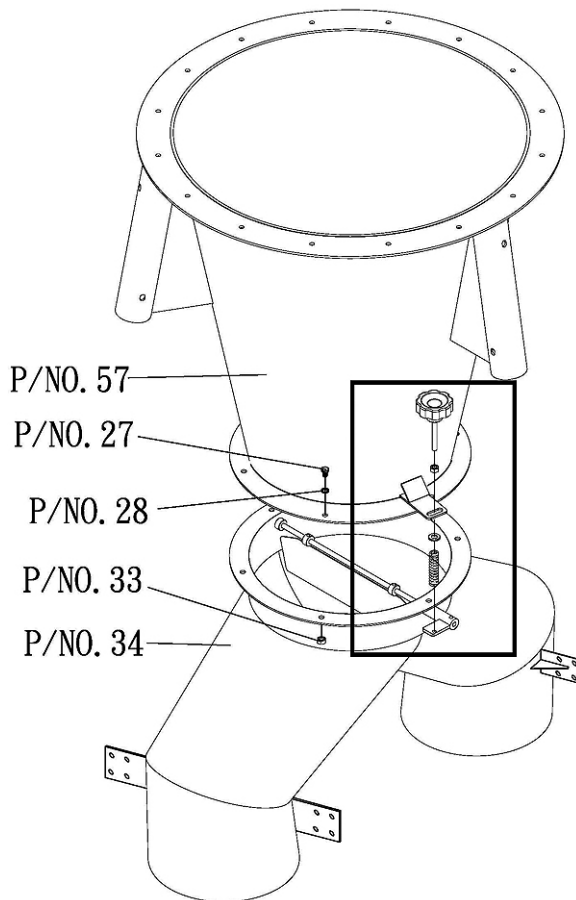
9. Insert the inlet (NO.63) onto the outlet of the Collector support Frame with Motor (NO.26) and secure using round head screw 3/16" x 3/8" (NO.3) and fully tighten.



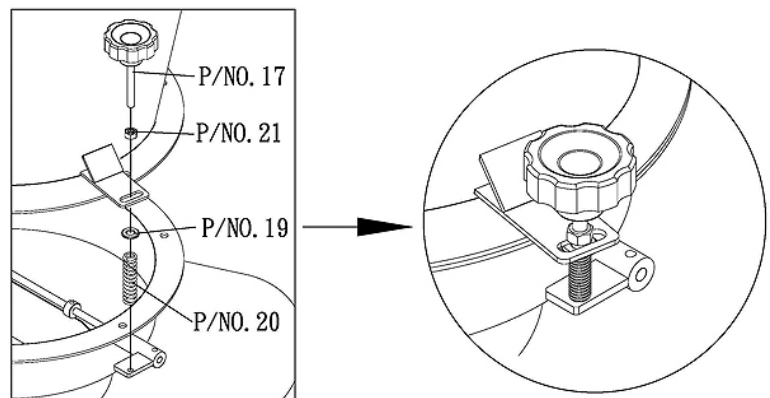
(Fig.7)



10. Mount the 2 hole outlet (NO.34) at the bottom of reducing collector support frame (NO. 57) by using the hex head screw 5/16" x 1" (NO.27), Washer 5/16" x 18mm (NO.28) and hex nut 5/16" (NO.33).
11. Then, install the baffle adjustment screw assembly of the Knob Head Screw M8 x 65 (NO.17), Nut M8 (NO.21), Flat Washer 8.2x18 (NO.19), and Compression Spring (NO.20) through the collector tab and into the baffle tab. See (Fig.8 and Fig. 9)



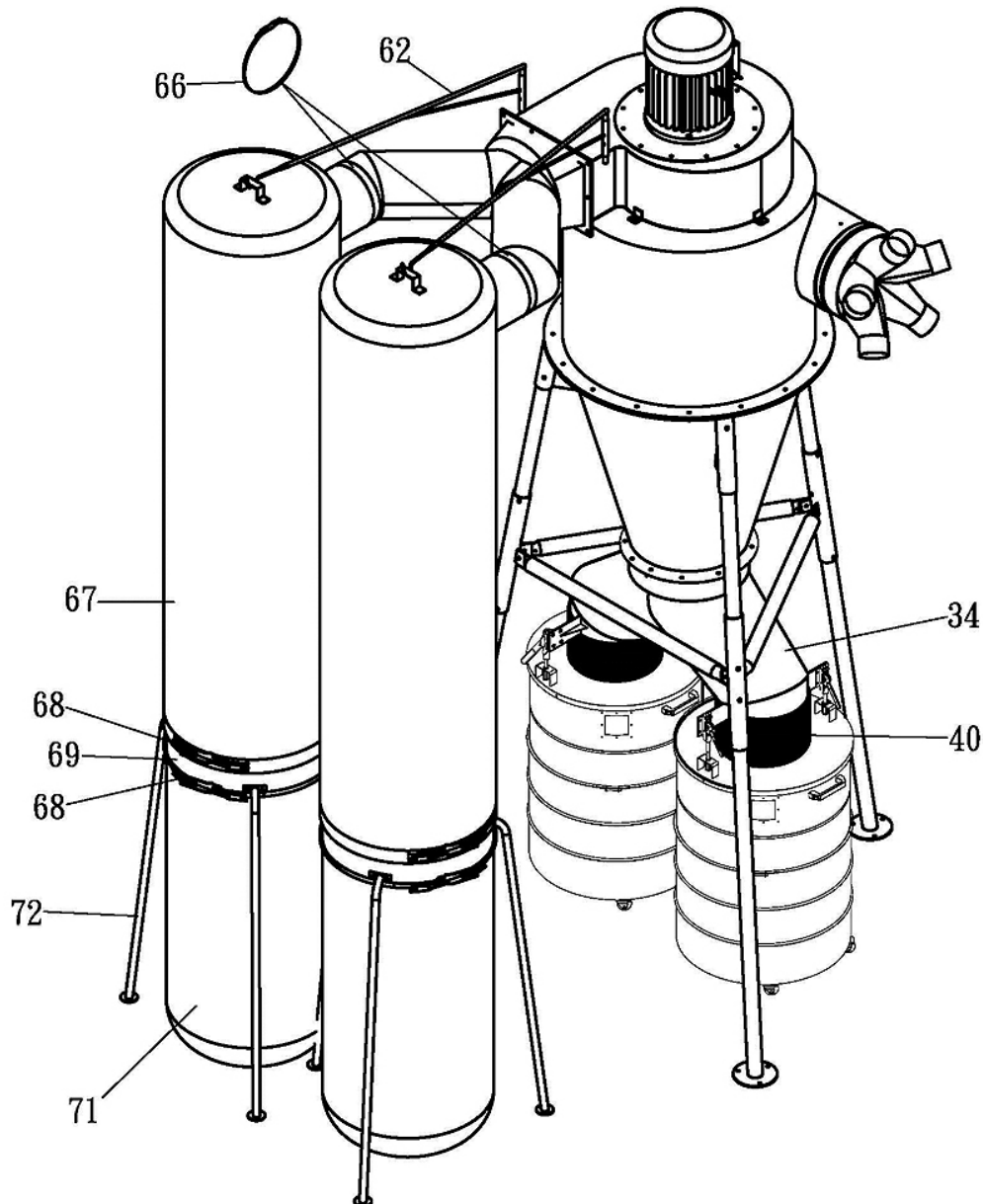
(Fig.8)



(Fig.9)



12. Insert the 2 hole inlet for reducing collector (NO.34) at the bottom of reducing collector support frame (NO.57) by using hex head screw 5/16" x 1/2" (NO.70).
13. Then place the hose (NO.40) at both 2 hold inlet and connect with the drum cover. See Fig 10.
14. Hang on the Filter bag (NO.67) on the hanger (NO.62) and clamp it the bag clamp (NO.66).
15. Mount the plastic bag (NO.71) and filter bag (NO.67) at the collector (NO.69) by using the bag clamp (NO.66).
16. Fixing the collector supporter (NO.72) on the each side of collector (NO.69).
17. The two stage dust cyclone assembly is completed as shown in Fig 10.



(Fig.10)



## **ELECTRICAL**



**WARNING:** Baileigh Industrial Holdings LLC is not responsible for any damage caused by wiring up to an alternative 3-phase power source other than direct 3-phase. If you are using an alternate power source, consult a certified electrician or contact Baileigh Industrial Holdings LLC prior to energizing the machine.



**CAUTION:** HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!  
Check if the available power supply is the same as listed on the machine nameplate.



**WARNING:** Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

### **Power Specifications**

Your machine is wired for 440 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is  $\pm 5\%$ , and for the frequency is  $\pm 1\%$ .

### **Considerations**

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machine. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

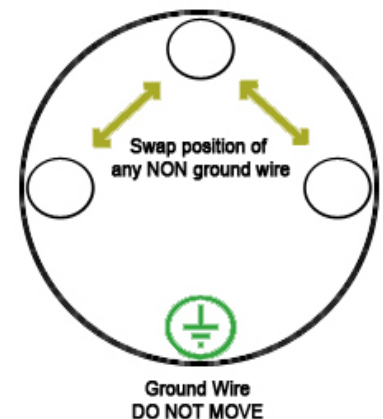


**⚠ WARNING:** In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

#### **Power cord connection:**

1. Turn the main disconnect switch on the control panel to the OFF position.
2. Unwrap the power cord and route the cord away from the machine toward the power supply.
  - a. Route the power cord so that it will NOT become entangled in the machine in any way.
  - b. Route the cord to the power supply in a way that does NOT create a trip hazard.
3. Connect the three power wires terminals L1, L2, & L3 to the power supply or install the correct plug for the application onto the power cord. Connect the ground wire (typically green) to the E terminal.
4. When the machine is clear of any obstruction. The main power switch may be turned ON to test the operation. Turn the switch OFF when the machine is not in operation.



#### **Check for correct rotation of the motor (Proper suction)**

5. If not, disconnect power to the machine, and switch the L1 and L3 wires; but DO NOT change the position of the green grounding wire!





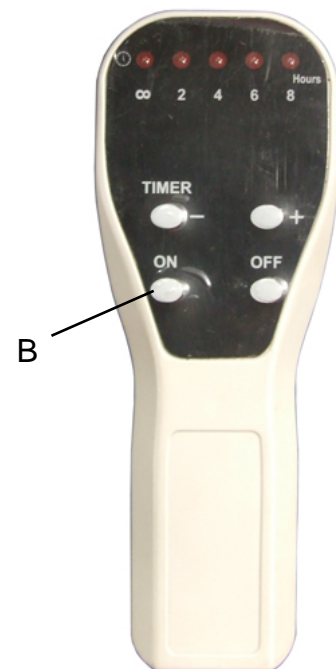
## **REMOTE RESET AND CLEAR FUNCTION**

### **Clear**

1. Press the reset button (A) on the control box for 3 seconds until the receiver "beep" 3 times.

### **Reset**

2. Press the reset button (A) on the control box for 1 second until the receiver "beep" once.
3. Press "ON" button (B) on the hand held remote control until the receiver "beep" twice. If using more than one remote, repeat this step for all remotes before continuing.
4. Press the reset button (A) on the control box for 3 seconds until the receiver "beep" 3 times.







## **LUBRICATION AND MAINTENANCE**



**WARNING:** Make sure the electrical disconnect is OFF before working on the machine.

Maintenance should be performed on a regular basis by qualified personnel.

Always follow proper safety precautions when working on or around any machinery.

### **Daily Maintenance**

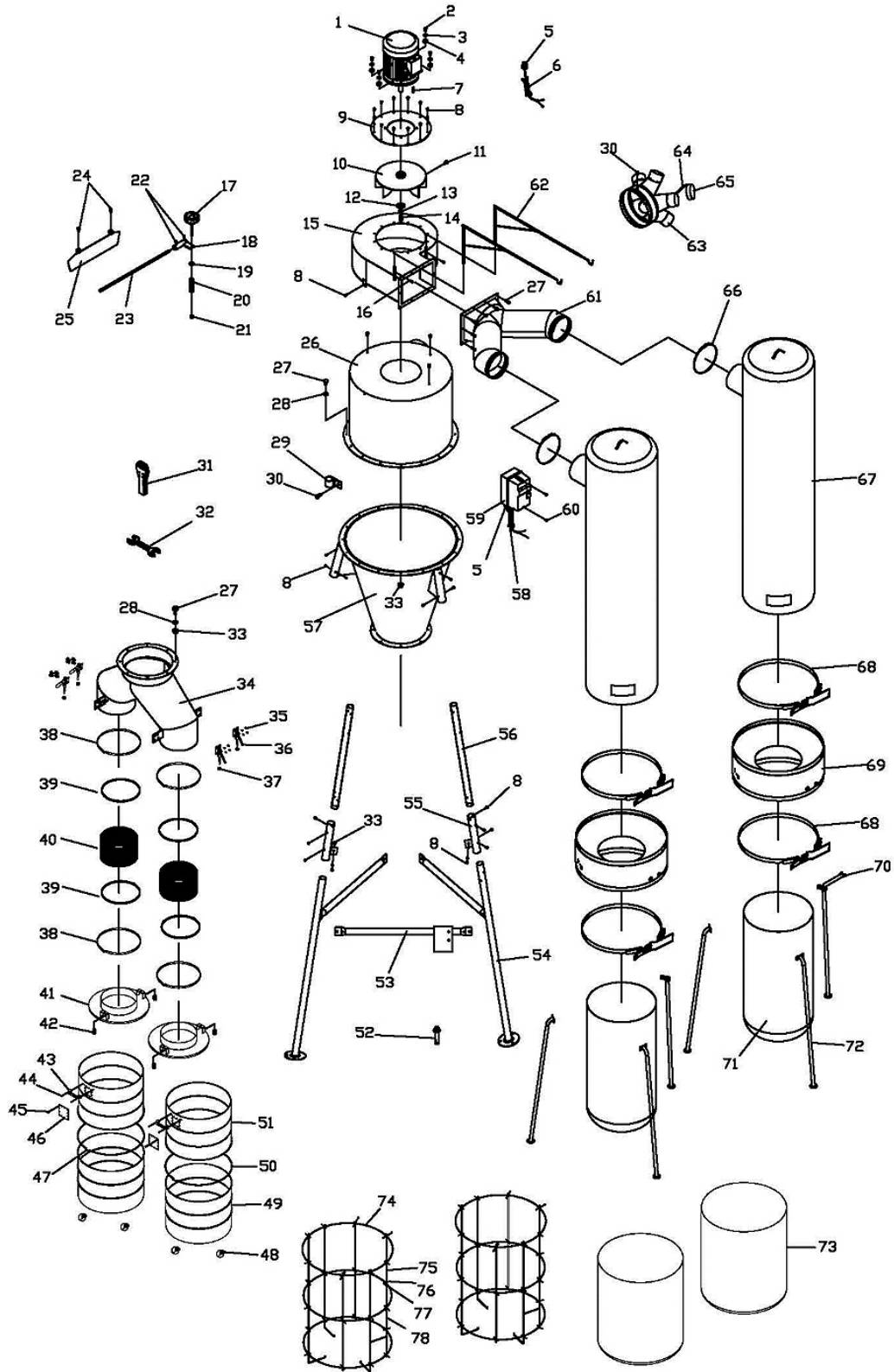
- Do a general cleaning by removing dust and chips from the machine.
- Clean filters.
- Check and tighten any loose mounting bolts.
- Inspect the power plug and cord.
- Keep area around machine clear of debris.
- Check for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.



**Note:** When cleaning chips and debris from the machine, use a brush and a shop vacuum. **DO NOT** blow off the machine with compressed air. The force of the compressed air may force chips into critical mechanisms or may inflict injury to yourself or others.



## EXPLODED VIEW PARTS DIAGRAM





## Part List

NO.	Description	Specification	Qty.
1	Motor		1
2	Hex. Head Screw	1/2"x1-1/2"	4
3	Spring Washer	1/2"	4
4	Nut	1/2"	4
5	PG Bushing	PG-25	3
6	Motor Wire	5.5x4Cx230cm	1
7	Key	10x8x56	1
8	Hex. Head Screw	5/16"x3/4"	49
9	Motor Plate		1
10	Impeller	18.5"	1
11	Set Screw	3/8"*1"	1
12	Washer	3/8"x23	1
13	Flat Washer	φ12.2x60x3	1
14	Socket Screw	3/8"x3/4"	1
15	Main Housing		1
16	Hex. Head Screw	1/4"x1/2"	2
17	Wing Head Screw	M8x65m/m	1
18	Swing Spindle		1
19	Flat Washer	5/16"x18x2	1
20	Compression Spring	1.35x12x50	1
21	Nut	M8	1
22	Hex. Socket Screw	6x10	2
23	Adjusted Board		1
24	Set Screw	M6x10	2
25	Adjusted Board Spindle		1
26	Collector		1
27	Hex. Head Screw	5/16"x1	34
28	Washer	5/16"x18m/m	34
29	Wire Clamp		1
30	Round Head Screw	3/16"x3/8"	2
31	Remote Control Bar		1
32	Open End Wrench	10x12mm	1



NO.	Description	Specification	Qty.
33	Nut with Flange	5/16"	40
34	2 Hole outlet		1
35	Phillip Head Screw	M5*8	16
36	Quick Lever		4
37	Nut	3/8"	4
38	Foam	1m*30*970	4
39	Hose Clamp	12-1/2"	4
40	Hose	Dia.12"x30cm	2
41	Drum Lid		2
42	Long Nut	3/8"	4
43	Handle		2
44	Phillip Head Screw	1/4"*5/8"	4
45	Rivet	4-2	24
46	PC Board		2
47	Phillip Head Screw	1/4"x2-1/2"	2
48	Caster	2"	8
49	Lower Collecting Drum		2
50	Drum Clamp		2
51	Upper Drum		2
52	Connecting Screw	1/4"	9
53	Stiffener		3
54	Bottom Leg		3
55	Connecting Tub		3
56	Upper Leg		3
57	Reducing Support Frame		1
58	Power Cord		1
59	Switch		1
60	Round Head Screw	3/16"x3/4"	2
61	2 Hole Outlet (Main Housing)		1
62	Hanger		2
63	5 Way Inlet	13"x4"x5	1
64	Chain		4
65	Inlet Cap	4"	4
66	Bag Clamp	9"	2



NO.	Description	Specification	Qty.
67	1 Micron Filter Bag	Dia.600x2600mm	2
68	Bag Clamp		4
69	Collector		2
70	Hex. Head Screw	5/16"x1/2"	12
71	Collecting Bag		2
72	Collector Support Leg		6
73	PE Bag		2
74	Loop		6
75	Barrel Fixing Stick (Long)		8
76	Nut	M3	48
77	Phillips Head Screw	M3*12	48
78	Barrel Fixing Stick (Short)		8

### **NOTES**



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