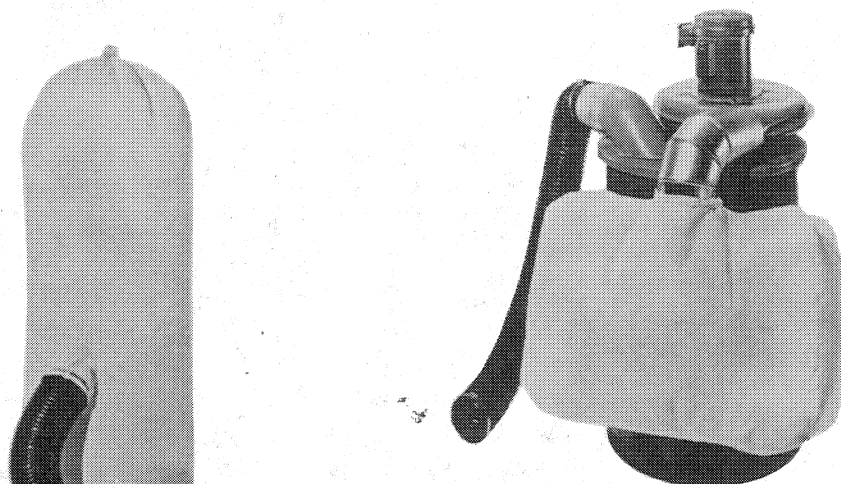


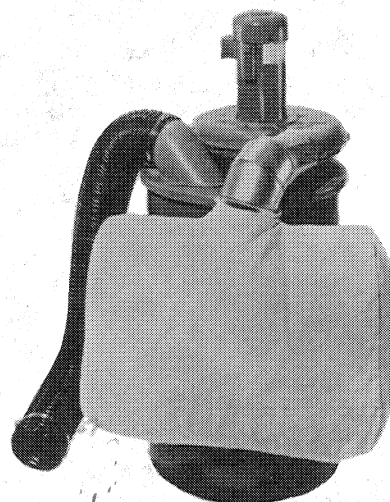
# DUST COLLECTORS



50-180



50-182



50-181

NOTE: 55-gallon drums not included

Catalog Number	Motor	Motor Voltage	Hertz and Motor RPM	Maximum CFM	Maximum Static Pressure (In. Water)	Maximum Hose Velocity FPM	Bag Area in Sq. Ft.	dBA @ 5 Ft.	Hose Size	Drum Size
50-180	1 HP 1 Ph.	115/230	60-3450	700	4½"	5131	19.0	83	5" x 60"	55 Gal.
50-181	2 HP 1 Ph.	230	60-3450	1100	8½"	5600	19.0	85	6" x 60"	55 Gal.
50-182	3 HP 3 Ph.	230/460	60-3450	1300	10"	6619	50.0	84	6" x 60"	55 Gal.

DATED 11-28-94

PART NO. 410-06-651-0001  
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**READ INSTRUCTIONS CAREFULLY BEFORE ATTEMPTING TO ASSEMBLE, INSTALL, OPERATE OR SERVICE YOUR DUST COLLECTOR! RETAIN INSTRUCTIONS FOR FUTURE REFERENCE.**

## **SAFETY RULES**

1. Follow all local electrical and safety codes, as well as the National Electric Code (NEC) and the Occupational Safety and Health Act (OSHA). All electrical connections and wiring should be performed by qualified personnel only.
2. National Fire Protection Association (NFPA) standards require specific duct design and dust collector configuration when collecting potentially reactive metal dusts, such as aluminum and magnesium. Consult current NFPA standards before setting up a dust collector and/or duct design for these two materials.
3. Use only 3-wire extension cords which have 3 prong grounding type plugs and are of adequate size for longer runs.
4. Replace or repair damaged or worn cord immediately.
5. Protect the power cable and never allow the cable to come in contact with sharp objects.
6. Do not kink power cable and never allow the cable to come in contact with oil, grease, hot surfaces or chemicals.
7. Make certain that the power source conforms to the requirements of your equipment.
8. **KEEP AWAY FROM UNIT WHEN IT IS OPERATING.**
  - a. there is a high speed blower wheel inside the blower housing that can amputate fingers, grab loose clothes or neck ties.
  - b. there is also a high speed cooling fan wheel on the top of the motor that should be avoided for the same reasons mentioned in item (a).
9. This unit is heavier than the container it sits on and can be turned over if bumped or not placed on a clean, level area.
10. Do not attempt to clean or service without disconnecting from power source.

## **INTRODUCTION**

These dust collectors are designed to help maintain clean, safe conditions around dust creating machines in workshops and factories. The flexible hose included with each unit can be hooked directly into the dust creating machine.

Dust collectors work by moving larger volumes of air at lower suction pressures than vacuum cleaners. These units are not designed to be used as high-suction vacuum cleaners.

Components that must be assembled before operation are: sheet metal cylinder, suction hose, two adjustable clamps, sealing gasket, deflector elbow, discharge guard

bag, elbow and the dust bag. See assembly instructions for proper installation.

**CAUTION: The blower housing contains a high speed radial blade that can amputate fingers, grab loose clothing and neck ties, or propel dust at high velocities. DO NOT OPERATE WITHOUT THE DISCHARGE GUARD BAG, ELBOW AND DUST BAG IN POSITION.**

Do not attempt to clean, remove dust bag, service unit or move a dust collector while in operation. Disconnect from power source first.

## **UNPACKING**

Carton must be in upright position before opening. Inspect for shipping damage and advise carrier immediately if damaged. Check parts list for missing or damaged parts.

# ASSEMBLY

1. Assembly includes the installation of the sheet metal cylinder, inlet elbows, sealing gasket, discharge gird, bag elbow and dust bag.

2. To install the sheet metal cylinder, inlet elbows and sealing gasket, place the unit upside down on a cardboard covered flat area.

3. The inlet elbow (A) Fig. 2, is to be attached to the bottom of the lid (B). Remove the nuts and washers from the two studs extending out from the bottom of elbow (C). Position inlet elbow (A), as shown, on the two studs and fasten in place using the two washers and nuts.

4. Assemble the sheet metal cylinder (D) Fig. 2, to the bottom of the lid (B) using the three 1/4-20 screws which are installed into nut inserts on bottom of lid.

5. Remove the paper protection from the adhesive side of the sealing gasket (E) Fig. 2, and install the gasket (E) to the underside of the lid next to the rim. The unit will be more effective if there are no air leaks between the lid and the drum.

## FOR MODELS 50-180 AND 50-181 ONLY

6. After placing the unit right side up on the drum, assemble discharge elbow (F) Fig. 2, to the discharge end of the blower. Slip the 6-inch diameter o-ring (G) against the retaining ring on the open end of discharge elbow (F).

7. Clamp the open end of dust bag (H) Fig. 2, to elbow sleeve (J), using clamp (K) supplied. **NOTE:** Keep the edge of dust bag fabric 1/4-inch below flange of sleeve (J) to ensure correct locking action of the snap-latches, one of which is shown at (V). With the snap-latches (V) in the raised position, slide the elbow sleeve (J) with the bag attached, over the end of elbow (F) using a slight twisting motion. Snap the latches (V) downward to fasten the bag (H) to the elbow. **NOTE:** Make certain the bag fabric does not interfere with the locking action of the snap-latches.

8. On model 50-180 only, attach inlet hose reducer (M) Fig. 2, to inlet elbow (C) and clamp the suction hose (L) to the hose reducer using adjustable clamp (N) supplied.

On model 50-181, no reducer is used; the suction hose is attached directly to the inlet elbow.

## FOR MODEL 50-182 ONLY

9. After placing the unit right side up on the drum, attach the discharge hose (M) Fig. 3, directly to the blower using clamp (N).

10. Attach the other end of discharge hose (M) Fig. 3, to the dust bag (O) using the two clamps (P) and hose sleeve (R).

11. Attach inlet hose (S) Fig. 4, to inlet elbow (T) using adjustable clamp (U) supplied.

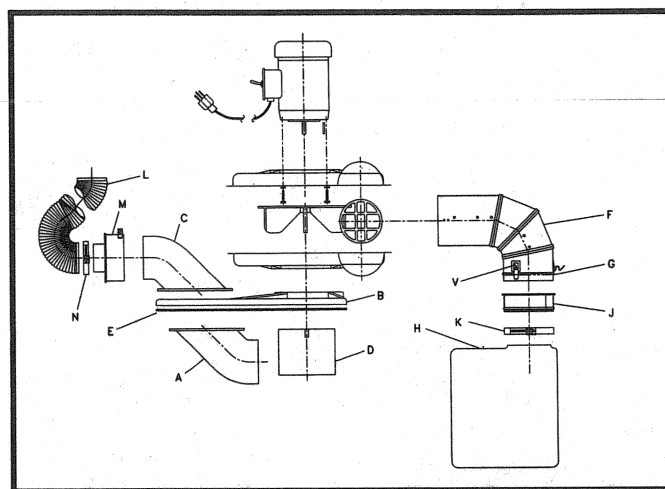


Fig. 2

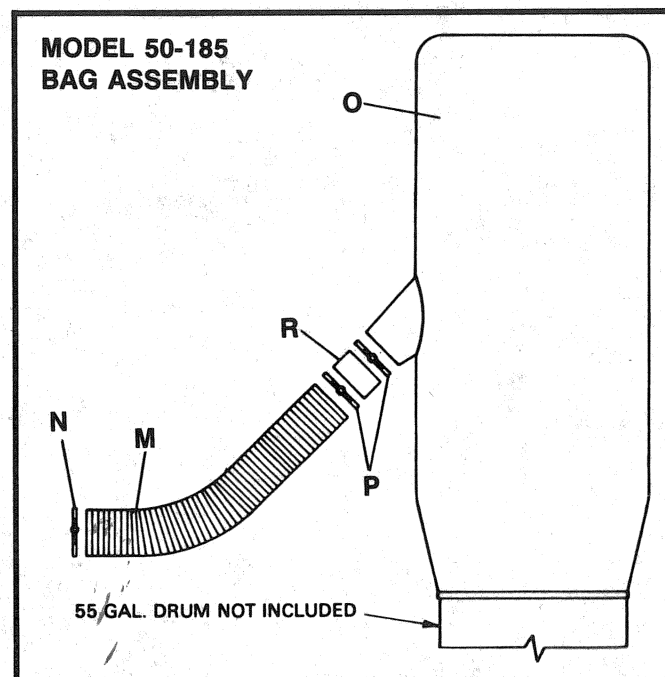


Fig. 3

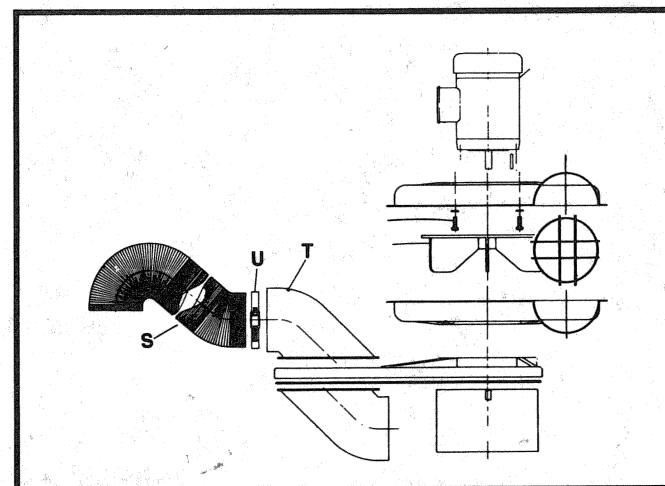


Fig. 4

# CONNECTING DUST COLLECTOR TO POWER SOURCE

Before connecting your dust collector to an electrical power system, be sure the motor rating agrees with the electrical system it is to be connected to.

## SINGLE PHASE OPERATION

If the motor on your dust collector is wired for 115 Volt, single phase, the power cord is equipped with a plug that has two flat, parallel current-carrying prongs, and one longer round or "U" shaped ground prong which requires a mating 3-conductor grounded type receptacle, as shown in Fig. 5.

If the motor on your dust collector is wired for 230 Volt, single phase, the power cord is equipped with a plug that has two flat, current-carrying prongs in tandem, and one round or "U" shaped longer ground prong. This is used only with the proper mating 3-conductor grounding type receptacle, as shown in Fig. 6.

When the three-prong plug on your dust collector is plugged into a grounded 3-conductor receptacle, the long ground prong on the plug contacts first so the machine is properly grounded before electricity reaches it.

**CAUTION: IN ALL CASES, MAKE CERTAIN THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED. IF YOU ARE NOT SURE, HAVE A CERTIFIED ELECTRICIAN CHECK THE RECEPTACLE.**

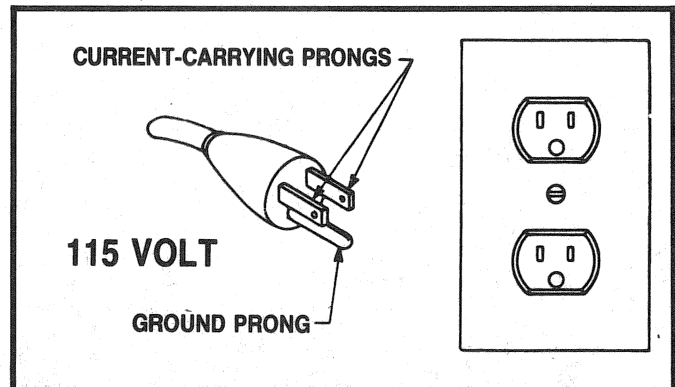


Fig. 5

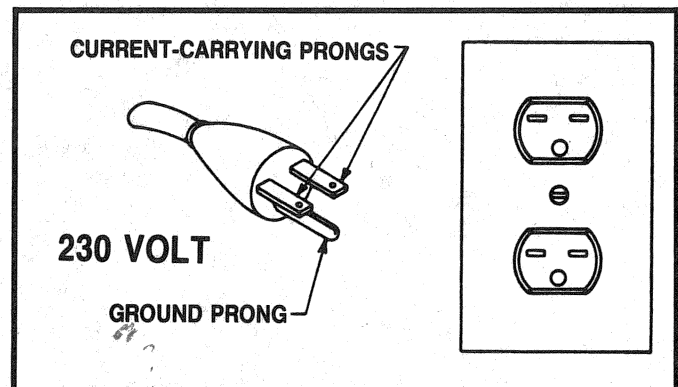


Fig. 6

## THREE PHASE OPERATION

If your dust collector is equipped with a three phase motor, the necessary wiring from the motor to the power source should be completed by a competent electrician. ELECTRICAL WIRING must be made in accordance with the local and national electrical codes, safety standards and in accordance with the motor nameplate. After connecting to power source, make certain the rotation of the motor is in the proper direction by viewing the rotation of the cooling fan on top of the motor. The cooling fan should rotate clockwise (in the same direction as the outlet of the blower casing). **CAUTION:** do not insert fingers or any foreign object into the cooling fan cover. Rotation of the motor can be reversed by interchanging any two of the three power lead connections to the motor lead wires.



# MAINTENANCE

**NOTE:** Before any maintenance or service is performed, be sure that unit is disconnected from power source to prevent accidental starting.

## CAST ALUMINUM & SHEET METAL FITTINGS:

The cast aluminum blower impeller, as well as all sheet metal fittings are maintenance free and should not require any maintenance during the life of the unit. In a severe dirty operation, the blower impeller should be cleaned with a wire brush to prevent an accumulation of foreign matter that could result in blower unbalance

After cleaning impeller, inspect for possible cracks or excessive wear, which can cause unbalance.

**DO NOT USE AN IMPELLER THAT IS CRACKED OR EXCESSIVELY WORN; REPLACE IT WITH A NEW IMPELLER.**

## MOTOR MAINTENANCE:

Removing dust and dirt: Blow off motor with low pressure air to remove dust or dirt. Air pressure above 50 P.S.I. should not be used as high pressure may damage insulation and blow dirt under loosened tape. The operator performing this cleaning function should always wear eye protective goggles. Dust can cause excessive insulation temperatures.

# SAFETY FEATURE

All Dust Collectors have a safety guard at the discharge of the blower housing. This guard is for your safety. Do not remove this guard for any reason. **DISCONNECT ALL UNITS FROM POWER SOURCE BEFORE ATTEMPTING ANY MAINTENANCE.**

# TROUBLE SHOOTING GUIDE

**WARNING: DISCONNECT UNIT FROM POWER BEFORE TROUBLE SHOOTING**

TROUBLE!!	WHAT'S WRONG?	WHAT TO DO . . .
Unit will not operate.	<ol style="list-style-type: none"><li>1. Improper electrical connection.</li><li>2. Blower wheel loose.</li></ol>	<ol style="list-style-type: none"><li>1. Turn power off - assure unit is wired per instructions.</li><li>2. Disconnect power cord. Turn unit over &amp; spin wheel by hand. Re-position and tighten set screws if necessary.</li></ol>
Low suction or flow rate.	<ol style="list-style-type: none"><li>1. Incorrect rotation.</li><li>2. Suction hose too long.</li></ol>	<ol style="list-style-type: none"><li>1. Turn unit off and observe motor cooling wheel rotation as it stops. Rewire correctly if necessary.</li><li>2. Place unit closer to dust source &amp; shorten hose.</li></ol>

# CENTRAL DUST COLLECTION SYSTEMS

The model 50-181 2 H.P. dust collector is widely used to power small central dust collection systems. Model 50-182 may be used if three phase power is available. NOTE: Model 50-180 should not be used for multi-unit central system hook-ups.

The following steps will assist in designing and building a convenient space-saving central collection system.

## DESIGN STEPS

(Applicable ONLY to Delta Two Stage Collectors)

1. Determine the **Equivalent Length** for each duct run. A "run" is the duct going directly from each tool to the collector; several different runs may use parts of the same branch and main ducts. Equivalent length is determined as follows:

Smooth wall pipe (metal or plastic) - actual length

Wire reinforced flexible hose - 150% actual length

Direction change equivalent lengths:

- Curved 90° Elbow (include hose bends) = 10 feet (45° = 5 feet)
- Sharp 90° Bend (Tee joint or Elbow) = 20 feet
- Special Y Branch Tee (including required 45° Elbow) = 10 feet

Add together the component equivalent lengths for each run to obtain its total equivalent length. (Do not be concerned with the total length of the entire duct system.)

2. Determine Air Flow; (use only 4" or 5" pipe for duct.) The maximum allowable equivalent length of either size duct in each duct run is **100 feet; 120 feet with Model 50-182\***. Use the same diameter duct throughout the system.

Air flow at any duct length can be calculated from this table:

Dust Collector Model	Duct Size	Max. Length	Air Flow At Max. Length	Increase Per Foot Under Max. Length	Max. Air Flow
50-181	4"	100 FT.	310 CFM	2.6 CFM	570 CFM
	5"	100 FT.	470 CFM	2.2 CFM	690 CFM
50-182	4"	120 FT.	310 CFM	2.6 CFM	615 CFM
	5"	120 FT.	470 CFM	2.2 CFM	735 CFM

Example: 70' Equivalent length, 5" duct, Model 50-181.

$$\text{CFM} = 470 + (2.2 \times 30) = 470 + 66 = 536 \text{ CFM}$$

**\*DO NOT EXCEED MAXIMUM DUCT LENGTH IN ANY INDIVIDUAL DUCT RUN AS THIS WILL CAUSE CHIPS TO FALL OUT OF THE AIRSTREAM AND CLOG THE DUCT.**

### 3. DUCT PIPE SELECTION

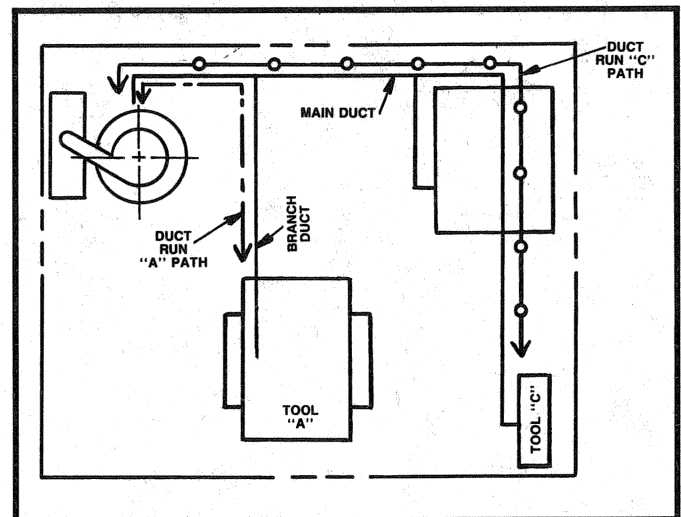
Air flow of 350-550 CFM provides the best dust collection at any woodworking tool. Five inch duct is optimum, and is available in metal furnace pipe. Plastic pipe is easier to install, but is available only in 4" diameter and **MUST BE ASSEMBLED WITH AN INTERNAL GROUND WIRE** to conduct away potentially explosive static charges. Metal pipe must be sealed with silicone sealant at all joints.

### 4. TOOL AIR INLET LIMITATIONS

Branch ducts can be attached to one main duct and run to many different tools. However, air must flow at only one tool at a time to ensure adequate dust collection. Additional tool inlets must be plugged or slide gates installed to limit the air flow to only one tool. (Do not use a damper to close off a duct.) There is no limit to the number of branch runs in a system as long as each run does not exceed the maximum length, and air flow is limited to one tool at a time.

Built-in (on tools) dust collection hoods (or other inlets) which have an inlet opening of less than 4", will restrict air flow and cause chips to drop out in the duct. This will not be a problem, however, if another full size inlet in the **same** duct run is opened periodically to provide a blast of air to flush out the duct. Be sure the second inlet (which may be a full size inlet at another tool) is located farther away from the collector than the undersize inlet.

Shop Duct Layout

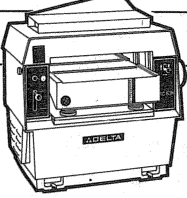
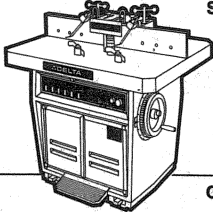
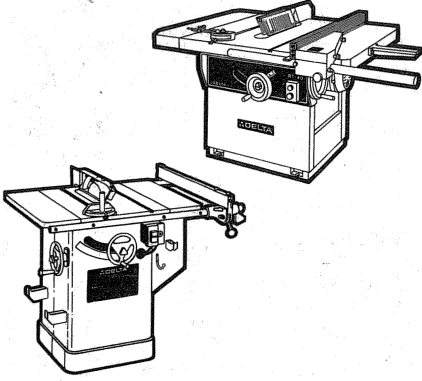
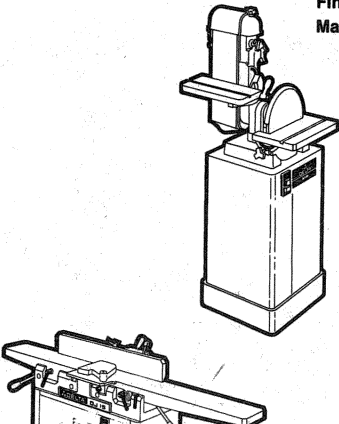
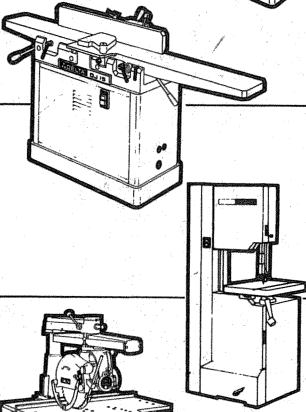
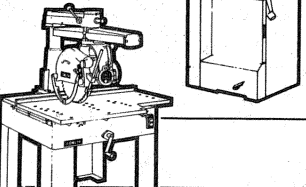
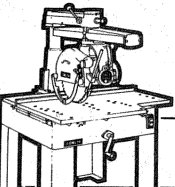


NOTE: For additional information on how to plan your system, send \$2 for Delta Bulletin "Central Dust Collection Systems" to Delta International, 246 Alpha Drive, Pittsburgh, PA 15238.

# Dust Collection Adaption for Delta Machinery

The chart below lists the catalog numbers of the various connectors, adapters and other accessories required for hook-up of the recommended Delta Dust Collector to various

Delta Machines in either a fixed or quick-disconnect installation. For detailed descriptions of the various items refer to the Dust Collector Accessories, Attachments and Connectors.

Machine	Model No.	Outlet O.D.	Type of Installation	Recommended Dust Collector	
				50-180	50-181 or 50-182
 Machine Planers	RC-63 and RC-51	6"	Fixed	—	None Required
			Quick Disconnect	—	50-218 & 50-232
	DC-33	4 7/8"	Fixed	22-658	22-658, 50-231 & 50-219
			Quick Disconnect	22-658, 50-231 & 50-226	22-658, 50-231 & 50-232
 Shapers	RS-15	10 3/4" x 4 1/4"	Fixed	50-246	50-246 & 50-219
	H.D.	2 3/4"	Fixed	50-234	50-234 & 50-219
			Quick Disconnect	50-234 & 50-226	50-234 & 50-232
	43-355	5 1/2" x 4 1/2"	Fixed	50-212	50-212 & 50-219
			Quick Disconnect	50-212 & 50-226	50-212 & 50-232
	 Circular Saws	DE-40	3" (Guard) 5" (Cabinet)	Fixed	50-242
Quick Disconnect				50-242 & 50-226	50-242 & 50-232
RT-40 and RE-35		4"	Fixed	50-236	50-236 & 50-219
			Quick Disconnect	50-236 & 50-226	50-236 & 50-232
RT-31		3"	Fixed	50-237	50-237 & 50-219
			Quick Disconnect	50-237 & 50-226	50-237 & 50-232
Unisaw Series 2000		2" x 15 3/4"	Fixed	50-243	50-243 & 50-219
			Quick Disconnect	50-243 & 50-226	50-243 & 50-232
Unisaw		3" x 4 9/16"	Fixed	34-843 & 50-222	34-843, 50-222 & 50-219
			Quick Disconnect	34-843, 50-222 & 50-226	34-843, 50-222 & 50-232
10" T.A. Saw		4 1/2" x 15 1/4"	Fixed	50-213	50-213 & 50-219
			Quick Disconnect	50-213 & 50-226	50-213 & 50-232
10" Contractor's Saw		Fixed	50-220 & 50-219	50-220	
		Quick Disconnect	50-220 & 50-226	50-220 & 50-232	
 Finishing Machines	6" Belt	3 1/4"	Fixed	50-214	50-214 & 50-219
			Quick Disconnect	50-214 & 50-226	50-214 & 50-232
	12" Disc		Fixed	50-224 & 50-237	50-224, 50-219 & 50-237
			Quick Disconnect	50-224, 50-237 & 50-226	50-224, 50-237 & 50-232
	6" Belt & 12" Disc		Fixed	50-224, (2) 50-186 & 50-190	50-224, (2) 50-186 & 50-189
			Quick Disconnect	50-224, (2) 50-186, 50-228 & 50-226	50-224, (2) 50-186, 50-228 & 50-232
	6" x 132" and 4" x 132" Edge Sanders	(2) 4"	Fixed	50-209	50-209 & 50-219
			Quick Disconnect	50-209 & 50-226	50-209 & 50-232
	Sanding Center Belt/ Disc Sander	4" (Both base & accessory tray)	Fixed	31-289 & 50-209	31-289, 50-209 & 50-219
			Quick Disconnect	31-289, 50-209 & 50-226	31-289, 50-209 & 50-232
 Jointers	RJ-42	17 1/4" x 8 1/2"	Fixed	50-258	50-258 & 50-219
			Quick Disconnect	50-258 & 50-226	50-258 & 50-232
	DJ-20	8 3/4" x 6 1/4"	Fixed	50-221	50-221 & 50-219
			Quick Disconnect	50-221 & 50-226	50-221 & 50-232
	DJ-15	6 1/2" x 6 3/4"	Fixed	50-221	50-221 & 50-219
			Quick Disconnect	50-221 & 50-226	50-221 & 50-232
 Band Saws	14"	1 3/8"	Fixed	50-239	50-239 & 50-219
			Quick Disconnect	50-239 & 50-226	50-239 & 50-232
	20"	2 3/8"	Fixed	50-238	50-238 & 50-219
			Quick Disconnect	50-238 & 50-226	50-238 & 50-232
 Radial Saws	12", 14" 16" and 18"		Fixed	50-291	50-291 & 50-219
			Quick Disconnect	50-291 & 50-226	50-291 & 50-232

# Delta Dust Collector Accessories & Attachments

**No. 50-183 Collector Drum.** 55-gallon capacity. Fire resistant aluminum foil lined fiber drum. 24" diameter x 31" high. 14 lbs.

**No. 50-311 Drum Dolley.** 5-wheel. Accommodates 55-gallon capacity fiber or metal drum. Adds portability to your dust collector system.

**No. 50-225 2' Diameter x 3' Dust Bag.** 22 sq. ft. filter area. New 3-dimensional weave for improved dust retention. With drawstring to fit standard 55-gallon drum. For use with No. 50-180 1 HP and 50-181 2 HP Dust Collectors for planer chip pick up. Also No. 50-180 1 HP Unit when major use is fine sanding dust collection.

**No. 50-185 2' Diameter x 6' Dust Bag.** 40 sq. ft. filter area. New 3-dimensional weave for improved dust retention. With drawstring to fit standard 55-gallon collector drum. Eyelet at top for overhead suspension. Supplied with 6" x 60" hose, sleeve and two clamps. For use with No. 50-182 3 HP Dust Collector. Also No. 50-181 2 HP Unit for fine dust pick up. 10¼ lbs.

**No. 50-195 Side-Hanging Dust Bag.** 19 sq. ft. filter area. New 3-dimensional weave for improved dust retention. Replacement bag for No. 50-180 1 HP and 50-181 2 HP Dust Collectors.

**No. 50-186 3" Dia. x 60" Hose.** 1½ lbs.

**No. 50-187 5" Dia. x 60" Hose.** 2½ lbs.

**No. 50-188 6" Dia. x 60" Hose.** 2¾ lbs.

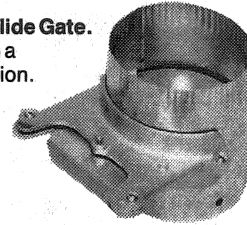
**No. 50-189 Y-Connector.** 6" x 3" x 3". For fixed installation. 2 lbs.

**No. 50-190 Y-Connector.** 5" x 3" x 3". For fixed installation. 1½ lbs.

**No. 50-229 Y-Connector.** 5" x 5" x 5". For use in a fixed 5" duct installation.



**No. 50-230 Slide Gate.** Fits 5" duct in a fixed installation.



**No. 50-191 6" to 5" Dia. Reducer.**

For fixed installation. 1½ lbs.

**No. 50-226 Quick Disconnect.**

With clamp for attachment to 5" dia. hose. A quick change connector or coupling for hook-up of the No. 50-180 1 HP Dust Collector to machinery with 5" dia. connector outlets.



**No. 50-232 Quick Disconnect.** With clamp for attachment to 6" dia. hose. Reduces inlet to 5" dia. For hook-up of the No. 50-181 2 HP or 50-182 3 HP Dust Collector to machinery with 5" dia. connector outlets.

**No. 50-227 Hose Coupler.**

For connecting two lengths of 5" dia. hose and/or use with Nos. 50-226 or 50-232 Quick Disconnects.



**No. 50-219 5" to 6" Dia. Increaser.** With clamping lug on 5" end. Used in a fixed type installation to attach most woodworking machines to 6" dia. hose of No. 50-181 1 HP or 50-182 3 HP Dust Collectors.

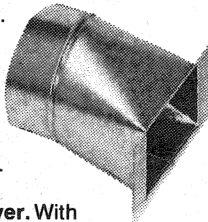
## Dust Collector Connectors

**For Circular Saws**

**No. 50-220 10" Contractor's Saw Connector.** Including mounting screws. Attaches to underside of saw mounted to No. 50-314 stand. 5" dia. outlet.

**No. 50-213 10" Tilting Arbor Saw Connector.** Attaches over opening in side of cabinet under motor cover. 5" dia. outlet.

**No. 50-243 Unisaw Series 2000 Connector.** Attaches over opening in side of cabinet under accessory motor cover. 5" dia. outlet.



**No. 50-222 Unisaw Connector.** Attaches over opening in base frame of older Delta Unisaws. 5" dia. outlet.

**No. 34-843 Motor Cover.** With mounting hardware. For older Delta Unisaws.

**No. 50-237 RT-31 Saw Connector.** 3" to 5" dia. increaser with clamping lug on 3" end. Attaches to dust chute of saw.

**No. 50-236 RE-35 and RT-40 Saw Connector.** 4" to 5" dia. increaser with clamping lug on 4" end. Attaches to dust chute of saw.

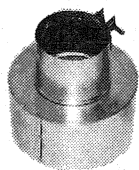
**No. 50-242 DE-40 Connector Kit.** Includes one 5" dia. x 90" hose, one 3" dia. x 144" hose, 5" x 5" x 3" Y-Connector; clamps and Velcro fasteners. Attaches to dust chute of saw and saw guard.

**For Radial Saws**

**No. 50-291 Radial Saw Connector.** Attaches to base frame of radial saw, left of column. 5" dia. outlet.

**For Band Saws**

**No. 50-238 20" Band Saw Connector.** Attaches to 2¾" dia. dust spout of band saw increasing outlet to 5" diameter.



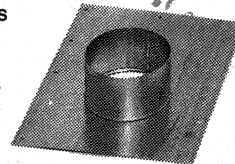
**No. 50-239 14" Band Saw Connector.** Replaces dust spout on band saw. 5" dia. outlet.

**For Jointers**

**No. 50-258 RJ-42 Jointer Connector.** Includes mounting screws. Attaches to jointer cabinet covering factory installed chute. 5" dia. outlet.

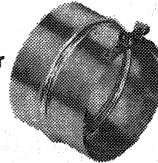
**No. 50-221 DJ-20 and DJ-15 Jointer Connector.** Includes mounting screws.

Attaches to jointer cabinet covering factory installed chute. 5" dia. outlet.



**For Planers**

**No. 50-231 DC-33 Planer Connector.** Attaches to 22-658 Shaving Hood. 5" dia. outlet.



**No. 22-604 24" Planer Dust Chute.** For old style 22-600 24" Planer. 5¾" dia. outlet.

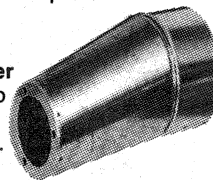
**No. 50-218 RC-63 and RC-51 Planer Connector.** 6" to 5" reducer with clamping lug on 6" end. Attaches to planer shaving hood.



**For Shapers**

**No. 50-212 43-355 Shaper Connector.** Attaches to dust chute of shaper fence. 5" dia. outlet.

**No. 50-234 H.D. Shaper Connector.** Attaches to fence guard assembly of shaper. 5" dia. outlet.

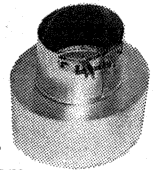


**No. 50-246 RS-15 Shaper Connector Kit.** Includes fence and backside exhaust chute connectors, two 5" dia. x 14" hose, clamps and 5" x 5" x 5" Y-Connector.

**For Finishing Machines**

**No. 50-209 6" x 132" and 4" x 132" Edge Sander Connector Kit.** Includes two 4" dia. x 60" hose, 4" x 4" x 5" Y-Connector and clamps. Attaches to outlets in belt guard end caps.

**No. 50-214 6" Belt Sander Connector.** 3¼" to 5" dia. increaser with clamping lug on 3¼" end. Attaches to exhaust chute of sander.



**No. 50-224 12" Disc Sander Connector.** Attaches to bottom of sander. 3" dia. outlet. Requires 50-237 Increaser for hook-up to wood dust collector.

**No. 50-237 3" to 5" Dia. Increaser.** With clamping lug on 3" end. Attaches to 50-224 Connector on 12" Disc Sander.

**No. 50-228 3" x 3" x 5" Y-Connector.** For dual hook-up of Belt and Disc Sander on combination unit. Requires two 50-186 hose, and 50-224 Connector for 12" Disc Sander.

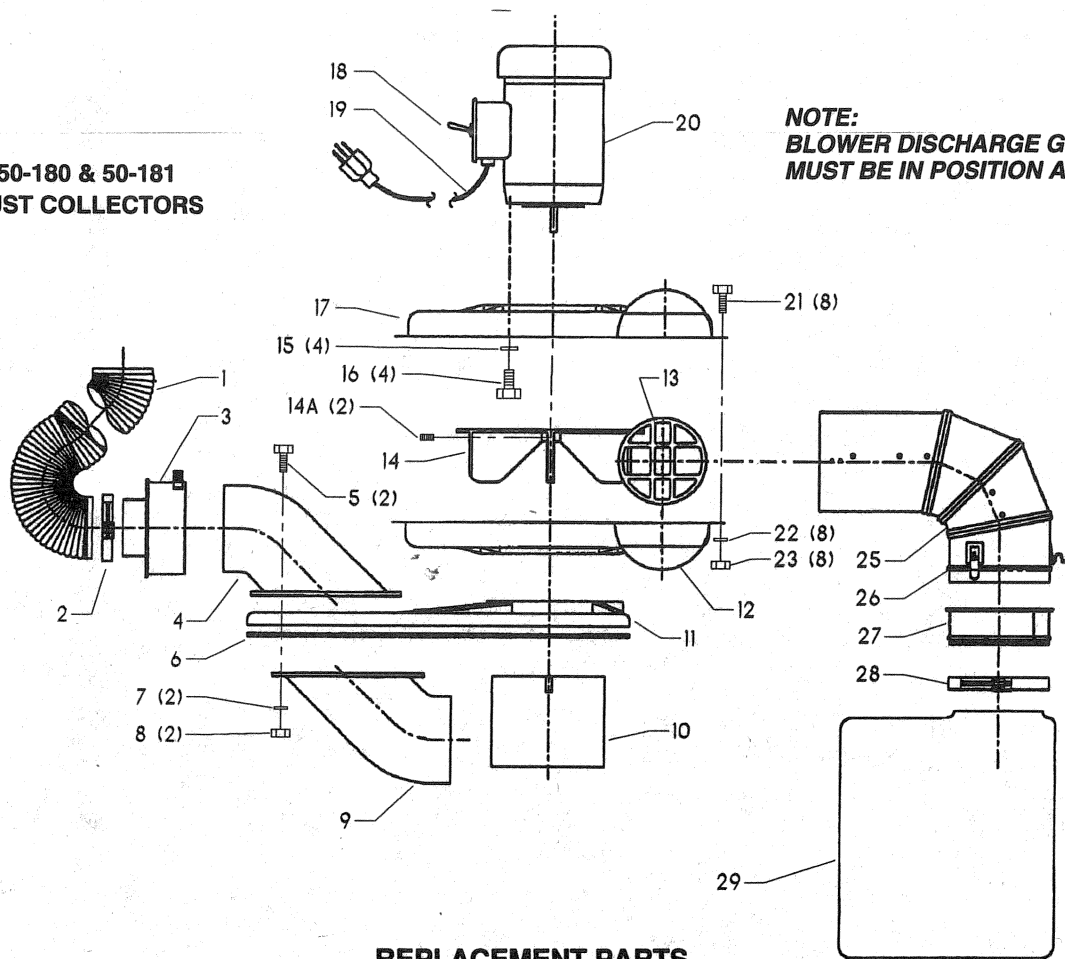
**No. 50-186 3" Dia. x 60" Hose.** Two required for use with 50-228 Y-Connector in dual hook-up of Belt and Disc Sander on combination unit.

**No. 31-289 Sanding Center / Dust Collector Tray & Connector Kit.** For use with sanding drums at power take-off site of machine. Includes dust chute with 4" dia. outlet and mounting hardware.

**No. 50-236 4" to 5" Increaser.** With clamping lug on 4" end. Attaches to 4" outlet of dust chute increasing outlet size to 5" diameter.

**No. 50-209 Sanding Center / Dual Dust Collector Connector Kit.** Includes two 4" x 60" hose, clamps and 4" x 4" x 5" Y-connector with gates. For use when dust collection hook-up to both base machine and accessory 31-289 Collector Tray is desired.

**50-180 & 50-181  
DUST COLLECTORS**



**NOTE:**  
**BLOWER DISCHARGE GUARD (REF NO. 13)**  
**MUST BE IN POSITION AT ALL TIMES**

**REPLACEMENT PARTS**

REF NO	PART NUMBER	DESCRIPTION	REF NO	PART NUMBER	DESCRIPTION
*	50-180	DUST COLLECTOR - 1 HP, CONST OF:	*	50-181	DUST COLLECTOR - 2 HP, CONST OF:
1	50-187	HOSE, INCL:	1	50-188	HOSE, INCL:
2	410-06-027-0002	CLAMP - 5"	2	410-06-027-0001	CLAMP - 6"
3	50-191	INLET HOSE REDUCER	4	410-06-001-0001	ELBOW
4	410-06-001-0001	ELBOW	5	901-01-060-0626	1/4-20 X 3/4" HEX HD SCREW
5	901-01-060-0626	1/4-20 X 3/4" HEX HD SCREW	6	410-06-116-0001	GASKET
6	410-06-116-0001	GASKET	7	904-02-020-1702	1/4" LOCK WASHER
7	904-02-020-1702	1/4" LOCK WASHER	8	902-01-120-1034	1/4-20 HEX NUT
8	902-01-120-1034	1/4-20 HEX NUT	9	410-06-001-0001	ELBOW
9	410-06-001-0001	ELBOW	10	410-06-035-0001	INTAKE CYLINDER
10	410-06-035-0001	INTAKE CYLINDER	11	410-06-031-0003	LID
11	410-06-031-0003	LID	12	410-06-031-0002	HOUSING - INLET SIDE
12	410-06-031-0002	HOUSING - INLET SIDE	13	410-06-054-0001	DISCHARGE GUARD
13	410-06-054-0001	DISCHARGE GUARD	14	410-06-100-0002	FAN
14	1342482	FAN	14A		HEX SOC SET SCREW
14A	1346931	5/16-18 x 3/8" HEX SOC SET SCREW (See Service Note A)	15	904-02-020-1704	3/8" LOCKWASHER
15	904-02-020-1704	3/8" LOCKWASHER	16	901-01-060-3104	3/8-16 X 1/2" HEX HD SCREW
16	901-01-060-3104	3/8-16 X 1/2" HEX HD SCREW	17	410-06-031-0001	HOUSING - MOTOR SIDE
17	410-06-031-0001	HOUSING - MOTOR SIDE	18	438-01-628-0004	SWITCH
18	438-01-628-0004	SWITCH	19	49-514	CORD SET
19	49-514	CORD SET	20	438-02-314-1010	MOTOR - 2 HP
20	438-02-314-1009	MOTOR - 1 HP	21	901-01-060-0626	1/4-20 x 3/4" HEX HD SCREW
21	901-01-060-0626	1/4-20 x 3/4" HEX HD SCREW	22	904-03-030-1757	1/4" EXT TOOTH WASHER
22	904-03-030-1757	1/4" EXT TOOTH WASHER	23	902-01-120-1034	1/4-20 HEX NUT
23	902-01-120-1034	1/4-20 HEX NUT	25	1345343	BAG LATCH ASSY (Current Models Only, See Service Note B)
25	1345343	BAG LATCH ASSY (Current Models Only, See Service Note B)	25	410-06-001-0004	BAG ELBOW (Early Models Only, See Service Note B)
25	410-06-001-0004	BAG ELBOW (Early Models Only, See Service Note B)	26	1345345	O RING
26	1345345	O RING	27	1345346	LATCH SLEEVE
27	1345346	LATCH SLEEVE	28	410-06-027-0001	CLAMP - 6"
28	410-06-027-0001	CLAMP - 6"	29	50-195	DUST BAG
29	50-195	DUST BAG			

**AVAILABLE AS ACCESSORY**

**	50-183	55 GAL DRUM
**	50-311	DRUM DOLLY

**AVAILABLE AS ACCESSORY**

**	50-183	55 GAL DRUM
**	50-311	DRUM DOLLY

\* NOT SHOWN ASSEMBLED  
\*\* NOT SHOWN

\* NOT SHOWN ASSEMBLED  
\*\* NOT SHOWN

**SERVICE NOTES:**

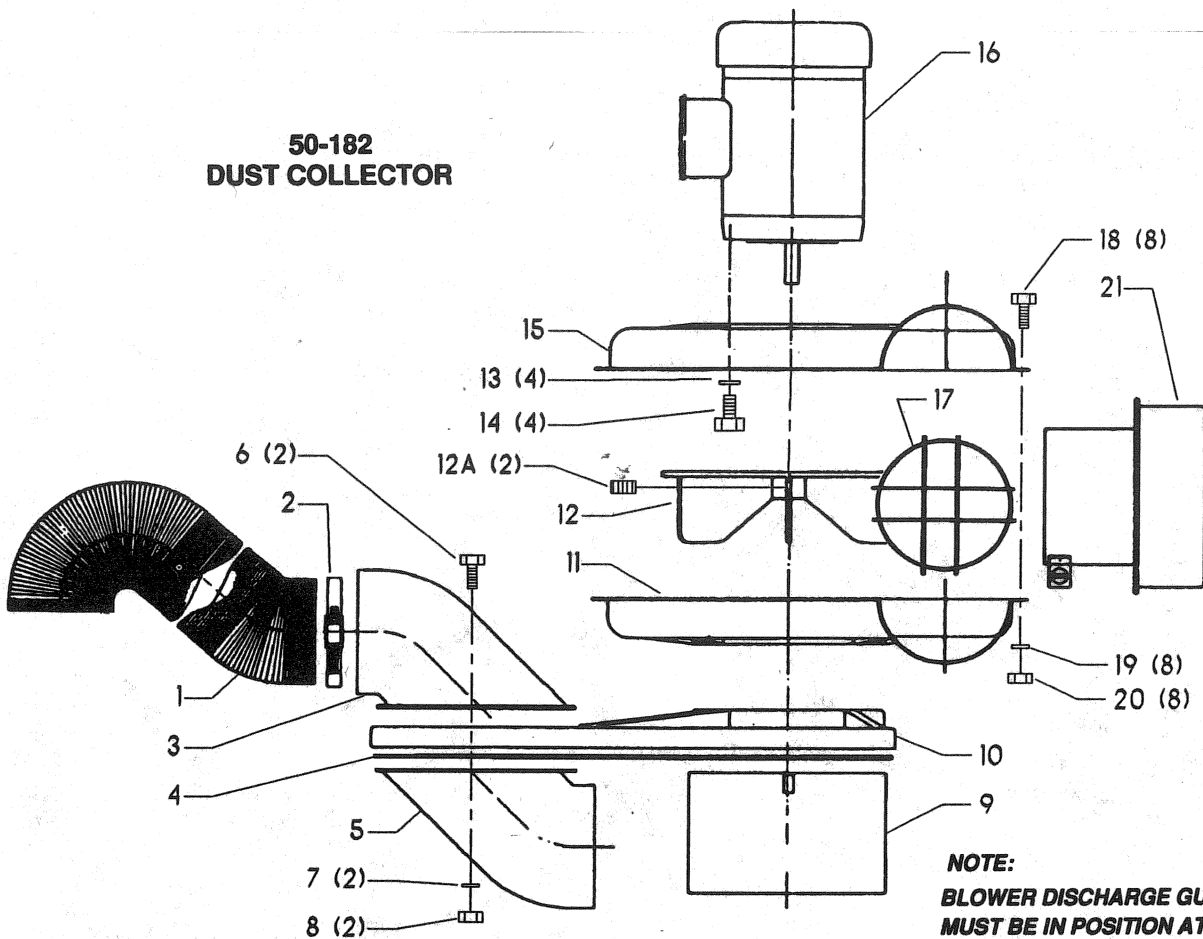
A - When screw requires servicing install at 100 inch lbs

B - For early model units without bag quick disconnect



# REPLACEMENT PARTS

## 50-182 DUST COLLECTOR



**NOTE:**  
**BLOWER DISCHARGE GUARD (REF NO 17)**  
**MUST BE IN POSITION AT ALL TIMES**

REF NO	PART NUMBER	DESCRIPTION	REF NO	PART NUMBER	DESCRIPTION
*	50-182	DUST COLLECTOR - 3 HP, CONST OF:	13	904-02-020-1704	3/8" LOCKWASHER
1	50-188	HOSE, INCL;	14	901-01-060-3104	3/8-16 X 1/2" HEX HD SCREW
2	410-06-027-0001	CLAMP - 6"	15	410-06-031-0006	HOUSING - MOTOR SIDE (Early Models Only, See Service Note C)
3	410-06-001-0002	ELBOW (Early Models, Only, See Service Note C)	15	410-06-031-0001	HOUSING - MOTOR SIDE (Current Models Only, See Service Note C)
3	410-06-001-0001	ELBOW (Current Models, Only, See Service Note C)	16	438-02-314-1011	MOTOR - 3HP
4	410-06-116-0001	GASKET	17	410-06-054-0002	DISCHARGE GUARD (Early Models, Only, See Service Note C)
5	410-06-001-0003	ELBOW (Early Models Only)	17	410-06-054-0001	DISCHARGE GUAD (Current Models, Only, See Service Note C)
5	410-06-001-0001	ELBOW (Current Models Only)	18	901-01-060-0626	1/4-20 x 3/4" HEX HD SCREW
6	901-01-060-0626	1/4-20 X 3/4" HEX HD SCREW	19	904-03-030-1757	1/4" EXT TOOTH WASHER
7	904-02-020-1702	1/4" LOCK WASHER	20	902-01-120-1034	1/4-20 HEX NUT
8	902-01-120-1034	1/4-20 HEX NUT	21	410-06-001-0005	INCREASER (Early Models, Only, See Service Note C)
9	410-06-035-0001	INTAKE CYLINDER	**	50-183	55 GAL DRUM
10	410-06-031-0004	LID (Early Models, Only, See Service Note C)			
10	410-06-031-0003	LID (Current Models, Only, See Service Note C)			
11	410-06-031-0005	HOUSING - INLET SIDE (Early Models Only, See Service Note C)			
11	410-06-031-0002	HOUSING - INLET SIDE (Current Models, Only, See Service Note C)			
12	410-06-100-0003	FAN	**	50-311	DRUM DOLLY
12A	1346931	5/16-18 X 3/8" HEX SOC SET SCREW (See Service Note D)	*		NOT SHOWN ASSEMBLED
			**		NOT SHOWN

AVAILABLE AS ACCESSORY

### SERVICE NOTES:

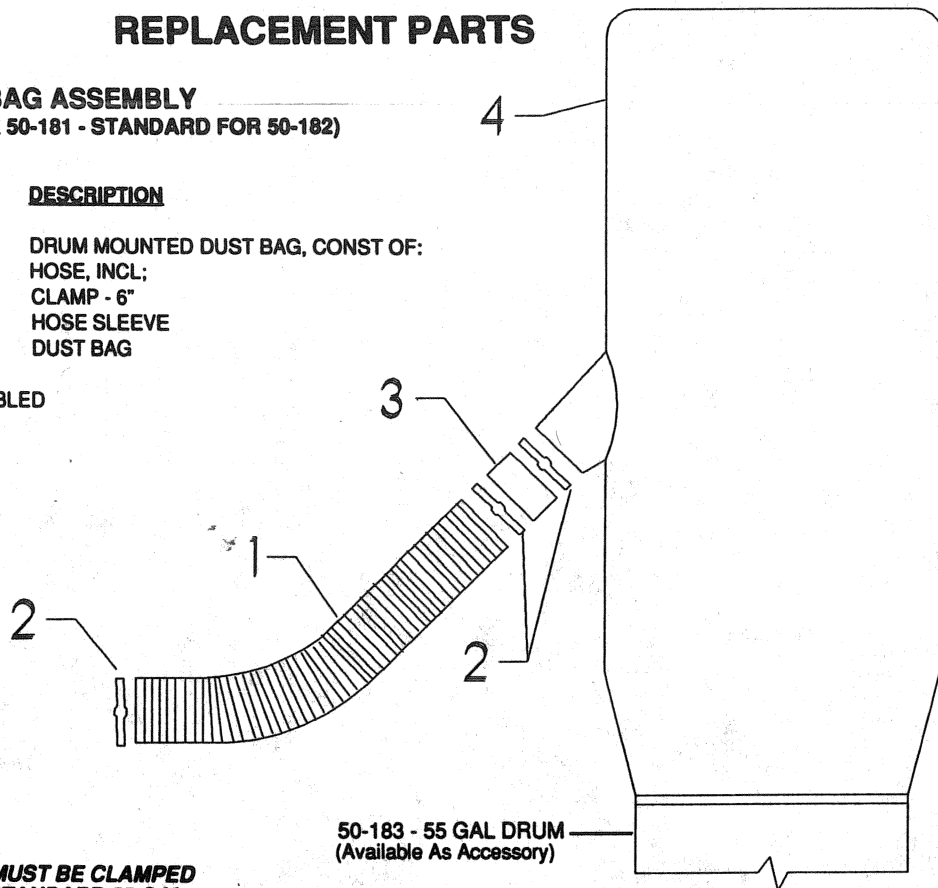
**C -** Early models had cast aluminum blower housings. Current models have stamped sheet metal blower housings.

**D -** When screw requires servicing install at 100 inch lbs

## REPLACEMENT PARTS

### 50-185 BAG ASSEMBLY (OPTIONAL FOR 50-180 & 50-181 - STANDARD FOR 50-182)

REF NO	PART NUMBER	DESCRIPTION
*	50-185	DRUM MOUNTED DUST BAG, CONST OF:
1	50-188	HOSE, INCL;
2	410-06-027-00001	CLAMP - 6"
3	410-06-105-0001	HOSE SLEEVE
4	50-195	DUST BAG
*	NOT SHOWN ASSEMBLED	



**NOTE:**  
THE NECK OF THE BAG MUST BE CLAMPED TO THE DRUM USING A STANDARD 55 GAL DRUM LID CLAMP

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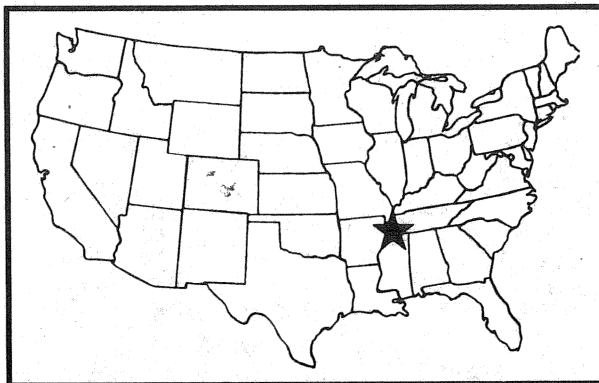
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