



## User Manual

Read and understand this manual before using machine.

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# 1 HP DUST COLLECTOR

Model Number  
65110





**THANK YOU** for purchasing your new Steel City Dust Collector. This dust collector has been designed, tested, and inspected with you, the customer, in mind. When properly used and maintained, your dust collector will provide you with years of trouble free service, which is why it is backed by one of the longest machinery warranties in the business.

This dust collector is just one of many products in the Steel City's family of woodworking machinery and is proof of our commitment to total customer satisfaction.

At Steel City we continue to strive for excellence each and every day and value the opinion of you, our customer. For comments about your dust collector or Steel City Tool Works, please visit our web site at [www.steelcitytoolworks.com](http://www.steelcitytoolworks.com) .

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## INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

This Dust Collector is intended for use of wood dust removal only. Any other use is forbidden. This machine is not to be modified for any reasons.

The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to Steel City Tool Works.

# WARRANTY

## 2 YEAR LIMITED WARRANTY

Steel City Tool Works, LLC (SCTW) warrants this SCTW machinery to be free of defects in workmanship and materials for a period of 2 years from the date of the original retail purchase by the original owner for domestic use. Granite components are warranted for 2 years based on normal use and is void if non SCTW accessories are used that cause the break or chip. Customer must advise SCTW within 30 days for any damage or defect found upon receipt of the product to qualify for the warranty on granite.

The warranty does not cover any product used for professional or commercial production purpose nor for industrial or educational applications. Such cases are covered by our 1 year Limited Warranty with the Conditions and Exceptions listed below.

Conditions and exception:

Warranty applies to the original buyer only and may not be transferred. Original proof of purchase is required.

Warranty does not include failures, breakage or defects deemed after inspection by an Authorized Service Center, (ASC) or agent of, have been directly or indirectly caused by or resulting from improper use, lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any part or component.

Additionally, warranty is void if repairs or alterations are made to the machine by an unauthorized service center without the direct consent of SCTW

Consumables such as blades, knives, bits and sandpaper are not covered.  
Wear items such as drive belt, bearings, switch, are covered for 1 year.

To file a claim of warranty or to find a service center, call toll free 877-724-8665 or email [customercare@steelcitytoolworks.net](mailto:customercare@steelcitytoolworks.net) and you must be able to present the original or photo copy of the sales receipt including the serial number from the machine and/or carton.

SCTW will inspect, repair or replace, at its expense and its option, any part that has proven to be defective in workmanship or material, provided that the customer returns the product prepaid to a designated ASC and provides SCTW with a reasonable opportunity to verify the alleged defect by inspection. SCTW will return the product or replacement at our expense unless it is determined by us that there is no defect or that the defect resulted from causes not within the scope of our *warranty in which case we will, at your direction, dispose of or return the product.* In the event you choose to have the product returned, you will be responsible for the handling and shipping costs of the return.

SCTW furnishes the above warranties in lieu of all other warranties, express or implied. SCTW shall not be liable for any special, indirect, incidental, punitive or consequential damages, including without limitation loss of profits arising from or related to the warranty, the breach of any agreement or warranty, or the operation or use of its machinery, including without limitation damages arising from damage to fixtures, tools, equipment, parts or materials, direct or indirect loss caused by and other part, loss of revenue or profits, financing or interest charges, and claims by and third person, whether or not notice of such possible damages has been given to SCTW. Damages or any kind for any delay by or failure of SCTW to perform its obligations under this agreement or claims made a subject of a legal proceeding against SCTW more than one (1) year after such cause of action first arose.

The validity, construction and performance of this Warranty and any sale of machinery by SCTW shall be governed by the law of the Commonwealth of Pennsylvania, without regard to conflicts of law's provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by SCTW or any claim related to the performance of and agreement including without limitation this Warranty, shall take place in the federal or state courts in Allegheny County, Pennsylvania.

Warranty registration card must be submitted to SCTW for purpose of proof within 90 days of purchase with a copy of the sales receipt. Failure to do so will, revert the 2 year warranty to 1 year as in the terms stated above. This registration is also needed to facilitate contact in case of a safety recall.

This warranty gives you specific legal rights and you may have other rights which vary in certain States or Provinces.

### Note to user

This instruction manual is meant to serve as a guide only. Specification and references are subject to change without prior notice. Check the website [www.steelcitytoolworks.com](http://www.steelcitytoolworks.com) for updated manuals with reference to the VER# located on the front page.

### **LIMITED WARRANTY – ACCU-SHOP line of bench top tools**

Steel City Tool Works, LLC (SCTW) warrants this SCTW ACCU-SHOP machinery to be free of defects in workmanship and materials for a period of 2 years from the date of the original retail purchase by the original owner for domestic use.

Consumables such as blades, knives, bits and sandpaper are not covered.  
Wear items such as drive belt, bearings, switch, are covered for 1 year.

The warranty does not cover any product used for professional or commercial production purpose nor for industrial or educational applications. Such cases are covered by our 30 days Limited Warranty with the Conditions and Exceptions listed previously.

# WARRANTY CARD

Name \_\_\_\_\_  
 Street \_\_\_\_\_  
 Apt. No. \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Phone Number \_\_\_\_\_  
 E-Mail \_\_\_\_\_

Product Description: \_\_\_\_\_  
 Model No.: \_\_\_\_\_  
 Serial No. \_\_\_\_\_

***The following information is given on a voluntary basis and is strictly confidential.***

1. Where did you purchase your STEEL CITY machine?  
 Store: \_\_\_\_\_  
 City: \_\_\_\_\_

2. How did you first learn of Steel City Tool Works?  
 Advertisement       Mail Order Catalog  
 Web Site             Friend  
 Local Store         Other \_\_\_\_\_

3. Which of the following magazines do you subscribe to?  
 American Woodworker       American How-To  
 Cabinetmaker                 Family Handyman  
 Fine Homebuilding          Fine Woodworking  
 Journal of Light Construction    Old House Journal  
 Popular Mechanics          Popular Science  
 Popular Woodworking        Today's Homeowner  
 WOOD                          Woodcraft  
 WOODEN Boat                Woodshop News  
 Woodsmith                   Woodwork  
 Woodworker                  Woodworker's Journal  
 Workbench                 Other \_\_\_\_\_

4. Which of the following woodworking / remodeling shows do you watch?  
 Backyard America       The American Woodworker  
 Home Time                 The New Yankee Workshop  
 This Old House          Woodwright's Shop  
 Other \_\_\_\_\_

5. What is your annual household income?  
 \$20,000 to \$29,999       \$30,000 to \$39,999  
 \$40,000 to \$49,999       \$50,000 to \$59,999  
 \$60,000 to \$69,999       70,000 to \$79,999  
 \$80,000 to \$89,999       \$90,000 +

6. What is your age group?  
 20 to 29 years             30 to 39 years  
 40 to 49 years             50 to 59 years  
 60 to 69 years             70 + years

7. How long have you been a woodworker?  
 0 to 2 years                 2 to 8 years  
 8 to 20 years               over 20 years

8. How would you rank your woodworking skills?  
 Simple                       Intermediate  
 Advance                     Master Craftsman

9. How many Steel City machines do you own? \_\_\_\_\_

10. What stationary woodworking tools do you own?  
*Check all that apply.*  
 Air Compressor             Band Saw  
 Drill Press                   Drum Sander  
 Dust Collection             Horizontal Boring Machine  
 Jointer                       Lathe  
 Mortiser                     Panel Saw  
 Planer                         Power Feeder  
 Radial Arm Saw             Shaper  
 Spindle Sander             Table Saw  
 Vacuum Veneer Press     Wide Belt Sander  
 Other \_\_\_\_\_

11. Which benchtop tools do you own? *Check all that apply.*  
 Belt Sander                 Belt / Disc Sander  
 Drill Press                  Band Saw  
 Grinder                      Mini Jointer  
 Mini Lathe                  Scroll Saw  
 Spindle / Belt Sander    Other \_\_\_\_\_

12. Which portable / hand held power tools do you own?  
*Check all that apply.*  
 Belt Sander                 Biscuit Jointer  
 Dust Collector             Circular Saw  
 Detail Sander              Drill / Driver  
 Miter Saw                  Orbital Sander  
 Palm Sander                Portable Thickness Planer  
 Saber Saw                  Reciprocating Saw  
 Router                      Other \_\_\_\_\_

13. What machines / accessories would you like to see added to the STEEL CITY line?  
 \_\_\_\_\_  
 \_\_\_\_\_

14. What new accessories would you like to see added?  
 \_\_\_\_\_  
 \_\_\_\_\_

15. Do you think your purchase represents good value?  
 Yes                         No

16. Would you recommend STEEL CITY products to a friend?  
 Yes                         No

17. Comments:  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

CUT HERE

FOLD ON DOTTED LINE

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PLACE  
STAMP  
HERE

**SteelCityToolWorks**  
**#4 Northpoint Court**  
**Bolingbrook, IL 60440**

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FOLD ON DOTTED LINE

# PRODUCT SPECIFICATIONS

## Motor Specifications:

Type	Induction, Ball Bearing
Continuous Duty	
Horsepower	1
Amps	8.5
Voltage	120
Phase	Single
Hertz	60
RPM	3450 (no load)

Collection Bag Capacity	2.5 cubic feet (88.5 cubic cm)
Collection Hose Type	Flexible
Collection Hose Diameter	4-inch (10.2cm)
Collection Hose Length	6-foot (1.8 meter)

## Product Specifications:

Noise Level (Decibel)	87 dB
CFM	700
Static Pressure (inches of water)	8.5
Number of ports	1
Port Diameter	4-inch (10.2cm)
Filter Bag Micron	3
Filter Bag Capacity	2.5 cubic feet (88.5 cubic cm)
Collection Bag Micron	Plastic

## Product Dimensions:

Footprint	28-1/2" x 15-1/2" (72.4cm x 39.4cm)
Length	28-1/2" (72.4cm)
Width	15-1/2" (39.4cm)
Height	72" (1829cm)
Weight	79 Lbs. (36Kg)

## Shipping Dimensions:

Carton Type	Cardboard
Length	31-1/8" (79cm)
Width	17" (43cm)
Height	15-3/8" (39cm)
Gross Weight	84 Lbs. (38Kg)

# ACCESSORIES AND ATTACHMENTS

## WARNING

- Use only accessories recommended for this machine. Using other accessories may cause serious injury and cause damage to the machine.

Contact your local Steel City dealer for accessories, or visit our website at: [www.steelcitytoolworks.com](http://www.steelcitytoolworks.com).

# DEFINITION OF TERMS

Below are some terms that will help you to understand and setup your Dust Collector and design your own Dust Collection System.

**Dust Collector** – A machine used to collect fine wood dust and chips.

**Dust Collection System** – A dust collector connected to multiple woodworking machines utilizing various types of hose/pipe and fittings.

**C.F.M.** = Cubic Feet/Minute – A measurement of the amount of air volume that can move through a dust collector in one minute.

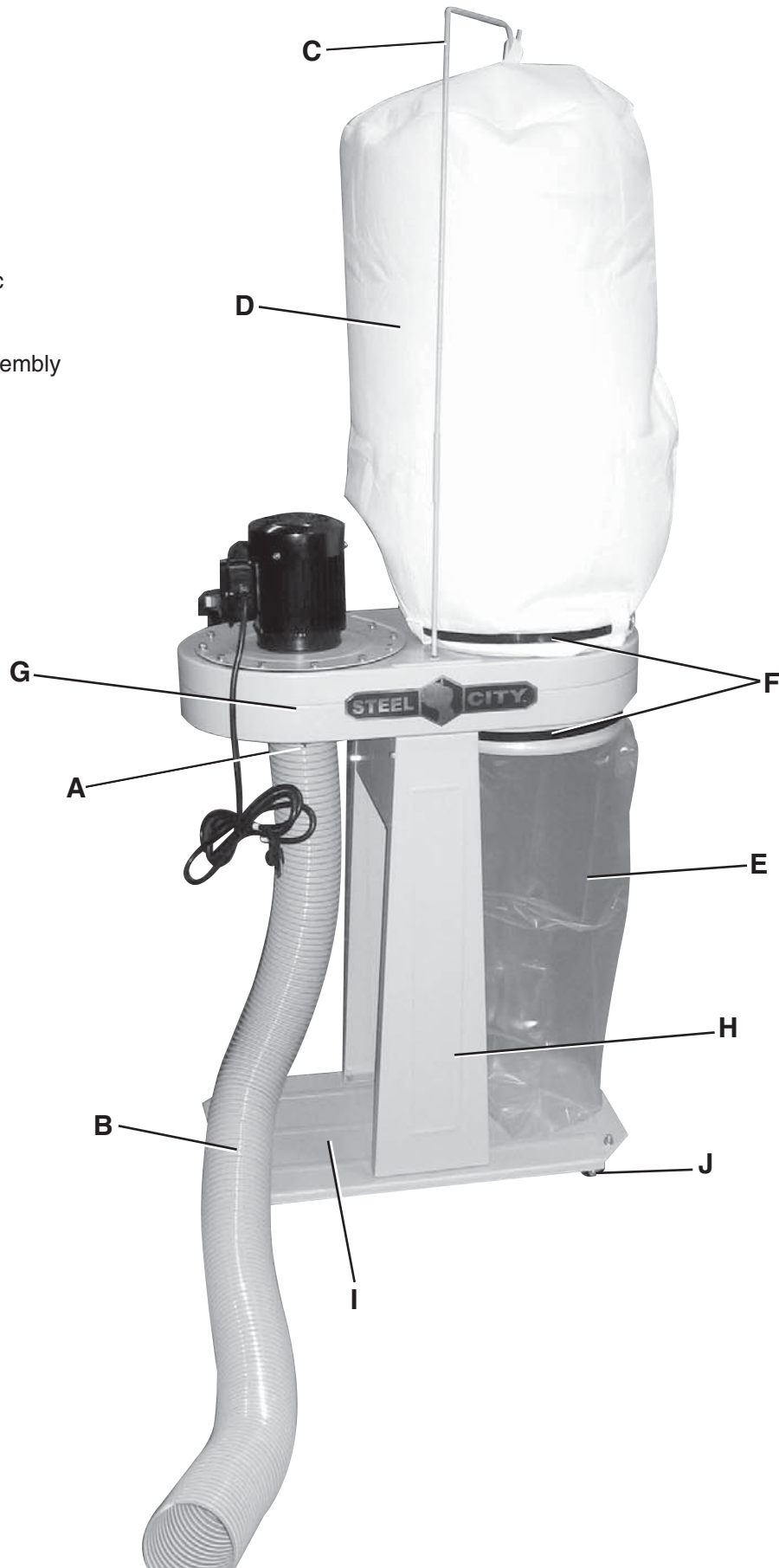
**Static Pressure** – A measurement of the amount of the resistance to airflow in a dust collection system.

**One Micron** – One micron is equal to one millionth of a meter.

# FEATURE IDENTIFICATION

**Fig. 1-1**

- A. 4-inch Intake Port
- B. 4-inch Flexible Hose
- C. Filter Bag Hanger
- D. Filter Bag
- E. Collection Bag, Plastic
- F. Locking Band
- G. Blower and Motor Assembly
- H. Side Support
- I. Base
- J. Caster





# GENERAL SAFETY

## **⚠ WARNING**

**TO AVOID** serious injury and damage to the machine, read and follow all Safety and Operating Instructions before assembling and operating this machine.

This manual is not totally comprehensive. It does not and can not convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws and any regulations having jurisdiction covering the safety requirements for use of this machine take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

Below is a list of symbols that are used to attract your attention to possible dangerous conditions.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

## **⚠ DANGER**

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

## **⚠ WARNING**

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

## **⚠ CAUTION**

Indicates a potentially hazardous situation, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

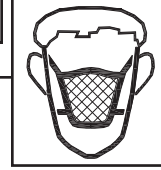
## **CAUTION**

**CAUTION** used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

## **NOTICE**

This symbol is used to alert the user to useful information about proper operation of the machine.

## **⚠ WARNING**



Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

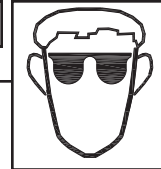
Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

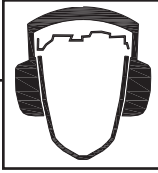
1. To avoid serious injury and damage to the machine, read the entire Instruction Manual before assembly and operation of this machine.

## **⚠ WARNING**



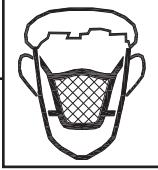
2. **ALWAYS** wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

**⚠ WARNING**



3. **ALWAYS** wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

**⚠ WARNING**



4. **ALWAYS** wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.

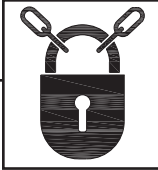
5. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an area that have slippery floor surfaces from debris, grease, and wax.
6. **ALWAYS** unplug the machine from the electrical receptacle when making adjustments, changing parts or performing any maintenance.
7. **AVOID ACCIDENTAL STARTING.** Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

**⚠ WARNING**



8. **AVOID** a dangerous working environment. **DO NOT** use electrical tools in a damp environment or expose them to rain.

**⚠ WARNING**



9. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.

10. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.
11. **DO NOT FORCE** the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.
12. **DO NOT** stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.
13. **DO NOT** store anything above or near the machine.
14. **DO NOT** operate any machine or tool if under the influence of drugs or alcohol.
15. **EACH AND EVERY** time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.
16. Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the third prong.
17. Keep visitors and children away from any machine. **DO NOT** permit people to be in the immediate work area, especially when the machine is operating.
18. **KEEP** protective guards in place and in working order.
19. **MAINTAIN** your balance. **DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.
20. **MAINTAIN** all machines with care. **ALWAYS KEEP** machine clean and in good working order. **KEEP** all blades and tool bits sharp.
21. **NEVER** leave a machine running, unattended. Turn the power switch to the OFF position. **DO NOT** leave the machine until it has come to a complete stop.
22. **REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning the machine ON.
23. **SECURE** all work. When it is possible, use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.

24. **STAY ALERT**, watch what you are doing, and use common sense when operating any machine. **DO NOT** operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.
25. **USE ONLY** recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, **DO NOT** use it.
26. **ONLY** use a proper extension cord in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.
27. Wear proper clothing, **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.
28. **SAVE** these instructions and refer to them frequently and use them to instruct other users.
29. Information regarding the safe and proper operation of this tool is also available from the following sources:


Power Tool Institute  
1300 Summer Avenue  
Cleveland, OH 44115-2851  
[www.powertoolinstitute.org](http://www.powertoolinstitute.org)


National Safety Council  
1121 Spring Lake Drive  
Itasca, IL 60143-3201


American National Standards Institute  
25 West 43rd Street, 4th floor  
New York, NY 10036  
[www.ansi.org](http://www.ansi.org)


ANSI O1.1 Safety Requirements for  
Woodworking Machines, and the U.S. Department  
of Labor regulations  
[www.osha.gov](http://www.osha.gov)

## PRODUCT SAFETY

1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.
  2. Every work area is different. Always consider safety first, as it applies to your work area. Use this machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.
  3. Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.
-  **WARNING**



  4. **TO REDUCE** the risk of electrical shock. **DO NOT** use this machine outdoors. **DO NOT** expose to rain. Store indoors in a dry area.
5. **STOP** using this machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.
  6. Safety decals are on this machine to warn and direct you to how to protect yourself or visitors from personal injury. These decals **MUST** be maintained so that they are legible. **REPLACE** decals that are not legible.
  7. **DO NOT** leave the dust collector plugged into the electrical outlet. Unplug dust collector from the outlet when not in use and before servicing, changing bags, unclogging and cleaning.
  8. **ALWAYS** turn the power switch "OFF" before unplugging the dust collector.
-  **WARNING**



  9. **DO NOT** handle the plug or dust collector with wet hands.
10. **DO NOT** use the dust collector to pick up flammable or combustible liquids, such as gasoline. **NEVER** use the dust collector near any flammable or combustible liquids.
  11. **USE** the dust collector to pick up wood materials only. **DO NOT** use the dust collector to pick up metal shavings, metal dust, or parts.
  12. **NEVER** use the dust collector to dissipate fumes or smoke. **NEVER** pick up anything that is burning or smoking, such as cigarettes, matches or hot ashes.

13. **USE** only as described in this manual. **USE** accessories only recommended by Steel City.
14. **DO NOT** pull the dust collector by the power cord. **NEVER** allow the power cord to come in contact with sharp edges, hot surfaces, oil or grease.
15. **DO NOT** unplug the dust collector by pulling on the power cord. **ALWAYS** grasp the plug, not the cord.
16. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. If the dust collector is not operating properly, or has been damaged, left outdoors or has been in contact with water.
17. **DO NOT** use the dust collector as a toy. **DO NOT** use near or around children.
19. **DO NOT** use the dust collector without the dust collection bag in place and properly secured.
20. **ALWAYS** use safety gates or caps to cover dust ports when the dust collector is not in use or mounted to a supporting surface for storage.
21. **PERIODICALLY INSPECT** dust bag for any cuts, rips or tears. **NEVER** operate the dust collector with a damaged bag or vacuum hose.
22. The dust collector is designed for home use or light commercial duty **ONLY**.
23. **CONNECT** dust collector to a properly grounded outlet only. See grounding instructions.

**⚠ WARNING**



18. **DO NOT** insert fingers or foreign objects into the dust intake port. Keep hair, loose clothing, fingers, and all body parts away from openings and moving parts of the dust collector.

## ELECTRICAL REQUIREMENTS

**⚠ WARNING**

**TO PREVENT** electrical shock, follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

**TO REDUCE** the risk of electrical shock, **DO NOT** use machine outdoors. **DO NOT** expose to rain. Store indoors in a dry area.

**DO NOT** connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

# GROUNDING INSTRUCTIONS

## ⚠ WARNING



This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. This machine is equipped with an electric cord that has an equipment-grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. All connections must also adhere to all of OSHA mandates.

**IMPROPER ELECTRICAL CONNECTION** of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

## PLUGS/RECEPTACLES

## ⚠ WARNING



- Electrocutation or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.
- **MAKE CERTAIN** the machine is disconnected from power source before starting any electrical work.
- **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

The motor supplied with your machine is a 120 volt, alternating current, 60 hertz, single phase motor. It is shipped wired for 120 volt application. Never connect the green or ground wire to a live terminal.

This tool is intended for use on a circuit that has an electrical receptacle as shown in Figure 1-1. Figure 1-1 shows a NEMA approved 3-wire, 15 amp electrical plug and receptacle that have a grounding conductor. If a properly grounded electrical receptacle is not available, an adapter as shown in Figure 1-2 can be used to temporarily connect this plug to a 2-contact ungrounded receptacle. The adapter has a rigid lug extending from it that **MUST** be connected to a permanent earth ground, such as a properly grounded receptacle box. **THIS ADAPTER IS PROHIBITED IN CANADA.**

Fig. 1-1

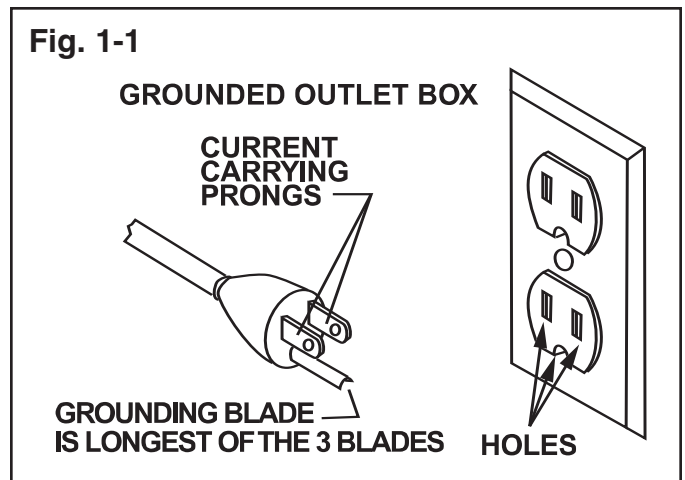
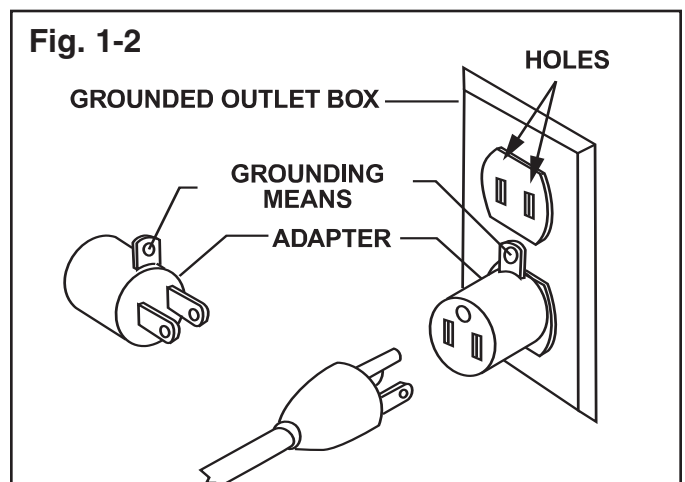


Fig. 1-2



## EXTENSION CORDS

### ⚠ WARNING



To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

### ⚠ CAUTION

**USE ONLY** a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug.

If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

#### MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)

120 VOLT OPERATION ONLY			
	25' LONG	50' LONG	100' LONG
0 to 6 Amps	18 AWG	16 AWG	16 AWG
6 to 10 Amps	18 AWG	16 AWG	16 AWG
10 to 12 Amps	16 AWG	16 AWG	14 AWG

# UNPACKING & INVENTORY

## ⚠ WARNING



- The machine is heavy, two people are required to unpack and lift.
- Use a safety strap to avoid tip over when lifting machine.

Check shipping carton and machine for damage before unpacking. Carefully remove packaging materials, parts and machine from shipping carton. Always check for and remove protective shipping materials around motors and moving parts. Lay out all parts on a clean work surface.

Remove any protective materials and coatings from all of the parts and the dust collector. The protective coat-

ings can be removed by spraying WD-40 on them and wiping it off with a soft cloth. This may need redone several times before all of the protective coatings are removed completely.

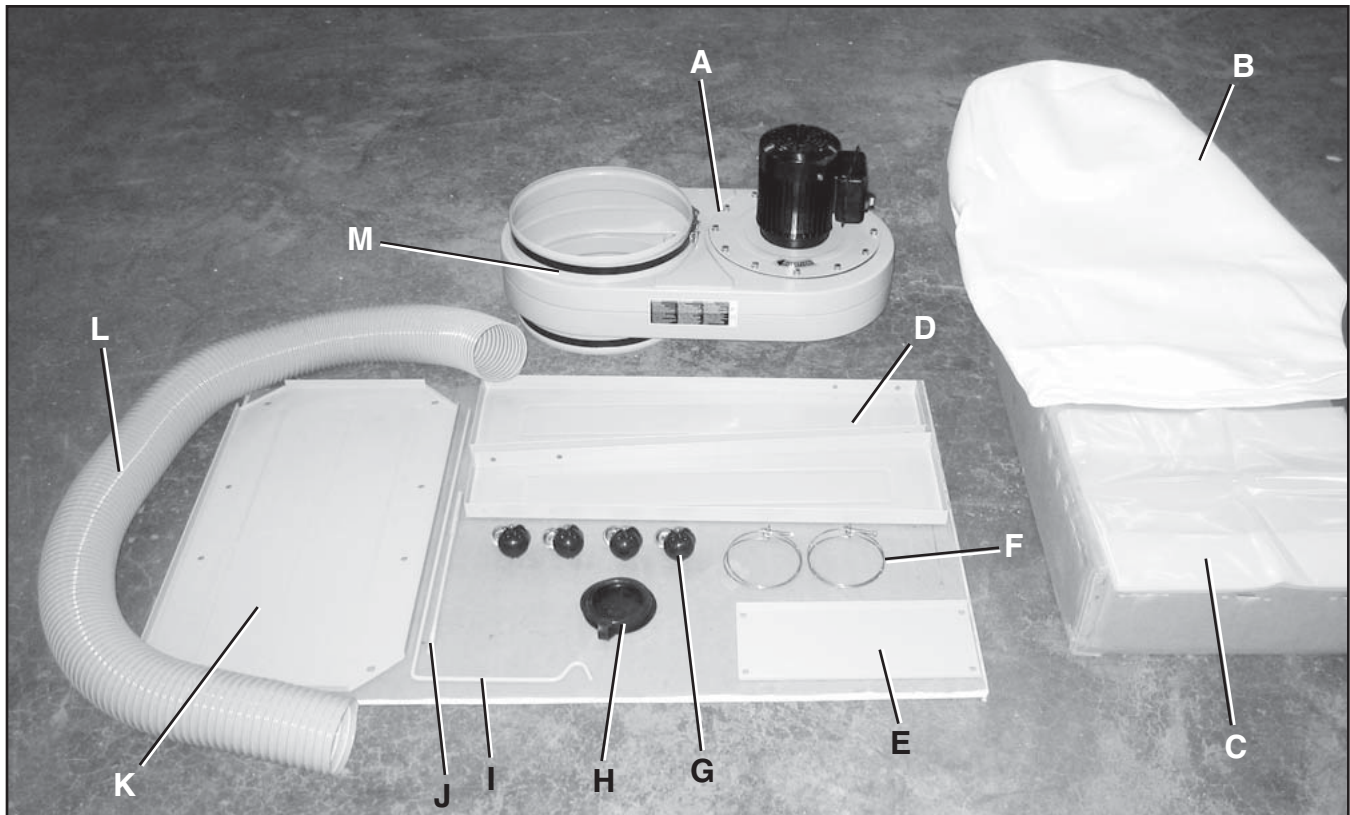
After cleaning, apply a good quality paste wax to any unpainted surfaces. Make sure to buff out the wax before assembly.

Compare the items to inventory figures; verify that all items are accounted for before discarding the shipping box.

## ⚠ WARNING

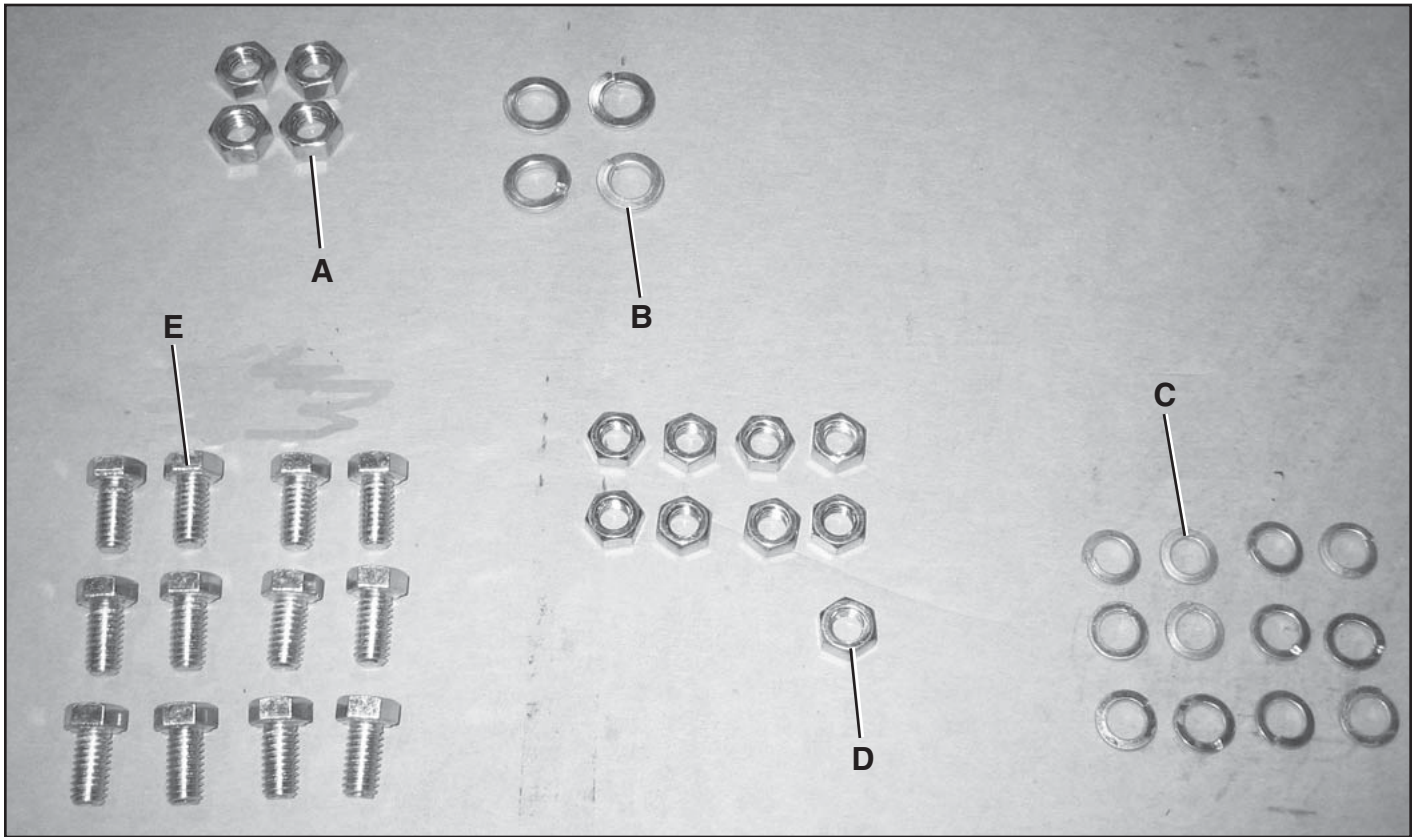
If any parts are missing, do not attempt to plug in the power cord and turn "ON" the machine. The machine should only be turned "ON" after all the parts have been obtained and installed correctly. For missing parts, contact Steel City at 1-877-SC4-TOOL.

**Fig. 1-1**



- |                              |                          |                         |
|------------------------------|--------------------------|-------------------------|
| A. Motor and blower assembly | E. Support               | J. Lower support rod    |
| B. Filter bag                | F. 4-inch hose clamp (2) | K. Base                 |
| C. Collection bag, Plastic   | G. Caster (4)            | L. 4-inch flexible hose |
| D. Side support (2)          | H. Intake port cap       | M. Locking band (2)     |
|                              | I. Filter bag hanger     |                         |

Fig. 1-2



- A. Hex nut 3/8-16 (4)
- B. Lock washer 3/8" (4)
- C. Lock washer 5/16" (12)
- D. Hex nut 5/16-18 (9)
- E. Hex head screw 5/16-18 x 5/8" (12)



# ASSEMBLY

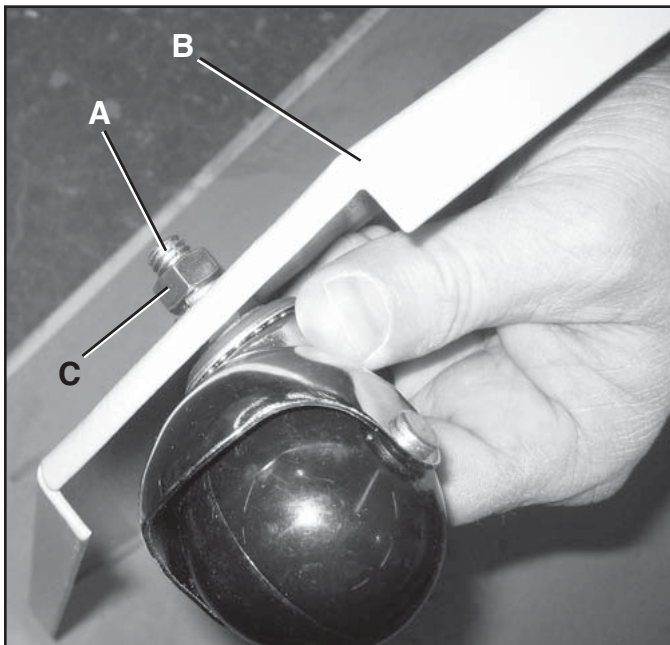
## **⚠ WARNING**

1. **DO NOT** assemble the Dust Collector until you are sure the tool **IS NOT** plugged in.
2. **DO NOT** assemble the Dust Collector until you are sure the power switch is in the “OFF” position.
3. 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 Owner’s Manual.

## SWIVEL CASTER TO BASE ASSEMBLY

**MAKE CERTAIN THE DUST COLLECTOR IS DISCONNECTED FROM THE POWER SOURCE.**

**Fig. 1-1**



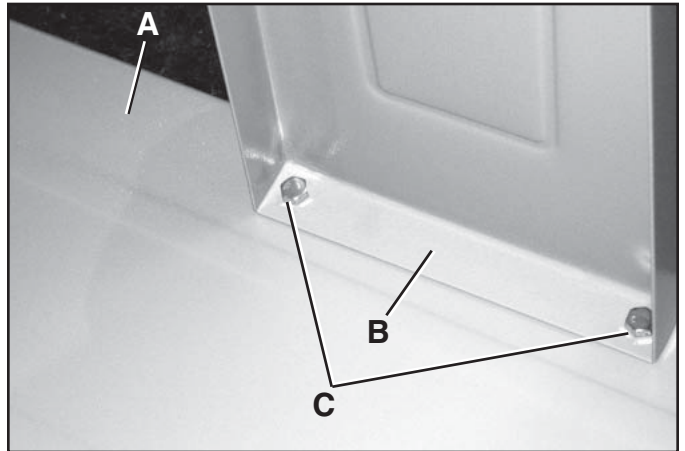
1. Insert bolt (A) from swivel caster through one of the four holes in the base (B), three are not shown. See figure 1-1.
2. Place 3/8-16 hex nut and 3/8” lock washer (C) onto bolt of swivel caster and tighten.
3. Repeat Steps 1, 2 and 3 for the remaining three swivel caster assemblies.

## SIDE SUPPORT ASSEMBLY

## **⚠ WARNING**

**MAKE CERTAIN THE DUST COLLECTOR IS DISCONNECTED FROM THE POWER SOURCE.**

**Fig. 2-1**



1. Place the base (A) in an upright position. See figure 2-1.
2. Align two holes in the wider end of side support (B) with two holes (C) in the base.
3. Insert a 5/16-18 x 5/8” hex head screw with 5/16” lock washer through each of the two holes in the side support and base.
4. Place a 5/16-18 flange hex nut onto each screw and tighten securely.

**Fig. 2-2**



5. Repeat Steps 1, 2, 3, and 4 to assemble the second side support. See figure 2-2.

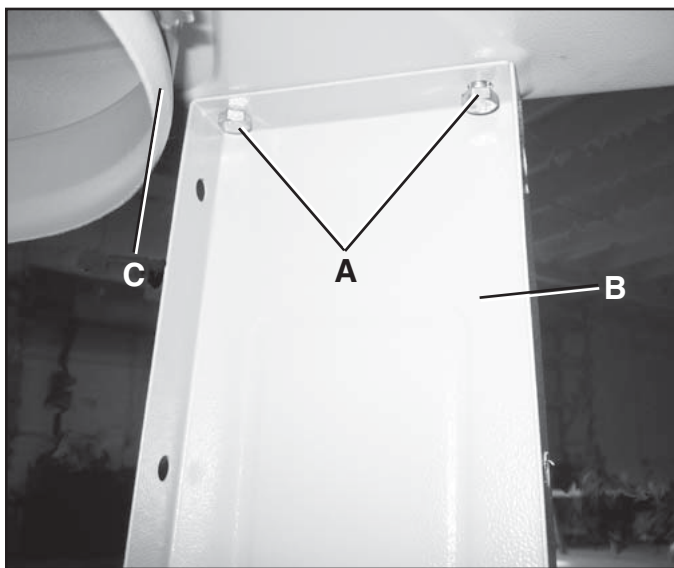
## MOTOR AND BLOWER TO BASE ASSEMBLY

### **⚠ WARNING**

**MAKE CERTAIN THE DUST COLLECTOR IS DISCONNECTED FROM THE POWER SOURCE.**

1. Place motor and blower assembly and base on their side with intake port pointing towards base.

**Fig. 3-1**



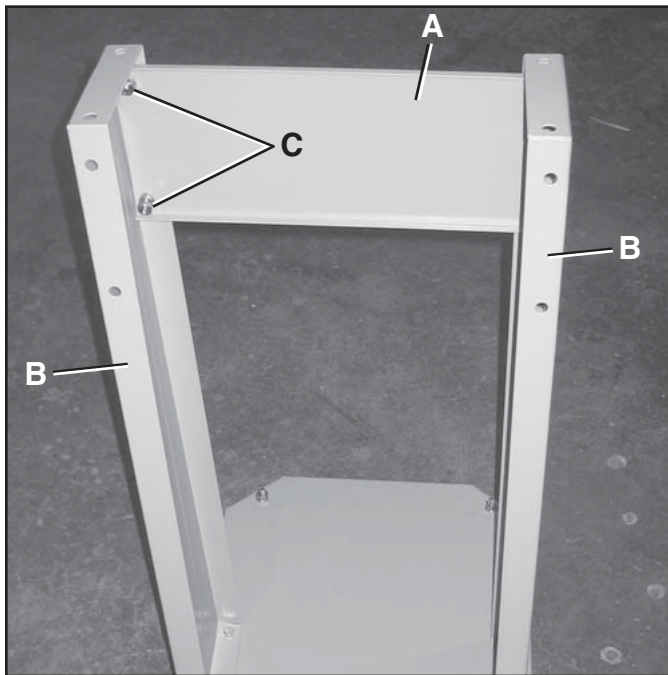
2. Align the four holes, two shown (A) on the top of both side supports (B) with four holes in the motor and blower assembly (C). See figure 3-1.
3. Place a 5/16" lock washer onto a 5/16-18 x 5/8" hex head screw and insert the screw through the side support and thread screw into tapped hole in the motor and blower assembly. Do not completely tighten.
4. Repeat this process for the remaining three holes; tighten securely.

## SUPPORT ASSEMBLY

### **⚠ WARNING**

**MAKE CERTAIN THE DUST COLLECTOR IS DISCONNECTED FROM THE POWER SOURCE.**

**Fig. 4-1**



**(Blower housing not shown for clarity.)**

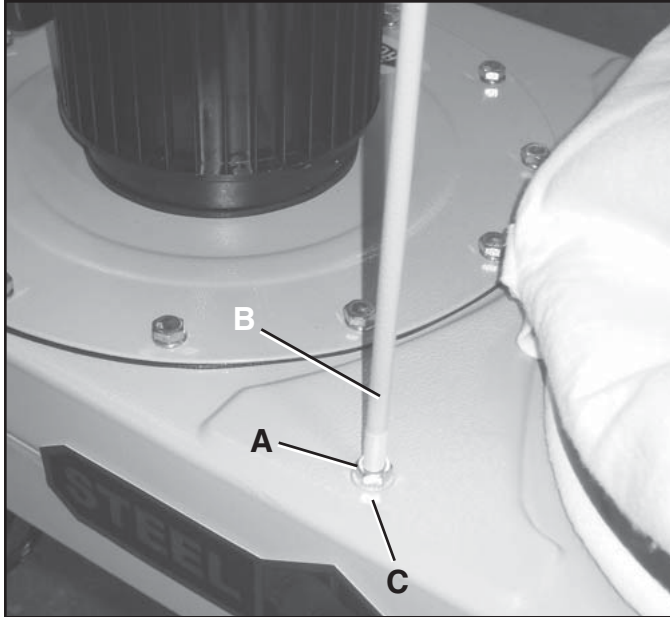
1. Place the support (A) inside the two side supports (B). **MAKE CERTAIN THE SUPPORT IS ATTACHED TO THE SIDE SUPPORTS CLOSEST TO THE MOTOR.** See figure 4-1.
2. Align the four holes (C) three shown, in the support with the four holes in the side supports.
3. Insert a 5/16-18 x 5/8" hex head screw with a 5/16" lock washer through the side support and support.
4. Place a 5/16-18 flange hex nut onto the 5/16-18 x 5/8" hex head screw. Do not completely tighten.
5. Repeat Steps 3 and 4 for remaining three holes and tighten securely.

## FILTER AND COLLECTION BAG TO DRUM ASSEMBLY

### **⚠ WARNING**

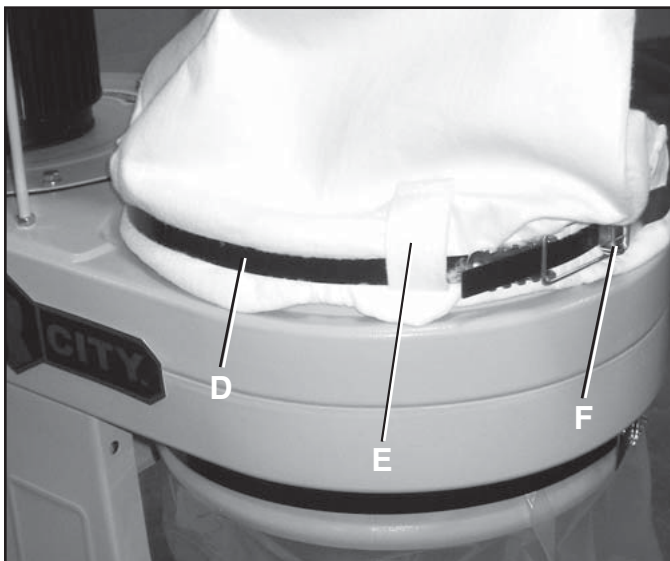
**MAKE CERTAIN THE DUST COLLECTOR IS DISCONNECTED FROM THE POWER SOURCE.**

**Fig. 5-1**



1. Thread 5/16-18 hex nut (A) onto the end of lower support rod (B). Thread lower support rod about 1/2 inch into the tapped hole (C) on top of the blower and motor assembly. Tighten the 5/16-18 hex nut on the lower support rod against the blower and motor assembly. See figure 5-1.
2. Place the end of filter bag hanger into the mating end of the lower support. Hook the loop on the top filter bag onto hook of the filter bag hanger.

**Fig. 5-2**



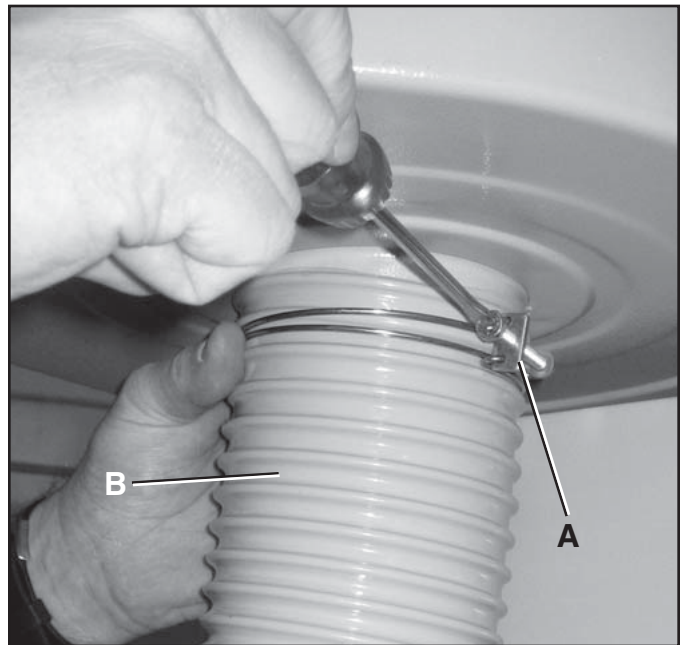
3. Insert locking band (D) through all the loops of filter bag (E). Position the open end of the filter bag over the top lip of the drum. Make certain the locking band is positioned in the upper recessed channel of the drum and fasten clamp (F) securely to drum. See figure 5-2.
5. Place the collection bag over the lower lip of the drum. Make certain the locking band is positioned in the lower recessed channel of the drum and fasten clamp securely to drum.

## INTAKE PORT CAP AND HOSE ASSEMBLY

### **⚠ WARNING**

**MAKE CERTAIN THE DUST COLLECTOR IS DISCONNECTED FROM THE POWER SOURCE.**

**Fig. 6-1**



1. Slide the collar of the intake port cap over intake port. Make sure the collar is positioned to the back if you intend to attach the hose at this time. See figure 6-1.
2. Place 4-inch hose clamp (A) onto the end of 4-inch flexible hose (B).
3. Slide the end of 4-inch flexible hose with 4-inch hose clamp onto intake port and tighten securely.

**IMPORTANT:** When connecting a flexible hose to intake port, **DO NOT REMOVE THE INTAKE PORT CAP COLLAR FROM THE INTAKE PORT.** Slide the collar of intake port cap further back when attaching a flexible hose.

# OPERATIONS

According to many OSHA, ANSI, STATE, and LOCAL CODES, it is the Employers Responsibility to:

- **PERMIT ONLY** trained and authorized employees to operate equipment.
- **INSPECT AND MAINTAIN** guards, safety devices and start/stop controls.
- **INSTRUCT, TRAIN** and **SUPERVISE** the safe method of work.

## **⚠ WARNING**

Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with the machine and its operations.

Every work area is different. Always consider safety first, as it applies to your work area. Use any machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.

**STOP** using the machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.

## ON/OFF SWITCH

The ON/OFF switch assembly is located on the side of the motor. To turn the dust collector "ON", move the switch up to the "ON" position. To turn the dust collector "OFF", move the same switch down to the "OFF" position.

## **⚠ WARNING**



**CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.

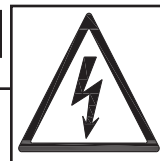
## LOCKING SWITCH IN THE "OFF" POSITION

When the Dust Collector is not in use, the switch key should be removed so that it cannot be started. Grasp the switch key and pull it out of the switch assembly. With the switch key removed, the switch will not operate. However, should the switch key be removed while the dust collector is running, it can be turned "OFF", but cannot be restarted without inserting the switch key.

## HELPFUL HINTS:

- Always run the largest appropriate diameter hose as far as possible. Running a smaller diameter hose will greatly reduce the C.F.M. at the tool, yielding marginal dust collection.
- The use of a low rated micron filter and collection bag can increase the effectiveness of your dust collector in removing fine particles of dust.
- Determine if you are to use your Dust Collector in a Dust Collection System or as a direct hook-up to an individual tool. If used in a Dust Collection System, review Static Pressure Requirements.

## **⚠ WARNING**



To protect yourself from a static shock, ground the dust collection system to a known ground.

If using the Dust Collector in a Dust Collector System, make certain to:

- Ground the dust collection system to a known ground.
- Always keep blast gates closed to unused tools.
- Make all runs as short as possible, minimizing the number of bends or turns that could greatly reduce the efficiency of your Dust Collector.
- Position the tools that have the highest C.F.M. requirements closest to the Dust Collector.

## THINGS TO CONSIDER:

- What is the maximum C.F.M. required for each tool you intend to use? Your Dust Collector should be rated for the tool that has the highest C.F.M. requirement.
- Will two or more tools be running at the same time? The Dust Collector should be rated to handle the combined C.F.M. requirements of all operating tools.

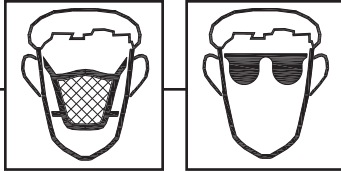
# MAINTENANCE

## **⚠ WARNING**

- **DO NOT** begin clean up until you have read and understand all of the clean up instructions.
- Follow proper Lock-Out / Tag-Out Procedures prior to cleaning this machine or any part of this machine.
- Read and follow current MSDS (Material Safety Data Sheets) and technical data sheets that relate to the cleaning materials used.
- **DO NOT USE FLAMMABLE MATERIALS** to clean Dust Collector.

## CLEANING

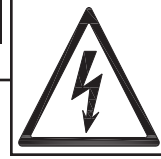
### **⚠ WARNING**



With the machine unplugged, 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-pressured air may damage insulation. The operator should always wear a respirator and eye protection when using compressed air.

Do not allow chips and dust to accumulate under dust collector. Keep area clean and in safe order.

## **⚠ WARNING**



Turn the power switch "OFF" and unplug the power cord from its power source prior to any maintenance. Always make sure that the intake port caps covers the intake port when a hose is not connected to the dust collector.

## LUBRICATION

The Dust Collector has sealed lubricated bearings in the motor housing that does not require any additional lubrication from the operator.

### **⚠ WARNING**

Repairs to the Dust Collector should be performed by trained personnel only. Contact your nearest Steel City Dealer for authorized service. Unauthorized repairs or replacement with non-factory parts could cause serious injury to the operator and damage to the Dust Collector.

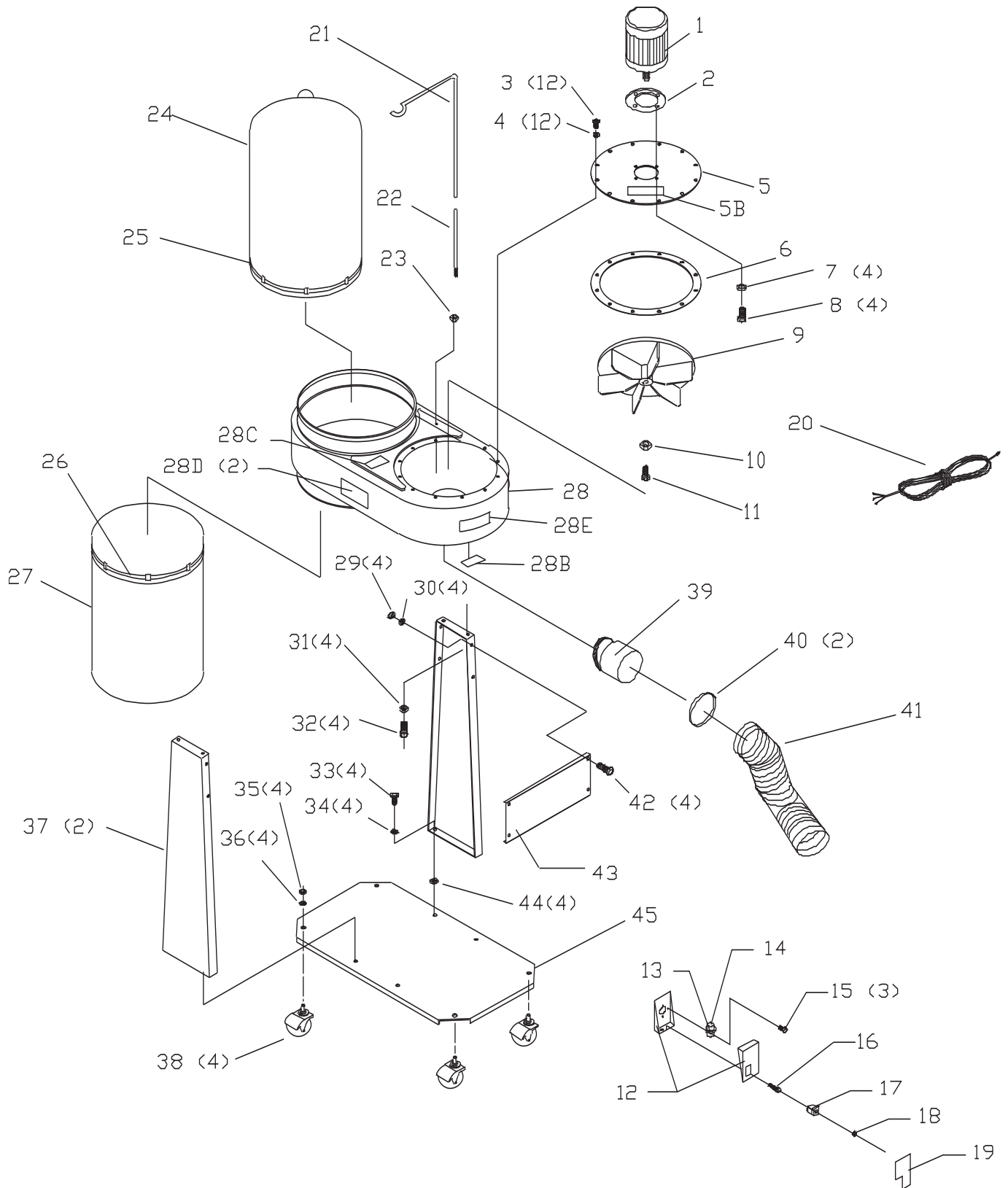
# TROUBLESHOOTING GUIDE

**TO PREVENT INJURY TO YOURSELF** or damage to the machine, turn the switch to the “OFF” position and unplug the power cord from the electrical receptacle before making any adjustments.

PROBLEM	LIKELY CAUSE(S)	SOLUTION
<b>Motor does not start</b>	<ol style="list-style-type: none"> <li>1. Switch is not in the “ON” position</li> <li>2. Defective switch</li> <li>3. Defective capacitor</li> <li>4. Low line voltage</li> <li>5. Defective motor</li> </ol>	<ol style="list-style-type: none"> <li>1. Make certain that switch lockout key is fully inserted into the switch and turn unit “ON”.</li> <li>2. Have switch replaced.</li> <li>3. Have capacitor replaced.</li> <li>4. Correct low line voltage condition.</li> <li>5. Have motor replaced/repaired.</li> </ol> <p>NOTE: 2, 3, 4 and 5 must be done by a qualified service technician.</p>
<b>Motor stalls (resulting in blown fuses or tripped circuit breakers)</b>	<ol style="list-style-type: none"> <li>1. Circuit overload</li> <li>2. Low line voltage</li> <li>3. Chips or debris clogged impeller.</li> <li>4. Motor overload</li> <li>5. Incorrect fuses on circuit breakers</li> <li>6. Short circuit in motor; loose connections or worn insulation on lead wires</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce circuit load</li> <li>2. Correct low line voltage condition.</li> <li>3. Clean all hoses, bags and blower housing of chips and debris.</li> <li>4. Reduce load on motor.</li> <li>5. Have correct fuses on circuit breakers installed.</li> <li>6. Inspect terminals in motor for damaged insulation and shorted wires and have them replaced.</li> </ol>
<b>Motor starts slowly or fails to come to full speed</b>	<ol style="list-style-type: none"> <li>1. Defective motor windings</li> <li>2. Defective capacitor</li> </ol>	<ol style="list-style-type: none"> <li>1. Have motor replaced/repaired.</li> <li>2. Have capacitor replaced.</li> </ol>
<b>Motor running too hot</b>	<ol style="list-style-type: none"> <li>1. Restricted air circulation due to dust accumulation.</li> <li>2. Motor overload</li> </ol>	<ol style="list-style-type: none"> <li>1A. Clean dust and restore normal air circulation.</li> <li>1B. Empty and clean filter and collection bags.</li> <li>2. Reduce load on motor.</li> </ol>
<b>Frequent blowing of fuse or circuit breakers</b>	<ol style="list-style-type: none"> <li>1. Fuses or circuit breakers do not have sufficient capacity</li> <li>2. Circuit overloaded</li> <li>3. Motor overload</li> </ol>	<ol style="list-style-type: none"> <li>1. Have correct fuses or circuit breakers installed.</li> <li>2. Reduce circuit load (turn off other appliances).</li> <li>3. Reduce load on motor.</li> </ol>



# PARTS





# PARTS

KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
1	OR70409	MOTOR ASSEMBLY COMPLETE WITH SWITCH BOX, 1 HP, DUST COLLECTOR	1	35	OR90646	HEX NUT 3/8-16	4
2	OR90653	GASKET	1	36	OR90647	LOCK WASHER 3/8"	4
3	OR90654	HEX HEAD SCREW 5/16-18 X 1/2"	12	37	OR70091	SIDE SUPPORT	2
4	OR90615	LOCK WASHER 5/16"	12	38	OR90648	SWIVEL CASTER	4
5	OR70083	BLOWER COVER ASSEMBLY	1	39	OR90650	INTAKE PORT CAP	1
6	OR90657	GASKET	1	40	OR65935	4" HOSE CLAMP	2
7	OR90615	LOCK WASHER 5/16"	4	41	OR90717	4" X 6' FLEXIBLE HOSE	1
8	OR90640	HEX HEAD SCREW 5/16-18 X 3/4"	4	42	OR90635	HEX HEAD SCREW 5/16-18 X 5/8"	4
9	OR90658	IMPELLER	1	43	OR70092	SUPPORT	1
10	OR90625	FLAT WASHER 5/16	1	44	OR90616	HEX NUT 5/16-18	4
11	OR90640	HEX HEAD SCREW 5/16-18 X 3/4"	1	45	OR70093	BASE	1
12	OR90628	SWITCH BOX ASSEMBLY	1	N/A	OR70081	USER MANUAL, MODEL 65110 (NOT SHOWN)	1
13	OR90727	CLAMP	1		OR70690	USER MANUAL, MODEL 65110 FRENCH (NOT SHOWN)	
14	OR90659	CAPACITOR 50uf	1		OR70691	USER MANUAL, MODEL 65110 SPANISH (NOT SHOWN)	1
15	OR90629	PAN HEAD SCREW #10-24 X 3/8"	3		OR90669	HARDWARE PACK FOR #65110 INCLUDES:	
16	OR90630	TRUSS HEAD SCREW #10-24 X 3/8"	1		OR90616	HEX NUT 5/16-18	8
17	OR70094	SWITCH ASSEMBLY, 4-POLE, COMPLETE WITH SWITCH KEY	1		OR90615	LOCK WASHER 5/16"	12
18	OR70095	SWITCH KEY	1		OR90635	HEX HEAD SCREW 5/16-18 X 5/8"	12
19	OR70082	SPEC LABEL	1		OR90646	HEX NUT 3/8-16	4
20	OR90633	POWER CORD	1		OR90647	LOCK WASHER 3/8"	4
21	OR70085	UPPER HANGER	1		OR90648	SWIVEL CASTER	4
22	OR70086	LOWER HANGER	1		OR90650	INTAKE PORT CAP	1
23	OR90616	HEX NUT 5/16-18	1		OR65935	4" HOSE CLAMP	2
24	OR70087	FILTER BAG, 3 MICRON with Steel City Logo	1				
25	OR90662	LOCKING BAND	1				
26	OR90662	LOCKING BAND	1				
27	OR70088	COLLECTION BAG, PLASTIC	3				
28	OR70089	BLOWER HOUSING ASSEMBLY	1				
29	OR90616	HEX NUT 5/16-18	4				
30	OR90615	LOCK WASHER 5/16"	4				
31	OR90615	LOCK WASHER 5/16"	4				
32	OR90635	HEX HEAD SCREW 5/16-18 X 5/8"	4				
33	OR90635	HEX HEAD SCREW 5/16-18 X 5/8"	4				
34	OR90615	LOCK WASHER 5/16"	4				
35	OR90646	HEX NUT 3/8-16	4				

<b>LABELS</b>			
KEY NO.	PART NO.	CUSTOMER DESCRIPTION	QTY.
5B	OR90607	ROTATION ARROW LABEL	1
19	OR70082	SPEC LABEL	1
28 B,			
28C	OR90601	INTAKE WARNING LABEL	1
28E	OR90600	WARNING LABEL	1
19A	OR70358	MOTOR SPEC LABEL (NOT SHOWN)	1

## ◆ NOTES ◆



# **STEEL CITY TOOL WORKS**

**[www.steelcitytoolworks.com](http://www.steelcitytoolworks.com)**

**1-877-SC4-TOOL**  
**(1-877-724-8665)**

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*2 Year Warranty*

