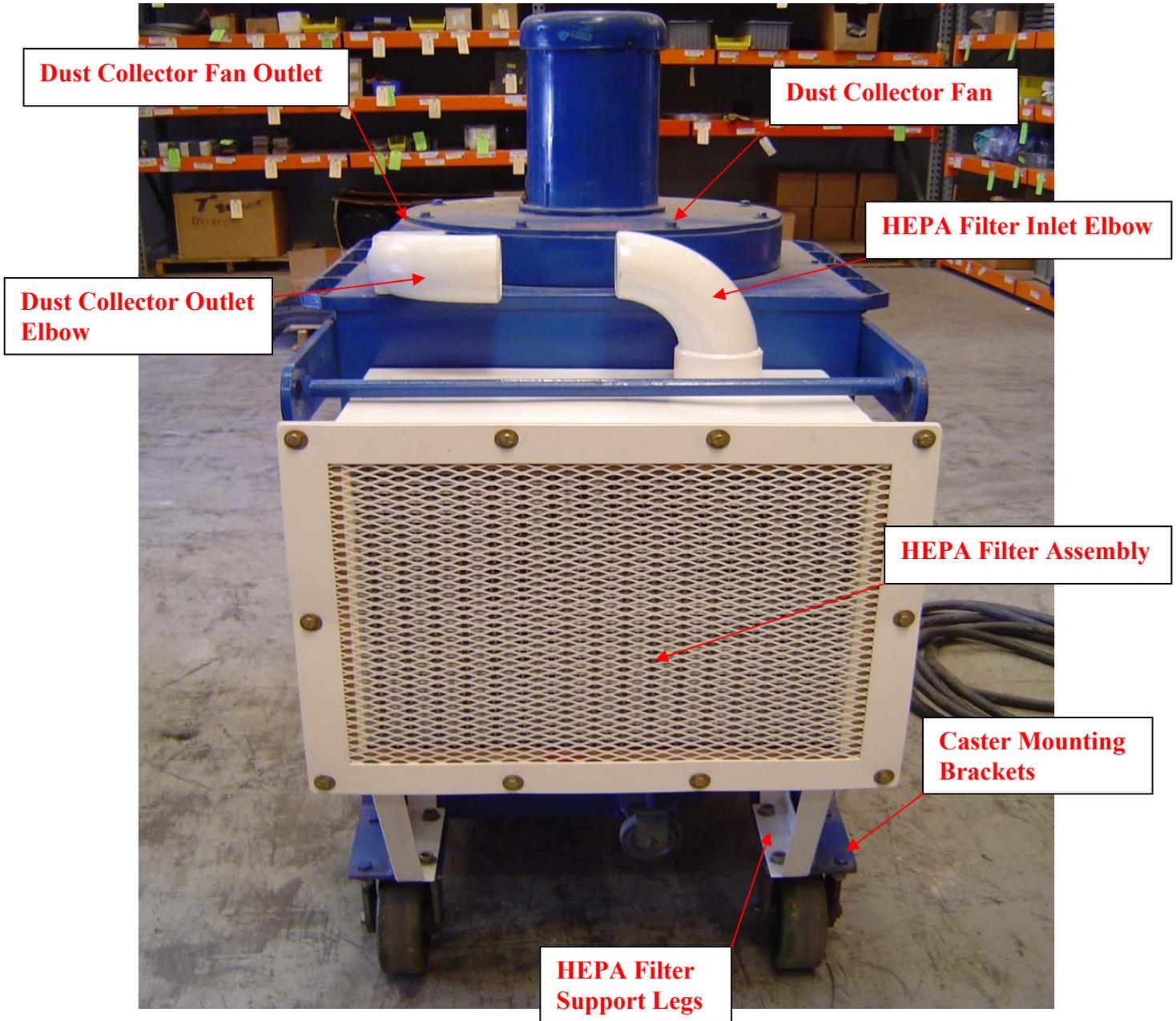


**6-54 HEPA Filter Assembly**



The Blastrac® 6-54 HEPA Filter Assembly in conjunction with your 6-54 Dust Collector provides a system filtration of 99.97% at 0.3 microns. The improved efficiency of the system provides adequate filtration for most contaminant removal applications.

 **WARNING**

By definition, High Efficiency Particulate Arrestance (HEPA) filters are tested by the Dispersed Oil Particulate (DOP) method and certified at 99.97% efficiency at 0.3 microns or larger. This rating is for the filter **cartridge ONLY** and particles less than 0.3 microns may still present a health risk. The **filtration system**, in this case the 6-54 and HEPA Attachment, is not guaranteed or certified to these specifications due to the unknown condition of the system and the effectiveness of the assembly (air leaks, etc). Always used approved air monitoring equipment and appropriate personnel protective equipment (PPE) on the job site while working with hazardous materials and this equipment. Failure to use the appropriate PPE may result in severe injury, or death.

Replace the filter element, part number 6814780, when the gauge on the side of the HEPA Filter Assembly consistently reads 4 to 5 in of H<sub>2</sub>O. The system will not work effectively with pressure levels above these readings.

Using the following assembly procedure your new HEPA Filter Assembly can be integrated easily to your 6-54 Dust Collector.

Due to the unknown condition of customers' dust collection units, some drilling and alignment procedures are necessary to complete the assembly process.

**Materials required:**

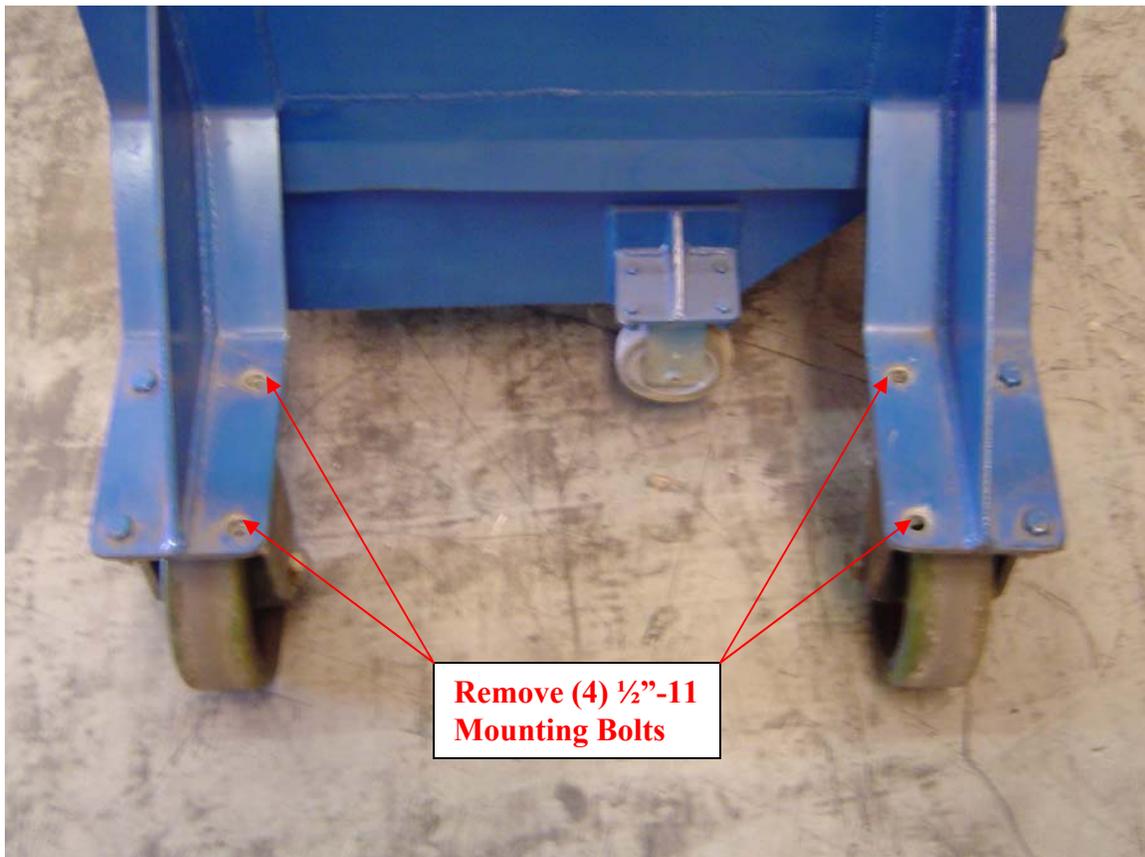
- (1) 4.00 inch ID x 12.00 inch long flexible hose
- (2) Worm drive hose clamps
- (3) 1/4"-20 self tapping screws
- (1) Tube of silicone sealer

**Tools Required:**

3/4" Box Wrench  
3/4" Socket and drive  
3/8" Socket and drive  
Center punch  
Marking pen  
5/16" Nut driver for hose clamps  
Drill  
7/32" drill bit  
5/8" drill bit  
3/8" drill bit  
Caulk gun

**Assembly Procedure:**

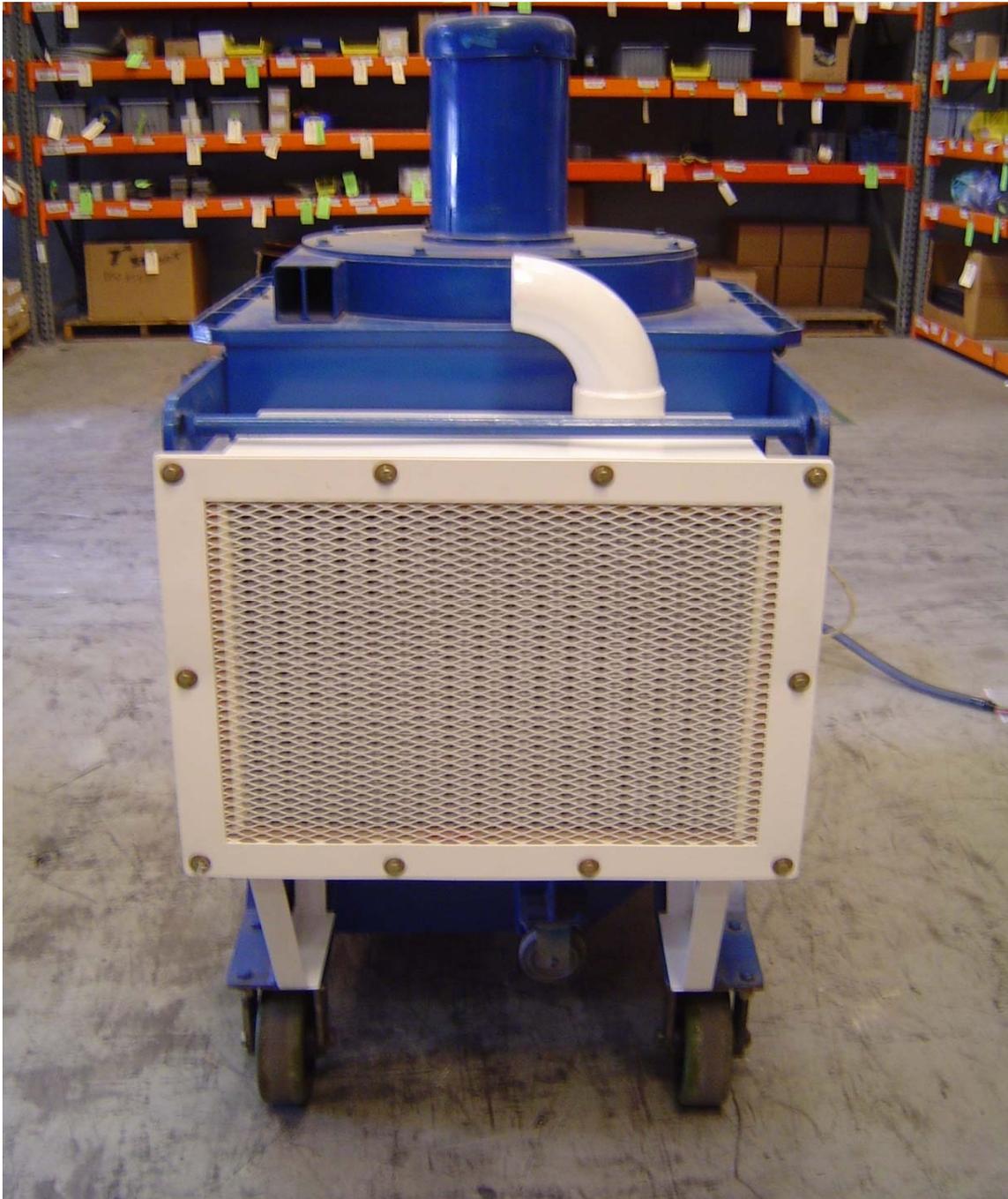
1. Remove the (4) inside bolts that mount the casters on the fan outlet side of the dust collector chassis.



Assembly Instructions  
**6-54 HEPA Filter Assembly**

June 2004  
Part Number: **6805920**

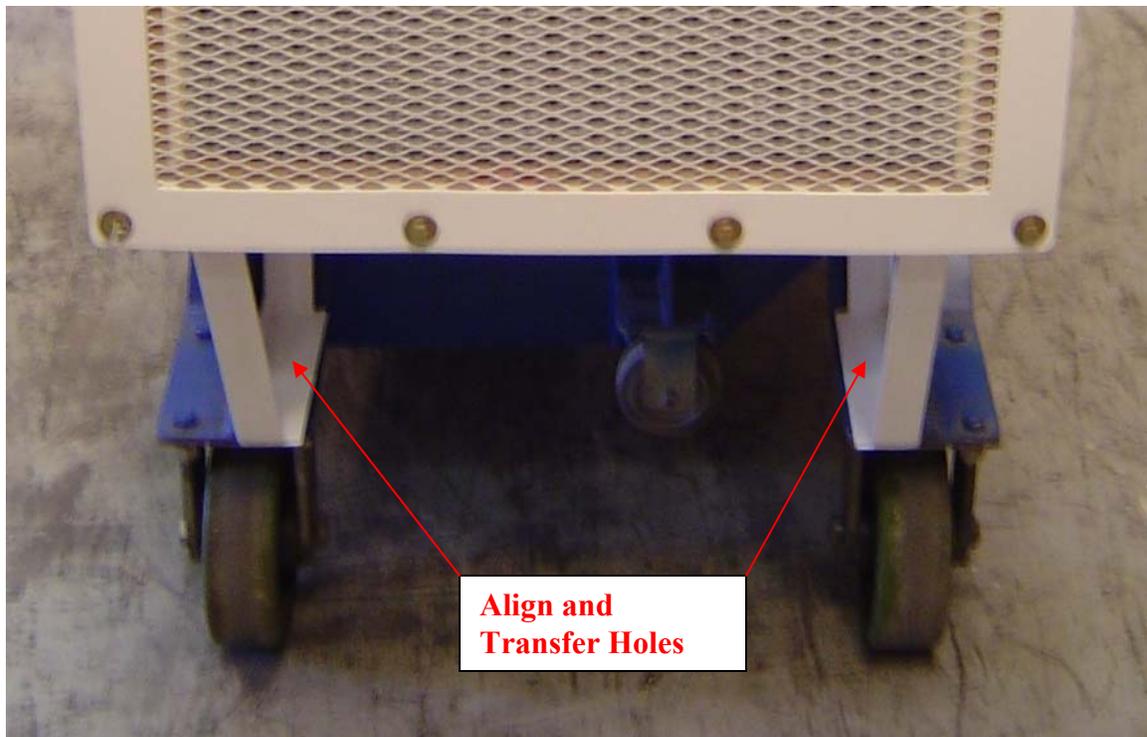
2. Using two people, tilt the HEPA filter housing so that the 90 degree elbow passes under the chassis cross bar and the lower frame of the HEPA filter housing rests on the caster mounting brackets below.



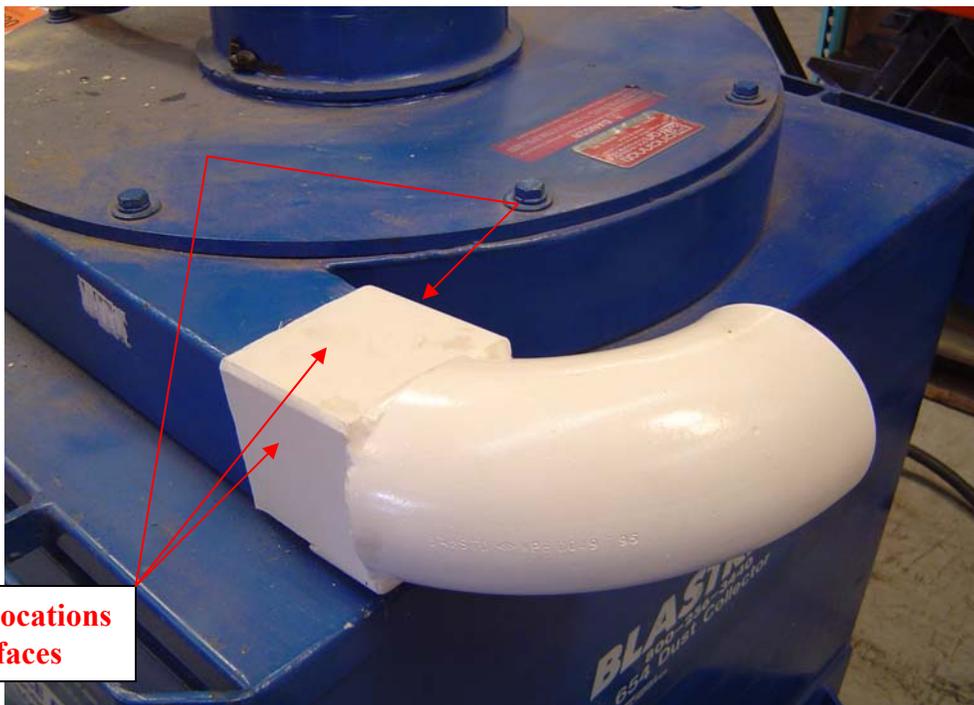
Assembly Instructions  
**6-54 HEPA Filter Assembly**

June 2004  
Part Number: **6805920**

3. Align the HEPA filter housing such that the support legs are centered on the caster mounting brackets. Allow for approximately 1 inch of clearance between the HEPA filter housing and the dust collector housing.
4. Once the HEPA filter housing is aligned, be sure there is enough material on the HEPA filter housing support legs to transfer the mounting holes.
5. From the bottom of the caster mounting brackets, transfer the (4) mounting hole positions to the bottom of the HEPA filter housing support legs.
6. Remove the HEPA filter housing and drill (4) 5/8" holes in the HEPA filter housing support legs at the transfer points.
7. Install the HEPA filter housing using step 2.
8. Using the existing caster mounting hardware, align and hand tighten the (4) inside mounting bolts.



9. Assemble outlet elbow as shown and mark three sides of the square portion of the outlet elbow for mounting with the 1/4"-20 mounting hardware. During the installation, align the outlet elbow with the inlet elbow of the HEPA filter assembly. The alignment does not have to be exact, the flex hose will allow for misalignment.
10. Remove the outlet elbow and drill (3) 3/8" hole on the layout marks.
11. Assemble the outlet elbow using step 9.
12. Transfer the (3) 3/8" hole locations to the blower outlet.
13. Remove the outlet elbow and drill (3) 7/32" pilot holes in the blower outlet for the 1/4"-20 self tapping screws.
14. Assemble the outlet elbow using step 9 and secure with the 1/4"-20 mounting hardware.
15. Silicone around all four sides of the mating surfaces between the outlet elbow and the dust collector fan outlet. It is important that a positive seal is created around these surfaces. If it is not sealed correctly, dust may escape through the connection.



**Mark Hole Locations  
and Seal Surfaces**

Assembly Instructions  
**6-54 HEPA Filter Assembly**

June 2004  
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16. Be sure the alignment is correct and tighten the (4) ½"-11 bolts on the HEPA filter support legs.
17. Slide one hose clamp over the outlet elbow and one clamp over the HEPA filter inlet elbow.
18. Install the 4 inch ID tubing between the elbows and secure with the hose clamps.

