Important:
This manual contains specific cautionary statements relative to worker safety. Read this manual thoroughly and follow as directed. It is impossible to list all the hazards of dust control equipment. All persons involved with the equipment or systems should be instructed how to operate in a safe manner.
WARNINGS:

⚠️ All electrical work must be done by a qualified electrician according to local, state and national codes.

⚠️ CAUTION: Installation can cause exposure to live components. Disconnect electrical power before proceeding with installation. Proper Lock Out / Tag Out procedures should be used.

Improper installation or operation of this equipment can cause damage to equipment and / or injury to personnel. The installation/operation manual must be read and followed in its entirety.

SPECIFICATIONS XA34:

- Input Voltage: 230/460 VAC 3-Phase
- Motor: 3 HP TEFC
- Max Current: 8.6/4.3 Amps
- Filter Area: 200-348 square feet (media dependent)
- Load Capacity: 1,000 pounds
- Air Flow: 3,720 CFM
- Capture Velocity: 250 FPM average @ 1” above work surface.
- Noise level: 79 dBA at operator
  74 dBA at operator with silencer
- Overall Dimensions: Base table: 36H x 58W x 37D
  With shields: 73H x 58W x 37D

COMPRESSED AIR REQUIREMENTS:

3/4” Air line with clean, dry compressed air regulated to 80-90 psi max is required for proper operation of the Roto-Pulse filter cleaning system. It is recommended that a pressure regulator and coalescing filter be installed between the compressed air source and the inlet to the downdraft table.

EQUIPMENT/TOOLS REQUIRED:

- Standard wrenches
- Forklift
- Pipe wrench
- Cordless drill

INSTALLATION:

1. Inspect the Unit for any visible damage that may have occurred during shipment. Note any damage on the packing slip.
2. Uncrate the unit. Use caution not to damage the paint while dismantling the crate.
3. Remove any options ordered from the skid.
4. Using a forklift, lift the unit off of the skid. Carefully place the downdraft table into its location.
5. Connect compressed air supply to the 3/4” NPT nipple on the unit.
6. Connect the wire whip to the appropriate plug based on unit and voltage ordered. Plug into properly sized electrical outlet.
7. Mount any optional accessories per instructions if ordered.

OPERATION:

- To start the unit, toggle the switch located on the front of the unit to the ON position. To stop the unit, toggle the switch to the OFF position.
- If equipped: To turn the light on toggle the switch located on the front of the unit to the ON position. To turn the light off, toggle the switch to the OFF position.
- To clean filters depress and hold down the pulse push-button for 2 seconds at least once per hour, and once after shutdown.
- Units equipped with auto-pulse do not require manual activation of the pulse system while the unit is running. The filters will clean automatically for 2 seconds, every 45 seconds that the unit is running. It is recommended that at least one manual pulse is completed after the unit is turned off.
OPTIONAL SILENCER ASSEMBLY INSTRUCTIONS

1. Remove all items from packaging.
2. Apply foam (P1031) to the transition as shown.
3. Using supplied sheet metal screws (P2059) align and attach transition to pre-drilled holes in the unit.
4. Using supplied bolts (P129) and associated hardware (P242, P246) bolt the silencer filter to the transition.
XA34 MAX Wiring Diagram

**XA34**

**Voltage**
- □ 208V
- □ 230V
- □ 460V

**Frequency**
- 60 Hz.

**CAUTION:** Disconnect power to unit prior to servicing or installation of parts.

**Max Current**
- □ 7.8 Amps
- □ 8.6 Amps
- □ 4.3 Amps

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**Diagram Notes:**
- L1, L2, L3, A1, A2, B1, B2, C1, C2, L1, L2, T1, T2, T3, N0, X, Y, Z
- Motor, Pilot Valve, Lamp, Lamp Switch
- 120V: BLK
- 120V: GRY
- 120V: ORG
- 120V: RED

**Wiring Colors:**
- RED: For 208V
- ORANGE: For 230V
- GRAY: For 460V

---

- --- LED Lamp (Optional)
<table>
<thead>
<tr>
<th>Item</th>
<th>Part No.</th>
<th>Description</th>
<th>Item</th>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>39130-02</td>
<td>Back &amp; Top Shield</td>
<td>14</td>
<td>P7108</td>
<td>Handle</td>
</tr>
<tr>
<td>2</td>
<td>P7170</td>
<td>2' Dust Proof LED Light Fixture</td>
<td>15</td>
<td>P7106</td>
<td>Under Center Latch</td>
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<tr>
<td>3</td>
<td>39133-04</td>
<td>Side Shield - Right</td>
<td>16</td>
<td>P7107</td>
<td>Latch Catch</td>
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<tr>
<td>4</td>
<td>P7105</td>
<td>Hinge</td>
<td>17</td>
<td>P7102</td>
<td>Leveling Leg</td>
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<tr>
<td>5</td>
<td>39108-02</td>
<td>Perforated Table Top</td>
<td>18</td>
<td>39120-02</td>
<td>Dust Drawer Assembly</td>
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<tr>
<td></td>
<td>P7134</td>
<td>Rubber Work Mat</td>
<td>19</td>
<td>P2221</td>
<td>0-5&quot; Mini-Helic gauge</td>
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<td>6</td>
<td>39127-02</td>
<td>Top Baffle</td>
<td>20</td>
<td>39139-02</td>
<td>Exhaust Grille</td>
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<tr>
<td>7</td>
<td>39124-01</td>
<td>Bottom Baffle</td>
<td>21</td>
<td>P7115</td>
<td>Motor Pulley</td>
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<tr>
<td>8</td>
<td>P3495</td>
<td>3HP TEFC Motor</td>
<td>22</td>
<td>P3549</td>
<td>Drive Belt</td>
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<td>9</td>
<td>39110-01</td>
<td>Shield Bracket</td>
<td>23</td>
<td>P1711</td>
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<td>10</td>
<td>36720-10</td>
<td>Roto-Pulse Assembly</td>
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<td>P3498</td>
<td>Blower</td>
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<td>11</td>
<td>P7401RM</td>
<td>80/20 Cartridge Filter</td>
<td>25</td>
<td>P1719</td>
<td>Edge Guard</td>
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<td>P7408RM</td>
<td>100% Spunbond Cartridge Filter</td>
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<td>39133-03</td>
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<td>P7416NM</td>
<td>Nano-Max Cartridge Filter</td>
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<td>P7109</td>
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<td>12</td>
<td>P3649</td>
<td>4-Prong Knob</td>
<td>N/S</td>
<td>P2075</td>
<td>Diaphragm Valve</td>
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<td>13</td>
<td>39135-01</td>
<td>Access Door</td>
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</tbody>
</table>

**Diagram:**
- Item numbers correspond to the parts listed in the table.
- The diagram shows the assembly of the components listed.

**Note:** Item numbers 21 and 22 are not explicitly listed in the table but are shown in the diagram. Item 13 (39135-01) includes a description of Access Door.
<table>
<thead>
<tr>
<th>Item</th>
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<td>P3118</td>
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<td>2</td>
<td>P3735</td>
<td>1/4” Elbow Preslock Fitting</td>
<td>7</td>
<td>P1754</td>
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<td>P2922</td>
<td>Auto-Pulse Timer</td>
<td>8</td>
<td>P3915</td>
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<td>3 Conn. Terminal Block</td>
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<td>P3910</td>
<td>Motor Contactor</td>
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<tr>
<td>5</td>
<td>P3246</td>
<td>8 Conn. Terminal Block</td>
<td>10</td>
<td>P2219</td>
<td>On / Off Switch</td>
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