

ACT18CE Cyclone Extractor



Cert No: FM300, FM300C

Axminster Tool Centre Ltd
Axminster Devon
EX13 5PH UK
axminstertools.com

declares that the machinery described:-

Type	Cyclone Extractor
Model	AC118CE

Signed



Andrew Parkhouse
Operations Director

Date: **08/08/2016**

EU Declaration of Conformity

This machine complies with the following directives:

2006/42/EC	EN 55014-1:2017
06/42/EC - Annex I/05.2006	EN 55014-2:2015
EN 62233:2008	EN 61000-3-2:2014
EN 60335-2-69:2012	EN 55014-1:2006+A1+A2
EN 60335-1:2012+A11	EN 55014-2:1997+A1+A2
2014/30EU	EN 61000-3-11:2000

and conforms to the machinery example for which the
EC Type-Examination Certificate No AM 50352808, AE 50398634
has been issued by **Laizhou Planet Machinery Co., Ltd.**
at: Yutai West Street Laizhou, Shandong 261400 China (Mainland)

and complies with the relevant essential health and safety requirements.

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Preface



Before commissioning the machine, please read these operating instructions thoroughly and get familiar with the machine. Please also make sure that all persons operating the machine have read and understood the operating instructions beforehand.

Keep these operating instructions in a safety place nearby the machine.



Information

The operating instructions include indications for safety-relevant and proper installation, operation and maintenance of the machine. The continuous observance of all notes included in this manual guarantee the safety of persons and of the machine.

The manual determines the intended use of the machine and includes all necessary information for its economic operation as well as its long service life.

The illustration and information included in the present manual can possibly deviate from the current state of construction of your machine. Being the manufacturer we are continuously seeking for improvements and renewal of the products. Therefore, changes might be performed without prior notice. The illustrations of the machine may be different from the illustrations in these instructions with regard to a few details. However, this does not have any influence on the operability of the machine. Therefore, no claims may be derived from the indications and descriptions.

Your suggestion with regard to these operating instructions are an important contribution to optimising our work which we offer to our customers. For any questions or suggestions for improvement, please do not hesitate to contact our service department.

WARNING



Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding toolb integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

1. Safety

This operating instructions

- ▲explains the meaning and use of the warning notes included in the operating instructions
- ▲points out the dangers that might arise for you or others if these instructions are not observed.
- ▲informs you how to avoid dangers.

In addition to these operation instructions, please observe

- ▲the applicable laws and regulations
- ▲the statutory provisions for accident prevention
- ▲the prohibition, warning and mandatory signs as well as the warning notes on the machine.

If required, the relevant measures to comply with the country-specific regulations must be taken before commissioning the machine.

Always keep this documentation close to the machine.

1.1 Safety instructions for general machinery

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Some dust created by power sanding, sawing, grinding, drilling, and other construction activities may contain chemicals, including lead, birth defects, or other reproductive harm. Wash hands after handling. 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.

Your risk from these exposures varies depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area with approved safety equipment such as dust masks specially designed to filter out microscopic particles.

	For your own safety, read instruction manual before operating the machine. Learn the machine's application and limitations as well as the specific hazards peculiar.
	Always wear approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles everyday. Eyeglasses are not approved safety glasses.
	Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear an approved respirator to reduce your risk.
	Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.
	Keep hands and clothing away from moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of workpiece control.

1.11 Personal protective equipment

protective suit	safety shoes	protective gloves	protective glasses
			



Dirty or contaminated personal protective equipment can cause illness. Clean your personal protective equipment after each use and once a week.

1.2 Safety instructions for dust collector



Long-term respiratory damage can occur from using dust collectors without proper use of a respirator. Fire or explosions can result in smoke inhalation, serious burns, or death—if machine is used to collect incorrect materials, is operated near potential explosion sources, or ducting is improperly grounded. Entanglement, amputation, or death can occur if hair, clothing, or fingers are pulled into the inlet. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

INTENDED USE	This dust collector is only intended for collecting wood dust and chips from woodworking machines. Do not use this dust collector to collect metal, dirt, pebbles, drywall, asbestos, lead paint, silica, liquids, aerosols, or any flammable, combustible, or hazardous materials.
HAZARDOUS DUST	Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each work piece material, and always wear a NIOSH-approved respirator to reduce your risk.
DUST ALLERGIES	Dust from certain woods may cause an allergic reaction in people and animals. Make sure you know what type of wood dust you will be exposed to in case there is a possibility of an allergic reaction.
WEAR RESPIRATOR	Fine dust that is too small to be caught in the filter will be blown into the ambient air during operation. Always wear a NIOSH-approved respirator during operation and for a short time after to reduce your risk of permanent respiratory damage.
EMPTYING DUST	When emptying dust from the collection container, wear a respirator and safety glasses. Empty dust away from ignition sources and into an approved container.
DISCONNECTING POWER SUPPLY	Turn the switch off, disconnect the dust collector from the power supply, and allow the impeller to come to a complete stop before leaving the machine unattended or doing any service, cleaning, maintenance, or adjustments.
SUSPENDED DUST PARTICLES AND IGNITION SOURCES	Do not operate the dust collector in areas where explosion risks are high. Areas of high risk include, but are not limited to, areas near pilot lights, open flames, or other ignition sources.
FIRE SUPPRESSION	Only operate the dust collector in locations that contain a fire suppression system or have a fire extinguisher nearby.
IMPELLER HAZARDS	Do not place your hands or tools near the open inlet during operation for any reason. The powerful suction could easily cause accidental contact with the impeller, which will cause serious personal injury or damage to the machine. Always keep small animals and children away from open dust collection inlets.
AVOIDING SPARKS	Do not allow steel or rocks to strike the impeller—this may produce sparks. Sparks can smolder in wood dust for a long time before a fire is detected. If you accidentally cut into wood containing tramp metal (nails, staples, spikes, etc.), immediately turn off the dust collector, disconnect it from power, and wait for the impeller to stop—then empty the collection container into an approved airtight metal container.
OPERATING LOCATION	To reduce respiratory exposure to fine dust, locate permanently installed dust collectors away from the working area, or in another room that is equipped with a smoke detector. Do not operate the dust collector in rainy or wet locations—exposure to water may create a shock hazard or decrease the life of the machine.

STATIC ELECTRICITY	Plastic dust lines generate high amounts of static electricity as dust chips pass through them. Although rare, sparks caused by static electricity can cause explosions or fire. To reduce this risk, make sure all dust lines are thoroughly grounded by Using a grounding wire.
REGULAR CLEANING	Regularly check/empty the collection bags or drum to avoid the buildup of fine dust that can increase the risk of fire. Make sure to regularly clean the surrounding area where the machine is operated—excessive dust buildup on overhead lights, heaters, electrical panels, or other heat sources will increase the risk of fire.



No list of safety guidelines can be complete. Every shop environment is different. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY. FOR YOUR OWN SAFETY, READ AND UNDERSTAND THE INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.



KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents.
DON'T USE IN DANGEROUS ENVIRONMENT. Don't use this unit in damp or wet locations, or expose it to rain. Keep work area well-lighted.
KEEP CHILDREN AND VISITORS AWAY. All children and visitors should be kept a safe distance from work area.
DISCONNECT UNIT before servicing.
CHECK DAMAGED PARTS. Before further use of the unit, properly repair or replace any part that is damaged.

2. Technical Specification



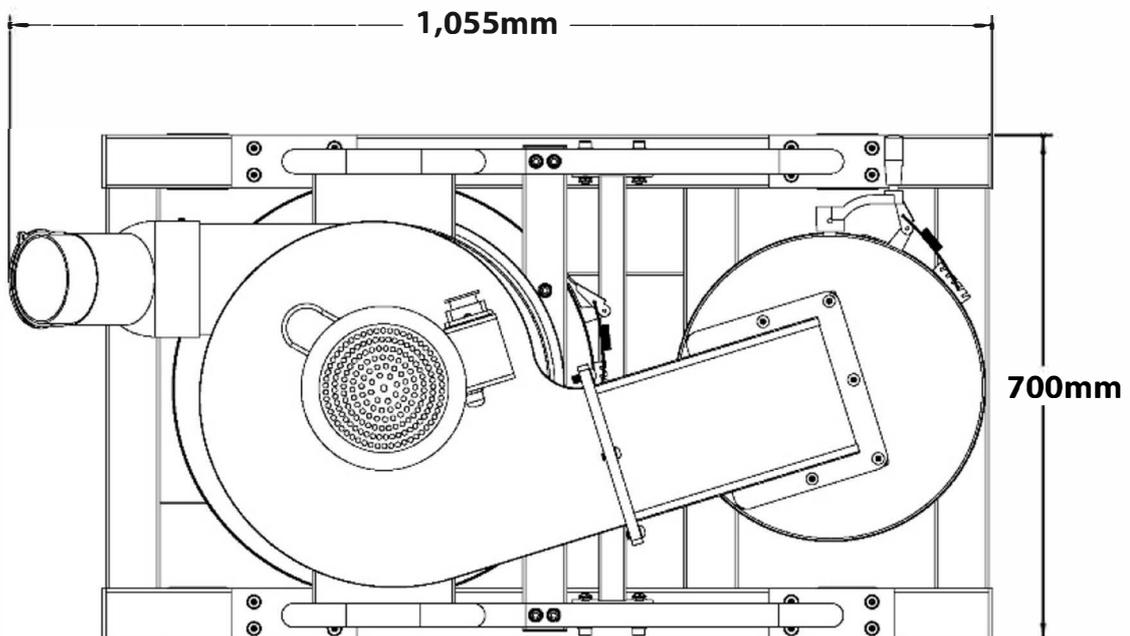
The following information represents the dimensions and weight information and the manufacturer's approved machine data.

2.1 Specification

MODEL NO.	AC118CE
Motor(W)	1500
Motor speed 50Hz (RPM)	2950r/min
Impeller size(MM)	Φ305
Inlet hole size(MM)	Φ125
Number of Intake holes(MM)	2XΦ100
Bag size(MM)	Φ470X920
Bag volume (m ³)	0.16
Air speed 50Hz (m ³ /h)	960
Filter area(m ²):	2.6
Filtration	1 micron @ 99.97%
Overall L x W x H	1,100 x 570 x 1,785mm

2.2 Dimensions

MODEL NO. AC118CE



3. Assembly

The cyclone dust collector is delivered pre-assembled. After unpacking, the machine must be installed.



Transport the dust collector in its packing crate to a place near its final installation site before unpacking it. If the packaging shows signs of possible transport damage, take the necessary precautions not to damage the machine when unpacking. If any damage is discovered, the carrier and/or shipper must be notified of this fact immediately to establish any claim which might arise.

3.1 Grounding instructions

The appliance must be grounded, if it should malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This appliance is equipped with a cord having equipment-ground conductor and grounding plug. The plug must be inserted into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

For grounded, cord-connected appliances: Make sure that the appliance is connected to an outlet having the same configuration as the plug. No adaptor should be used with this appliance. If the appliance must be reconnected for use on a different type of electric circuit, qualified service personnel should make the reconnection.

For a permanently connected appliance: This appliance must be connected to a grounded metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment grounding terminal or lead on the appliance.

Inspect the machine completely and carefully, making sure that all materials, such as shipping documents, instructions and accessories supplied with the machine have been received.

3.2 Unpacking

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

A. Base	K. Support connect bar	
B. Bracket	L. Main house	
C. Transom	M. Connecting tube	
D. Big collector bag	N. Wheel	
E. Close cover	O. Canister filter	
F. Inlet	P. Drum clamp	
G. Drum lip	Q. Bag clamp	
H. Big block	R. Small collector bag	
I. Small block	S. Connecting tube	
J. Support connect ring	T. Seal pad	



If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

3.3 Placement location

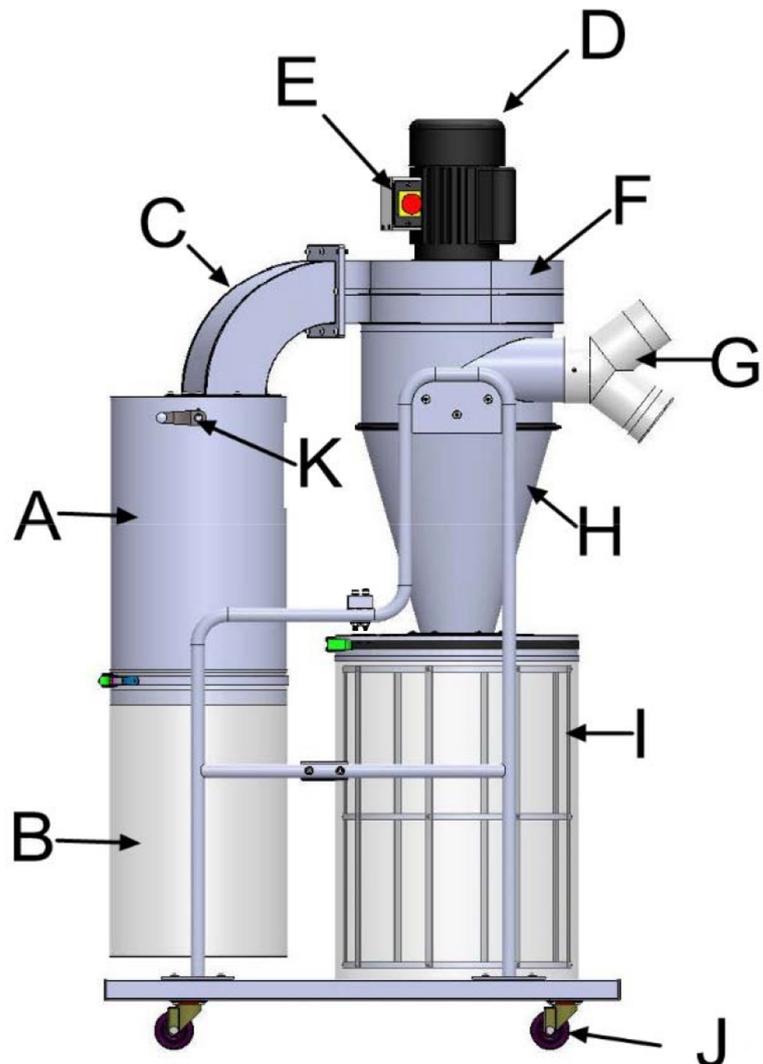
Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. See 2.2 Dimensions for reference.

3.4 Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

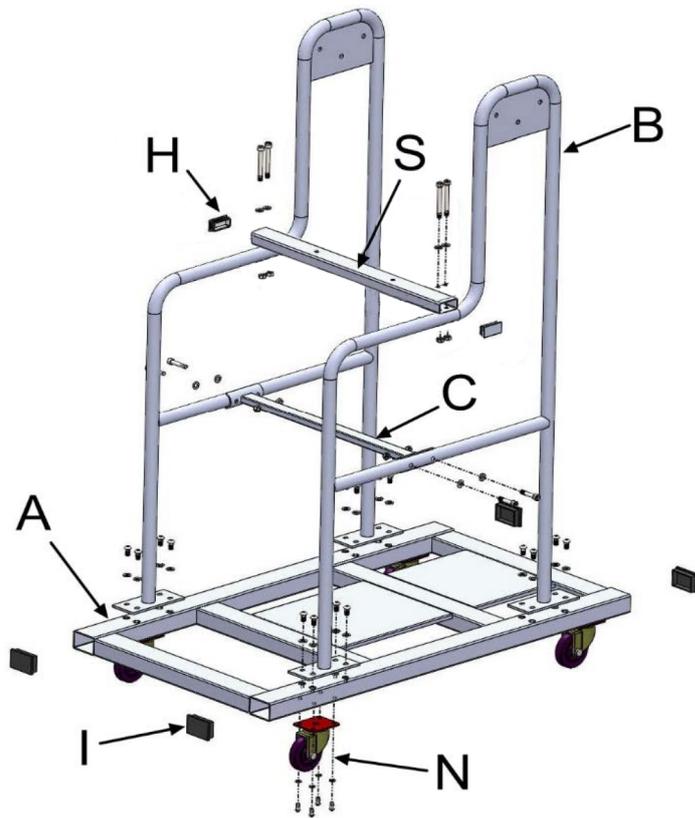
3.4.1 Know your dust collector

A: Canister filter
B: Dust collect bag
C: Connecting tube
D: Motor
E: Switch
F: Impeller housing
G: Inlet
H: Cyclone interceptor
I: Dust collect bag
J: Wheels

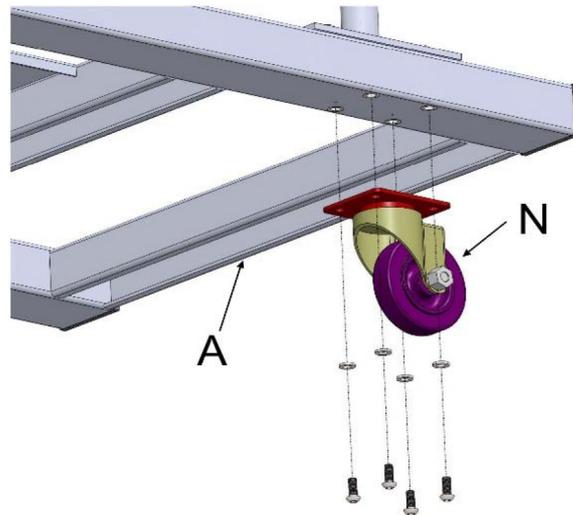


3.4.2 To assemble machine

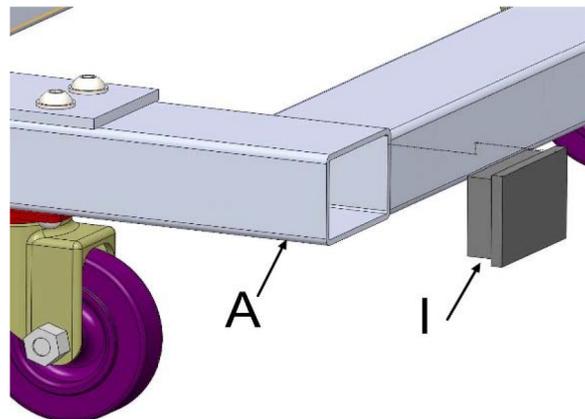
STEP-1 Install the main frame. Please refer to the following picture.



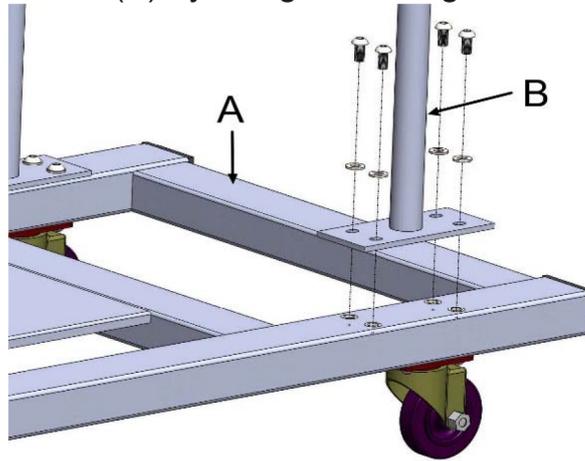
1.1 Fix the wheels (N) to the base (A) by using the hex socket button screw M6x15 and flat washer $\Phi 6$.



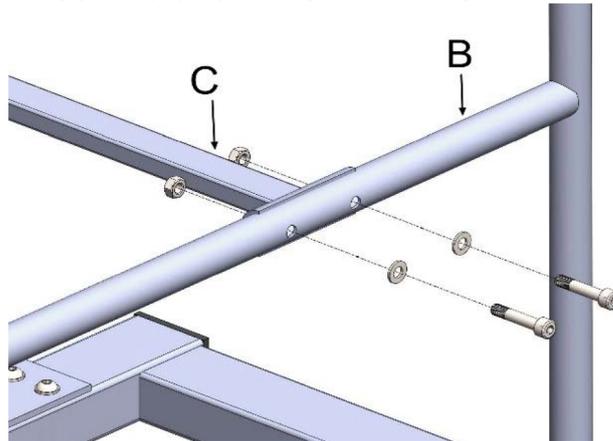
1.2 Insert the cover (I) into the four sides of the base (A).



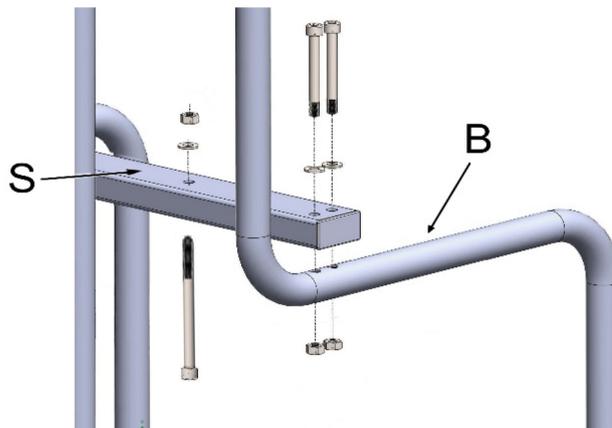
1.3 Fix the support (B) on the base (A) by using the hexagon socket button screw M8x16 and flat washer $\Phi 8$.



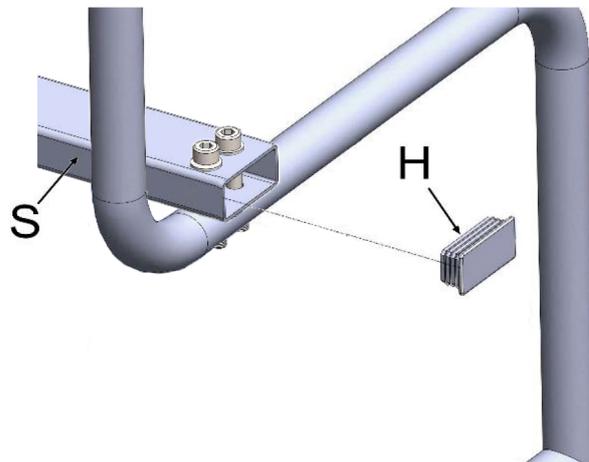
1.4 Fix the transom (C) to the support (B) by using the hexagon socket cap head bolt M8x40, washer $\Phi 8$ and hex nut M8.



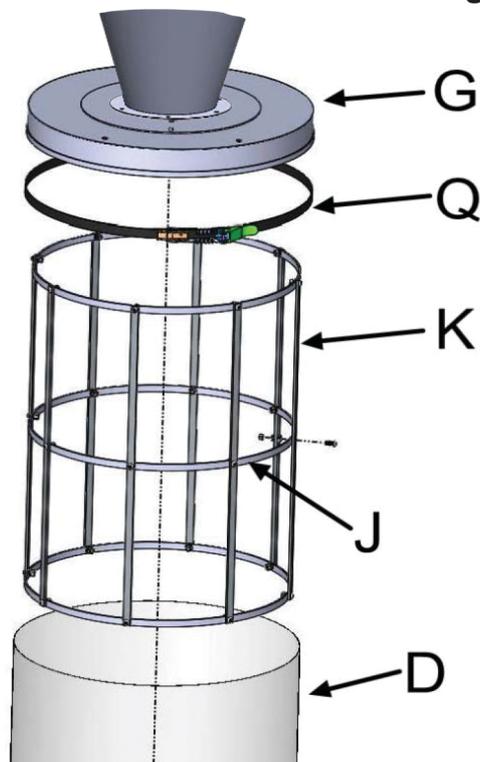
1.5 Fix the connecting tube (S) to support (B) by using the hexagon socket cap head bolt M8x70, flat washer 8 and hex nut M8.



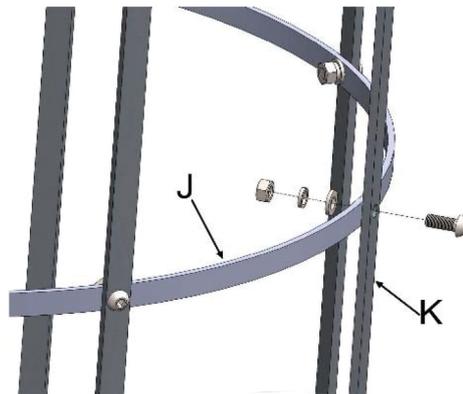
1.6 Insert the big cover (H) to the two sides of connecting tube (S).



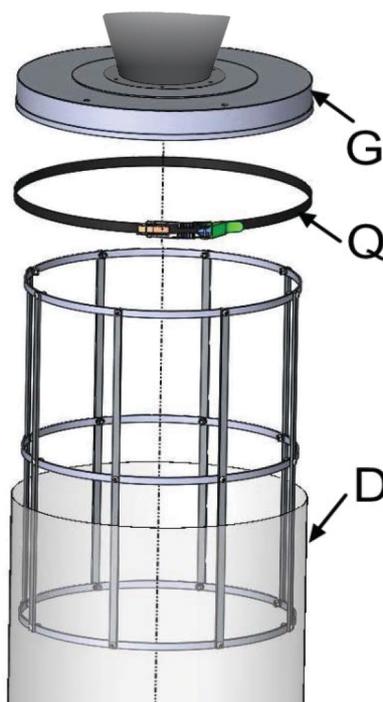
STEP-2 Install the collection drum. Please refer to the following picture.



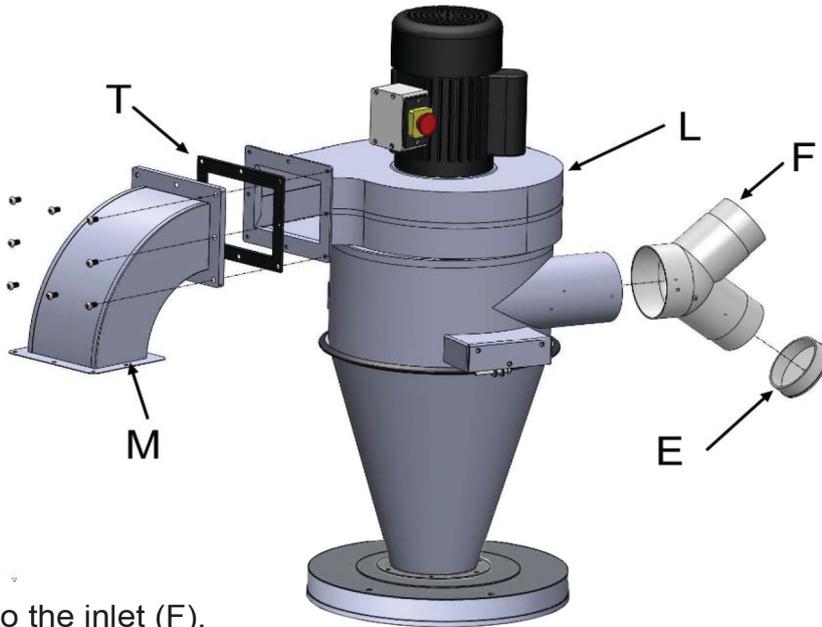
2.1 Fix the support connecting bar (K) to the support connecting ring (J) one by one by using the hexagon socket button screw M8x15, flat washer 6, spring washer and hex nut m6.



2.2 Tighten the collector bag (D) to the drum lip (G) by using the bag clamp (Q).



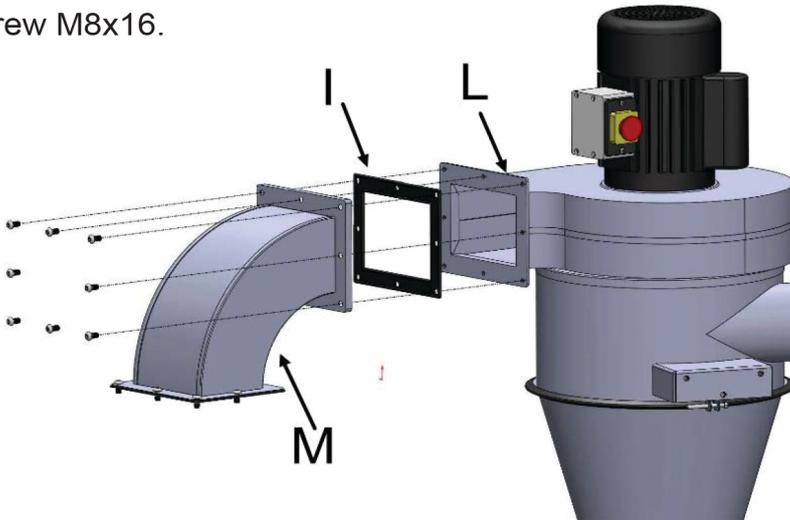
STEP-3 Install the main house assembly. Please refer to the following picture.



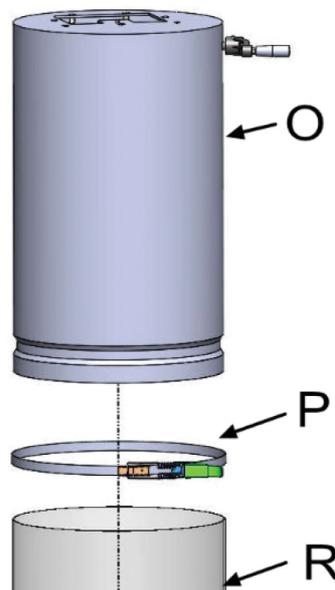
3.1 Put the cover (E) to the inlet (F).

3.2 Fix the inlet (F) to the main house assembly (L) by using the Philip head screw M5x8.

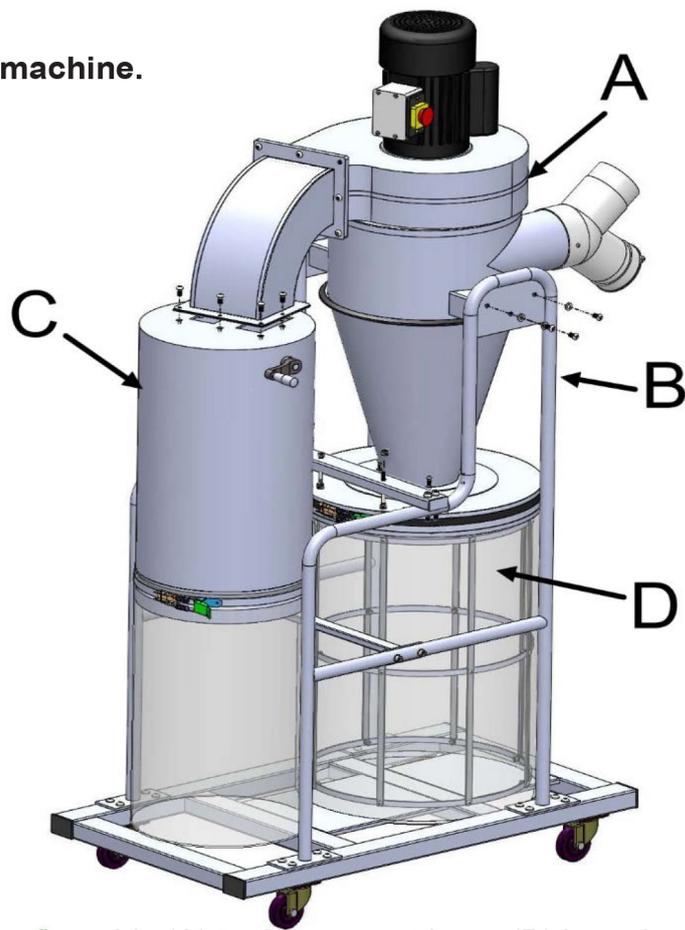
3.3 Fix the connector (M) and seal pad (I) to the main house assembly (L) by using the hexagon socket button screw M8x16.



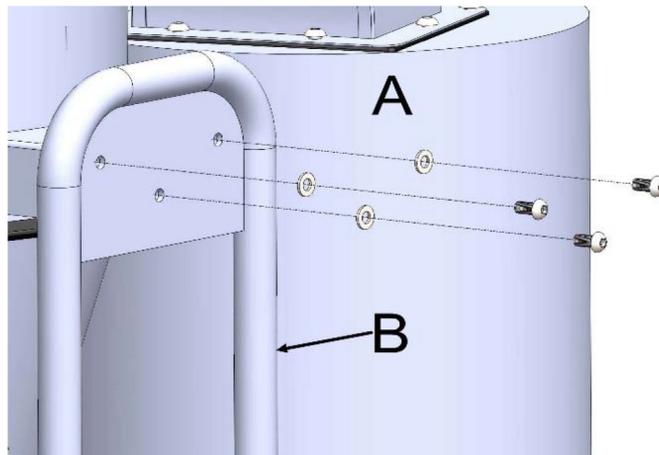
STEP-4 Fix the collector bag (R) to the canister filter (O) by using the bag clamp (P).



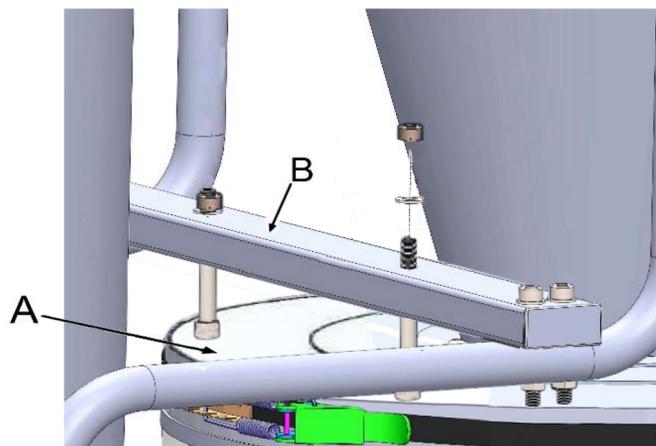
STEP-5 Install the whole machine.



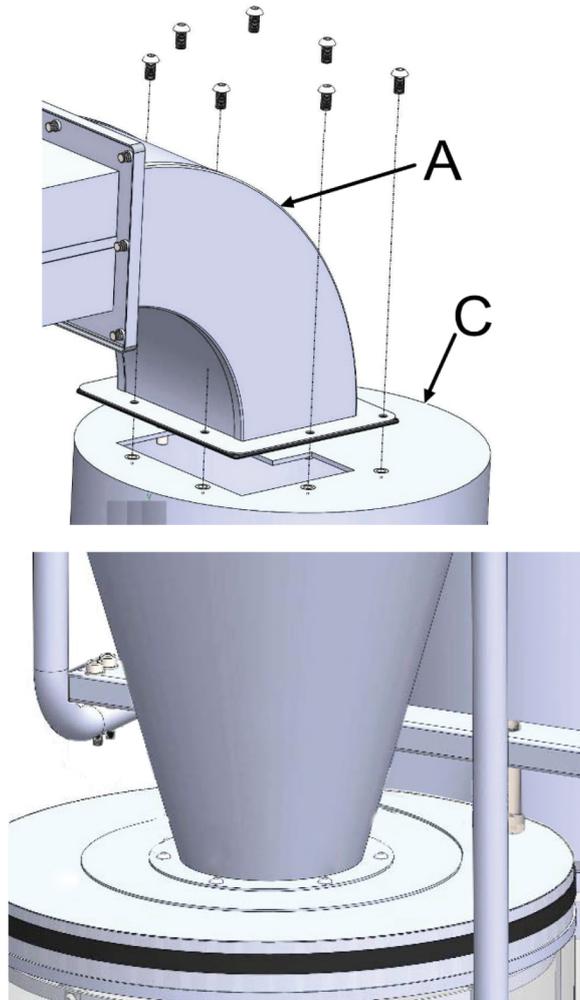
5.1 Install the main housing assembly (A) to the support base (B) by using the hexagon socket button screw M8x16 and flat washer 8.



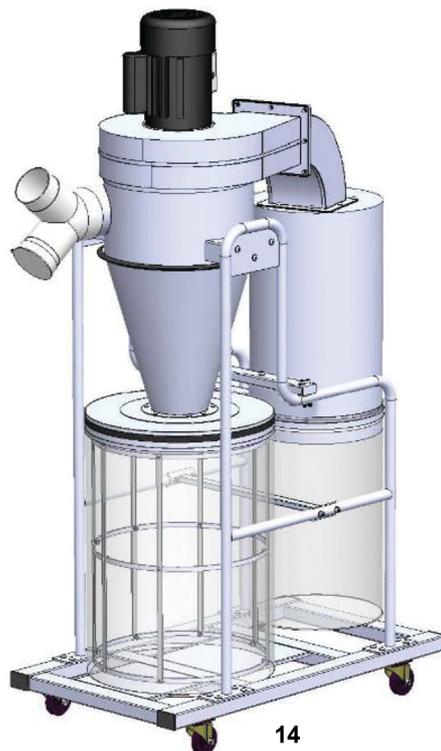
5.2 Fix the main housing assembly (A) to the support base (B) by using the hexagon socket head cap bolts M8x100 and washer 8.



5.3 Fix the seal pad and canister filter (C) to the main housing assembly (A) by using the hexagon socket button screw M6X15.



The machine is installed well as the following picture.
Attention: Before use the machine, please check all the screws and bolts are tightened.



3.5 Initial commissioning

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again.



DO NOT start machine until all preceding setup instructions have been performed.

Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.
2. Lock all swivel casters on base stand.
3. Connect machine to dust-collection system or place covers over inlet adapter ports.



DO NOT operate the dust collector without first connecting it to a dust-collection system or covering an inlet adapter port. Otherwise, the lack of airflow resistance will cause the motor to operate at full amperage load, which could trip your circuit breaker or blow a fuse.

4. Press Emergency Stop button in.
5. Connect machine to power.
6. Standing away from intake port, press green "I" button to turn machine ON. Verify motor starts up and runs smoothly without any problems or unusual noises.
8. Press Emergency Stop button to turn machine OFF.

4. Operation

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand. Due to the generic nature of this overview, it is not intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



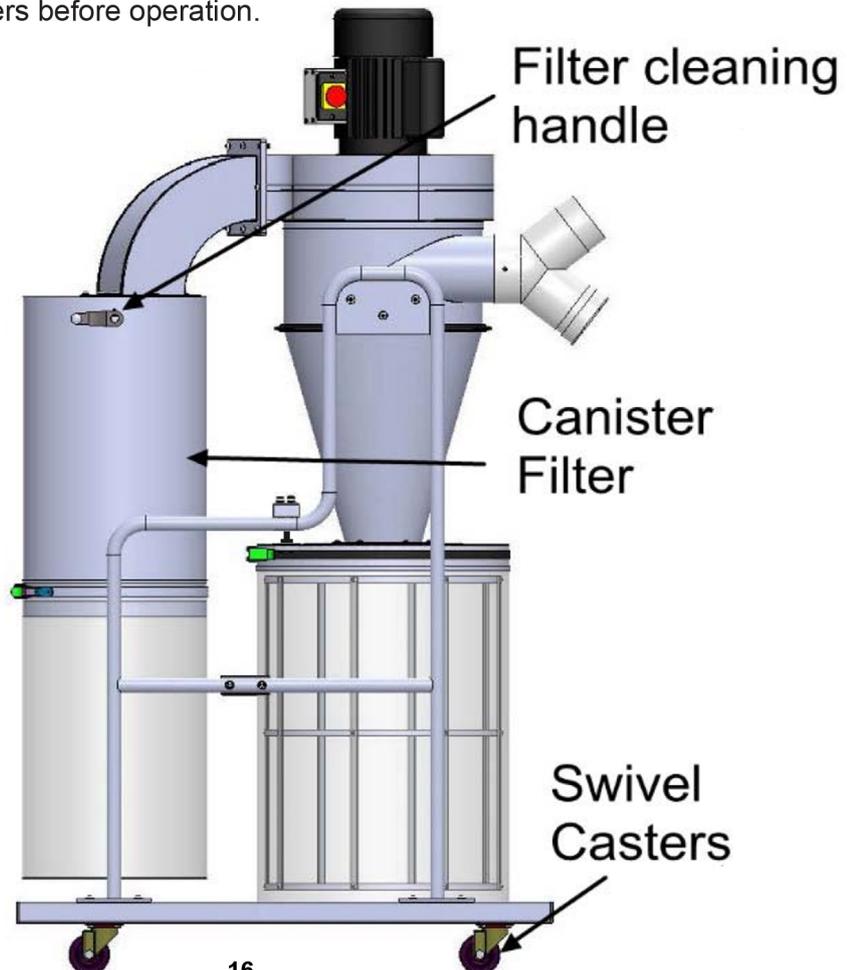
If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects.

This cyclone dust collector creates a vortex of incoming air that extracts heavy wood chips and large dust particles, and then drops them into the collecting bag.

The remaining fine dust travels past the impeller and is then caught by a canister filter and deposited in the plastic collection bag below. The spun-bond polyester filters are pleated to provide maximum surface area for efficient air flow.

To maintain CFM during heavy dust-collection operations, turn the filter cleaning handle to knock caked-on dust into the plastic collection bag.

Always lock all four swivel casters before operation.



4.1 Tips for optimum performance

- ▲ Avoid using more than 10' of flexible hose on any ducting line. The ridges inside flexible hose greatly increase static pressure loss, which reduces suction performance.
- ▲ Keep ducts between the dust collector and machines as short as possible.
- ▲ Keep ducting directional changes to a minimum. The more curved fittings you use, the greater the loss of suction at the dust-producing machine.
- ▲ Gradual directional changes are more efficient than sudden directional changes (i.e. use 45° elbows in place of 90° elbows whenever possible).
- ▲ The simpler the system, the more efficient and less costly it will be.

4.2 Required CFMs

Since each machine produces a different amount of sawdust, the requirements for the minimum amount of CFM to move that sawdust is unique to the machine (for example, a planer produces more sawdust than a table saw). Knowing this required CFM is important to gauging which size of duct to use.

Refer to the figure below for a close estimation of the airflow each machine requires. Keep in mind that machines that generate the most sawdust should be placed closest to the dust collector. If the machine has multiple dust ports, the total CFM required is the sum of all ports.

Machine Dust Port Size	Approximate Required CFM
2"	100
2.5"	150
3"	250
4"	400
5"	600
6"	850
7"	1200
8"	1600
9"	2000
10"	2500

4.3 System Grounding

Since plastic hose is abundant, relatively inexpensive, easily assembled and air tight, it is a very popular material for conveying dust from woodworking machines to the dust collector.

We recommend using flexible hose (flex-hose) to connect the woodworking machine to the dust collector. However, plastic flex-hose and plastic duct are an insulator, and dust particles moving against the walls of the plastic duct create a static electrical build up. This charge will build until it discharges to a ground. If a grounding medium is not available to prevent static electrical build up, the electrical charge will arc to the nearest grounded source. This electrical discharge may cause an explosion and subsequent fire inside the system.

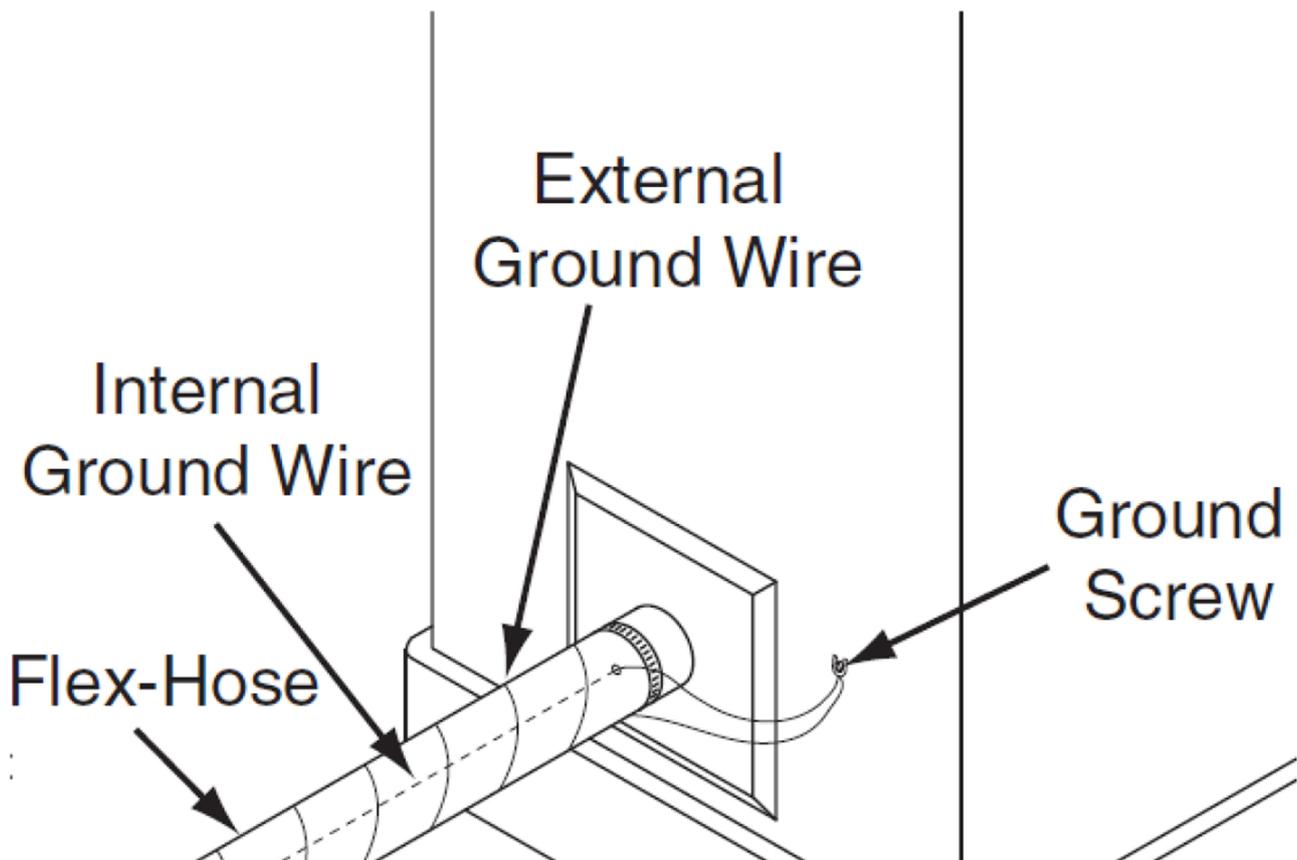
To protect against static electrical build up inside a non-conducting duct, a bare copper wire should be placed inside the duct along its length and grounded to the dust collector. You must also confirm that the dust collector is continuously grounded through the electrical circuit to the electric service panel. If you connect the dust collector to more than one machine by way of a non-conducting branching duct system and blast gates, the system must still be grounded as mentioned above. We

recommend inserting a continuous bare copper ground wire inside the entire duct system and attaching the wire to each grounded woodworking machine and dust collector.

Be sure that you extend the bare copper wire down all branches of the system. Do not forget to connect the wires to each other with wire nuts when two branches meet at a “Y” or “T” connection. Ensure that the entire system is grounded. If using plastic blast gates to direct air flow, the grounding wire must be jumped around the blast gate without interruption to the grounding system.

We also recommend wrapping the outside of all plastic ducts with bare copper wire to ground the outside of the system against static electrical build up. Wire connections at Y’s and T’s should be made with wire nuts.

Attach the bare ground wire to each stationary woodworking machine and attach to the dust collector frame with a ground screw. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.



5. Maintenance

5.1 Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To maintain a low risk of injury and proper machine operation, if you ever observe any of the items below, shut down the machine immediately and fix the problem before continuing operations:

- ▲ Loose mounting bolts.
- ▲ Damaged filter canister, cleaning paddle components, or collection bags.
- ▲ Worn or damaged wires.
- ▲ Suction leaks.
- ▲ Any other unsafe condition.

Monthly Check

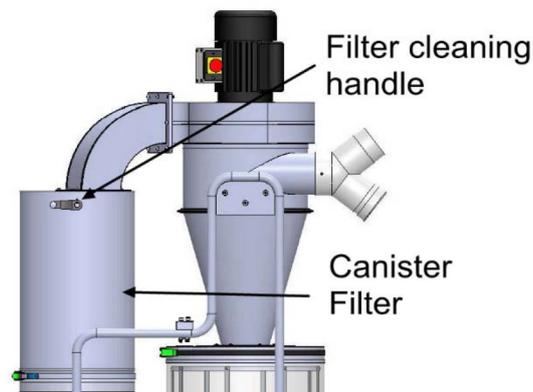
- ▲ Clean/vacuum dust buildup off machine body and motor.

5.2 Cleaning canister filter

This dust collector uses a handle and internal paddles to remove dust buildup and debris from the filter pleats. Turn the handle through its range of motion to clean the canister filter and knock dust cake into the filter bag.

For a more thorough cleaning every few months under heavy use, wash the filter by hand.

IMPORTANT: To contain wood dust and minimize risk of exposure, firmly tie bag closed.

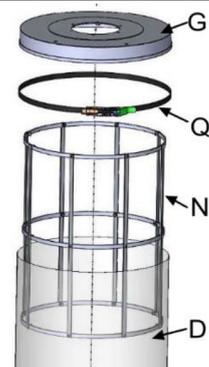


5.3 Removing/Replacing collection drum bag

Dispose of the collection drum bag when dust fills it 3/4 full. Replace the bag if it develops a leak or becomes damaged.

To remove and replace collection drum bag:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen the bag clamp (Q) which tightens the bag (D) to the drum lip (G).
3. Take out the drum frame (N) in the bag (D).
4. Clean or replace the bag (D).
5. Put the drum frame into the cleaned or new bag.
6. Tighten the collector bag (D) to the drum lip (G) by using the bag clamp (Q)

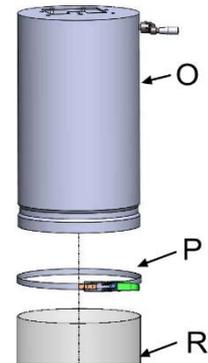


5.4 Removing/Replacing filter bag

Remove and replace the filter bag when it is about 1/2 full.

To remove & replace filter bag or bags:

1. DISCONNECT MACHINE FROM POWER!
2. Release clamp around bottom of canister filter, then remove filter bag.
3. Attach new filter bag around bottom of canister filter and secure with clamp.

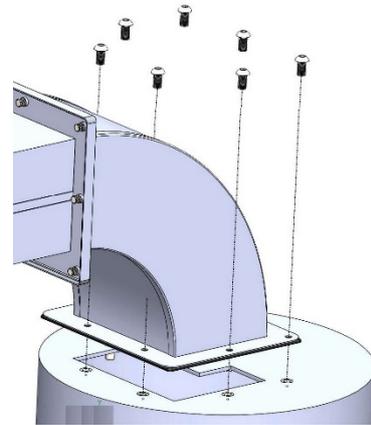


5.5 Removing/Replacing canister filter

If the canister filter is clogged or dirty and cleaning or washing it does not improve dust-collection performance, the canister filter must be replaced.

To remove and replace canister filter:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen the hexagon socket button screw M6X15 which fixed the seal pad and canister filter to the main housing assembly.
3. Fix the seal pad and new canister filter to the main housing assembly by the screw M6X15.



5.6 Washing canister filter

For a more thorough cleaning every few months under heavy use, wash the filter by hand.

To wash canister filter by hand:

- ▲ DISCONNECT MACHINE FROM POWER!
- ▲ Remove canister filter (see Removing/ Replacing Canister Filter on this page).
- ▲ Rinse filter outside under warm water.

IMPORTANT: DO NOT use a pressure washer to clean the filter, or compressed air to dry it. High pressure will damage filter fibers.

- ▲ Allow filter to air dry only.

Note: Do not leave filter in the sun to dry or apply heat to speed the process; heat exposure can damage your filter.

- ▲ Re-install canister filter.



Dust exposure created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Always wear goggles and a NIOSH approved respirator when working with the dust collection bags or canisters.

6. Accessories for dust collector



Visit our website to see the full range of accessories.

[axminstertools.com](https://www.axminstertools.com)

7. Troubleshooting

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call us.

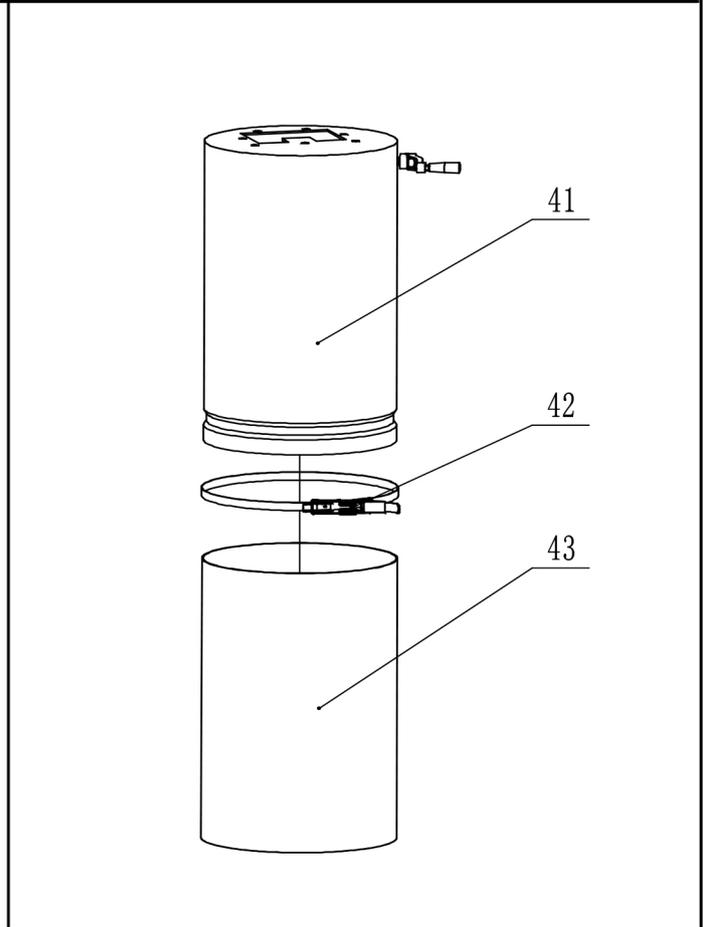
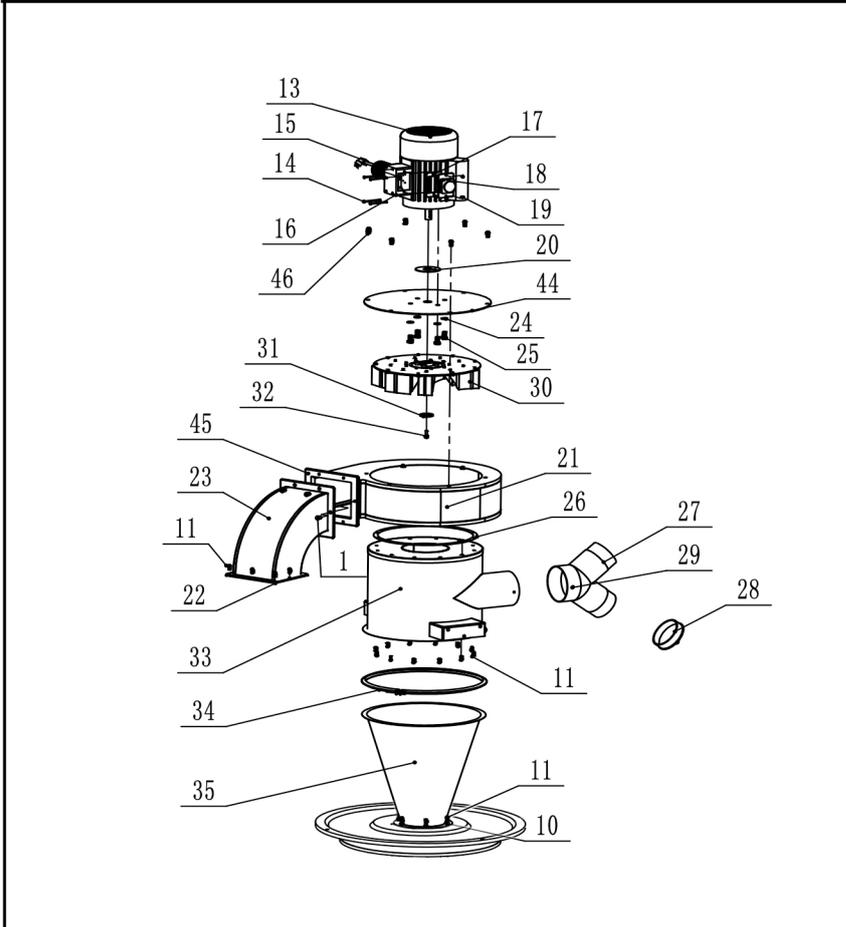
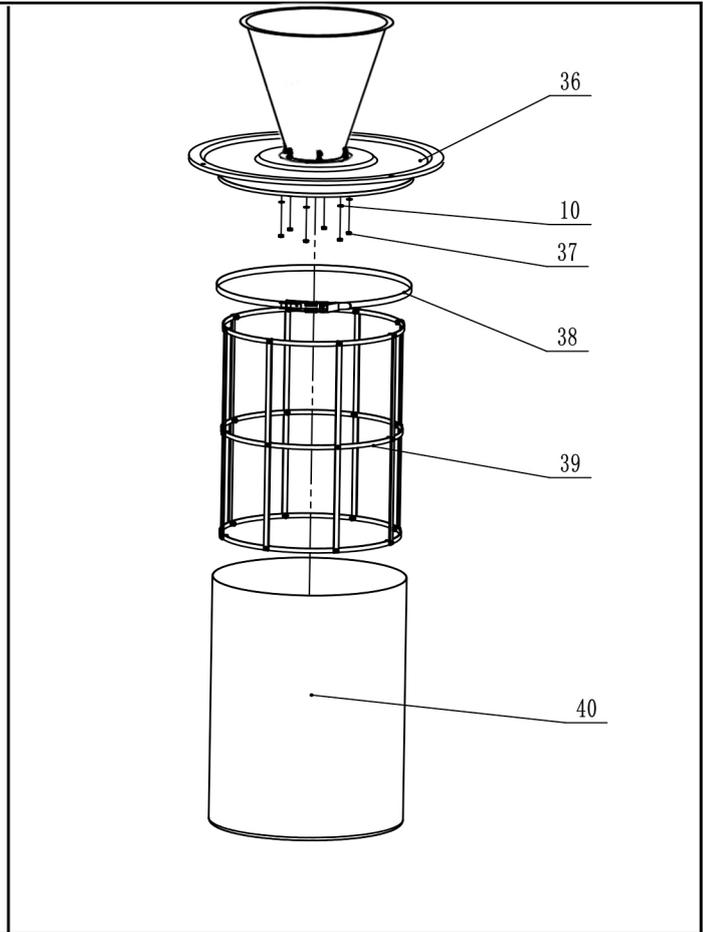
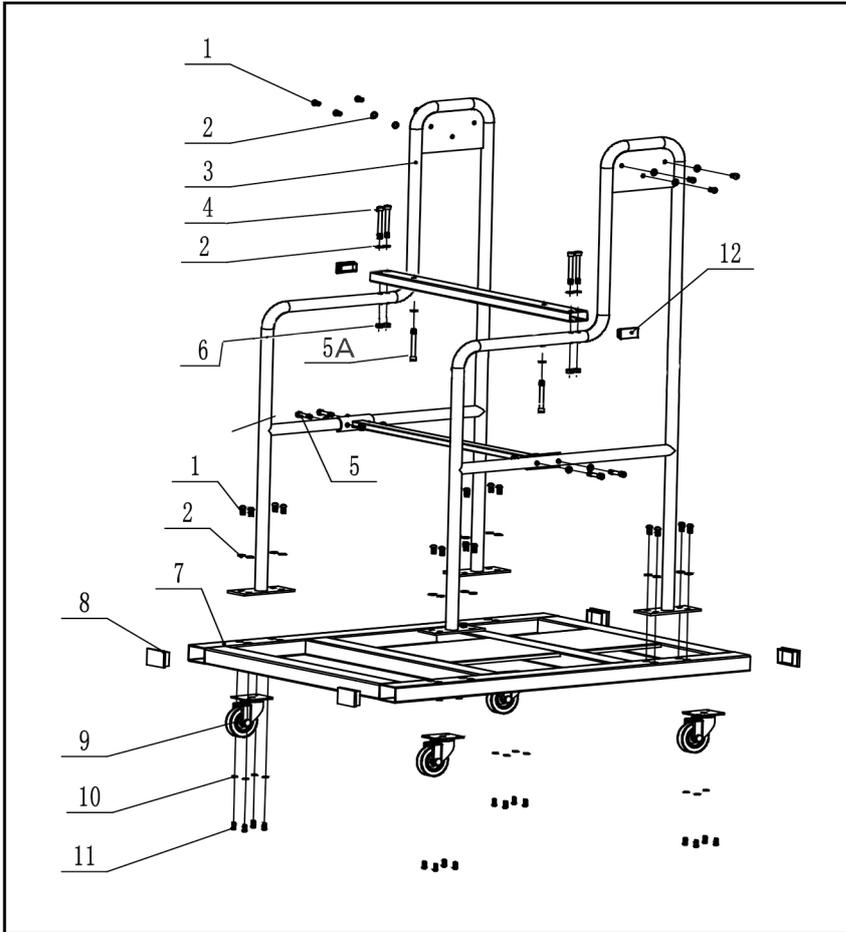
Note: Please gather the serial number and manufacture date of your machine before calling.

Symptom	Possible Cause	Possible Solution
Machine does not start, or powersupply fuse/breaker trips immediately after startup.	<ol style="list-style-type: none"> 1. Dust collector not properly connected to ducting. 2. E-Stop Button depressed/at fault. 3. Incorrect power supply voltage or circuit size. 4. Power supply circuit breaker tripped or fuse blown. 5. Motor overheated. 6. Machine circuit breaker has tripped. 7. Wiring open/has high resistance. 8. Power switch/circuit breaker at fault. 9. Start capacitor at fault. 10. Motor at fault. 	<ol style="list-style-type: none"> 1. Connect dust collector to ducting. 2. Rotate E-Stop Button to reset. Replace if at fault. 3. Ensure correct power supply voltage and circuit size. 4. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 5. Allow motor to cool, reset overload if necessary. 6. Reset circuit breaker on switch. 7. Check/fix broken, disconnected, or corroded wires. 8. Test/replace. 9. Replace. 10. Test/repair/replace.
Machine seems underpowered.	<ol style="list-style-type: none"> 1. Motor overheated. 2. Dust-collection ducting problem. 3. Canister filter clogged/at fault. 4. Dust collector too far from machine or undersized for dust-collection system. 5. Run capacitor at fault. 6. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Allow motor to cool, reset overload if necessary. 2. Clear blockages, seal leaks, use smooth-wall duct, eliminate bends, close other branches. 3. Clean canister filter; replace canister filter. 4. Move closer to machine/redesign ducting layout/ upgrade dust collector. 5. Test/repair/replace. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Motor fan rubbing on fan cover. 3. Motor mount loose/broken. 4. Impeller damaged, unbalanced, or loose. 5. Motor bearings at fault. 6. Motor shaft bent. 	<ol style="list-style-type: none"> 1. Inspect/replace damaged bolts/nuts, and retighten with thread-locking fluid. 2. Fix/replace fan cover; replace loose/damaged fan. 3. Tighten/replace. 4. Inspect/tighten/replace. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Test with dial indicator. Replace motor if damaged.
Loud, repetitious noise, or excessive vibration coming from dust collector (non-motor related).	<ol style="list-style-type: none"> 1. Dust collector not on a flat surface and wobbles. 2. Impeller damaged and unbalanced. 3. Impeller loose on the motor shaft. 	<ol style="list-style-type: none"> 1. Stabilize dust collector; lock casters. 2. Inspect/replace. 3. Secure impeller; replace motor and impeller as a set if motor shaft and impeller hub are damaged.

Symptom	Possible Cause	Possible Solution
Dust collector does not adequately collect dust or chips; poor performance.	<ol style="list-style-type: none"> 1. Collection bag full. 2. Canister filter clogged/at fault. 3. Ducting blocked/restricted. 4. Dust collector too far away from point of suction; duct clamps not properly secured; too many sharp bends in ducting. 5. Lumber is wet and dust is not flowing smoothly through ducting. 6. Ducting has one or more leaks, or too many open ports. 7. Not enough open branch lines at one time, causing velocity drop in main line. 8. Ducting and ports are incorrectly sized. 9. The machine dust-collection design inadequate. 10. Dust collector undersized. 	<ol style="list-style-type: none"> 1. Empty collection bag. 2. Clean canister filter; replace canister filter. 3. Remove ducting from dust collector inlet and unblock restriction. A plumbing snake may be necessary. 4. Relocate dust collector closer to point of suction; re-secure ducts; remove sharp bends. 5. Only process lumber with less than 20% moisture content. 6. Seal/eliminate all ducting leaks; close dust ports for lines not being used. Refer to Designing the System in manual. 7. Open 1 or 2 more blast gates to different branch lines to increase main line velocity. 8. Install correctly sized ducts and fittings 9. Use dust-collection hood on stand. 10. Install larger dust collector.
Dust collector blows sawdust into the air.	<ol style="list-style-type: none"> 1. Duct clamps or filter bag(s) are not properly clamped and secured; ducting loose/ damaged. 2. Cylinder or funnel seals are loose or damaged. 	<ol style="list-style-type: none"> 1. Re-secure ducts and filter bag, making sure duct and bag clamp are tight; tighten/replace ducting. 2. Retighten all mounting and sealing points; replace damaged seals/gaskets.

8. Diagram and part list

8.1 Diagram



8.2 Part list

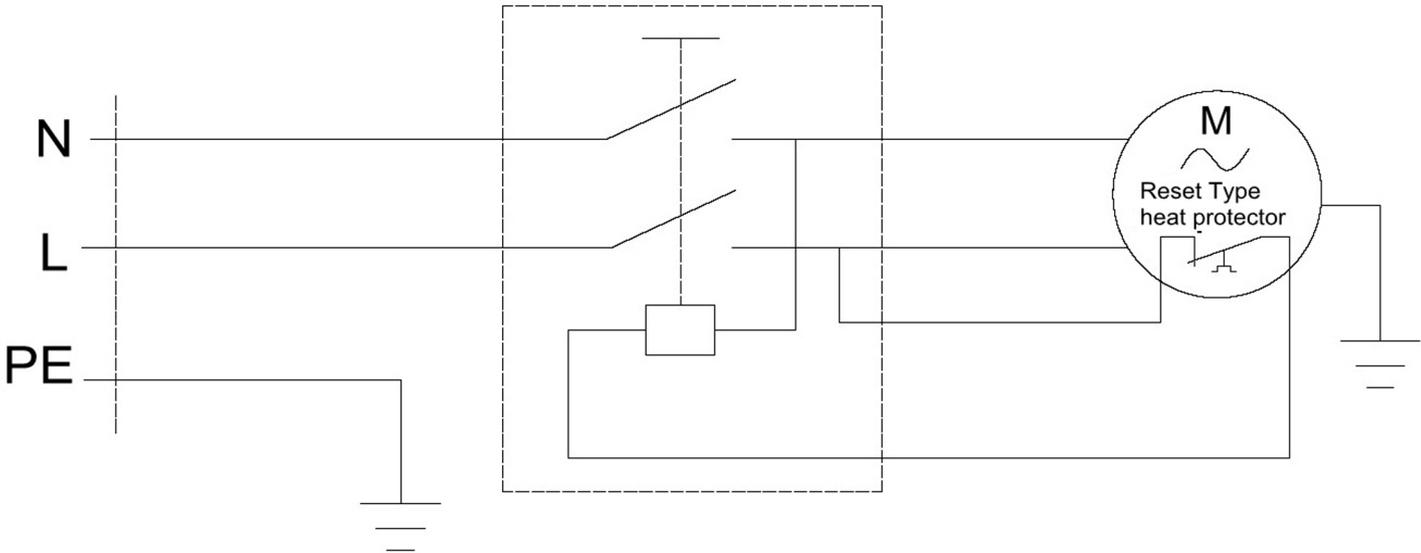
Part No.	Description	Qty
1	Hexagon socket button head screw M8x16	30
2	Flat washer 8	40
3	Support frame	2
4	Hexagon socket cap head bolt M8x70	4
5	Hexagon socket cap head bolt M8x40	4
5A	Hexagon socket cap head bolt M8x100	2
6	1 type hex nut M8	8
7	Base	1
8	Cover	4
9	Wheel 3"	4
10	Flat washer 6	53
11	Hexagon socket button head screw M6x15	65
12	Big cover	2
13	Motor	1
14	Cross recessed pan head screw M4x60	4
15	Power Cord	1
16	Switch box	1
17	Switch board	1
18	Emergency switch	1
19	Self setting screw ST4x12	4
20	Rubber pad	1
21	Fan house	1
22	Seal pad	1
23	Conncting tube	1

Part No.	Description	Qty
24	Spring ring 10	4
25	Hex head bolt M10x20	4
26	Seal circle	1
27	Inlet	1
28	Inlet cover	1
29	Cross recessed pan head screw M5x8	1
30	Impeller	1
31	Circlip	1
32	Hexagon socket cap head bolt M6x20-left thread	1
33	Collector	1
34	Steel clamp	1
35	Reducing house	1
36	Drum cover	1
37	1 type hex nut M6	30
38	Bag clamp	1
39	Collecting bag Support frame	1
40	Collect bag 738x920x0.24	1
41	Canister filter	1
42	Durm clamp	1

8.3 Wiring diagram for AC118CE

230V/50HZ

KJD17B



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