

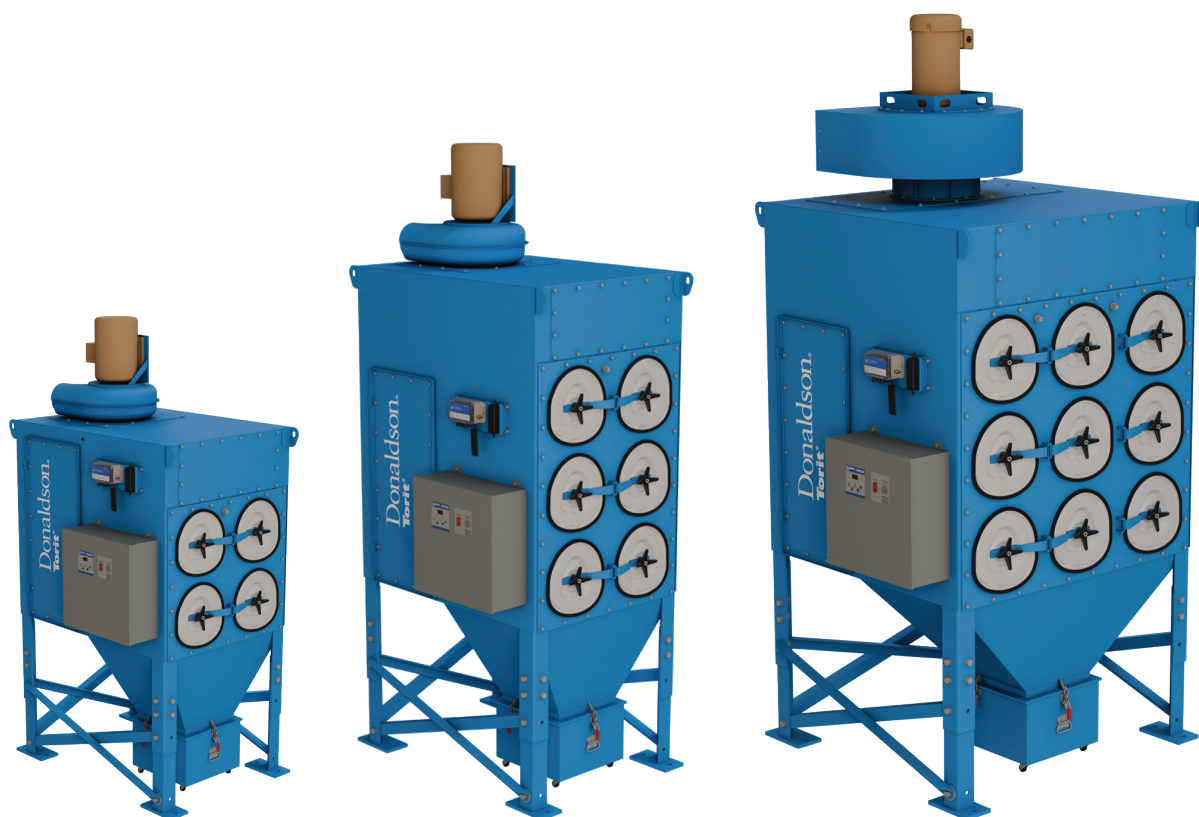


Downflo® Evolution Pre-Assembled

Series DFPRE 4, 6 and 9

Installation and Operation Manual

Installation, Operation and Service Information



This manual contains specific precautions related to worker safety. The hazard alert image denotes safety related instructions and warnings in this manual. DO NOT install, operate, or perform maintenance on this collector until you have read and understood the instructions, precautions and warnings contained within this manual.

IMPORTANT NOTES

This manual has been supplied to assist with the installation, operation and maintenance for the collector purchased. Please read the manual before installing, operating, or performing maintenance on the collector as it contains specific precautions for worker safety. It is the owner's responsibility to ensure that this manual is available for use by installers, operators and maintenance personnel that will be working with this collector. This manual is the property of the owner and should be left with the collector when installation has been completed. **DO NOT** operate this collector until you have read and understood the instructions and warnings located in this manual.

For additional copies of this manual, contact Donaldson Torit.



The Safety Alert Symbol indicates a hazardous situation which, if not avoided could result in death or serious injury. Obey all safety messages following this symbol to avoid possible injury or death. The possible hazards are explained in the associated text messages.

NOTICE

NOTICE indicates a potential situation or practice which is not expected to result in personal injury, but which if not avoided, may result in damage to equipment.

Contents

IMPORTANT NOTES	i
1 Safety Communication	1
2 Product Description	3
3 Operation	5
4 Product Service	6
Dust Disposal	7
Filter Replacement	7
Compressed Air Components	9
HEPA Afterfilter Replacement	9
Troubleshooting	10
Appendix A - Installation	13
Compressed Air Installation	16
Electrical Wiring	17
Cleaning Controls and Sensors	17
Connected Technology Through iCue	17
Options and Accessories	18
Hopper Discharge Accessories	18
55-Gallon Drum Pack	18
Spark Reducing Inlet	20
Sprinkler Coupling	20
Inlet Duct Locations	21
Start-up / Commissioning	22
Decommissioning	23
Product Information	24
Service Notes	25
Donaldson Industrial Air Filtration Warranty	28

1

Safety Communication



Improper operation of dust, fume or mist collectors and/or dust, fume or mist control systems may contribute to conditions in a work area or facility which could result in severe personal injury, and product or property damage. All dust, fume or mist collection equipment should be used only for its intended purpose and should be properly selected and sized for its intended use.

Process owners have important responsibilities relating to identifying and addressing potential hazards in their processes. When the potential for handling combustible particulate exists within a process the process owner should include combustion hazards in their risk management activities and should comply with applicable codes and standards relating to combustible hazards.

Electrical installation must be performed by a qualified electrician.

This equipment is not designed to support site ducts, piping, or electrical services. All ducts, piping, or electrical services must be adequately supported to prevent injury and/or property damage.

Site selection must account for applicable load conditions such as wind, seismic and snow.

Equipment may reach peak sound pressure levels above 80 dB (A). Noise levels should be considered when selecting collector location.

Most dust, fume and mist present safety and health hazards that require precautions. Wear eye, respiratory, head and other protection equipment suitable for the type of dust, fume or mist.

Some components may be heavier than they appear. Use appropriate lifting methods to avoid personal injury and/or property damage.

Combustible Dust Hazards

Among other considerations, the current NFPA standards require owners whose processes involve potentially combustible materials to have a current Dust Hazard Analysis (DHA), which can serve as the foundation for their process hazard mitigation strategy. Mitigation may include but is not limited to:

- Prevention of all ignition sources from entering any dust, fume, or mist collection equipment.
- Selection and implementation of fire and explosion mitigation, suppression, and isolation strategies appropriate for the risks in their process.
- Development and use of work practices to maintain safe operating conditions, and to ensure combustible particulate does not accumulate within their plant or process equipment.

Donaldson designs, manufactures, and sells industrial air filtration products for a wide variety of applications. Some applications may include processes or materials with inherent fire and explosion hazards. Donaldson is neither an expert nor a certified consultant in fire, spark, or explosion detection, suppression, or control. Donaldson does not provide engineering consulting services related to process or dust hazard analyses, or code and standard compliance. Complying with applicable codes and standards and managing the risks associated with the process or materials remains the responsibility of the process owner/operator. Donaldson may provide referrals to consultants, suppliers of equipment or services related to the detection and/or mitigation of sparks, fires and/or explosions, but Donaldson does not assume responsibility for any such referrals, nor does Donaldson assume any liability for the fitness of a mitigation strategy or product for a particular installation or application. The process owner's final selection of dust, fume, or mist collection equipment and risk mitigation strategies should be based on the outcome of a Dust Hazard / Process Hazard Analysis performed by the process owner. Although early engagement of a dust collector manufacturer provides helpful insights on the availability and features of various products, process owners should consult with a combustible dust expert and/or a process safety expert before making actual product and mitigation strategy selections.

Donaldson recommends that all industrial air filtration system designs be reviewed and approved by an expert consultant who is responsible for the integrity of the system design and compliance with applicable codes and standards. It is the process owner's responsibility to understand the risks in their process and mitigate those risks in accordance with all applicable laws, regulations and standards, including those published by the NFPA. Donaldson also recommends that proper maintenance and housekeeping procedures and work practices be evaluated, developed, and followed to maintain any industrial air filtration products in safe operating condition.

Many factors beyond the control of Donaldson can affect the use and performance of Donaldson products in a particular application, including the conditions under which the product is used. Since these factors are uniquely within the user's knowledge and control, it is essential the user evaluate the Donaldson products to determine whether the product is fit for the particular purpose and suitable for the user's application. All products, product specifications, and data (airflow, capacity, dimensions, or availability) are subject to change without notice, and may vary by region or country.

2 Product Description

The Downflo Evolution Pre-Assembled (DFPRE) is a dust collector with triangular, cartridge-style filters. The downward airflow design delivers high filtration efficiency while using less energy. All models are one-filter deep collectors; model DFPRE 4 is a four-filter collector, model DFPRE 6 is a six-filter collector, and model DFPRE 9 is a nine-filter collector. The filters for DFPRE can be pulse-cleaned on line, depending on the type of cleaning control options selected. Options include various cleaning controls, a spark reducing inlet, and multiple fan packs.

Intended Use

The Downflo Evolution Pre-Assembled is intended for filtration of nuisance dust or fume where the load to the collector is less than two grains per cubic foot. Typical applications include plasma cutting, laser cutting, or other metal fabrication processes. Each application is different and selecting the correct filter for the application and type of dust collected is important. Contact Donaldson Torit for selection assistance.

Rating and Specification Information

General rating and specification information can be found in the product literature provided with the collector and is available on the Donaldson website. For specific load values, refer to drawings shipped with the collector.

Standard Equipment

Standard collectors include an integrated fan, pre-installed filters, motor, Delta P control panel and 20-gallon dust container. The collector is fully assembled and ready to connect to electrical supply, compressed air, and ductwork. A detailed drawing, shipped with each collector, provides weight, specifications, and collector dimensions including anchor bolt locations for the collector's base plate.

Compressed Air

The DFPRE requires an external source of compressed air to supply the manifold and pulse system. Air is stored in the manifold and released when the system cleans through the blow pipes and into the filters.

20-Gallon Dust Bin

A 20-gallon dust bin is standard with all models.

Cleaning Controls and Sensors

Connected Technology Through iCue

The iCue platform, through the Contura controller or a separate Gateway, captures data from sensors and transmits it wirelessly via a cellular connection to the web-based Donaldson iCue application.

The Contura Controller is a touch screen and microcontroller-based solution for advanced dust collector system management, integrating the key functionalities of the Delta P, Delta P Plus, Airflow Controller and Valve Pulse Sequencer. Designed to help drive your productivity and uptime. Powered by iCue™ Connected Filtration Technology, the system simplifies your equipment management, delivering cloud-based monitoring for a comprehensive view of your dust collection system.

The system activates easily and quickly delivers data, trend tracking, and troubleshooting information so you can address potential issues before they can impact productivity.

For collectors without Contura, the standalone iCue Gateway includes internal sensors for differential pressure and compressed air manifold pressure in a pre-mounted location on the collector or through a stand-alone enclosure. This platform operates independently of the dust collector control system.

Options and Accessories

Hopper Discharge Accessories

55-Gallon Drum Pack

The drum pack is designed to fit a customer-supplied, standard 55-gallon drum and provides easy access for dust removal and disposal. A flexible hose connects the drum cover to the hopper. Placing a pallet under the drum allows heavier materials to be moved quickly using a forklift or pallet jack. If a pallet is used, the length of flexible hose may need to be shortened.

Exhaust Damper

An exhaust damper control regulates or limits airflow when the DFPRE is in operation.

HEPA Afterfilter

The HEPA afterfilter is designed to capture small particulate and is attached to the DFPRE collector clean-air outlet and may be pre-installed on the collector.

Spark Reducing Inlet

The Spark Reducing Inlet is recommended for applications where sparks are commonly present, such as laser cutting or welding processes. When used as part of an overall fire mitigation strategy, the Spark Reducing Inlet reduces the risk of a spark entering the dust collector by directing the airstream through a series of panels, creating a tortuous path to help extinguish the sparks.

Product Disclaimer



The Spark Reducing Inlet is intended for use in applications that have an increased fire risk and can be used as part of an overall fire mitigation strategy. No single spark mitigation device, including the Spark Reducing Inlet, can guarantee the elimination of all sparks and ignition sources from entering the dust collector. Please contact your Donaldson sales representative to discuss additional fire mitigation strategies as necessary.

Sprinkler Coupling

Sprinkler couplings are provided for the convenience of fire control system installers. The fire control system installer shall make their own decisions on the appropriate location of fire control system components.

3 Operation



Electrical work during installation, service or maintenance must be performed by a qualified electrician and comply with all applicable national and local codes.

Turn all power off and lock out all power before performing service or maintenance work.

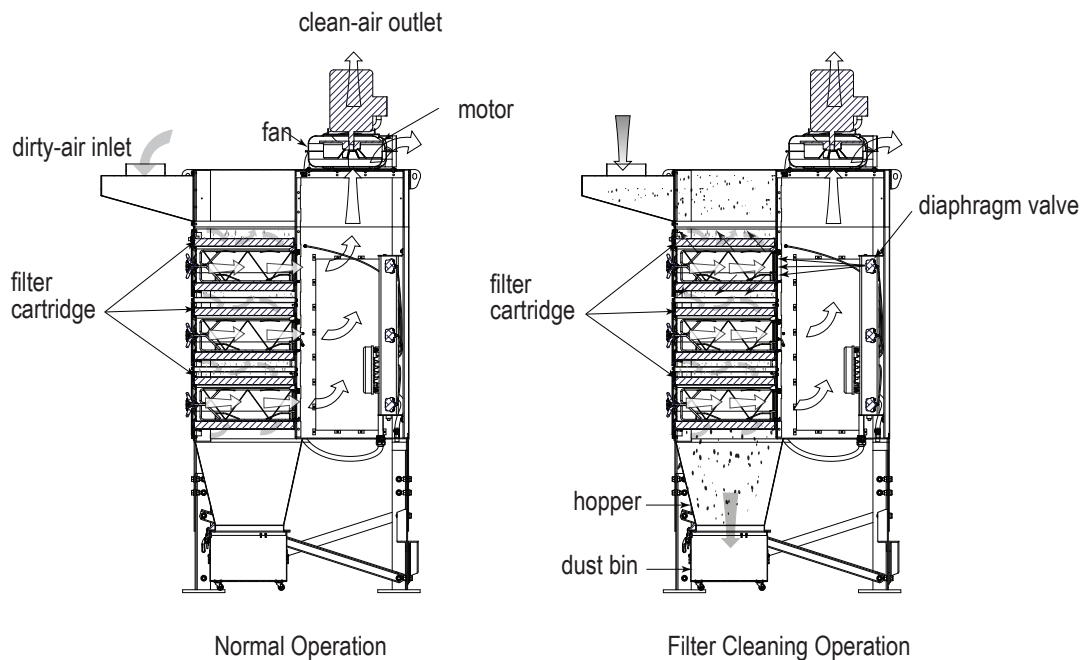
Turn compressed air supply off, bleed and lock out lines before performing service or maintenance work.

Check that the collector is clear and free of all debris before starting.

Do not install in classified hazardous atmospheres without an enclosure rated for the application.

During normal operation, dust-laden air enters the collector through the top dirty-air inlet. Airflow is directed downward through the collector and heavier particulate falls directly into the hopper. The cartridges remove fine particulate and clean, filtered air passes through the cartridge to the clean-air plenum and discharges through the clean-air outlet.

Filter cleaning is completed using pulse-jet technology. An air diaphragm valve aligned to each filter provides the pulse cleaning. Either a manual push-button valve or electronic solenoid valve actuates the pulse cleaning. The cleaning sequence starts at the top filter and continues down through each filter. Remove, inspect, or change the filter cartridges from outside the collector by removing the filter access cover and sliding the filter out.



Collector Operation

4

Product Service

During service activities there is some potential for exposure to the dust in the collector. Most dusts present safety and health hazards that require precautions. Wear eye, respiratory, head and other protection equipment suitable for the type of dust when performing any service activities.

Use appropriate access equipment and procedures. Note the standard collector is not equipped with access platforms unless noted on the specification drawings.

LOCK-OUT all energy sources prior to performing any service or maintenance on the equipment.

Electrical service or maintenance work must be performed by a qualified electrician and comply with all applicable national and local codes.

Turn compressed air supply OFF, bleed and lock out lines before performing service or maintenance work.

NOTICE

Do not set compressed-air pressure above 60-psig as component damage can occur.

All compressed air components must be sized to meet the system requirements of supply pressure.

The compressed-air supply must be oil and moisture free. Contamination in the compressed air used to clean filters will result in poor cleaning, cleaning valve failure, or poor collector performance.

Purge compressed air lines to remove debris before connecting to the collector's compressed air manifold.

Operational Checklist

1. Monitor the physical condition of the collector and repair or replace any damaged components.

Routine inspections will minimize downtime and maintain optimum system performance. This is particularly important on continuous-duty applications.

2. Periodically check the compressed air components and replace compressed air filters.

Drain moisture following the manufacturer's instructions. With the compressed air supply ON, check the cleaning valves, solenoid valves, and tubing for leaks. Replace as necessary.

3. Monitor pressure drop across filters.

Abnormal changes in pressure drop may indicate a change in operating conditions and possibly a fault to be corrected. For example, prolonged lack of compressed air will cause an excess build-up of dust on the filters resulting in increased pressure drop. Cleaning off-line with no airflow usually restores the filters to normal pressure drop.

4. Monitor exhaust.
5. Monitor dust disposal.

Dust Disposal

1. Shut the collector OFF prior to emptying the dust container (bin, drawer, pail, or drum)
2. Remove dust container by releasing the latch clamps.
3. Transfer dust from the dust container to a suitable disposal site and dispose of dust in accordance with local requirements for the materials being collected.
4. Empty when dust container is 2/3 full. Check integrity of gasket under container cover. Replace gasket if worn or damaged.
5. Replace or reinstall dust container and reclamp to the collector.

NOTICE

The collector should not be operated without the dust container in place and should not be serviced while collector is running. Do not service the dust container without turning the collector OFF.

6. Remove spark reducing inlet access cover and clean out any accumulation of dust and dispose of in accordance with local requirements for the materials being collected.
7. Replace the spark reducing inlet cover.
8. The collector can now be returned to service.

Filter Replacement



Most dusts present safety and health hazards that require precautions. Wear eye, respiratory, head and other protection equipment suitable for the type of dust.

Use proper safety and protective equipment when removing contaminants and filters.

Dirty filters may be heavier than they appear. Use appropriate equipment to access filters and appropriate lifting methods to avoid personal injury and/ or property damage.

Turn all power OFF and lock out all power before performing service or maintenance work.

Turn compressed air supply OFF, bleed and lock out lines before performing service or maintenance work.

Do not operate with missing or damaged filters.

1. Turn all power to the collector OFF.
2. Begin filter replacement with the top row of filters. Select a filter access port and remove access cover by turning knob counterclockwise.
3. Break the seal between the filter cartridge and the sealing surface.
4. Slide each filter out the access port along the suspension yoke and dispose of in accordance with local requirements for the materials being collected.
5. Proceed to the next row of filters and repeat for all remaining filters.
6. Inspect and clean the sealing surface if necessary.

NOTICE

Clean dust from gasket sealing area to ensure a positive filter gasket seal.

7. Clean any dust from the yoke threads that may have accumulated during the filter removal.
8. Check for any accumulation of dust in the storage area and remove as necessary.
9. Slide the gasket end of each new filter onto the end of the suspension yoke.

NOTICE

The filter shape and yoke work together to ensure proper filter alignment during filter installation. To assist with alignment, an alignment mark ($\triangle$) at the top of the filter endcap (non-gasketed end) must match with the alignment mark (∇) at the top of the filter access opening.

10. Proceed to the next row of filters and repeat for all remaining filters.

11. Inspect cover gaskets. Clean and/or replace as necessary.
12. After new filters have been installed, place the access cover on the yoke and hold it in position while tightening the knob securely by hand (3 turns) before using tool assist option.

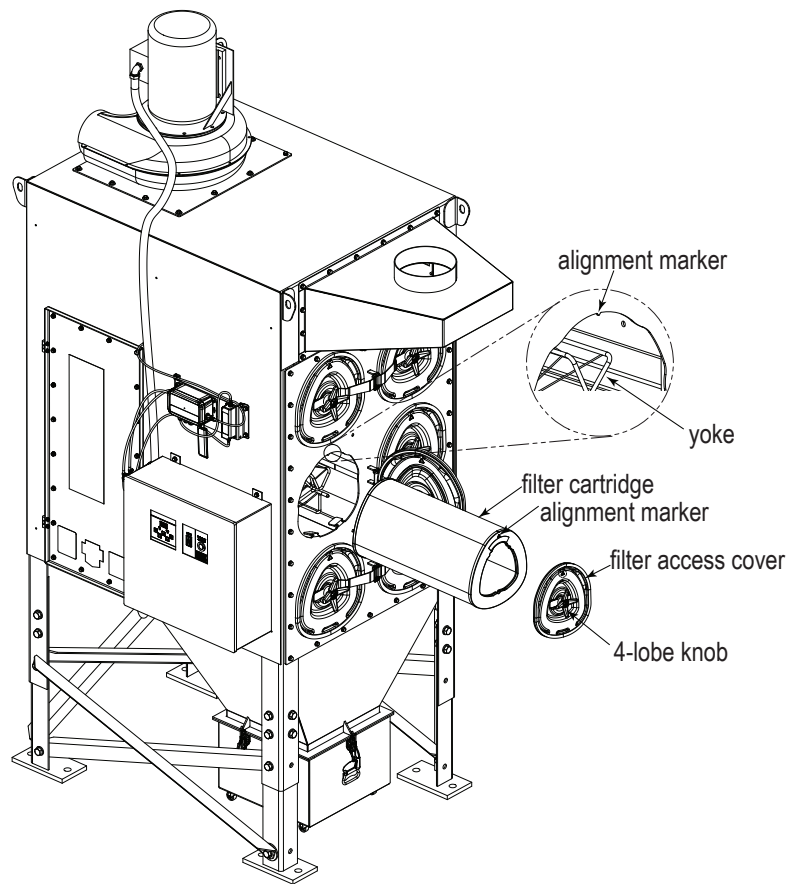
NOTICE

The access cover must be properly aligned to ensure a dust tight seal to the housing.

Do not exceed 150 in-lbs (12.5 ft-lbs) torque when securing the access cover as over tightening may cause damage to the filter and/or equipment.

When filter installation is complete, check to ensure that each access cover is seated and sealed against the filter housing to ensure a dust tight housing seal.

13. The collector can now be returned to service.



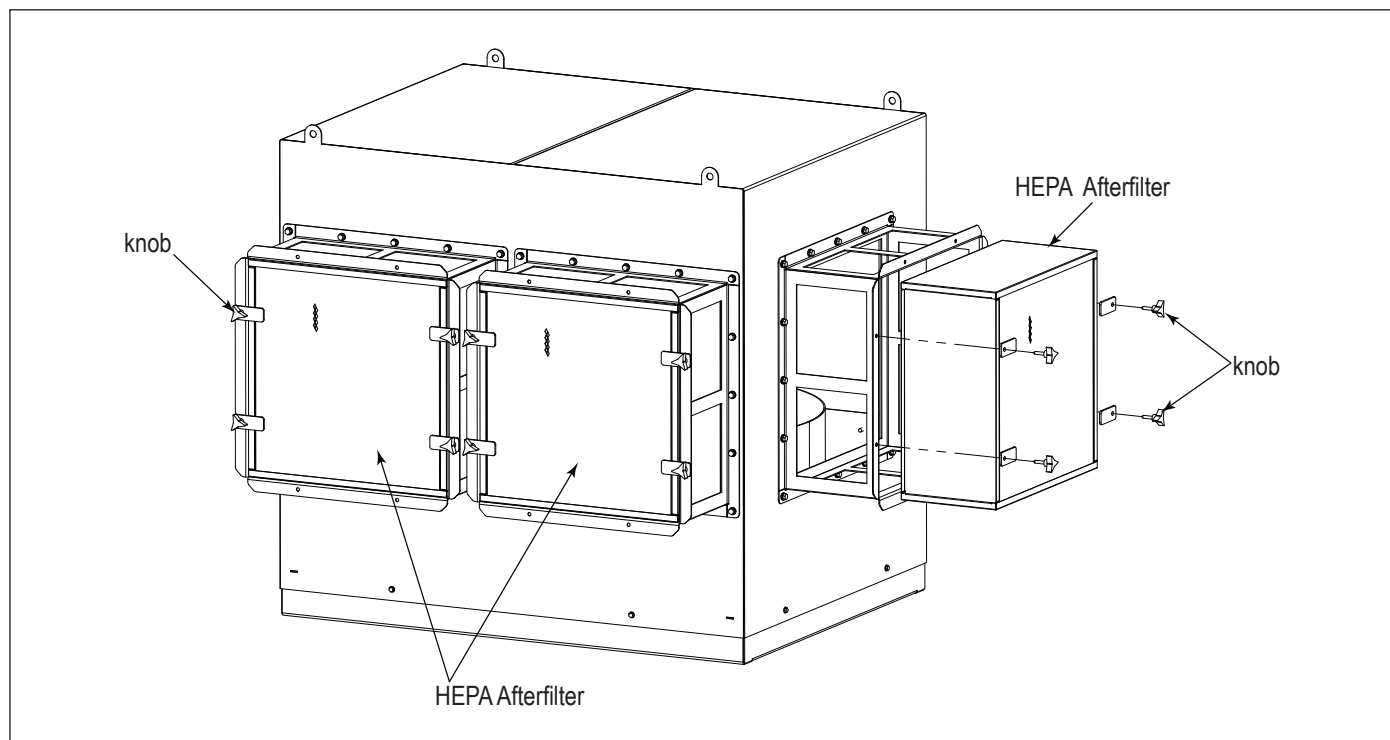
Filter Removal and Installation

Compressed Air Components

1. Periodically check the compressed air components (diaphragm valves, solenoid valves and tubing) and replace damaged or worn components as necessary.
2. Drain moisture from the compressed air filter at the collector following the manufacturer's instructions.
3. With the compressed-air supply ON, check the compressed air component functions by listening for proper actuation of each valve. You should note a crisp pulse sound for each diaphragm valve.
4. Note that all valves are activated in sequence as noted in the wiring diagram accompanying the collector.
5. Repair or replace components which do not function properly.

HEPA Afterfilter Replacement

1. Turn supply power OFF.
2. For each afterfilter, loosen the black three lobe knobs so that the hold down tab can be rotated out of contact with the afterfilter frame.
3. Remove the HEPA Afterfilter(s).
4. Install the new HEPA afterfilter with the gasket side towards the collector making contact with the metal frame.
5. Rotate the hold down tabs so they make contact with the afterfilter metal frame and hand tighten the black three lobe knobs. Position the HEPA Afterfilter on mounting frame on top of the clean-air outlet and align with the latches.
6. Repeat steps 2-5 for each remaining afterfilter.
7. Reset exhaust damper to fully closed position.
8. Turn collector ON.
9. Adjust airflow using the airflow control damper.



HEPA Afterfilter Replacement

Troubleshooting

Problem	Probable Cause	Remedy
Fan blower and motor do not start	Improper motor wire size	Rewire using the correct wire gauge as specified by national and local codes.
	Not wired correctly	Check and correct motor wiring for supply voltage. See motor manufacturer's wiring diagram. Follow wiring diagram and the National Electric Code.
	Collector not wired for available voltage	Correct wiring for proper supply voltage.
	Input circuit down	Check power supply to motor circuit on all leads.
	Electrical supply circuit down	Check power supply circuit for proper voltage. Check for fuse or circuit breaker fault. Replace as necessary.
	Damaged motor	Replace damaged motor.
Fan blower and motor start, but do not stay running	Incorrect motor starter installed	Check for proper motor starter and replace if necessary.
	Access doors are open or not closed tight	Close and tighten access doors. See Filter Replacement.
	Hopper discharge open	Check that dust container is installed and properly sealed.
	Damper control not adjusted properly	Check airflow in duct. Adjust damper control until proper airflow is achieved and the blower motor's amp draw is within the manufacturer's rated amps.
	Electrical circuit overload	Check that the power supply circuit has sufficient power to run all equipment.
Clean-air outlet discharging dust	Filters not installed correctly	See Filter Replacement.
	Filter(s) damaged or worn	Replace filters as necessary. Use only genuine Donaldson replacement parts. See Filter Replacement.
Insufficient airflow	Fan rotation backwards	Proper fan rotation is clockwise when viewed from the motor side or counterclockwise when viewed through the inlet cone. See Start-Up/Commissioning.
	Access doors open or not closed tight	Check that all access doors are in place and secured. Check that the hopper discharge opening is sealed and that dust container is installed correctly.
	Fan exhaust area restricted	Check fan exhaust area for obstructions. Remove material or debris. Adjust damper flow control.
	Filters need replacement	Remove and replace using genuine Donaldson replacement filters. See Filter Replacement.
	Hopper discharge open	Check that dust container is installed and properly sealed.

Troubleshooting

Problem	Probable Cause	Remedy
Insufficient airflow	Lack of compressed air	See the Specification Control Drawing shipped with the collector for compressed air supply requirements.
	Pulse cleaning not energized	Use voltmeter to check solenoid valves integrated into control panel or in separate enclosures.
	Dust storage area overfilled or plugged	Clean out dust storage area. See Dust Disposal.
	Pulse valves leaking compressed air	Lock out all electrical power to the collector and bleed the compressed air supply. Check for debris, valve wear, pneumatic tubing fault, or diaphragm failure by removing the diaphragm cover on the pulse valves. Check for solenoid leaks or damage. If pulse valves or solenoid valves and tubing are damaged, replace.
	Solid-State timer failure, if applicable	Using a voltmeter, check supply voltage to the timer board. Check and replace the fuse on the timer board if necessary. If the fuse is good and input power is present but output voltage to the solenoid is not, replace the timer board. See Solid-State Timer Installation.
	Solid-State timer out of adjustment if applicable	See Solid-State Timer and Solid-State Timer Typical Wiring Diagram.
Pulse cleaning never stops	High Pressure On or Low Pressure Off setpoint not adjusted for system conditions	Adjust setpoints to current conditions.
	Pressure tubing disconnected, ruptured, plugged, or kinked	Check tubing for kinks, breaks, contamination, or loose connections.
Alarm light is ON	Alarm setpoint too low	Adjust to a higher value.
	Excess pressure drop	Check cleaning system and compressed air supply. Replace filters if filters do not clean down.
	Pressure tubing disconnected, ruptured, plugged, or kinked	Check tubing for kinks, breaks, contamination, or loose connections.

Problem	Probable Cause	Remedy
Controller display or HMI not on or displaying a value	No power to the controller	Use a voltmeter to check for supply voltage.
	Fuse blown	Check the fuse in the control panel. See wiring diagram inside the control panel. Replace if necessary.
Value displayed on controller for differential pressure does not read zero when at rest	Out of calibration	Recalibrate using the procedure outlined in the controller manual.
	With collector discharging outside, differential pressure is present from indoor to outdoor	Recalibrate using the procedure outlined in the controller manual but leave tubing attached.

For Contura Controller troubleshooting, reference the Contura Controller Installation and Operation Manual for additional information.

Appendix A - Installation

Installation



Electrical Installation (including bonding and grounding of the collector) must be performed by a qualified electrician.

This equipment is not designed to support site ducts, piping, or electrical services. All ducts, piping, or electrical services must be adequately supported to prevent injury and/or property damage.

Do not install in classified hazardous atmospheres without an enclosure rated for the application.

Service must be performed by trained and qualified maintenance personnel.

Turn all power off and lock out all power before performing service or maintenance work. It is not unusual for the equipment to be operated from a remote location, so equipment may start or stop unexpectedly.

Equipment may reach peak sound pressure levels above 80 dB (A). Noise levels should be considered when selecting equipment location.

Location and Site Selection



Codes may regulate recirculating filtered air in your facility. Consult with the appropriate authorities having jurisdiction to ensure compliance with all national and local codes regarding recirculating filtered air.

Equipment location must conform to all codes and standards, should be suitable for the type of dust being handled and should ensure easy access for service and utility connections. Site selection must account for applicable load conditions such as wind, seismic and snow.

The equipment must be anchored once in final position. Anchors must comply with local code requirements. Anchors, foundation or support framing must be capable of supporting all applicable loads. Consult a qualified engineer for final selection of foundation or support framing.

Note: Ensure the inlet has at least five diameters of straight duct prior to the collector inlet including a transition to the full inlet dimensions. Use industrial duct design best practices for optimal dust collector performance.

Follow industry practice relative to clean air velocity into a fan.

Provisional Anchor Bolt Recommendations

The quantity of anchor bolts should match the number of holes provided in the base plates of the collector. Anchor diameter is typically 1/8-inch less than the baseplate hole diameter. Anchors should project a minimum of 1 3/4-inch and account for nut, washer, baseplate, and shims/grout.

Delivery and Inspection

Upon arrival inspect equipment and report any damage to delivery carrier. File any damage claims with the delivery carrier. Request a written inspection report from the Claims Inspector to substantiate all damage claims.

Compare the equipment received with the description of product ordered. Report any incomplete shipments to the delivery carrier and your Donaldson Torit representative.

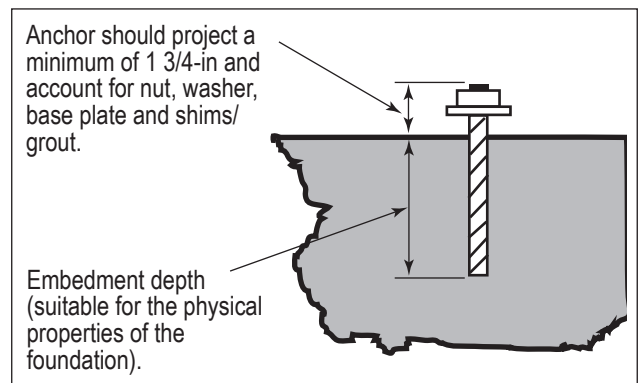
Unloading and Positioning



Equipment should be lifted only by qualified crane or fork truck operators.

Failure to lift the equipment correctly can result in severe personal injury and/or property damage.

1. Remove any crates or shipping straps.
2. Lift the packaged collector from transport container.
3. Inspect for any damage and/or missing parts and report to freight carrier.
4. Check for any hardware which may have become loose during shipment and tighten as necessary.



Typical Foundation Anchor

Lifting Information



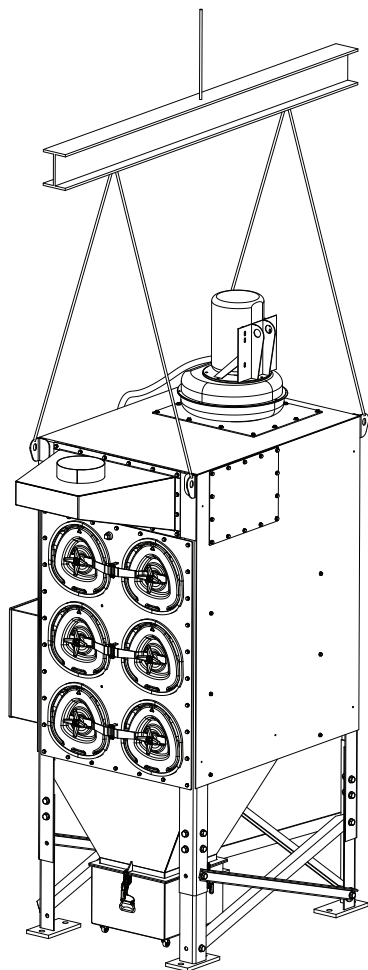
Failure to lift the equipment or sub-assemblies correctly can result in severe personal injury and/or property damage.

Only qualified crane or forklift operators should be allowed to lift equipment.

Lifting lugs are not intended for long-term support of equipment. If ceiling mount is required, an external structure (provided by others) must be designed to support dead and live loads and reduce chance of swaying during maintenance.

1. Use all lifting points provided.
2. Use clevis connectors, not hooks, on lifting slings.
3. Use spreader bars to prevent damage to equipment.
4. Check the drawing(s) shipped with the collector for weight and dimensions of the collector and components to ensure adequate crane capacity.
5. Lift collector and accessories separately and assemble after collector is in place.
6. Use drift pins to align holes in section flanges during assembly.

Typical Lifting Guidance



Typical Lifting Guidance

Compressed Air Installation



Turn compressed air supply OFF, bleed and lock out lines before performing service or maintenance work.

A safety exhaust valve should be used to isolate the compressed air supply. The safety exhaust valve should completely exhaust pressure in the collector manifolds when closed, should be capable of being interlocked with fire or explosion mitigation equipment and should include provisions to allow closed-position locking.

NOTICE

Do not set compressed-air pressure above 60-psig as component damage can occur.

All compressed air components must be sized to meet the system requirements of supply pressure.

The compressed-air supply must be oil and moisture free. Contamination in the compressed air used to clean filters will result in poor cleaning, cleaning valve failure, or poor collector performance.

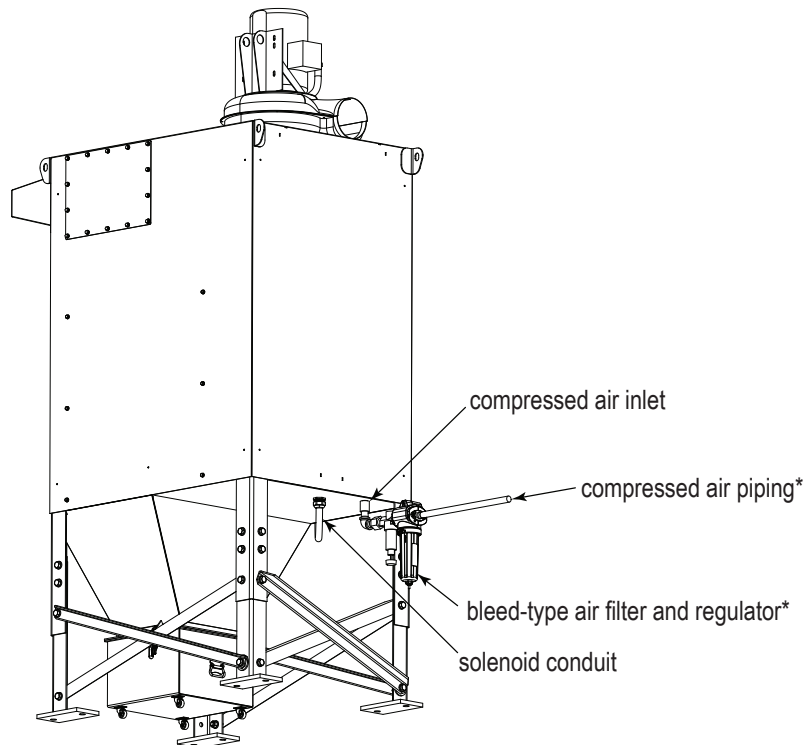
Purge compressed-air lines to remove debris before connecting to the collector's compressed-air manifold.

1. Remove the pipe plug from one end of the collector's compressed air manifold(s) (Note: some collectors may only have one manifold). Connect the compressed air supply lines. Use thread-sealing tape or pipe sealant on all compressed-air connections.
2. Install a shut-off valve, bleed-type regulator with gauge, filter, and automatic condensate valve in the compressed-air supply line all of which are supplied by the customer.
3. Set compressed-air supply pressure to a level suitable for the filters (60-psig).
4. The pulse-cleaning controls are factory set to clean one or more filters every 10-seconds during a cleaning cycle.



Turn power off and lock out all power before performing service or maintenance work.

Turn compressed air supply OFF, bleed and lock out lines before performing service or maintenance work.



*customer supplied

Typical Component Installation

Electrical Wiring



Electrical installation, service, or maintenance work must be performed by a qualified electrician and comply with all applicable national and local codes.

Turn all power off and lock out all power before performing service or maintenance work. It is not unusual for the equipment to be operated from a remote location so equipment may start or stop unexpectedly.

The appropriate wiring schematic and electrical rating must be used. See collector's rating plate for required voltage.

Do not install in classified hazardous atmospheres without an enclosure rated for the application.

Cleaning Controls and Sensors

Connected Technology Through iCue



The iCue Gateway should not be used to detect, monitor, warn, or alert personnel to hazards, potential safety issues, or combustion risks. Users should not rely on readings from the product to provide emergency or hazard prevention or for emergency response activities and decisions. Users remain solely responsible for maintaining a safe work environment. All dust collection equipment and accessories should be operated and maintained in accordance with the manufacturer's instructions.

iCue connected collectors utilize internal sensors in the Contura Controller or iCue Gateway for sensing filter differential pressure and pulse clean manifold compressed air pressure. Both the Contura and the iCue Gateway have inputs for Donaldson approved optional sensors. The platform captures data and transmits it wirelessly via a cellular connection to the web based Donaldson iCue application.

For additional installation information on the iCue Gateway operation or instruction on connecting additional sensors, refer to the installation and operation manual for the iCue Gateway.

Smart collectors may include connectivity in one of these configurations:

- Connectivity integral with the Contura pulse cleaning controller
- An iCue global Gateway mounted to the rear of the dust collector
- An iCue global Gateway shipped loose for remote field installation



Scan the QR on the right for a video highlighting the installation and set-up process for the iCue Gateway.

Options and Accessories

Hopper Discharge Accessories



Turn all power off and lock out all power to the collector and ancillary equipment before accessing the inside of the hopper and before performing service or maintenance work.

Most dusts present safety and health hazards that require precautions.

Wear eye, respiratory, head and other protective equipment suitable for the type of dust.

55-Gallon Drum Pack



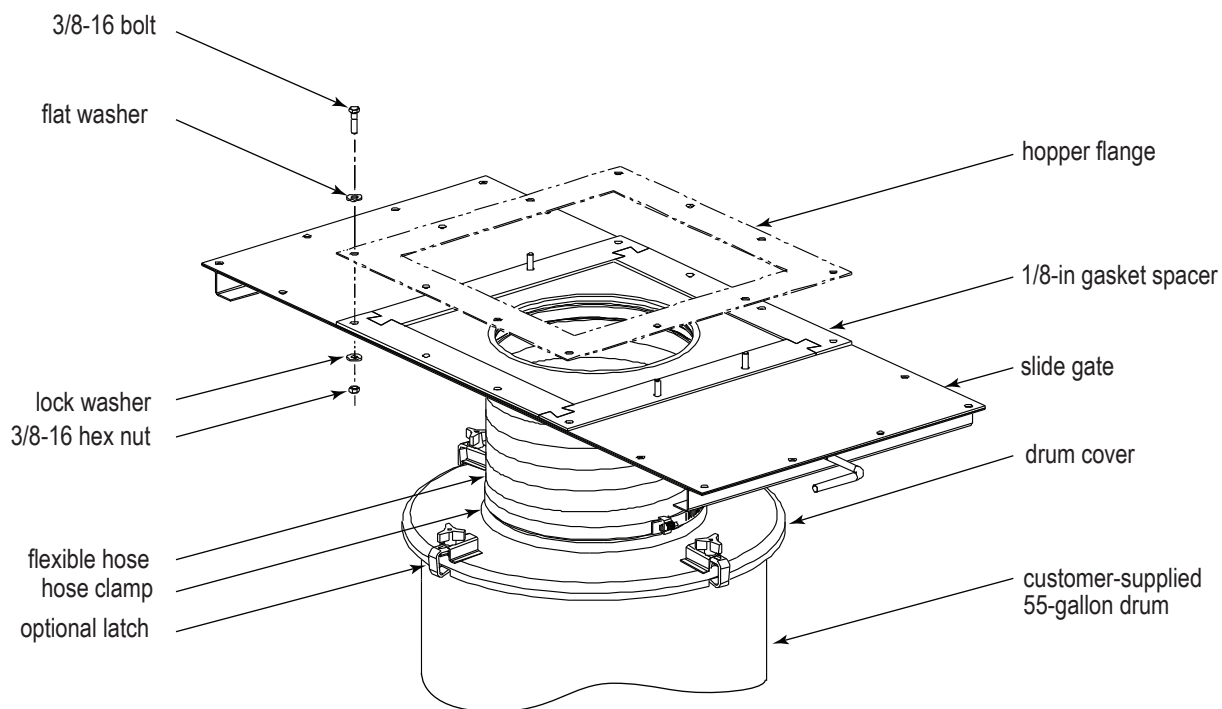
Sharp edge of slide gate may result in personal injury while closing the slide gate. Keep hands clear when operating the slide gate.

With Slide Gate

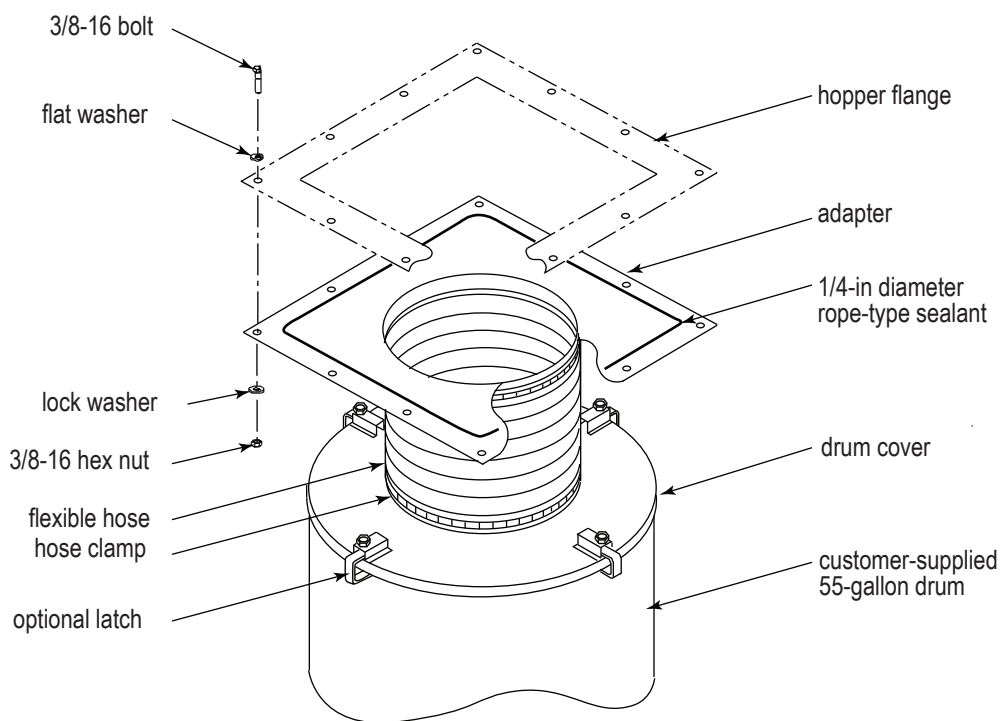
1. Place the 1/8-in gasket spacer between the hopper flange and slide gate as shown.
2. Attach the drum pack and slide gate to the hopper flange using 3/8-16 bolts, washers and hex nuts.
3. Attach the drum cover to the 55-gallon drum.
4. Use latches to secure the cover to the drum, if equipped.
5. Connect the flexible hose between the drum cover and slide gate. Secure with hose clamps.

Without Slide Gate

1. Place 1/4-in diameter rope-type sealant between the hopper flange and the drum cover mounting flange toward the inside edge of the bolt pattern.
2. Fasten using the bolts, washers, and nuts supplied.
3. Attach the drum cover to the 55-gallon drum.
4. Use latches to secure the cover to the drum, if equipped.
5. Connect the flexible hose between the drum cover and the adapter. Secure with hose clamps.



55-Gallon Drum Pack with Slide Gate



55-Gallon Drum Pack without Slide Gate

Spark Reducing Inlet



Do not use spark reducing inlet with explosion relief devices. Contact your Donaldson sales representative to discuss additional mitigation strategies as necessary.

Preventative Maintenance Recommendations

Inspect the spark reducing inlet at a minimum of every two weeks.

1. Turn all power to the collector OFF.
2. Remove the inlet access cover by turning the wing nuts counter clockwise. Do not fully remove the wings nuts.
3. Slide the inlet access cover to the bottom right corner of the opening and orientate diagonally to remove.
4. Clean out any accumulation of material buildup from inside the spark reducing inlet.
5. Inspect and clean the sealing surface if necessary.

NOTICE

Clean dust from gasket sealing area to ensure an effective gasket seal.

6. Reinstall the inlet access cover and tighten wing nuts to secure.
7. Turn the collector ON.
8. The collector can now be returned to service.

Sprinkler Coupling



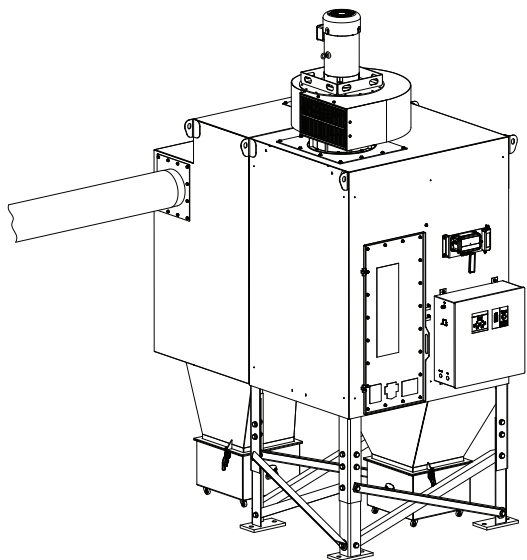
Sprinklers can place a large quantity of water in the dust collector when activated. Provide adequate drainage to remove water. Excess water weight can cause the leg structure to collapse.

Consult with local authorities when installing fire control systems on dust collection equipment.

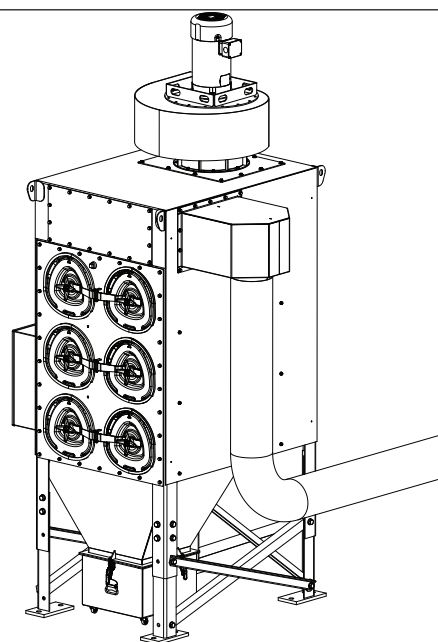
NOTICE

Sprinkler couplings are provided for the convenience of fire control system installers. The fire control system installer shall make their own decisions on the appropriate location of all additional fire control system components.

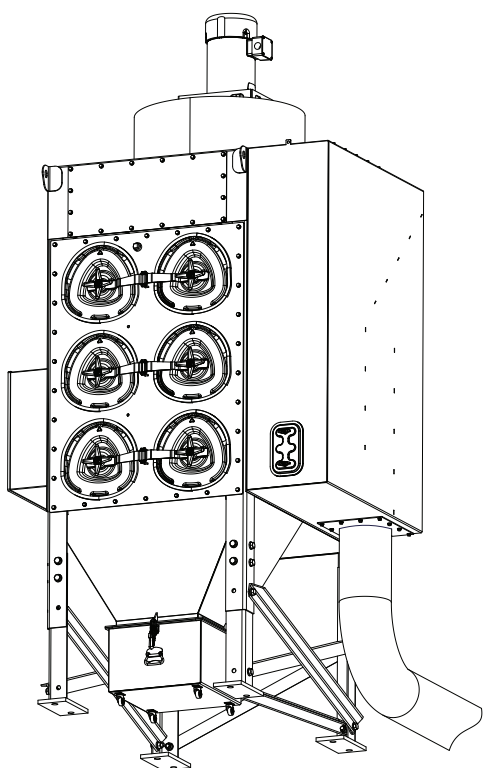
Inlet Duct Locations



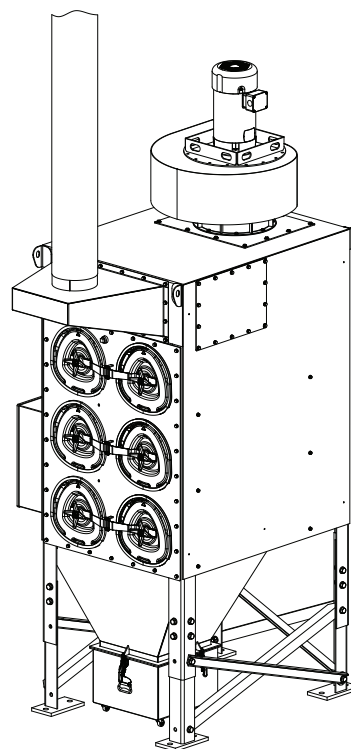
Cyclopeel Inlet Ducting



Grade Level Inlet Ducting



Spark Reducing Inlet Ducting



Abrasion Resistant Inlet Ducting

Start-up / Commissioning

Instruct all personnel on safe use and maintenance procedures.



Electrical installation, service, or maintenance work must be performed by a qualified electrician and comply with all applicable national and local codes. This equipment may start or stop unexpectedly from a remote location.

Turn all power off and lock out all power before performing service or maintenance work.

Turn compressed air supply OFF, bleed and lock out lines before performing service or maintenance work.

Check that the collector is clear and free of all debris before starting.

Do not operate in classified hazardous atmospheres without an enclosure rated for the application.

1. Check all electrical connections for tightness and contact.
2. Check for proper rotation on all motors as described below.



Do not look into fan outlet to determine rotation. View the fan rotation through the back of the motor.

Check that the exhaust plenum is free of tools or debris before checking fan rotation.

Stand clear of exhaust to avoid personal injury.

Do not interchange a power lead with the ground wire. Severe personal injury and/or property damage may result.

- a. "Bump" the fan to initiate rotation.
- b. As the fan is winding down (unpowered) compare fan rotation to the rotation label (located on fan housing) direction.
3. If the fan rotation is reversed, correct the rotation.

To reverse rotation, single-phase power supply: Follow manufacturer's instructions on the motor's nameplate.

To reverse rotation, three-phase power supply: Switch any two leads on the motor junction box.

- a. Turn power to the collector OFF and Lock-Out all energy sources.
- b. Within the junction box, swap the connection location of two power leads on the terminal block, making certain not to swap a power lead and the ground wire.



Do not interchange a power lead with a ground wire or severe personal injury and/or property damage may result.

4. Ensure all equipment access panels are sealed and secure.
5. Check that the dust container or dust discharge device is properly attached to the collector (if supplied).
6. Check that fan exhaust damper is set to the fully-closed position (if supplied).
7. Check and remove all loose items in or near the inlet and outlet of the collector.
8. Check that all remote controls and solenoid enclosures (if applicable) are properly wired and all service switches are in the OFF position.
9. Check that all optional accessories are installed properly and secured.
10. Turn power ON at source.
11. Turn the compressed-air supply ON. Set compressed-air supply pressure to a level suitable for the filters (60-psig).
12. Turn fan motor ON.
13. Adjust airflow with the exhaust damper.

NOTICE

Excess airflow can shorten filter life, cause electrical system failure and fan motor failure.

14. Turn powered hopper discharge material handling system components ON.
15. Turn ON remaining optional accessories.
16. Ensure any and all fire and explosion mitigation systems are engaged and armed.

Decommissioning

Once the collector has reached the end of operational life it will need to be decommissioned.



During decommissioning, there is potential for exposure to the dust in the collector. Most dusts present safety and health hazards that require precautions. Wear eye, respiratory, head, and other protection equipment suitable for the type of dust when performing any decommissioning activities.

LOCK-OUT all energy sources prior to performing any decommissioning activities on the equipment.

Electrical service must be performed by a qualified electrician.

Disconnection of ducts must be performed by a qualified contractor.

1. Lock-out all energy sources to the collector, material handling system and other associated equipment.
2. Remove all filters from the collector and dispose of in a suitable fashion for the dust in the collector. (See Filter Replacement for removal instructions).
3. Disconnect electrical power from the collector and material handling system components and remove any associated conduit or hardware from the exterior of the collector.
4. Clear residual dust accumulations from surfaces inside the collector and associated components in a fashion suitable for the dust, prior to further disassembly.
5. Remove and dispose of all material handling components from the collector hopper discharge.
6. Disconnect all ducts from the collector.
7. Once all cross bracing has been taken down, remove anchor bolts and lower leg pack columns.
8. Secure all collector components to a suitable transport carrier and transport to a disposal site suitable for the dust in the collector.

Product Information

(Process Owner to complete and retain for your records)

Model Number _____	Serial Number _____
Ship Date _____	Installation Date _____
Filter Type _____	
Collected Dust _____	
Dust Properties:	Kst _____ Pmax _____ MIE _____ MEC _____
Accessories _____	
Other _____	

Service Notes

[illegible]

[illegible]

Service Notes

[illegible]

Donaldson Industrial Air Filtration Warranty

Donaldson warrants to the original purchaser only that the Goods will be free from defects in material and manufacture for the applicable time periods stated below: (1) Major structural components for a period of ten (10) years from the date of shipment; (2) Non-Structural, Donaldson-built components and accessories including Donaldson Airlocks, TBI Fans, TRB Fans, Fume Collector products, Donaldson built electrical control components, and Donaldson-built Afterfilter housings for a period of twelve (12) months from date of shipment; and (3) Donaldson-built filter elements for a period of eighteen (18) months from date of shipment.

Buyer is solely responsible for determining if goods fit Buyer's particular purpose and are suitable for Buyer's process and application. Seller's statements, engineering and technical information, and recommendations are provided for the Buyer's convenience and the accuracy or completeness thereof is not warranted. If, after Seller receives written notice, within the warranty period, that any goods allegedly do not meet Seller's warranty, and Seller, in its sole discretion, determines that such claim is valid, Seller's sole obligation and Buyer's exclusive remedy for breach of the foregoing warranty or any Seller published warranty, will be, at Seller's option, either: (i) repair or replacement of such goods or (ii) credit or refund to Buyer for the purchase price from Seller. In the case of repair or replacement, Seller will be responsible for the cost of shipping the parts but not for labor to remove, repair, replace or reinstall the allegedly defective goods. Refurbished goods may be used to repair or replace the goods and the warranty on such repaired or replaced goods shall be the balance of the warranty remaining on the goods which were repaired or replaced. Any repair or rework made by anyone other than Seller is not permitted without prior written authorization by Seller, and voids the warranty set forth herein. Seller warrants to Buyer that it will perform services in accordance with the Sales Documents using personnel of required skill, experience and qualifications and in a professional and workmanlike manner in accordance with generally recognized industry standards for similar services. With respect to any services subject to a claim under the warranty set forth above, Seller shall, in its sole discretion, (i) repair or re-perform the applicable services or (ii) credit or refund the price of such services at the pro rata contract rate and such shall be Seller's sole obligation and the exclusive remedy for breach of the foregoing warranty on services. Products manufactured by a third party ("Third Party Product") may constitute, contain, be contained in, incorporated into, attached to or packaged together with, the goods. Buyer agrees that: (a) Third Party Products are excluded from Seller's warranty in this Section 7 and carry only the warranty extended by the original manufacturer, and (b) Seller's liability in all cases is limited to goods of Seller's design and manufacture only. EXCEPT FOR SELLER'S WARRANTY OF TITLE TO THE GOODS, SELLER EXPRESSLY DISCLAIMS AND EXCLUDES ALL OTHER WARRANTIES WHATSOEVER, WHETHER, EXPRESSED OR IMPLIED, ORAL, STATUTORY, OR OTHERWISE, INCLUDING BUT NOT LIMITED TO MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT OF THIRD PARTY INTELLECTUAL PROPERTY AND ANY WARRANTIES ARISING FROM TECHNICAL ADVICE OR RECOMMENDATIONS, COURSE OF DEALING OR OF PERFORMANCE, CUSTOM OR USAGE OF TRADE. Seller's obligations do not cover normal wear and tear or deterioration, defects in or damage to any goods resulting from improper installation, accident or any utilization, maintenance, repair or modification of the goods, or any use that is inconsistent with Seller's instructions as to the storage, installation, commissioning or use of the goods or the designed capabilities of the goods or that, in its sole judgment, the performance or reliability thereof is adversely affected thereby, or which is subjected to abuse, mishandling, misuse or neglect or any damage caused by connections, interfacing or use in unforeseen or unintended environments or any other cause not the sole fault of Seller, and shall be at Buyer's expense. Seller's warranty is contingent upon the accuracy of all information provided by Buyer. Any changes to or inaccuracies in any information or data provided by Buyer voids this warranty. Seller does not warrant that the operation of the goods will be uninterrupted or error-free, that the functions of the goods will meet Buyer's or its customer's requirements unless specifically agreed to, or that the goods will operate in combination with other products selected by Buyer or Buyer's customer for its use.

The terms of this warranty may only be modified by a special warranty document signed by a Director, General Manager or Vice President of Donaldson. To ensure proper operational performance of your equipment, use only genuine Donaldson replacement parts.

This Product is provided subject to and conditioned upon Donaldson's Terms of Sale ("Terms"), a current copy of which is located at termsofsale.donaldson.com. These Terms are incorporated herein by reference. By purchasing or using this Product, the user accepts these Terms. The Terms are available on our website or by calling our customer service line at 1-800-365-1331.



Donaldson.
FILTRATION SOLUTIONS

Donaldson Company, Inc.
Minneapolis, MN
donaldson.com • shop.donaldson.com

North America
Email: donaldsontorlit@donaldson.com
Phone: (USA): +1-800-365-1331
(within MX): +1-800-343-3639

Latinoamerica
Phone: +52-449-300-2442
Email: industrialair@donaldson.com
Toll Free: (CO) (57) 601-580-1611
(CL) +800-914-544 • (PE) +800-712-10
(BR) +55 (11) 99707-6689

IOM AG8797801 ENG, Revision 1 (May 2026)

©2024 Donaldson Company, Inc. All rights reserved. Donaldson Company, Inc. reserves the right to change or discontinue any model or specification at any time and without notice.

Important Notice: Many factors beyond the control of Donaldson can affect the use, performance, or results of Donaldson products or services in a particular application, including the conditions impacting how the products or services are selected, used, installed, or maintained. Because these factors are uniquely within the user's knowledge and control, it is essential the user evaluate both the products and any related services to determine their suitability for the user's intended purpose and application, including fitness for the particular purpose. All products, services, product specifications, availability and data are subject to change without notice and may vary by region or country.