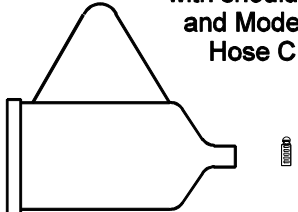
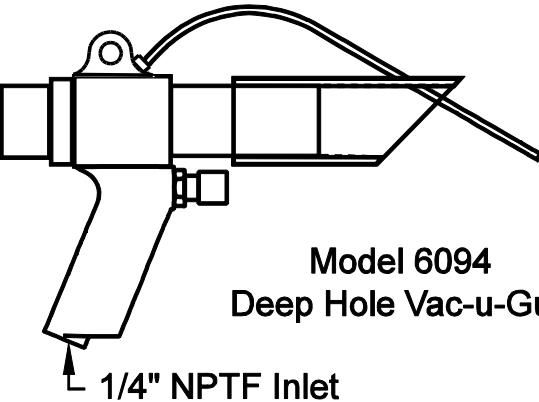
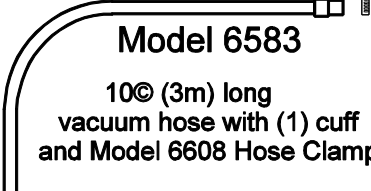
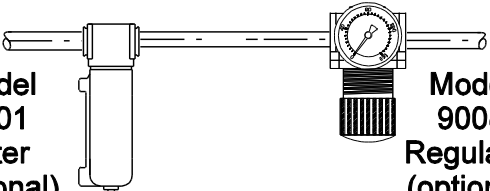


# EXAIR<sup>®</sup> Corporation

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## DEEP HOLE VAC-U-GUN™ INSTALLATION & MAINTENANCE



<p><b>Collection Attachment</b></p> <p><b>Model 6584 Vacuum Bag</b></p> <p>with shoulder strap and Model 6608 Hose Clamp</p> 	 <p><b>Model 6094 Deep Hole Vac-u-Gun</b></p> <p>1/4" NPTF Inlet</p>
<p><b>Transfer Attachment</b></p> <p><b>Model 6583</b></p> <p>10' (3m) long vacuum hose with (1) cuff and Model 6608 Hose Clamp</p> 	<p><b>Accessories</b></p>  <p><b>Model 9001 Filter (optional)</b></p> <p><b>Model 9008 Regulator (optional)</b></p>

**Model 6094 Deep Hole Vac-u-Gun Only**  
**Model 6194 Deep hole Vac-u-Gun with Bag (includes Model 6584 Vacuum Bag)**  
**Model 6394 Deep Hole Vac-u-Gun System (includes Model 6584 Vacuum Bag and Model 6583 Transfer Hose)**

### COMPRESSED AIR LINE SIZES

Compressed air lines should be sized to hold pressure drops to a minimum. Compressed air hose (not included) should be 1/4" I.D. up to 10' (3m) long, 3/8" I.D. hose up to 25' (7.6m) long. Do not use restrictive fittings such as quick connects. They can "starve" the Deep Hole Vac-u-Gun by causing excessive line pressure drop.

### COMPRESSED AIR SUPPLY

For best performance, use line pressure up to 100 PSIG (6.9 BAR, 689 kPa). With proper filtration and separation of dirt, moisture and oil from the compressed air supply, the Vac-u-Gun will operate for years with no maintenance required. Maximum pressure is 250 PSIG (17.2 BAR, 1.72 MPa).

Use a 10 micron filter separator on the compressed air supply (Model 9001 Automatic Drain Filter not included). To prevent problems associated with oil, use an oil removal filter (Model 9005 Oil Removal Filter not included.) The oil removal filter should be used downstream from the automatic drain filter separator. Filters should be close to the Deep Hole Vac-u-Gun, within 10 to 15' (3 to 4.6m) is best.

If air preparation units other than EXAIR models are being used, please note the following:

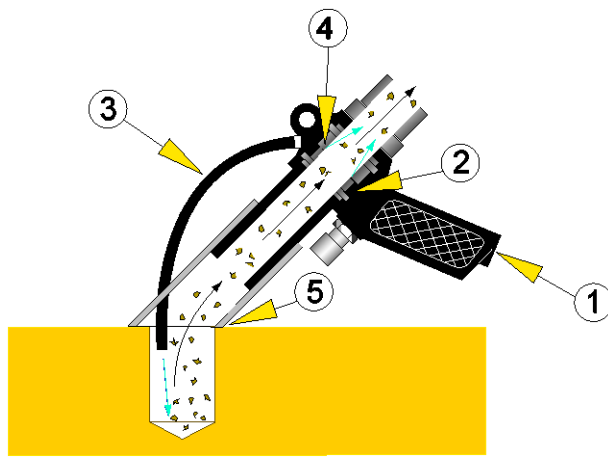
- **PRESSURE REGULATORS** – Must be pressure relieving and rated for a supply pressure of 250 PSIG (17.2 BAR, 1.72 MPa). Suggested operating pressure is 5-125 PSIG (0.3-8.6 BAR, 34-862 kPa). Flow should be minimum 24 SCFM (680 SLPM).
- **AUTO DRAIN FILTER SEPARATORS** – Must be rated for a supply pressure of 250 PSIG (17.2 BAR, 1.72 MPa) and have 5 micron filtration. Flow should be minimum 24 SCFM (680 SLPM).

- OIL REMOVAL FILTERS – Must be rated for a supply pressure of 250 PSIG (17.2 BAR, 1.72 MPa) and have 0.03 micron filtration. Flow should be minimum 24 SCFM (680 SLPM).

**CAUTION!**

**Connect a duct hose or bag to the knurled nut, when used for suction, to avoid possible injury.**

**WARNING: Do not use with any material that can create an explosive mixture.**



**HOW THE DEEP HOLE VAC-U-GUN WORKS**

Compressed air, normally 80-100 PSIG (5.5 - 6.9 BAR), flows through the inlet (1) into an annular plenum chamber (2) when the trigger is depressed. A small amount of air is injected into the blow tube (3) to provide lift for the chips or debris. The larger airflow is injected into the throat of the gun through directed nozzles (4). These jets of air create a vacuum at the intake (5) which draws material in and accelerates it through the unit. The chips or other particulate can be exhausted into a filter bag or hose.

**TROUBLESHOOTING & MAINTENANCE**

If there is reduced suction from the Deep Hole Vac-u-Gun, check the pressure by installing a gauge at the compressed air inlet. Large pressure drops are possible due to undersized lines, restrictive fittings and clogged filter elements.

**For replacement or repair filter and regulator parts, contact EPUTEC at +49 8191 91 51 19 0 or [info@eputec.de](mailto:info@eputec.de).**

**CLEANING**

If contaminants have clogged the Deep Hole Vac-u-Gun, inspect the unit by disassembling (turn the knurled silver cap counter-clockwise). The Deep Hole Vac-u-Gun consists of three component parts; the gun body, an internal nozzle ring and a knurled cap which holds the ring in place. Inspect each part for dirt contamination and a possible oil film on the nozzle ring.

Clean each part with a mild cleaning or degreasing solvent and a rag. Reassemble the Deep Hole Vac-u-Gun, making sure there is an “O”-ring on each end of the nozzle ring. It is also important to note the direction of the nozzle holes as this will determine which end produces a suction. Nozzle holes should not be visible when looking through the clear suction tube.

Always clean the vacuum hose and attachments after every use.

If routine cleaning does not solve your performance problems, please contact:

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