



## **INSTRUCTION AND MAINTENANCE MANUAL**

### **WELD'ONE**



This manual is an integral part of the vacuum. Carefully read this manual and its attachments. Knowing the instructions contained in it is crucial for using the vacuum and carrying out maintenance operations under full safety conditions.

**rev. 0 dated 18-12-2016**



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## 1. INFORMATIVE SECTION

### 1.1 Preface

Dear Customer

Congratulations on purchasing a WELD ONE series DEPURECO vacuum. Thank you for choosing us.

We have prepared this manual to allow you to fully appreciate the qualities of this machine.

We recommend reading it carefully before using it for the first time.

It includes information, recommendations and important warnings concerning the use of the vacuum, which will help fully exploiting the technical properties of your machine.

We recommend reading carefully the messages, warnings and indications preceded by the following symbols:



**for personal safety;**



**for vacuum integrity;**



**for environmental protection.**

This document has been designed for extracting dust and processing residues.

The vacuumed material tends to settle at the bottom of the container as a result of the deflector placed immediately at the entrance to the filter chamber; finer dust particles are transported by the air flow and are deposited on the surface of the filter placed above the container.

This manual provides all the necessary information for the use and maintenance of your vacuum.

This specific model has undergone strict testing to ensure maximum reliability. Its operation and durability will depend on proper use and maintenance.

This manual is integral part of the vacuum and must accompany it at all times, until its demolition.

In the event it is lost or damaged, you can request another copy from DEPURECO INDUSTRIAL VACUUMS S.r.l. (hereafter simply called DEPURECO).

The technical information contained in this manual is exclusive property of DEPURECO and must be considered confidential.

Reproduction, even partial, of graphics, text and illustrations is prohibited by law.

Some details shown in the figures in this manual can differ from those on your vacuum; this is because some components can be removed to ensure maximum clarity



For easier consultation, this manual is divided into sections that are identified by a specific graphic symbol. The topics covered in this manual are those expressly required by Machinery Directive 2006/42/CE and the technical data are taken from the technical file archived at DEPURECO.

In compliance with Regulation 1907/2006/EC (REACH), DEPURECO declares that its products do not contain any *Substances of Very High Concern* (SVHC) included in the Candidate List.

This manual must be kept in a place that can be easily accessed by the personnel in charge of running and maintaining the vacuum.

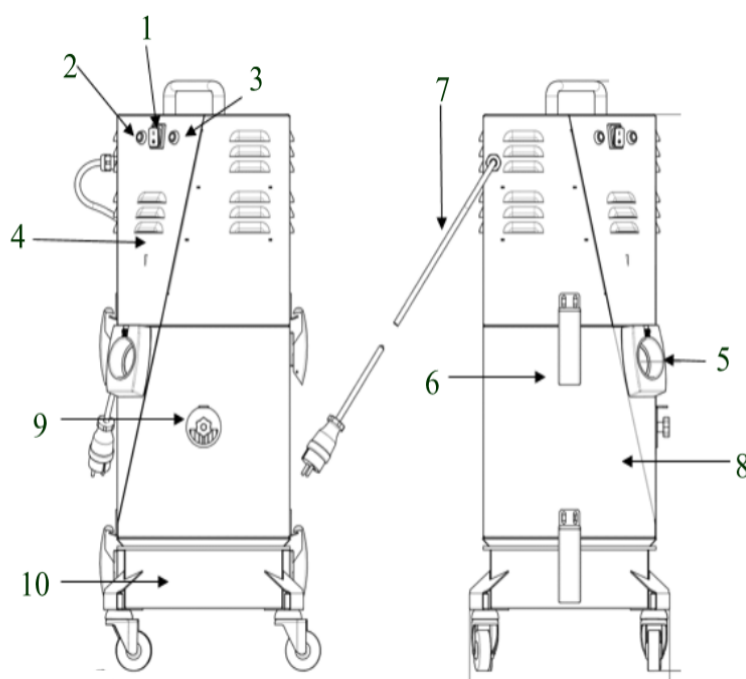
Any dispute will be heard by the Court of Turin (Italy)



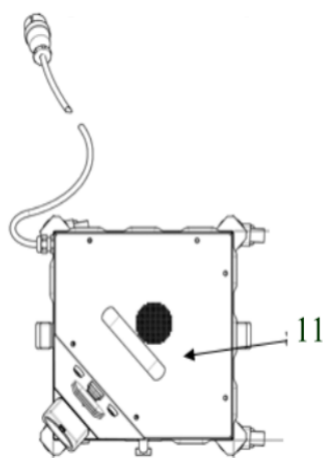
**This manual must accompany the vacuum even in the event it is sold!**



## 1.2 Identification of the main parts



- 1. ON/OFF Switch
- 2. Clogged filter
- 3. Power ON
- 4. Motor Deck
- 5. Suction Inlet
- 6. Latches
- 7. Power supply cable
- 8. Filter Housing
- 9. Flow regulator
- 10. Dust Bin
- 11. Handle



## 1.3 Optional parts

DEPURECO provides a wide range of optional accessories, according to the application of the vacuum.



## 1.4 Manufacturer's identification data

### DEPURECO INDUSTRIAL VACUUMS S.r.l.

Corso Europa, 609 - 10088 Volpiano (TO) - ITALY

tel. +39 011 98 59 117

fax +39 011 98 59 326


e-mail: [depureco@depureco.com](mailto:depureco@depureco.com)

website: [www.depureco.com](http://www.depureco.com)

VAT No. 02258610357

## 1.5 Identification plate

The data on the vacuum identification plate must be referred to in any communication with the manufacturer or the dealer.

<b>DEPURECO S.r.l</b>				C.so Europa, 609 - Volpiano (TO) 10088 - ITALY Tel. +39 011. 98. 59. 117 - Fax. +39 011. 98. 59. 326 MADE IN ITALY	
Mod.		Volt.			
Serial N.	kW	Amp.	Hz.		
Dust Class	IP	Kg.	Year		

## 1.6 Intended use

This model has been designed, manufactured and protected solely for professional industrial extraction of non-flammable and non-toxic wet and/or dry dust and shavings.  
Any other use is considered **IMPROPER**.

## 1.7 Allowed environmental conditions

To ensure proper operation, the vacuum must be protected from weather agents (rain, hail, snow, fog, suspended powders, etc.) at a room temperature ranging between 5 and 45 °C and a humidity below 70%.  
The work environment must be clean, suitably lit and must not give rise to potentially explosive atmosphere.

## 1.8 Noise level

Photometric tests carried out on these specific models have shown a sound pressure level of 72 dBa



### Attention!

For sound pressure levels above 85 dB(A), exposed workers must wear suitable personal protective equipment (PPE), such as type-approved individual hearing protection.



Under these conditions, workers must be provided with adequate training and information on risks arising from noise exposure.



## 1.9 Technical data

		WELDONE	WELDTWO
TENSIONE / VOLTAGE	V	230- 50/60	
POTENZA / POWER	KW	1,3	2,6
DEPRESSIONE / VACUUM	mBar	250	
PORTATA D'ARIA / MAX AIR FLOW	mc/h	190	380
MEDIA FILTRANTE / FILTER MEDIA	CELLULOSE		
SUP. FILTRANTE / FILTER SURFACE	cmq	300.000	
MOTORI / MOTORS	n.	1	2
LIVELLO SONORO / NOISE LEVEL	mm	40	2X40
BOCCA ASPIRANTE / INTAKE OPENING	Kg	25	28
PESO / WEIGHT	cm	30X30X72	
DIMENSIONI / DIMENSIONS			

(\*) without packaging



## 1.10 Warranty

DEPURECO guarantees this model for 12 months from the date of purchase indicated in the receipt upon delivery of the product.

The warranty is null and void in the event that the vacuum is repaired by unauthorised third parties, equipment, accessories or components not supplied or not authorised by DEPURECO are used or the serial number is removed (during the warranty period).

During the warranty period, DEPURECO undertakes to repair or replace free of charge parts and components, which prove to have manufacturing defects.

Repairs are made solely at our premises or in specific Service centres and must be delivered ex works (transport costs are charged to the purchaser, unless otherwise agreed upon).

The warranty does not cover cleaning of operating elements.

The purchase receipt must be shown to the authorised technical personnel carrying out the repair and must accompany the vacuum during its shipment.

Defects that are not evidently due to materials or manufacturing will be examined solely at our premises or at a specific Technical Service Centre.

Should the complaint be unjustified, all repair and/or replacement expenses shall be charged to the purchaser.

The following are excluded from the warranty: accidental damage due to transport, negligence, abnormal use, improper use, non-compliance with the instructions contained in this booklet or arising from phenomena that do not depend on normal use/operation of the vacuum.

DEPURECO shall not be held liable for any injuries to persons or damage to objects caused by misuse or improper use of the vacuum.

Any dispute will be heard by the Court of Turin (Italy).



Protect your purchases by joining the exclusive “warranty plus” program  
Go to [www.depureco.com](http://www.depureco.com) , fill in the form to extend the warranty up to 24 months.



**If you have any doubt do not act by yourself!**

**Please call your retailer**





## 2. SAFETY SECTION

### 2.1 Information on safety



In compliance with Italian Legislative Decree 81/08 and subsequent additions and amendments, the Safety Manager is obliged to educate, inform and train workers on the risks related to the use of the vacuum, in order for them to be able to protect their own and others' safety.

Failure to comply with basic safety standards and precautions can cause accidents during use, maintenance and repairs of the vacuum. Accidents can frequently be avoided by recognising potentially hazardous situations before they occur. Adequate training is crucial to this end.

DEPURECO shall not be held liable for accidents or damage due to the improper use of the vacuum by untrained personnel or to failure to comply, even partially, with the occupational safety standards and intervention procedures contained in this manual.

Safety warnings and precautions are indicated in this manual as well as on the product itself. Operators must pay special attention to these hazard warnings to prevent accidents with serious consequences for themselves and other people.

Safety messages are emphasised by the following symbol:



**Attention!**

**Failure to comply with these messages can cause injuries to the operator.**



**Attention!**

**Failure to comply with these messages can cause damage to the vacuum.**



**Attention!**

**Failure to comply with these messages can cause damage to the environment.**

DEPURECO designs and manufactures its equipment and accessories with care, identifying and compensating possible risks related to their use. In the event that equipment, procedures, work methods or techniques not expressly provided for by DEPURECO are used, it is crucial to ensure beforehand that there are no dangers for oneself and the others, notwithstanding that DEPURECO shall not be held liable.



### **Use only original DEPURECO replacement parts**

Depureco declines all responsibility  
for the use of non-original spare parts.



## 2.2 Safety requirements



### **Attention!**

The indications below are important to prevent hazards that can occur while operating the vacuum. However, they cannot replace the expertise and common sense of the operators as an overall framework for accident prevention.

Every section lists further safety requirements specific for the various operations.

## CAUTION!

- This vacuum can only be used by adequately trained adults.
- This vacuum is suitable for industrial use, such as: factories, warehouses, workshops.
- The equipment must be electrically connected to a mains equipped with efficient earthing.
- This vacuum is not intended to be used in corrosive or explosive environments.
- Keep the vacuum clear from foreign bodies, such as debris, oil, tools and other objects that could damage its operation and cause injuries.
- Avoid using flammable or toxic solvents, such as petrol, benzene, ether and alcohol for cleaning operations.
- Avoid prolonged contact with solvents and inhaling their vapours.
- Avoid using it in the proximity of naked flames or heat sources; ensure suitable ventilation.
- Do not, under any circumstance, use the vacuum without a filter.
- Do not vacuum lit cigarette butts: they could ignite the filter.
- Do not vacuum petrol or flammable liquids in general.
- Ensure that all the guards and protection devices are in place and that all the safety devices are properly installed and efficient.
- Do not wear loose or baggy clothing, such as ties, scarves, ripped clothes that could get easily caught or trapped in the vacuum.
- Do not open the refuse collection container while the vacuum is operating.
- Never put your hands inside the container's positioning guides: movement of the lifting handle can cause crushing of the fingers.
- Extensions, press-fit plugs and adapters are prohibited.
- Do not climb on the vacuum.
- Do not touch electric wires, switches, buttons, etc., with wet hands.
- Periodically verify the integrity of the power cord.
- When using the industrial vacuum, some components (motor terminal box, motor body in particular) can reach high temperatures.
- During the operations to restore original work conditions, the personnel in charge must ensure at the end of the procedure, normal operating and safety conditions of the vacuum and, in particular, of the safety devices and protective guards involved in the operation.



- In the event that the Customer installs a tool not supplied by DEPURECO on the vacuum, it is essential to verify that the safety requirements of Machinery Directive 2006/42/CE are met, notwithstanding that DEPURECO shall not be held liable for problems caused by the use of that part.
- Structural damage, alterations or improper repairs can modify the protective capacity of the vacuum, thereby nullifying this certification and releasing DEPURECO from any liability.
- This manual must always be kept at hand for consultation on the operating cycle and for clarifying any doubts.
- In the event it is lost or damaged, request another copy from DEPURECO.



**Attention!**

**This vacuum can contain harmful dust.**

**Emptying and maintenance procedures, including the disposal of the dust collection containers, must be carried out only by specialised personnel wearing suitable personal protective equipment.**

**Do not activate without a complete filtering system.**

## **2.3 Safety plates and symbols**

Plates with safety symbols and messages are applied to the vacuum and its packaging. These pages show their precise location and the nature of the hazard.



**Attention!**

**Ensure that all safety messages are perfectly legible.**

**Clean them with a cloth, water and soap. Do not use solvents, naphtha or petrol.**

**Replace damaged plates requesting them from DEPURECO.**

**In the event that a plate is located on a piece that is replaced, ensure that a new plate is affixed to the new piece.**



## 2.4 Residual risks

DEPURECO recommends complying with the instructions, procedures and recommendations in this manual and with the safety standards in force. DEPURECO also recommends using suitable personal protective equipment as well as the protection devices integrated in the vacuum.

The residual risks analysed on the vacuum and/or its components can be:

### **Electrical risks during maintenance on live parts**

Pursuant to Italian Legislative Decree 81/08 – articles from 80 to 87 – it is prohibited to operate on live parts, notwithstanding the exceptions set forth by said Legislative Decree.

### **Risk of improper use in presence of liquid, explosive and flammable substances**

The vacuum must not be used in environments containing liquid substances or liquids that can evaporate at room temperature, flammable powders and gas.

### **Risks related to operation in humid environments**

Comply with the limitations indicated in this manual, in section 1.7 “Allowed environmental conditions”.

### **Risk of crushing the upper limbs.**

A safety pictogram on the vacuum warns about this hazard.

### **Risks of misinterpretation of safety pictograms**

With reference to risk analysis and identification, DEPURECO has installed hazard labels on the vacuum, in compliance with the standard concerning graphic symbols.

The user must immediately replace any safety plate made illegible due to wear or damage.



#### **Attention!**

**It is strictly prohibited to remove the safety plates from the vacuum and/or its components and packaging.**

**DEPURECO shall not be held liable for the vacuum's safety in the event of failure to comply with this prohibition.**



### 3. HANDLING, UNPACKING

#### 3.1 Handling

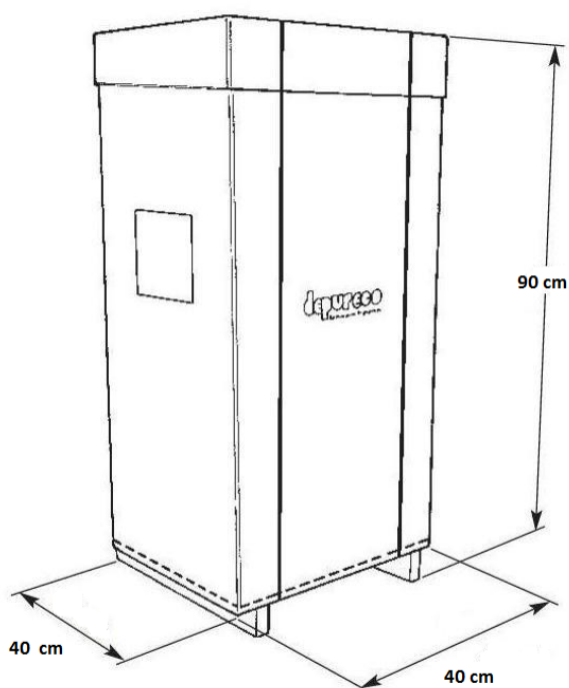


**Attention!**

The instructions for transporting and unpacking the vacuum correctly are shown also on the packaging.

The instructions below also include the operations to be carried out in the event that the vacuum must be packed or unpacked again for subsequent transport.

Dimensions of the packed vacuum:



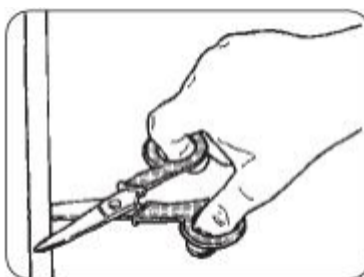
The vacuum must be lifted and handled only using a forklift whose load bearing capacity is suited to the weight.

When using a forklift, lift the load 200 mm off the ground and swing backwards. Always keep the height of the working environment in mind when lifting loads. Before starting any movement, ensure that the area is cleared and that there are no moving objects on the packaging. For lifting and handling operations, comply with the occupational safety standards in force and with the normal forklift driving instructions.

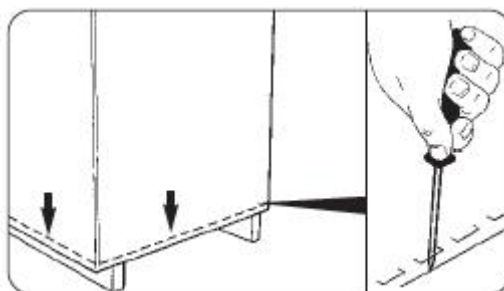


## 3.2 Unpacking

Cut and remove the two packaging fasteners,



with a screwdriver remove the staples that secure the carton to the pallet



remove the carton





## 4. OPERATION SECTION

### 4.1 Description of the controls



**Attention!**

The vacuum can be used solely by authorised personnel after having read these use and maintenance instructions.

The user of the equipment and the maintenance technician, who carry out interventions

on the vacuum, must be adequately educated, informed and trained, in compliance with the occupational safety standards in force and, during the various operations, must wear personal protective equipment (PPE), such as safety footwear, gloves, protective goggles, mask, etc. The user must comply with the provisions in force concerning extracted materials and their disposal.

### 4.2 Operating cycle

Ensure that the power cord is intact and in perfect state.



**Attention!**

Before inserting the plug, ensure that the voltage of the power supply line corresponds to that indicated on the vacuum's identification plate.

Ensure that the power cable is properly connected to the supply line.

Ensure that the hose is inserted properly on the suction inlet.



**Attention!**

Do not shift the vacuum while it is operating.



**Attention!**

If dust escapes from the exhaust the filter may be broken.

In this case, stop the vacuum immediately and verify the cause.



To move the vacuum use the special grip on the top part.



**Warning!**

During operation prevent the hose from rolling up or bending.



In case the filter clog indicator is lightened be sure that:

1. The main suction lines is not clogged
2. Verify the status of the filter cartridge.



**Warning!**

Do not, under any circumstance, use the machine with a clogged filter.



**Attention!**

If the vacuum is not working properly after having cleaned the filter, it can mean that the filter is clogged and needs to be replaced.

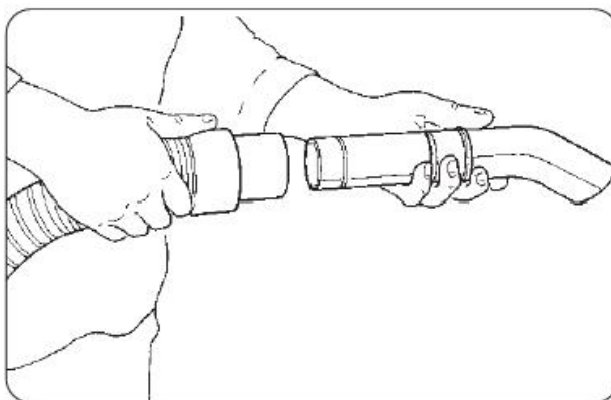




### 4.3 Flexible hose and accessories connection



connect the opposite side of the hose to the extraction Y connection of the welding torch



Note: the hose with its terminals and the suction accessories are not included as STANDARD. Contact your dealer (or DEPURECO) for information regarding the various types of OPTIONAL that can be used on this specific model.

**The following operation must be carried out by a qualified electrician.**

Ensure that the power supply line corresponds to the voltage and frequency indicated on the identification plate and that it is efficiently earthed.

The socket to power the vacuum must be protected by a mains disconnect switch in compliance with EU standards.

Insert the plug (standard supply) into the socket.

**Attention!**

**Do not insert the plug into the socket with wet hands.**

**The use of extensions is not allowed.**



#### 4.4 Emptying the dust tank



Unfasten the two latches on the side and pull up the upper part of the unit.

- empty the vacuum container in the dedicated container and dispose of it in compliance with the standards in force in the country of use



**Attention!**

In the event that the container weighs over 15 Kg, have somebody help you.



**Attention!**

Waste must be disposed of in compliance with the standards in force in the country of use – for Italy with Legislative Decree 152/2006 and subsequent amendments and additions.

In the event of use with class M and H dusts, these must be conveyed to a special plastic bag.



## 5. MAINTENANCE SECTION



### **Attention!**

**Special vacuum maintenance must be carried out solely by specialised technicians authorised by the DEPURECO dealer.**

### 5.1 Information notes

This section describes the verifications and routine maintenance operations required to ensure proper vacuum operation.

Maximum reliability and minimum maintenance costs are the result of a planned maintenance and inspection schedule carefully followed throughout the entire lifespan of the vacuum.

Observe the set maintenance intervals and schedule the interventions according to specific requirements in relation with the vacuum production cycle.

Always use tools that are in perfect state and that are specifically intended for the operation to be carried out; the use of inadequate or inefficient tools can cause serious damage.

Any other intervention required to eliminate faults or malfunctions must be expressly authorised by the manufacturer.

In these cases, always communicate the vacuum identification data - see para. 1.4 of this manual.

For important repairs, refer to the authorised dealer, whose specialised personnel has the technological expertise and is always available for prompt interventions.

As for interventions carried out by the user, the vacuum must be disassembled, cleaned and maintained, where possible, in such a way as to prevent hazards to the maintenance personnel and to third parties. Suitable precautions include decontamination prior to disassembly, forced filtered ventilation of the room where the equipment is disassembled, cleaning the maintenance area and wearing suitable personal protective equipment.

Once every three months (or more frequently, according to the operating cycle and the conditions of use), the manufacturer or a qualified technician must check the filters, ensuring that they are not damaged and must check the proper operation of the control devices.

Should maintenance operations or repairs be carried out, all contaminated objects must be adequately cleaned, placed in waterproof bags and disposed of in compliance with the standards in force.



## 5.2 General safety regulations



### Attention!

All the operations described above must be carried out with the cable disconnected from the supply line.

Before starting any maintenance or cleaning operation, wear suitable PPE (protective clothing, goggles and/or gloves, etc.) according to the work to be done.



Place a sign on the vacuum with the message:

**“MACHINE UNDER MAINTENANCE  
DO NOT START”**



Before resuming operation, verify the entire system according to start-up procedures. Run a few trial operating cycles after every maintenance operation to ensure proper machine operation.

Failure to comply with these precautions can cause serious injuries to the personnel.

Maintenance operations must be carried out by trained technicians specialised in the following sectors:

- Mechanical maintenance
- Electrical maintenance

It is the Safety Manager's duty to ensure the professionalism and skills of these technicians.

**Before starting any maintenance operation, the Safety Manager must:**

- Keep unauthorised personnel out of the work area.



- ☐ Ensure that the necessary tools are in good conditions and readily available to the maintenance technician.
- ☐ Ensure that the maintenance technician is equipped with the personal protective equipment required for the specific operation (gloves, goggles, shoes, mask, etc.).
- ☐ Ensure that the maintenance technician has carefully read the instructions contained in this manual and knows the operation of the vacuum and its components perfectly well.

- Ensure that there is enough light and, if necessary, provide 24 Volt torches.

**Before starting any maintenance operation, the Maintenance technician must:**

- disconnect all power supplies and safely lock the vacuum and
- disconnect the compressed air supply (where available).



**Attention!**

**If working with the power on is absolutely necessary, when provided by Legislative Decree 81/08, the maintenance technician must remain at a safe distance, have stop buttons at hand and must never place his hands into the discharge volume.**

Upon completing the intervention and before starting up again, the maintenance technician must verify the efficiency of the safety devices and the integrity of the protective guards.

Interventions on the motors or on other electrical components must only be carried out by the specially trained electrical maintenance technician authorised by the Safety Manager.



**Attention!**

**After every maintenance operation, the Safety Manager is obliged to ensure the safety conditions of the vacuum and its protection devices.**

**Before every work shift**

- Check that the power cord and plug are not damaged: replace immediately if it shows signs of wear, using a cable of the same type (information c/o DEPURECO) - this operation requires the skills of an electrician.
- Ensure the integrity of the safety symbols (pictograms) applied to the vacuum.
- Ensure that the refuse collection container is empty and properly locked under the vacuum.
- Ensure the correct performance of the filter by checking the indicator or the vacuum gauge.
- Ensure the integrity of the suction hose and of the accessories to be used.



**Attention!**

**A perforated hose reduces suction power and may let dust spread in the air.**



## 5.3 Replacing the filter

### 5.3.1 Primary filter



**Attention!**  
Wear appropriate PPE (dust mask, latex gloves, goggles, etc.).

To replace the filter, proceed as follows:



- turn off the machine
- disconnect the vacuum from electric power supply
- remove the container and the motor deck as described. (1□2□3□4)
- from the bottom of the filter chamber unscrew the fasten bolt and pull out the filter cartridge (5□6)



### 5.3.2 Hepa filter



UNSCREW THE  
FOUR FASTENER  
AND REMOVE THE  
BRACKET.





-remove the filter, place it inside a plastic bag, close it and **dispose of it in compliance with the laws in force**, according to the extracted material.

**To assemble the new filter**, proceed in reverse order:

- Insert the new filter in the filter housing and pay attention that the upper part rest perfectly on the base of the upper frame of the filter chamber.
- Insert the fastener stick in the cartridge fixing hole and fasten it.

**USE ONLY GENUINE DEPURECO FILTERS**

## 5.4 Troubleshooting

DETECTED ANOMALY	POSSIBLE CAUSE	SUGGESTED SOLUTION
The vacuum does not start	- No power supply	<ul style="list-style-type: none"><li>- Check that there is voltage in the socket</li><li>- Check the electric plug and power cord</li><li>- Contact the DEPURECO technical service centre</li></ul>
Motor excessively noisy	- Faulty motor	<ul style="list-style-type: none"><li>- Contact the DEPURECO technical service centre</li></ul>





## 5.5 Scrapping



To prevent damaging the environment in the event of scrapping, all the components of the vacuum must be disposed of responsibly in suitable landfills and in compliance with the standards in force - for Italy, Legislative Decree 152/2006 and subsequent amendments and additions.

Before scrapping the machine, the plastic and rubber materials must be separated from the electrical material.



### **Correct disposal of this product (electrical and electronic waste)**

Electric and electronic components of this product must be disposed of in accordance with Italian Legislative Decree 151/2005 and subsequent amendments and additions. (Directive 2002/96/CE regarding WEEE - Waste Electrical and Electronic Equipment)

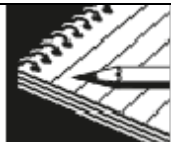


The parts of the vacuum made of plastic material, aluminium and steel can be recycled in appropriate centres.



**If you have any doubt do not act by yourself!**

**Please call your retailer**



## MAINTENANCE LOG

**INTERVENTION 1**

Date

Technical Assistance

Type of intervention

*Signature*

## INTERVENTION 2

Date

Technical Assistance

Type of intervention

Signature