



21" Metalworking Station

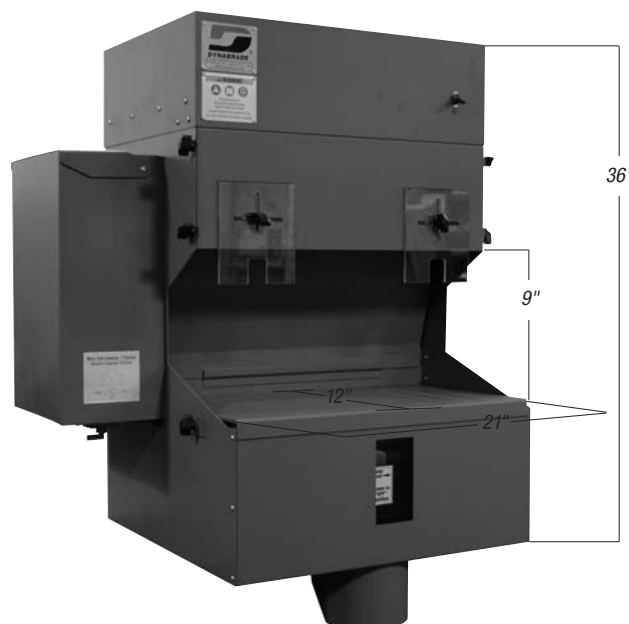
Operating Manual

Model:

64100 (120 Volt AC)

Work Surface: 21" Long x 12" Deep.

**Keep workplace area free
of contaminants while deburring.**



SAFETY LEGEND

	⚠ WARNING Read and understand tool manual before work starts to reduce risk of injury to operator, visitors, and tool.	⚠ WARNING Practice safety requirements. Work alert, have proper attire, and do not operate tools under the influence of alcohol or drugs.	
	⚠ WARNING Eye protection must be worn at all times, eye protection to conform to ANSI Z87.1.	⚠ WARNING Ear protection to be worn when exposure to sound, exceeds the limits of applicable Federal, State or local statutes, ordinances and/or regulations.	
	⚠ WARNING Respiratory protection to be used when exposed to contaminants that exceed the applicable threshold limit values required by law.	⚠ WARNING Electric shock hazard. Avoid bodily contact with grounded objects, bodies of water. Do not damage cord set.	

IMPORTANT SAFETY INSTRUCTIONS

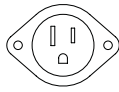
When operating this equipment, basic precautions should always be strictly followed including the instructions listed below:

WET DEBURRING STATION SAFETY INSTRUCTIONS

1. Always use a grounded power supply. There is an increased risk of electric shock with an ungrounded power supply.
2. Don't expose to rain or wet conditions. There is an increased risk of electric shock if the switch, cord or motor are wet.
3. Do not abuse the power cord. Never use the cord to move the station. Never use the cord to pull the plug from an outlet. A damaged cord increases the risk of electric shock.
4. Use caution when opening or closing guards, screens, etc. Switch power off and unplug cord before opening. Remove all work pieces and tools before opening to avoid injury. Keep fingers and hands clear when closing to avoid injury.
5. Never use to exhaust chemical vapors
6. Vibration may occur if unit is unlevel.
7. Unplug power cord when accessing blower compartment area.
8. Power switch must be off when servicing filter.

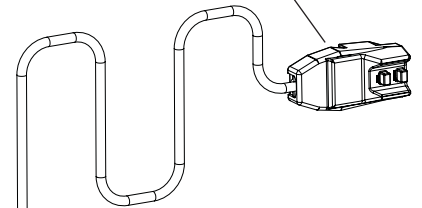
WET DEBURRING STATION: FEATURES & CONTROLS

AUXILIARY OUTLET/115V
(Accessed by removing upper panel)



POWER SWITCH
(Auxiliary power outlet switch)

GFI/POWER SUPPLY



UPPER ACCESS PANEL

DEBRIS SHIELD

FILTER ACCESS PANEL

**REMOVABLE
WORK SURFACE**

**WATER LEVEL
WINDOW**

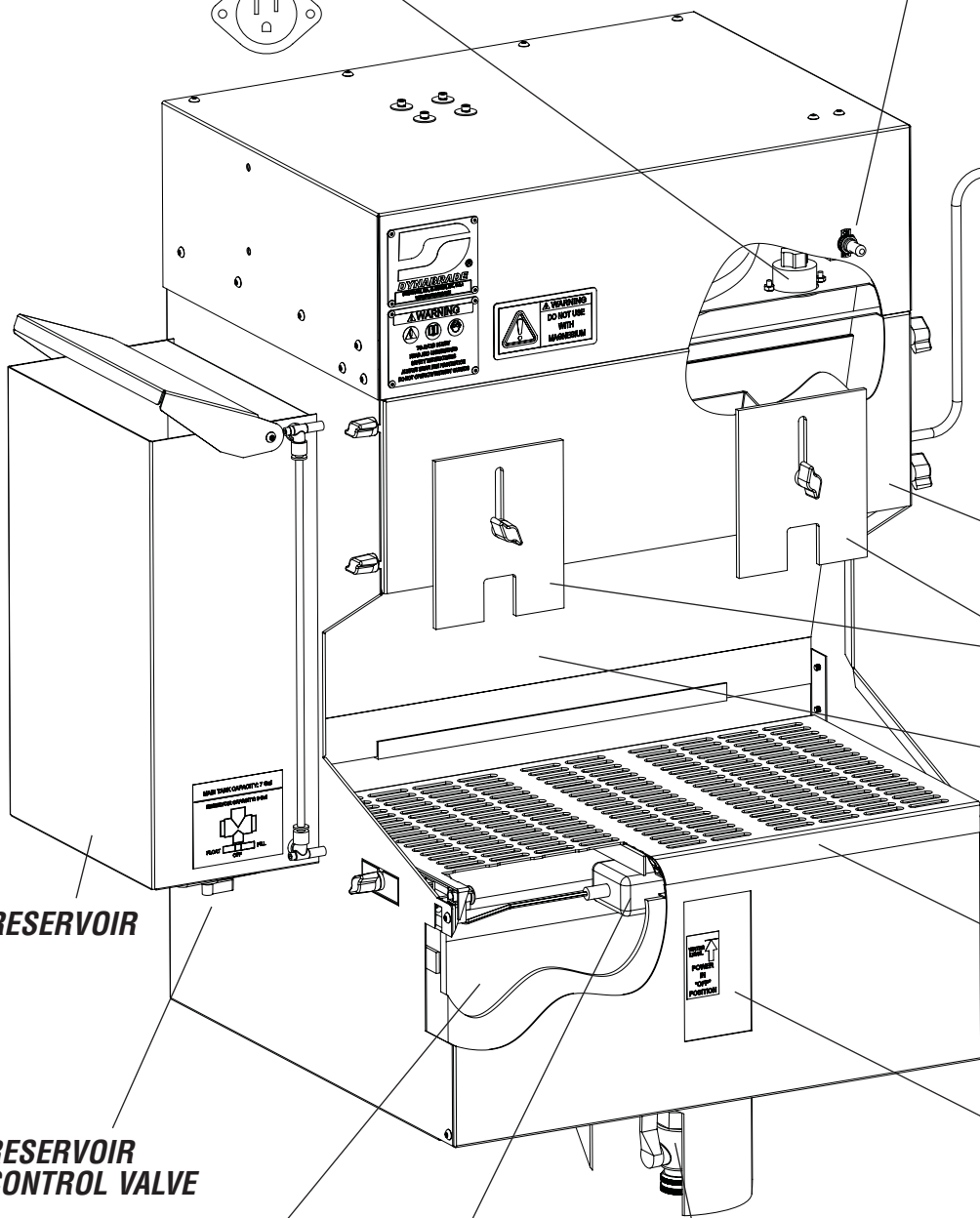
RESERVOIR

**RESERVOIR
CONTROL VALVE**

MAIN TANK

FLOAT ASSEMBLY

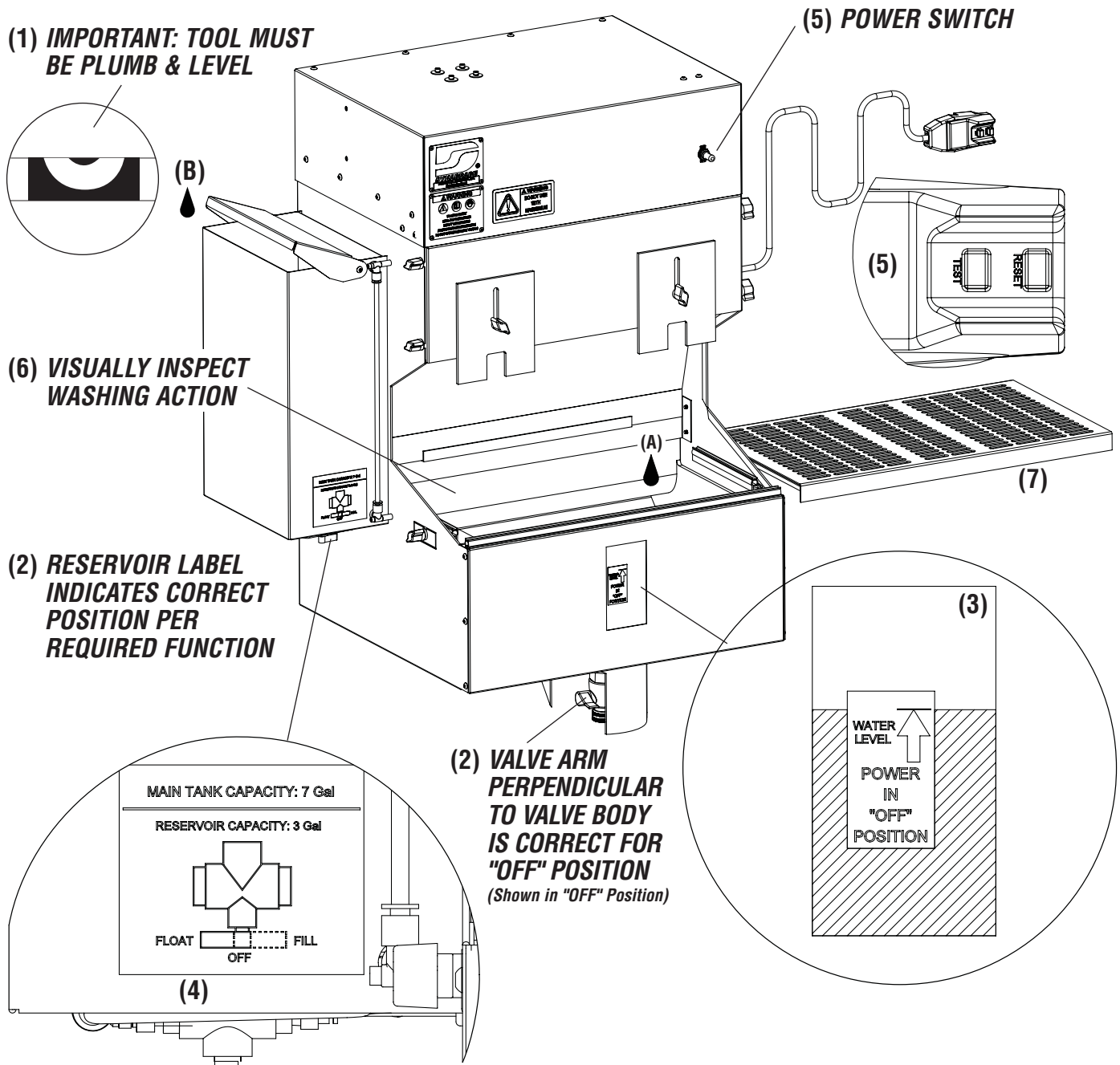
CLEAN OUT VALVE



WET DEBURRING STATION: SET-UP

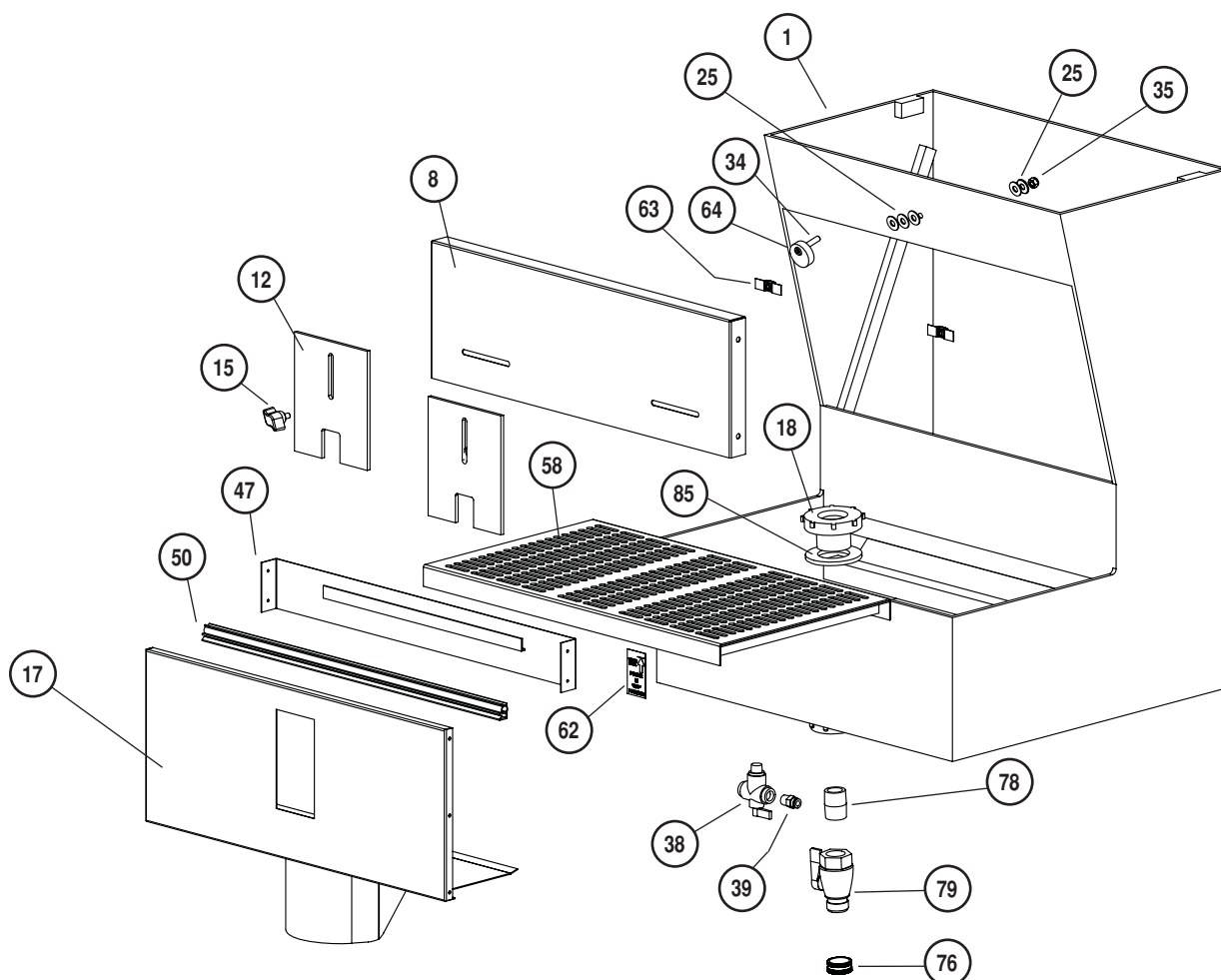
SET-UP INSTRUCTIONS

1. Before operating your 21" Metalworking Station, you must first make sure your tool is plumb and level. Failure to do so may impede proper function of the tool.
 2. Be sure that both your reservoir valve and your main tank valve are in the "OFF" position.
 3. The next step is to add water to your station. Fill the main acrylic tank (A) with water until you reach the line that indicates the proper level in the "Power off" position. Continue by adding water to the reservoir (B), approximately 3/4" to the top.
 4. Switch reservoir valve to "Float" position.
 5. Plug in the 21" Metalworking Station. Be sure to push the reset button on the GFI plug before turning system on. Turn power switch on.
- Note: Auxiliary outlet power is controlled by the main power switch.**
6. Continue by checking for vigorous washing action which is visible just below filter access panel as noted.
 7. Install work surface.

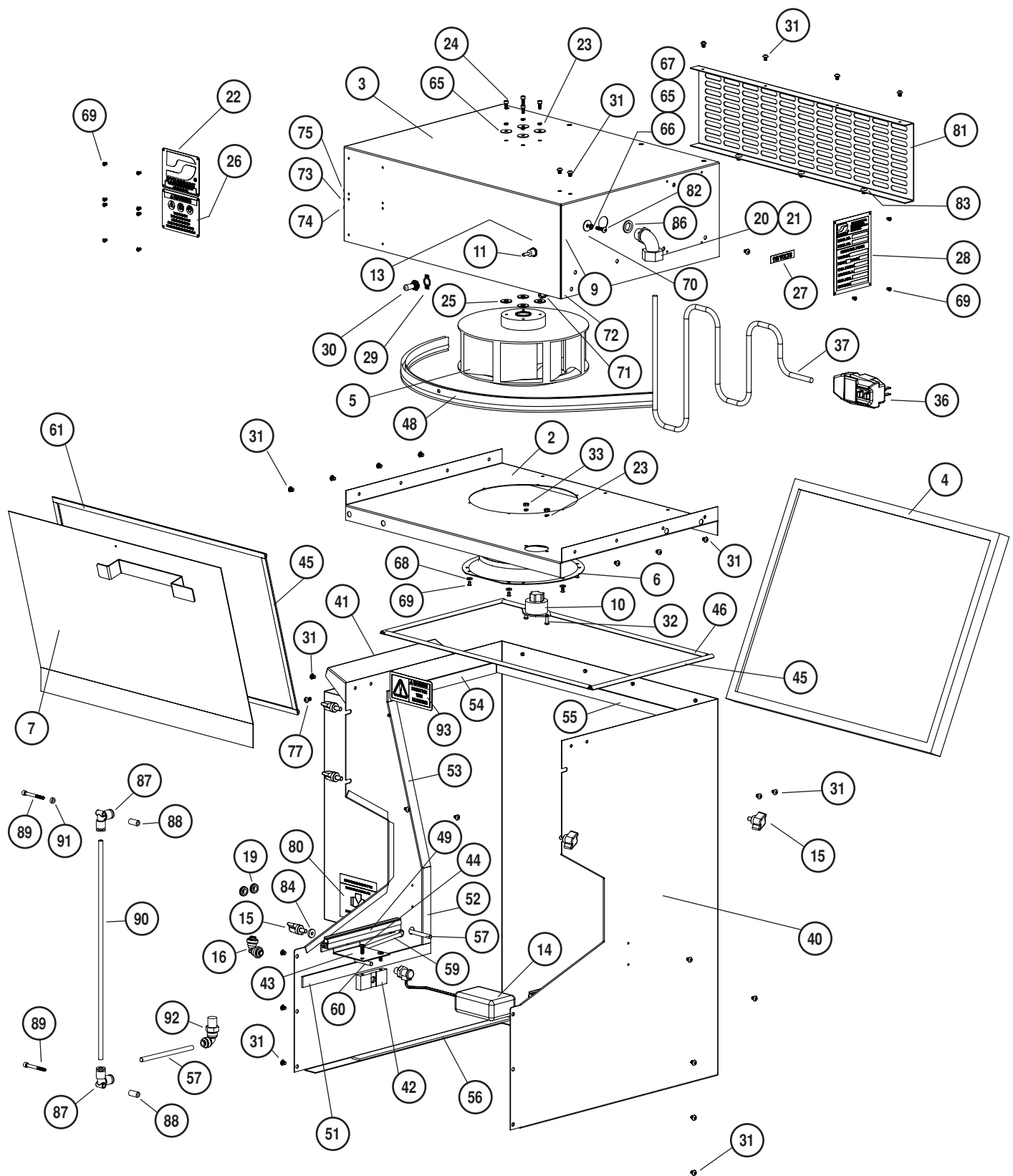


COMPLETE ASSEMBLY DIAGRAM/REPLACEMENT PARTS

PART #	DESCRIPTION				
1	64112	Scroll Assembly	32	95007	Screw
2	64114	Impeller Inlet Base	33	95294	Nut
3	64115	Hood/Scroll Assembly	34	97015	Screw
4	64116	Filter	35	98594	Lock Nut
5	64117	Impeller	36	64138	GFCI Plug
6	64118	Impeller Inlet Ring	37	98418	Cord
7	64121	Access Panel/Cord Mount Assy.	38	64140	3-Way Valve
8	64122	Panel & Bracket Assembly	39	97825	Quick Connect
9	64123	Capacitor	40	64113	Shell Assembly
10	64124	Receptacle	41	64141	Reservoir Lid
11	98369	Switch w/ Nut Assembly	42	64134	Float Mounting Head
12	64125	Debris Shield	43	64133	Bracket
13	64126	Capacitor Bracket	44	97160	Screw
14	64128	Float Valve	45	64144	Seal
15	64961	Knob	46	64163	Seal
16	64129	Fitting	47	64120	Support Bracket
17	64130	Front Panel	48	64147	Edge Trim
18	64131	Bulk Head Assembly	49	64149	Edge Trim
19	64132	Grommet	50	64150	Edge Trim
20	98746	Lock Nut	51	64152	Neoprene Strip
21	98709	Elbow	52	64153	Neoprene Strip
22	66084	Description Plate	53	64154	Neoprene Strip
23	01211	Lock Washer	54	64155	Neoprene Strip
24	01678	Screw	55	64156	Neoprene Strip
25	95166	Washer	56	64157	Neoprene Strip
26	64930	Warning Label	57	64158	Tubing
27	98421	Voltage Label	58	64160	Work Surface Assembly
28	65059	Electrical Specification Label	59	64159	Tubing
29	98500	On-Off Plate	60	64161	Tubing
30	98499	Switch Protector	61	64145	Seal
31	96492	Screw	62	64162	Water Level Label
			63	98598	Nut
			64	64164	Locking Cam
			65	97370	Washer
			66	97301	Lock Washer
			67	97213	Nut
			68	97063	Washer
			69	97062	Rivet
			70	98607	Ring Terminal
			71	98613	Barrel Terminal
			72	98616	Wire Connect
			73	98405	Black Wire
			74	98408	White Wire
			75	98407	Green Wire
			76	97362	Cap/Gasket
			77	97377	Screw
			78	97365	Nipple
			79	97364	Valve
			80	64165	Capacity Label
			81	64127	Exhaust Grate
			82	97379	Screw
			83	97383	Screw
			84	95417	Washer
			85	64137	Gasket
			86	98751	Sealing Ring
			87	97244	Fitting
			88	98438	Spacer
			89	98437	Screw
			90	98439	Tubing
			91	98440	Spacer
			92	98441	90° Quick Connect
			93	97102	Warning Label



COMPLETE ASSEMBLY DIAGRAM/REPLACEMENT PARTS



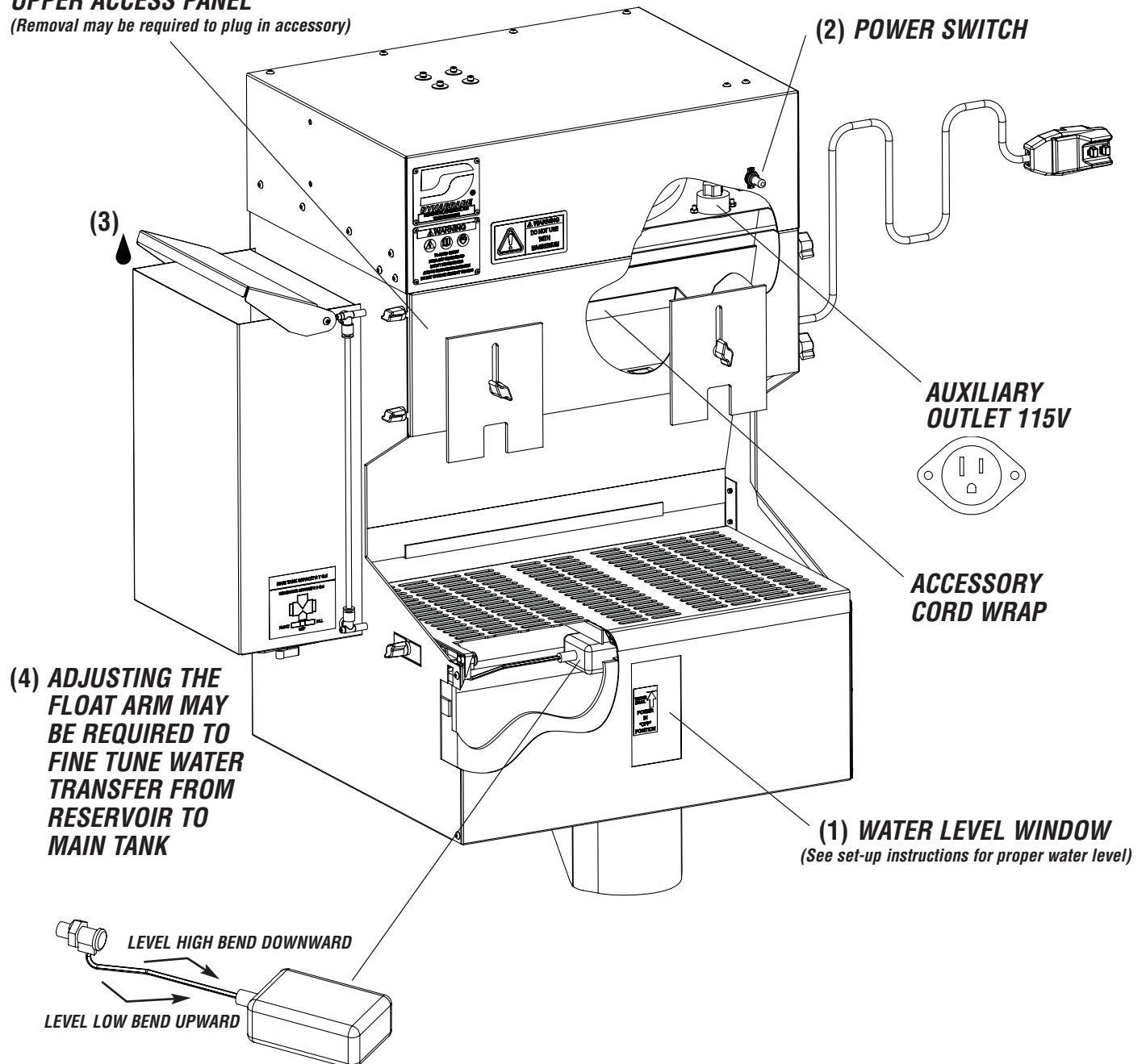
WET DEBURRING STATION: OPERATION

OPERATION INSTRUCTIONS

1. Before operation starts, you must first make sure that the main tank is at its proper water level in the "Power off" position. If water level is low add water to the main tank or, operate your reservoir valve to the fill position until desired level is reached as indicated on the label at the front of the machine. Continue by then switching reservoir valve to the "float" position.
2. Turn power switch on to start filtering action and begin work.
3. Check reservoir level every 8 hours and refill as necessary.
4. During operation, the float valve will transfer (Drip) water into the main tank from the reservoir to make up for evaporation. Turn power off after extended operation (Min 4 Hours) and re-check initial "Power off" water level. If low, carefully bend the brass rod on the float assembly to move float body up approximately 1/16". If "Power off" water level is high, bend the brass rod on the float assembly to move the float body down approximately 1/16". Re-check again after extended operation.

UPPER ACCESS PANEL

(Removal may be required to plug in accessory)

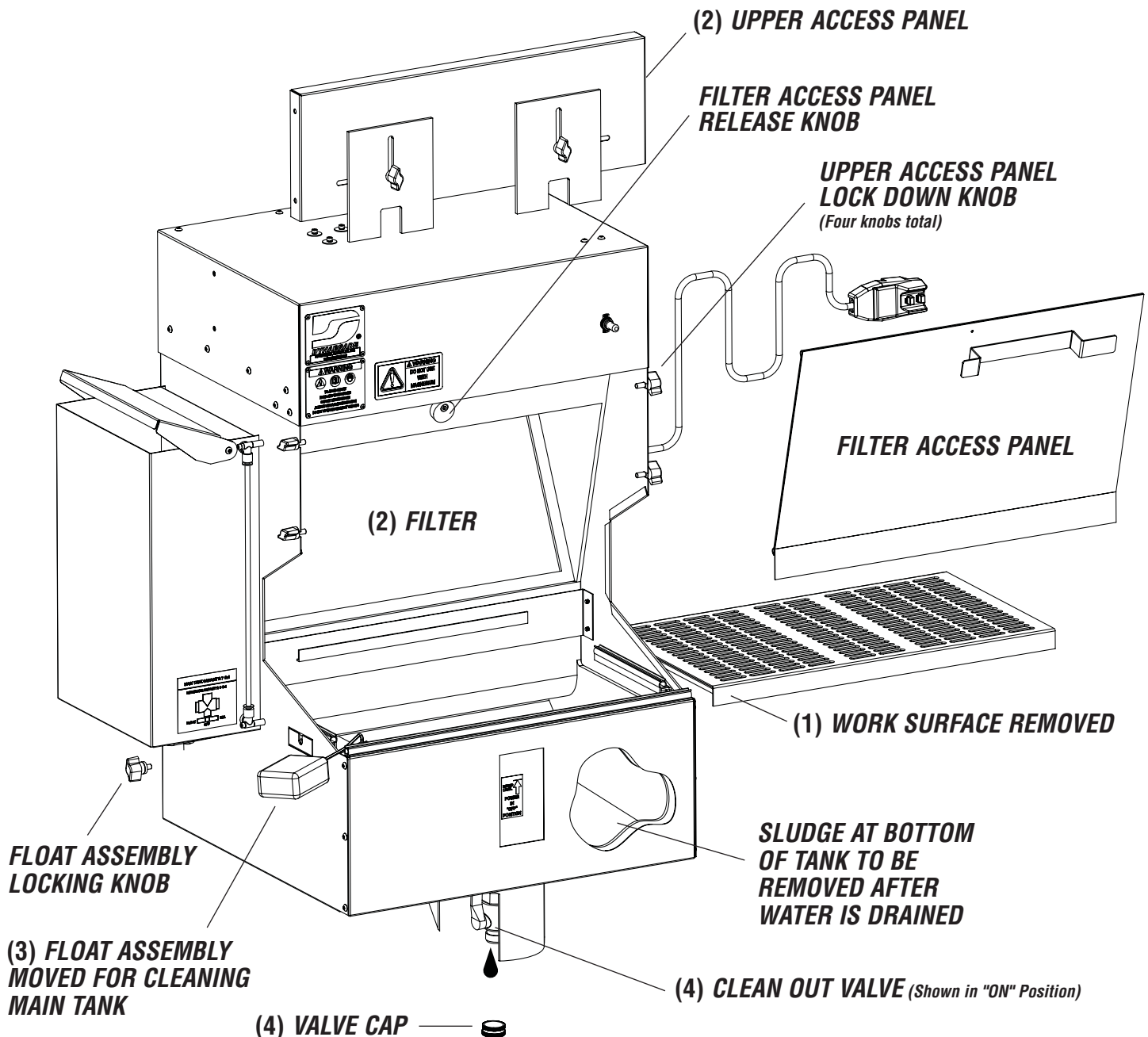


WET DEBURRING STATION: MAINTENANCE

MAINTENANCE INSTRUCTIONS

1. Before beginning maintenance on the 21" Metalworking Station, you must first unplug the GFI outlet from your main power source. Continue by unplugging any accessory and remove the work surface from the assembly. Also make sure to turn the reservoir valve to the "OFF" position.
2. Remove and set aside the upper access panel by loosening all four lock down knobs a full 2-3 full turns. Continue by turning the release cam and remove the filter access panel. Remove the filter and hose clean to remove any built up debris.
3. Now remove the float assembly by loosening the lock down knob. The float assembly should remain attached to all hose and just rest assembly over the tools edge as shown below. This should give you clear access to the main tank.
4. Making sure clean out valve is in the "OFF" position, remove the cap from the assembly. The valve provided hooks up to a female garden hose for ease of clean out. Turn valve lever to the "ON" position and drain tank. Remove the sludge and remainder of water from the bottom of the tank, making sure not to damage the acrylic tank while doing so. When tank is clean, turn valve back to the "off" position and re-cap assembly.

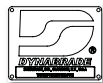
Re-assemble tool and refer to set-up instructions before operating the tool.



MACHINE SPECIFICATIONS

Model Number	Voltage	Phase	Frequency	Weight Pound (kg)	Width Inch (mm)	Depth Inch (mm)	Height Inch (mm)
64100	120	1	60 Hz	110 (50)	21 (533)	20 (508)	36 (914)

LABEL IDENTIFICATION



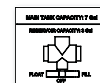
66048
Description Plate



64930
Warning Label



65059
Electrical Specification Label



64165
Capacity Label



64162
Water Level Label

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