**Operating Instructions**

1. **Do Not Restrict Air Flow at Pick-Up Nozzle. Allow at least 50% Air to Recovered Flux. (Overload Reset May Trip When Flow is Restricted.) Vacuum Will Automatically Restart When It Cools Down.**

2. **Empty Dust Drawer on a Regular Basis. Interval Will Vary With Usage.** (Typical is Once a Week.)

3. **Do Not Overfill Auxiliary Separator (i.e., FH-100, MS-1, PF-15000, etc.). This Will Cause Recoverable Flux to Be Drawn Into Dust Drawer.**

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**The Mighty-Mac**

**The E-TREME Vacuum System For Tough, Heavy-Duty Flux Recovery**

**Running Light Off Fuse On Manual Clean Repeat as Necessary.**

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**System Order List:***

1. @ MM-3000X/P OR MM-5000X/P (Vacuum)
2. @ FD-55 (Dust Drum) with LD-55 (Lid Assembly)
3. @ FH-100 OR HEATED FH-100 Hopper
4. *200 LBS. Capacity (Optional Electronic HI/LOW Level Sensor With Alarm, *Larger Hoppers, and Dual Inlets And/OR Dual Outlets Are Available)
5. @ MagSEP-100 (Magnetic Separator)
6. @ FCV-3000 (Flux Control Valve)
7. @ NZ-1 (Flux Pick-Up Nozzle)
8. @ VL-3000 (Vacuum Shut Off Valve)
9. @ DHK-55 (Dust Hose Kit)

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**Important Notes:**

1. **Vacuum Hoses Must Be Approximately Equal Lengths (i.e. 2 @ 25 FT.)**

2. **Recovery Hoses Must Be Approximately Equal Lengths (i.e. 2 @ 15 FT.)**

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**Heavy Dust Removal:**

For optimal heavy dust removal, order Teflon coated filters.

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**Note A -- Pallet:**

Customer provides a pallet for easy dust drum removal.

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**Mighty-Mac Vacuum Selection:**

**Use MM-3000X/P For...**

A) 50/60 Hz. Power Installations
B) Single Wire Welding On Each Head
C) Maximum 2" Vacuum Hose Per Head Is 30 FT.
D) Maximum 1 1/2" Recovery Hose Per Head Is 25 FT.

**Use MM-5000X/P For...**

A) 50 Hz. Power Installations With 2" Vacuum Hose Maximum of 30 FT. Per Head
B) 60 Hz. With 2" Vacuum Hose Over 50 FT. Per Head (Consult Factory For Maximum Length)
C) 1 1/2" Recovery Hose Over 25 FT. Per Head (Consult Factory For Maximum Length)
D) Twin Arc Welding Each Head (Not Tandem)

**Note:**

1. Dual System Not Recommended for Tandem or Triple Heads. Use One MM-3000X/P or MM-5000X/P Per Tandem Application.
2. MM-1500X/P Not Recommended for Dual Station.

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**BULLETIN: (Page 12) TB-MM708**

**FILE: 12-MMV~ 2 FH-100 MM X-P DRT 7-2-2008.CAD REvised: 2FH-100P.CAD (7-16-96 TB-MM294)**

**WELD ENGINEERING CO., INC**

**DRT 4-1-2011**