

VACTOR®

Manufacturing Inc.

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A variety of service parts require a final fit up and welding before being put into service. This guide is provided to identify where and how to weld as required. After installation all welds on the parts must be verified to be completed per the specifications.

Weld Size Minimum Requirements

Undercut should not exceed more than 25% of parent material thickness with 1/16" maximum depth.

Weld length is excluding crater minus zero and plus 25% on welds over 1", and minus zero plus 1/8" on welds under 1".

Weld can be oversized provided that they do not cause interference in assembly or distortion of the part.

Weld filler material must be suitable for the parts.

SERVICE PARTS

DATE: 1 February 2012

NOTICE



Follow recommended safety practices while performing all work. Refer to the Vactor/Guzzler Safety Manual for additional information.

This manual is available at: www.vactor.com

WARNING

Parts Not Fully Welded

Failure to properly install by welding appropriate pieces can cause failure, resulting in injury or damage to equipment.

Fit up and finish welding all parts before placing in service.

Consult the Vactor (EPG) Technical Service Hotline. In the USA or Canada Call:

877-DIAL EPG or 877-342-5374.

Outside the USA or Canada call 847-741-4330.

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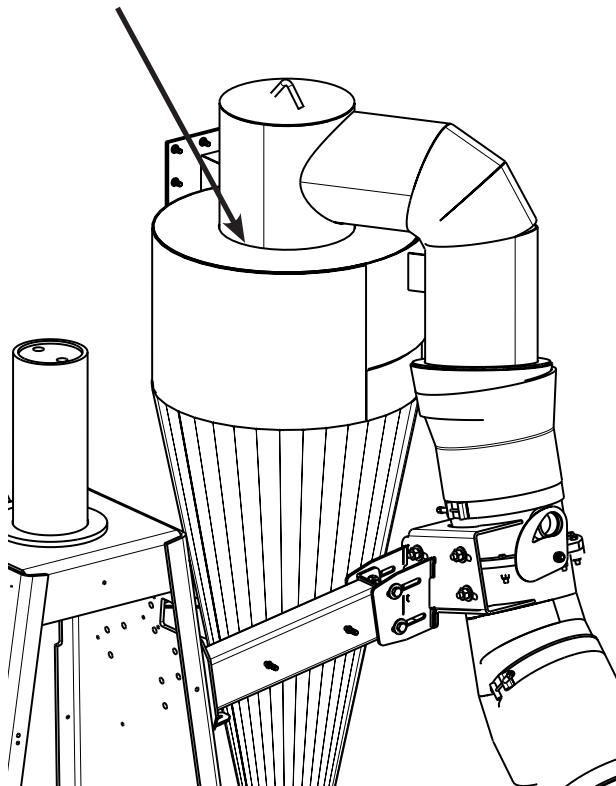
Porosity shall not exceed
.75" total in any 12" of weld
.69" total in any 11" of weld
.63" total in any 10" of weld
.56" total in any 9" of weld
.5" total in any 8" of weld
.44" total in any 7" of weld
.38" total in any 6" of weld
.31" total in any 5" of weld
.25" total in any 4" of weld
.19" total in any 3" of weld
.13" total in any 2" of weld
.06" total in any 1" of weld

Weld Size Minimum Requirements	
Base metal thickness (inches)	Minimum Weld Throat Size (in)
1/8 to 3/16	1/16
Over 3/16 to 1/4	1/8
Over 1/4 to 1/2	3/16
Over 1/2 to 3/4	1/4
Over 3/4 to 1 1/2	5/16
Over 1 1/2 to 2 1/4	3/8
Over 2 1/4 to 6	1/2
Over 6	5/8

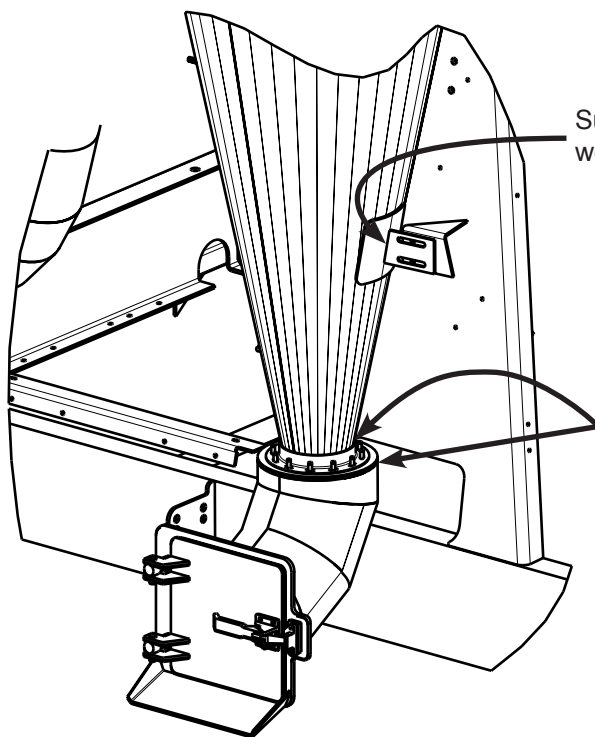
Revisions				
Rev.	Description	By	Date	ECN
0	Initial release	AC	12-18-2006	-
A	Added Guzzler pages	AC	8-21-2008	7678
B	Added hose reel frames	AC	6-10-2010	11892
C	Added elbows and final filters	AC	2-1-2012	15899

2100 Series cyclones

Cyclone receiver
weldment - weld
after final fit up.

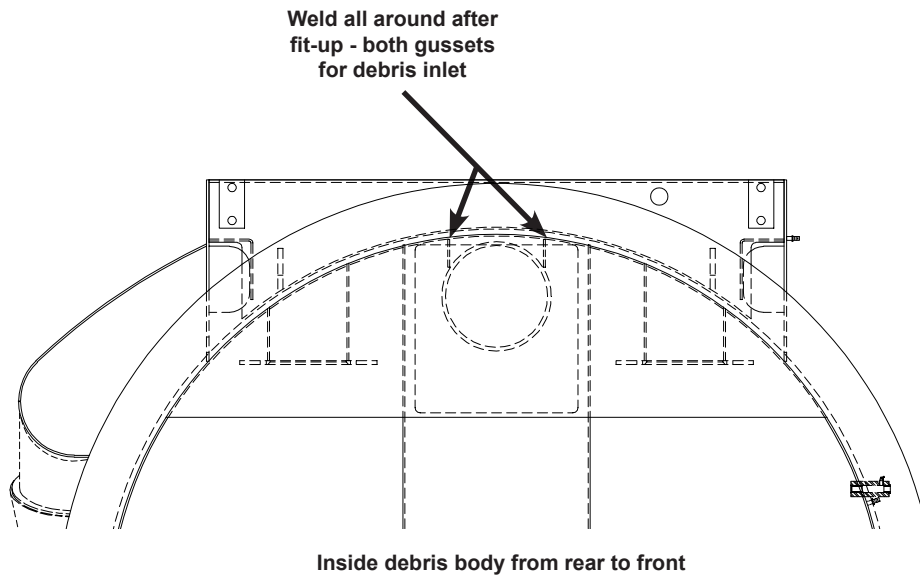
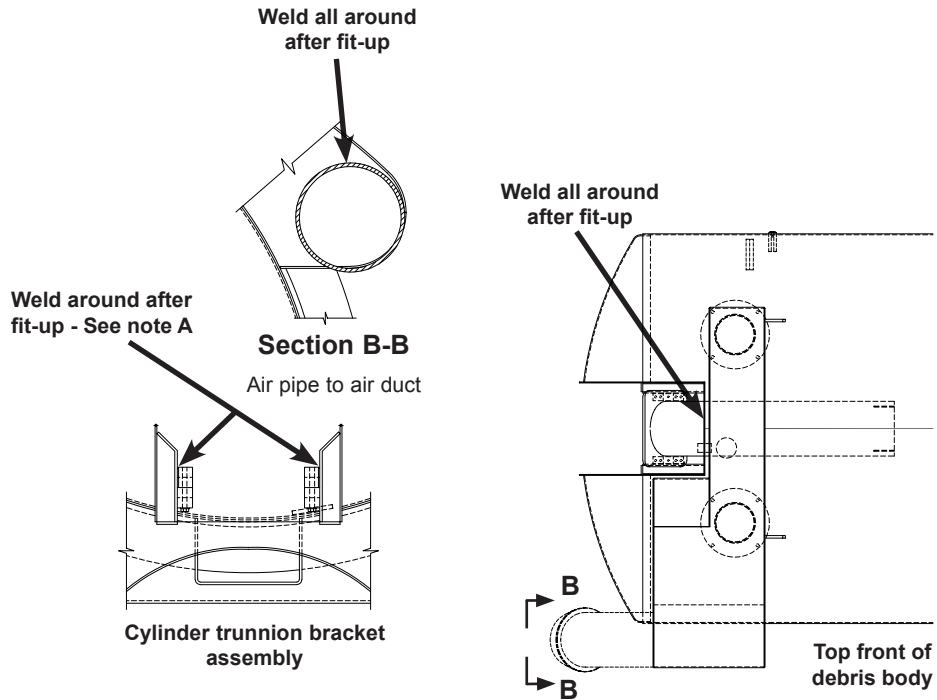


Support bracket -
weld after final fit up.



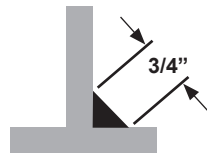
Cone and dust box
flanges - weld after
final fit up.

2100 Series debris body

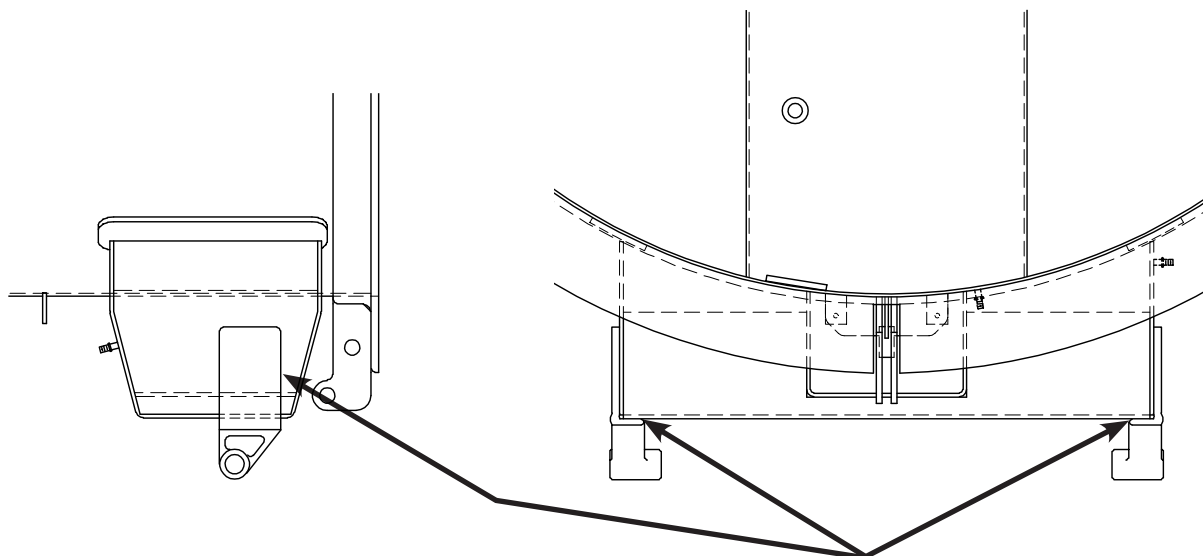


Notes

A 3/4" weld face



2100 Series debris body

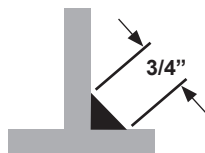


Both hinges - weld all around
after fit-up - See note A

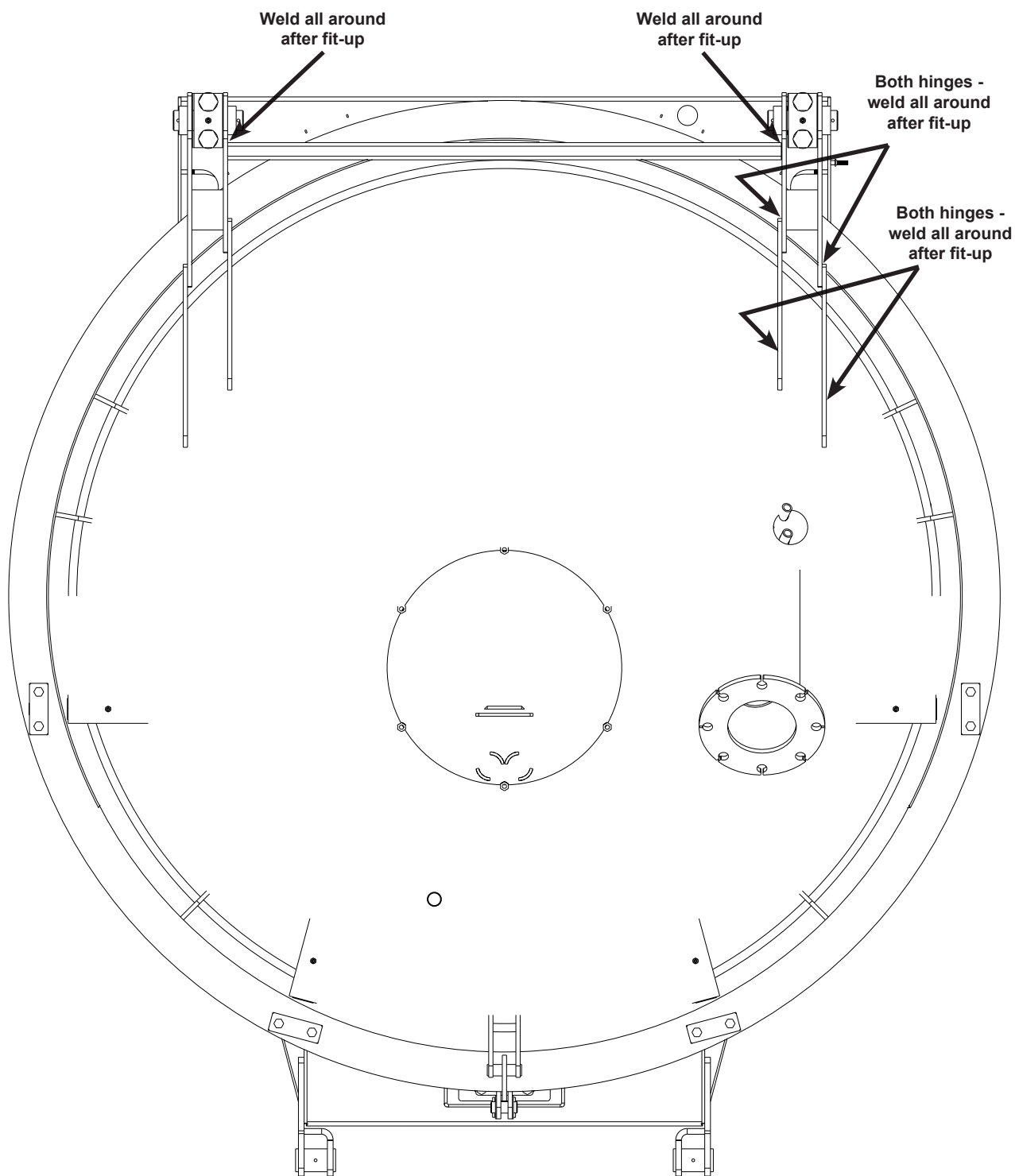
Rear of debris body - rear hinges

Notes

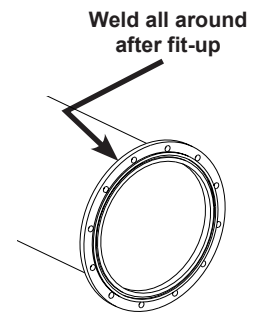
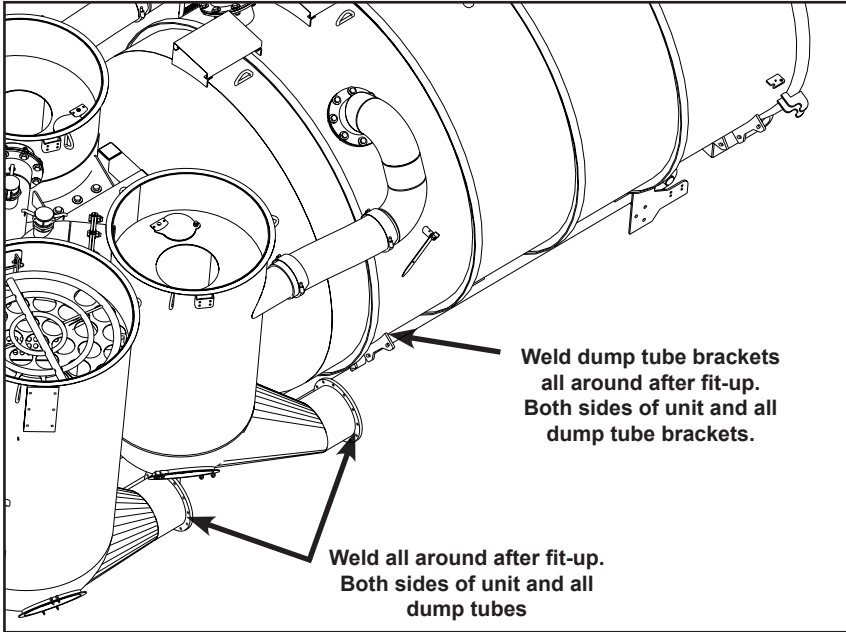
A 3/4" weld face



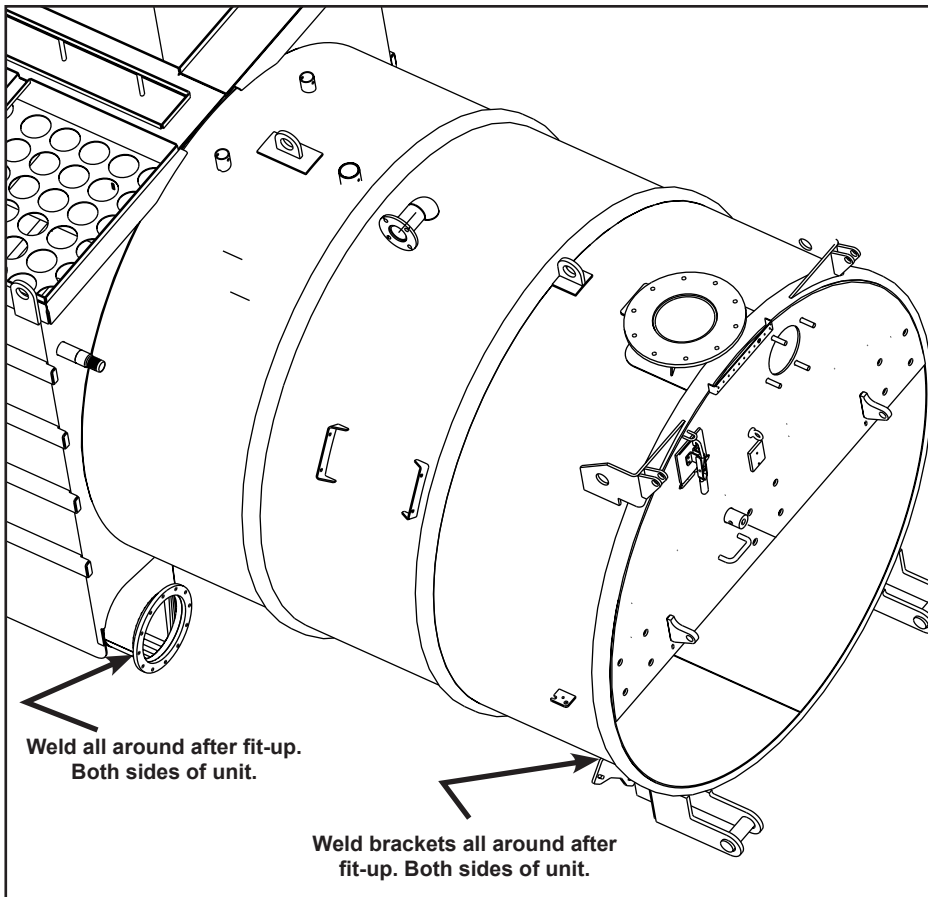
2100 Series domed rear doors



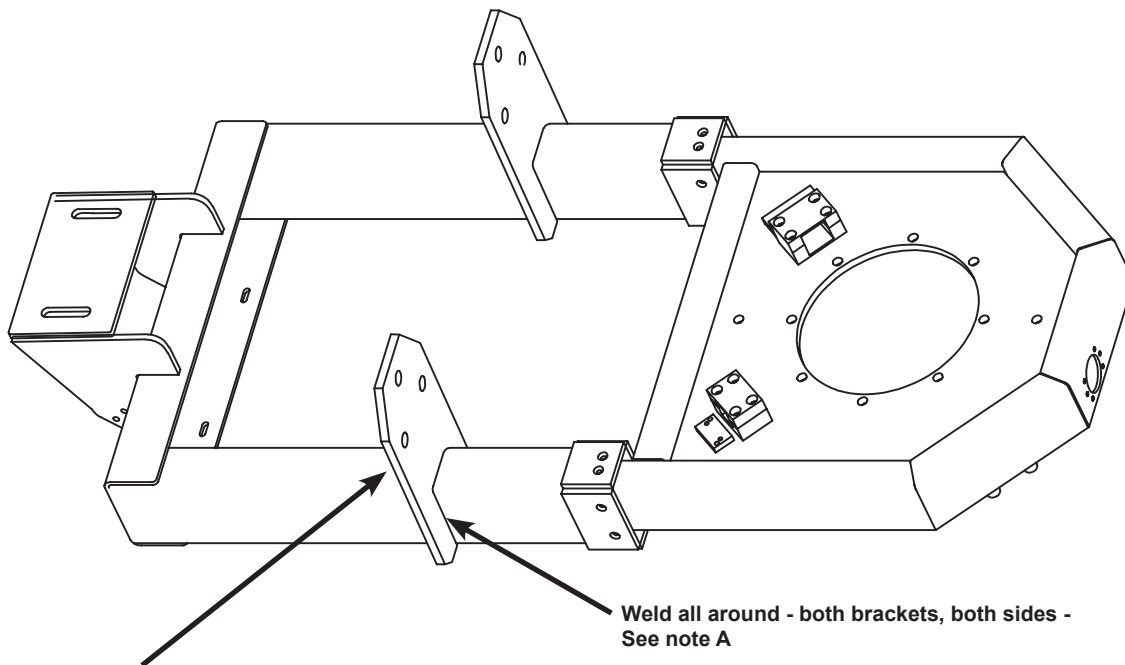
Guzzler ACE & CL Dump Tubes



All dump tubes
All models



Hose Reel Frame Weld

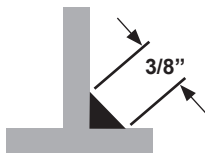


Top of tube on the back side can be left unwelded if welding is performed while fitted to chassis - both brackets.

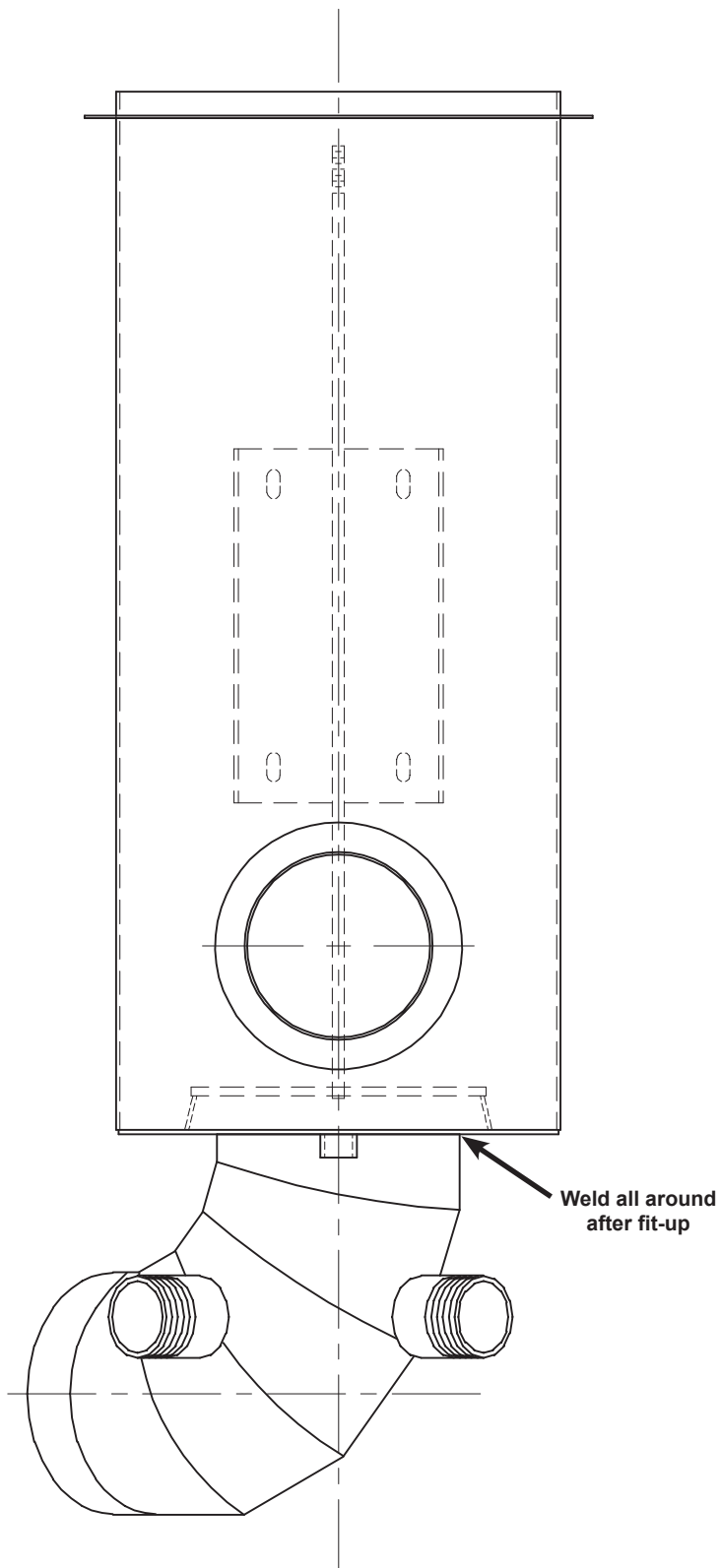
Weld all around - both brackets, both sides - See note A

Notes

A 3/8" weld face



2100 Series Final Filters



2100 Series Butterfly Valve Elbows

