



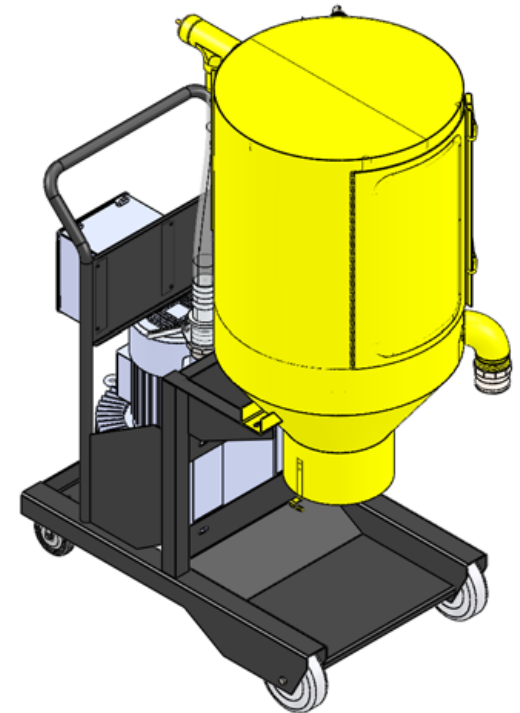
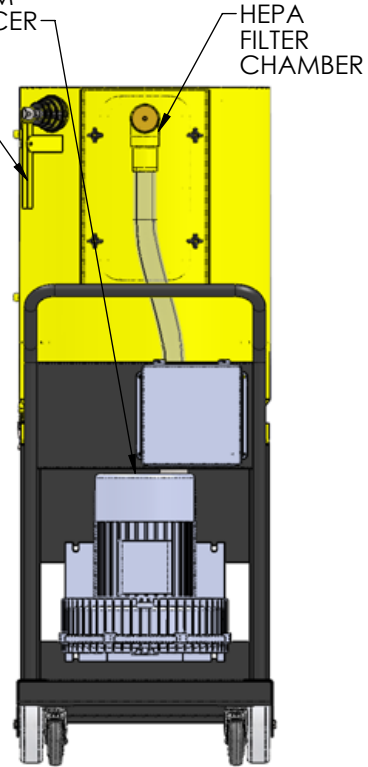
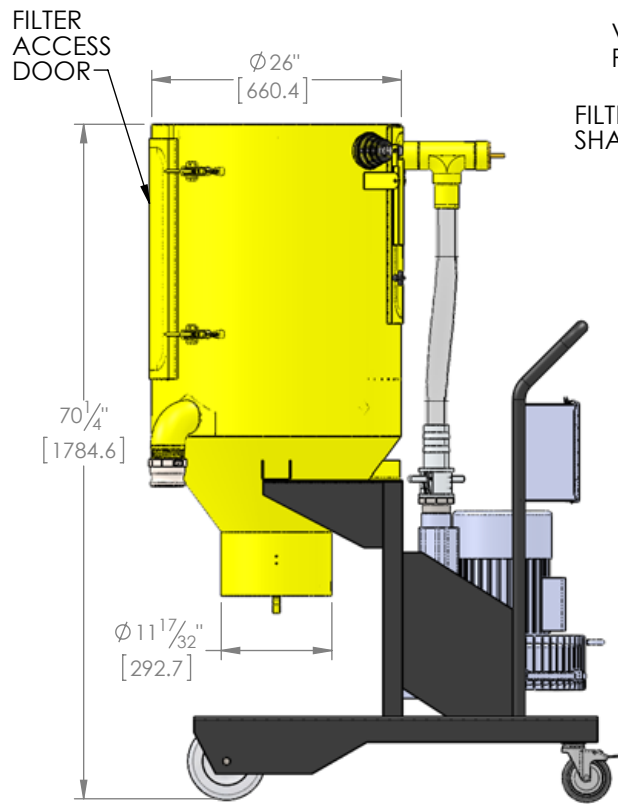
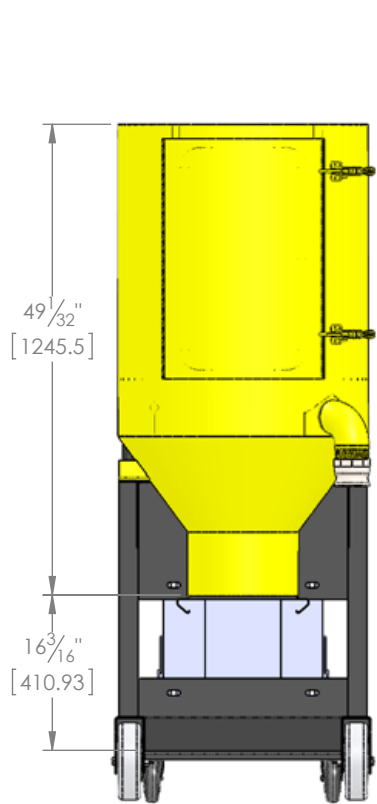
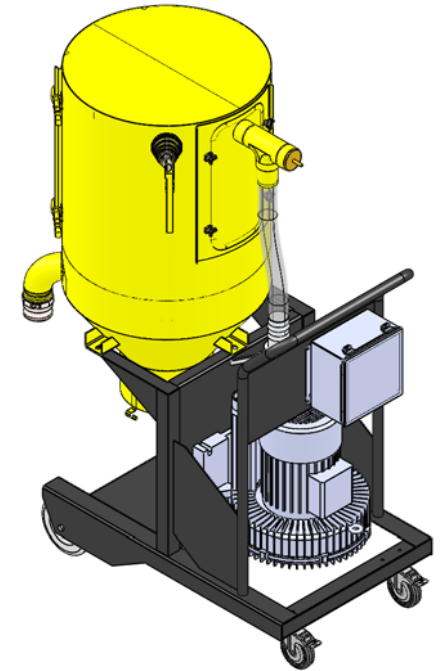
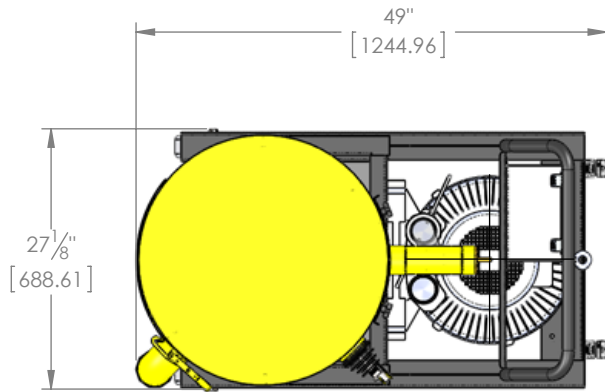
# **SASE BULL 1250EBS**

## Dust Collection System

### Owner's Manual



SASE Company, Inc  
800.522.2606  
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# Health and Safety Recommendations

The Information Contained In This Section  
Can Help Prevent Serious Personal Injury.

PLEASE READ THIS SECTION CAREFULLY  
BEFORE OPERATING OR SERVICING THIS  
EQUIPMENT.

**T**his section outlines some of the health and safety issues that must be acknowledged when operating or servicing your SASE industrial vacuum cleaning system.

It is important that plant operators are made aware of the responsibility incumbent on them to take all necessary precautions to ensure their health and safety, and that plant authorities implement the procedures necessary toward this end.

We strongly advise that you, the customer, add to, and tailor, these safety recommendations to suit your own particular working and operating environment.

## Explosive Dust

Please contact us if your process changes so we may help evaluate your risk.

The operators of this equipment must always be aware of the physical and chemical properties of the dust particles being collected. A surprising number of dusts are flammable or prone to explosion when mixed with air as we find with a filter receiver application.

Materials or processes presenting such hazards **MUST** be identified by the customer so that specific safety features can be built into the separator.

The customer must also be alert to any changes in the dust material or process. If a new process is introduced after the installation of the vacuum

system which changes the composition, quantity, or most especially the chemical type of material being introduced into the vacuum system, this may greatly increase the chance of explosion and fire.

If your process is to be changed, or if you have any concerns, we suggest you contact us to see how we can assist you to ensure that the operation of your SASE industrial vacuum cleaning system is as safe as possible.

## Isolate Electrical Before Maintenance

DO NOT ATTEMPT ANY MAINTENANCE WORK UNTIL ALL ELECTRICAL GEAR HAS BEEN ISOLATED.

Isolate all electrical before removing any guards, covers or accessories before beginning any maintenance or repair work.

Always lock out the main system blower disconnect before opening any inspection door on any separator or filter receiver.

Before re-connecting the electrical supply, ensure that all guards, covers and accessories are correctly replaced.

## Observe Accessories Safety Requirements

All the major equipment, including the blowers and all the separators, have accessory items attached and working in conjunction with them. The operators should be familiar with the safety and operating instructions of each accessory component.

NOTE: MANY ACCESSORIES ARE AUTOMATICALLY CONTROLLED AND MAY STARTUP AT ANY TIME!

## Implement Measures to Handle Respirable

### Dust

Operators must be fitted with appropriate respirators and must wear protective clothing if handling dust that may be irritating or even toxic.

We recommend that the MSDS's for each of the dusts to be handled by the vacuum system be included in this manual, and that specific measures to handle problem materials be clearly identified in those sections of this manual where the operator is exposed to these dusts; i.e. filter bag replacement, etc.

Company specific lockout and safety procedures should be inserted in this section.

## Use Suitable Electrical Warning Notices

Do NOT leave electrical gear live and unattended without a suitable warning notice.

Distinctive warning notices must be provided for posting in a conspicuous position to any piece of electrical equipment or machinery on which maintenance is being carried out, and which, for any reason whatsoever, is liable to be left unattended while in a live condition.

## Use CAUTION When Using the Hoses

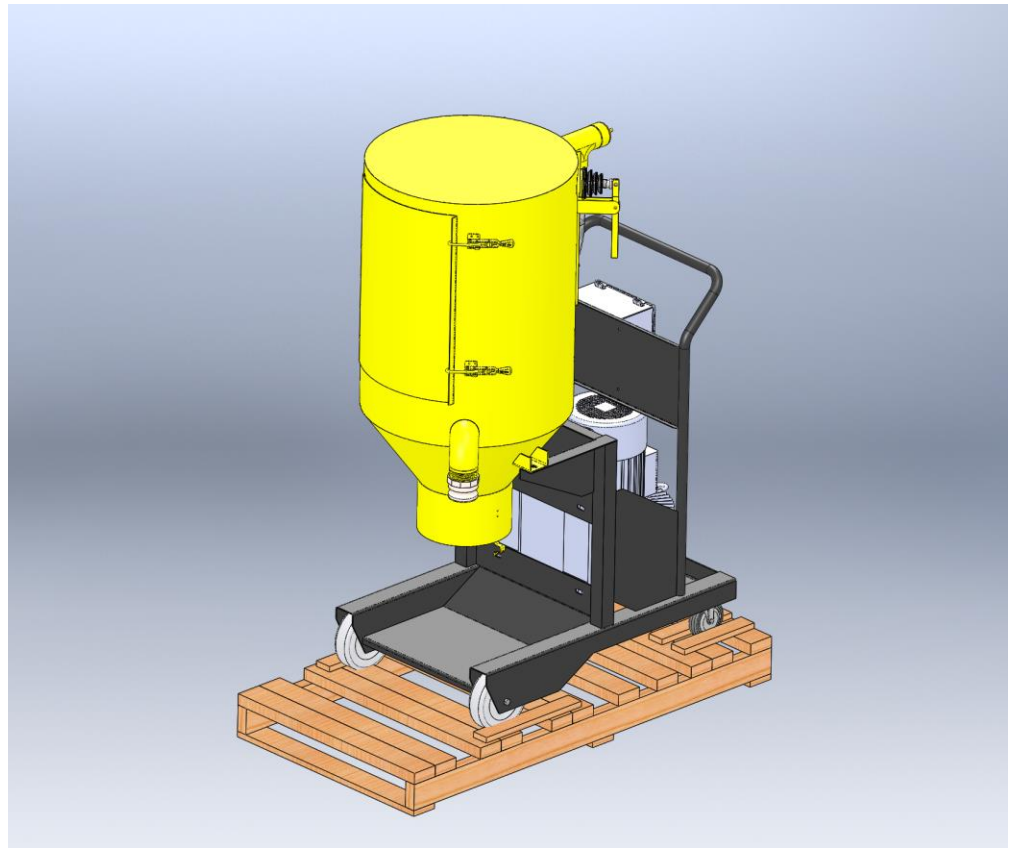
SASE vacuum systems use blowers that develop very high vacuum conditions which can be dangerous if caution is not observed.

**DO NOT PUT THE END OF THE HOSE AGAINST YOUR SKIN OR CLOTHES OR THOSE OF OTHERS!**

Remove the hose from the inlet valve to dislodge materials that plug the end of tools.

# Maintenance Instructions

*This Section Contains Information about the Upkeep and Maintenance of the SASE BULL 1250EBS Industrial Vacuum System*



*SASE BULL 1250EBS*

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This section contains information of the following topics:

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<b>3. Removing Filter Bags</b>	Page 3
<b>4. Installing New Filter Bags</b>	Page 3
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<b>6. The HEPA Inline Filter and Re-Order Info</b>	Page 5
<b>7. The Vacuum Producer</b>	Page 6
<b>8. The Discharge Flap</b>	Page 7
<b>9. Vacuum Seal Troubleshooting</b>	Page 8

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This equipment is designed for full time operation under the most severe conditions; however, proper maintenance procedures must be observed.

Please read and follow the instructions on the following pages to ensure proper operation of each of the components of your system.

## The Filtration System

The *SASE BULL 1250EBS* Series of vacuum systems is designed to handle super-fine powders, so the filtration sub-system is its “heart” and must be maintained properly. The unit is equipped with twenty (20) inverted bag type tubular filters which collect the fine dust particles on the filter’s **inside surfaces** during operation.

Before commissioning, open access door and check to ensure all bags are firmly secured to the lower bag plate. The top of the bags are attached to the top of the filter housing by bolts and the bags must not be loose or out of place.

**NOTE: A loose or unsecured bag will allow product to pass through the filter separator and will plug the in-line filter.**

**The filter bags should be shaken at least daily**, preferably after each use. To shake filter bags shake the filter assembly arm swiftly back and forth. This rapid movement will dislodge particles on the inside of the filter bag surfaces and drop them into the dust can.

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**NOTE: Please find a video for filter bag installation and removal in this manual kit.**

If the filters are to be replaced, please replace them ALL at once, or they will be a constant source of frustration.

## **Filter Bag Maintenance**

The following is a recommended program of preventative maintenance:

- 1.** Check that the filters are seated properly and that they do not appear to be leaking WEEKLY. **There should be NO appreciable or visible dust inside the service access door.**
- 2.** Replace ALL the filters if wear points or holes are noticed.
- 3.** If the secondary filter cartridge becomes plugged rapidly, check for holes in the primary filter bags, or upgrade the primary filter material to a more efficient type.
- 4.** Replace the secondary filter cartridge when you notice damage to media during visual inspection and fine dust emissions from the vacuum producer exhaust.

**Operators must be outfitted with appropriate respirators and must wear protective clothing if handling dust that may be irritating or toxic.**

**The most common installation mistake is to release the cuff lower than it should be. The groove in the bag cuff matches the hole size exactly.**

## **Removing Filter Bags**

To change the filter bags, remove each bag from the filter shaker assembly inside the tank at the top.

Squeeze the spring cuff at the bottom of the bag compressing the snap ring into a “U” shape, and remove from the bag plate hole.

## **Installing New Filter Bags**

Attach the grommet in the bag with bolts to the filter shaker assembly inside the tank at the top.

Grasp the spring cuff at the bottom of the bag and compress into a “U” shape. Insert into the proper hole in the bag plate, and release the bag bottom, **assuring the “groove” in the bag cuff is centered in the bag plate hole.**

After installing all the filters, check the installation from below; all the filters should be neatly and evenly seated.

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**WARNING:** Failure to assure proper seating of the bag in the bag plate will allow material leakage.

### **Filter Bag Specification**

The filter bags supplied with this system are:

<b>Material:</b>	Epitropic PTFE
<b>Quantity:</b>	20
<b>Length</b>	23"
<b>Bag Plate Hole Size</b>	4"

## **The HEPA Inline Filter Cartridge**

**The inline filter supplied with this unit will help prevent damage** to the exhauster in case of failure of a primary filter bags. To access this HEPA inline filter element the vacuum system should be turned off.

This secondary filter cartridge is located in the same filter housing along with the primary filter bags and can be accessed using a separate door located on the vacuum producer side of the filter housing. When you notice damage to media during visual inspection and fine dust emissions from the vacuum producer exhaust – it is time to replace this HEPA filter element.

In this situation, inspect the bags for damage, or to see if they have become loose. Properly clean the bags if no damage is seen.

Remove the HEPA cartridge element, and clean by back flushing with compressed air (NOT recommended), or replace the filter.

**NOTE: Do not under any circumstances run this system without the inline filter installed. Catastrophic failure of the vacuum pump can easily occur!**

## **The Other Mechanical Sub-Systems**

The *SASE BULL 1250EBS* features an **RON-TAI RT-7063 regenerative vacuum producer** designed to run continuously. The integral motors have **permanently sealed bearings and do not require periodic lubrication.**

**Section 2 of this manual features the vacuum producer.** Please refer to that section for vacuum producer troubleshooting and maintenance instructions.

The following sub-sections describe typical maintenance requirements and the problems that can occur.

### **The Discharge Flap**

Bull1250EBS has a unique design feature. It is called discharge flap and is loaded with spring. The torsion spring is designed such that the flap is partial open when the system is off.

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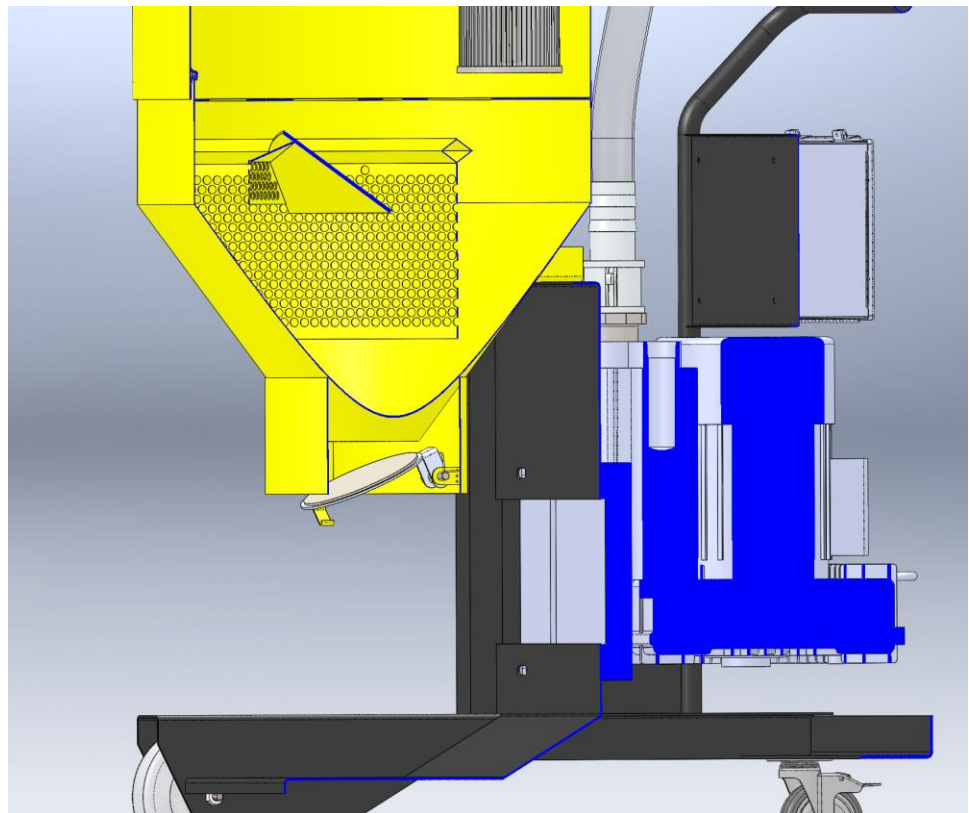
As soon as the system is turned on the flap with gasket closed against the discharge chute of the filter separator thus providing vacuum seal.

Never operate the unit with the discharge flap removed.

Do not try opening the discharge flap when the system is on as it could damage the flap and spring.

The two spring tabs are provided for the plastic bag adaptor, secure the bag adaptor on the tabs and feed in the bag over the discharge chute for continuous material collection.

**NOTE: Dispose of waste material in accordance with local environmental codes.**



## **Vacuum Seals**

If you experience a “lack of suction”, almost certainly there is a leak in a seal somewhere in the system. The following is a short list of common fail points:

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- 1. Check the door seals.** If air is leaking in through these seals, dust will normally collect on the inside surface of the door showing the exact location of the leak. Sometimes, running your hands around the door frame will allow you to locate the leak. Either way, replace the seals as required.
  - 2. DO NOT over-tighten the door latches!** Almost certainly that will cause more problems than it fixes.
  - 3. Check the HEPA filter cartridge element side access door gaskets.** If they are torn or worn, please replace them.
  - 4. Check the discharge flap spring lifting mechanism.** This mechanism sometimes loosens due to spring wear out over a period of time and must be re-adjusted / replaced.
  - 5. Check the hoses for leaks.** A hose covered in duct tape is a sure indicator that the hoses should be replaced.
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# SASE BULL 1250 EBS

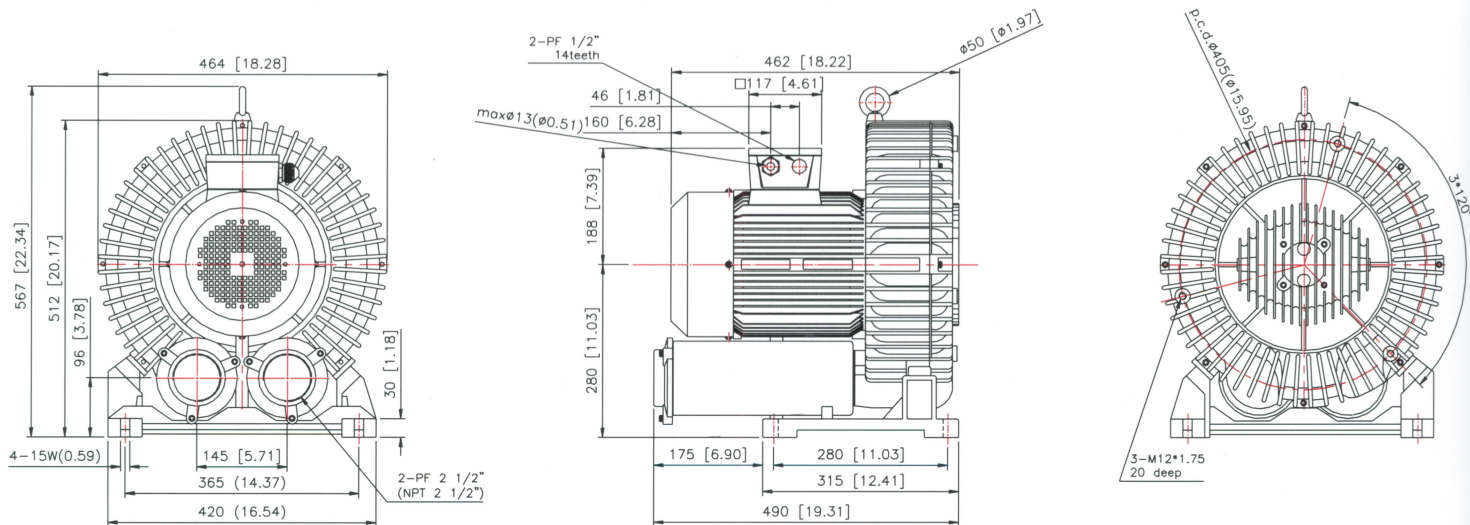
## Parts list

<b>Replacement Parts</b>	<b>SASE Part #</b>	<b>Recommended</b>
Filter bags, 4"x23"	NWA.00090	1 set/20
Inline Filter element, HEPA	NWA.800.EBS	1

Type Number		RT-7063	RT-8086
Phase		3	3
Output	50Hz	5.5	7.5
	Kw	6.3	8.6
Voltage	50Hz	220-240/380-415	220-240/380-415
	V	220-240/380-415	220-240/380-415
Current	50Hz	21/12	27/15.6
	Amp	26.5/15.3	34/19.6
Vacuum	50Hz	270	300
	mbar	290	350
Pressure	50Hz	300	400
	mbar	290	400
Air Flow	50Hz	9.2	9.2
	m <sup>3</sup> /min	10.9	10.9
Insulation Class		H	H

## RT-7 & 8 Series

Unit : mm (inch)



# Side Channel Blower & Turbo Blower



## Instruction Manual


### Instructions prior to installation and operation

1. Check if any part of the blower has been damaged during the transportation.
2. *Do not dispose of solid or material from suction inlet directly, shall use filter before inlet, otherwise damage to blower may occur.*
3. Do not dispose of acid, alkali or inflammable gas, otherwise explosion and damage may occur.
4. Do not dispose of liquid and air with high temperature.
5. *Do not touch the blower to avoid burn damage; temperature may rise due to long time continuous operation.*
6. High pressure blower (RT series) electric current is proportional to pressure and inverse proportional to air flow. Turbo blower (TB series) electric current is proportional to air flow and inverse proportional to pressure.
7. Locking pressure of high pressure blower (RT series) shall higher than max. static pressure (motor full loading) do not operate over loading remarked on rating plate or rating label, to prevent motor damage, electric current over load relay, adjustable pressure relief or vacuum limitation valve shall be installed to protect motor.
8. When blowing air into water, the maximum transportation depth shall not excess 70% max. static pressure remarked on catalogue. (water column )

### Installation

1. 3-phase blower shall be installed with ambient temperature  $-10 \sim +40^{\circ}\text{C}$ , single phase blower with ambient temperature  $-5 \sim +40^{\circ}\text{C}$ , relative humidity shall under 80%.
2. When installed outdoor, please check if any obstruction around blower suction inlet, and install shelter to avoid motor damage or electric shock due to getting wet.
3. If inlet does not connect any pipe, a filter with larger area shall be installed at suction inlet.
4. Over high pressure using shall be avoid in closed piping loop for high pressure blower (RT series), otherwise deformation and break may be occur to blower due to temperature raise, adjustable pressure relief or vacuum limitation valve shall be installed to protect motor.
5. Distance at least 50mm shall be maintained between blower motor fan and wall to avoid over heat due to poor motor heat dissipation.
6. Heat may be produced during operation due to friction between air, impeller and piping. Heat-resisted piping material shall be used over 1 m for outlet piping.
7. Section area of piping shall not smaller than 60% of blower inlet and outlet section area.
8. Centerline of piping and blower inlet and outlet shall remain the same, please do not connect forcibly.
9. Piping shall be fixed independently, the weight of piping shall not load on the rim of blower inlet nor outlet, to avoid damage occurred to rim.
10. Unusual sudden diameter shrinkage, enlarge or curve design of piping shall avoided to ensure best blower air efficiency.
11. When install blower in vertical or inclined position, please consider the total weight of impeller and rotor loading on bearing, please contact your blower supplier or manufacturer for further confirmation.
12. Blower with the same horse power could be installed in series or parallel connection, please contact your blower supplier or manufacturer for further confirmation before installation.
13. Installed with screw on leveling and hard foundation or base. Standard loading is generally about 3 times of blower weight, if installed on uneven base, vibration absorber shall be installed to avoid deformation or noise occurred due to fastening bolt of blower.

### Wiring and operation

1. *Make sure the voltage and frequency of power supply fits the requested electrical condition marked on blower rating plate or label, otherwise injury or motor damage may occur due to incorrect voltage.*
2. Allowable voltage variance shall be within 5% of rated voltage, and frequency variance shall be within 2%.
3. Please wiring according to the wiring instruction inside the cover of terminal box, and *connect earth lines*  *to prevent electrical leakage accident.*
4. Over-heat relay device is not available for normal blower, please install over-load switch according to the voltage marked on rating plate or rating label and choose the appropriate over-load switch.
5. Turn on switch for a short time (twinkling) and test run blower after wiring, make sure rotation in compliance with arrow direction. If wrong direction happened with three phase blower, please exchange any two lines of three wires. As for single phase blower, please contract your supplier or manufacturer.

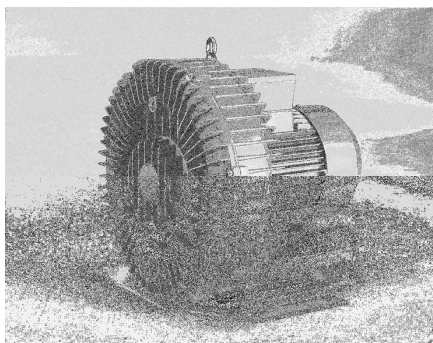
6. Over load may happen when all-close piping system for high pressure blower or all-open piping system for turbo blower, please keep the current in allowable range marked on rating plate or label to avoid motor damage.
7. Avoid turn blower switch on and off to many times within a short time, otherwise overheat may occur to motor.
8. Inverter is not available for single phase blower. When using inverter in three-phase blower, please avoid operation with too high or too low frequency, otherwise damage may occur to blower.

#### Maintenance and inspection

1. *Filer or filter net used in piping system may blocked after a period of operation, and may block air flowing, please clean filter or filter net periodically.*
2. Please clean the dust and oil on the blower housing to ensure best heat dissipation performance.
3. Bearing, seal and muffler cotton are consumptive parts with limited life, which would be different for different ambient and operation condition, please inspect and replace periodically.
4. Please inject lubrication oil periodically to ensure long bearing life for the models with oil injection nipple.
5. *Conveying air with higher moisture may make blower shorter service life, and moisture air shall be avoided, if not avoidable, shall inspect blower parts periodically to prevent blower damage or injury occurred due to corrosion problem.*

#### Trouble shooting

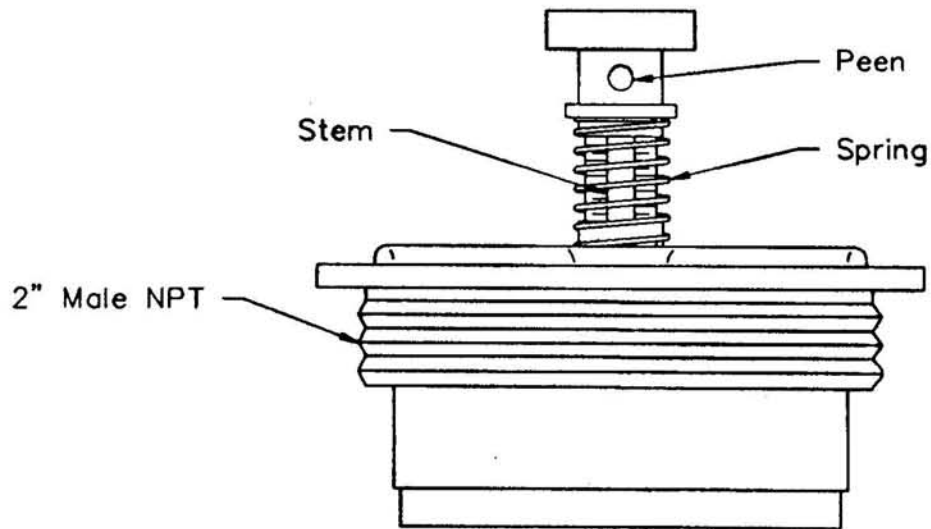
Status	Causes	Solution
Motor dose not work, without any sound	<ol style="list-style-type: none"> <li>1. Power lose phase</li> <li>2. Wiring disconnection</li> <li>3. Electro-magnetic switch broken</li> <li>4. Motor coil burnout</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power condition</li> <li>2. Check wiring connection and tighten again if loosen</li> <li>3. Check electro-magnetic switch condition</li> <li>4. Send for repair</li> </ol>
Motor do not work, with current Sound	<ol style="list-style-type: none"> <li>1. Blower impeller stuck</li> <li>2. Bearing can not rotate</li> <li>3. Screw loosen</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean blower inside</li> <li>2. Replace new bearing</li> <li>3. Check all screw and tighten if loosen</li> </ol>
Motor RPM not regular, with loud current sound	<ol style="list-style-type: none"> <li>1. Wrong wiring connection</li> <li>2. Wrong voltage</li> <li>3. Motor coil burnout</li> </ol>	<ol style="list-style-type: none"> <li>1. Check wiring connection method</li> <li>2. Use multi-meter to check power voltage</li> <li>3. Send for repair</li> </ol>
Motor RPM regular, blower with strange sound	<ol style="list-style-type: none"> <li>1. Impeller deformed or corrosion</li> <li>2. Worn bearing</li> <li>3. Blower housing damaged</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace new impeller</li> <li>2. Replace new bearing</li> <li>3. Send for repair</li> </ol>
Blower with harsh loud sound	<ol style="list-style-type: none"> <li>1. Blower crack from deformation or corrosion</li> <li>2. Worn muffler cotton</li> <li>3. Blower running pressure too high</li> </ol>	<ol style="list-style-type: none"> <li>1. Send for repair</li> <li>2. Replace new muffler cotton</li> <li>3. Check piping or filter blocked or not or choose blower with bigger capacity</li> </ol>
Blower work regularly, pressure or air flow lower than standard.	<ol style="list-style-type: none"> <li>1. Wrong motor rotation</li> <li>2. Worn blower impeller</li> <li>3. Blocked piping or filter</li> <li>4. Frequency too low</li> <li>5. Worn bearing</li> <li>6. Too many piping sudden change or curve design</li> </ol>	<ol style="list-style-type: none"> <li>1. Change motor rotation direction</li> <li>2. Replace new blower impeller</li> <li>3. Clean piping and filter</li> <li>4. Set the right frequency</li> <li>5. Replace new bearing</li> <li>6. Change piping design</li> </ol>
<p><i>- Blower is technical product, please do not dismantle and repair it without consulting professional technician to avoid any danger.</i></p>		



[www.blowertw.com](http://www.blowertw.com)

~Fall into the Excellence~





### **Specifications**

***Height - 4-1/4"***

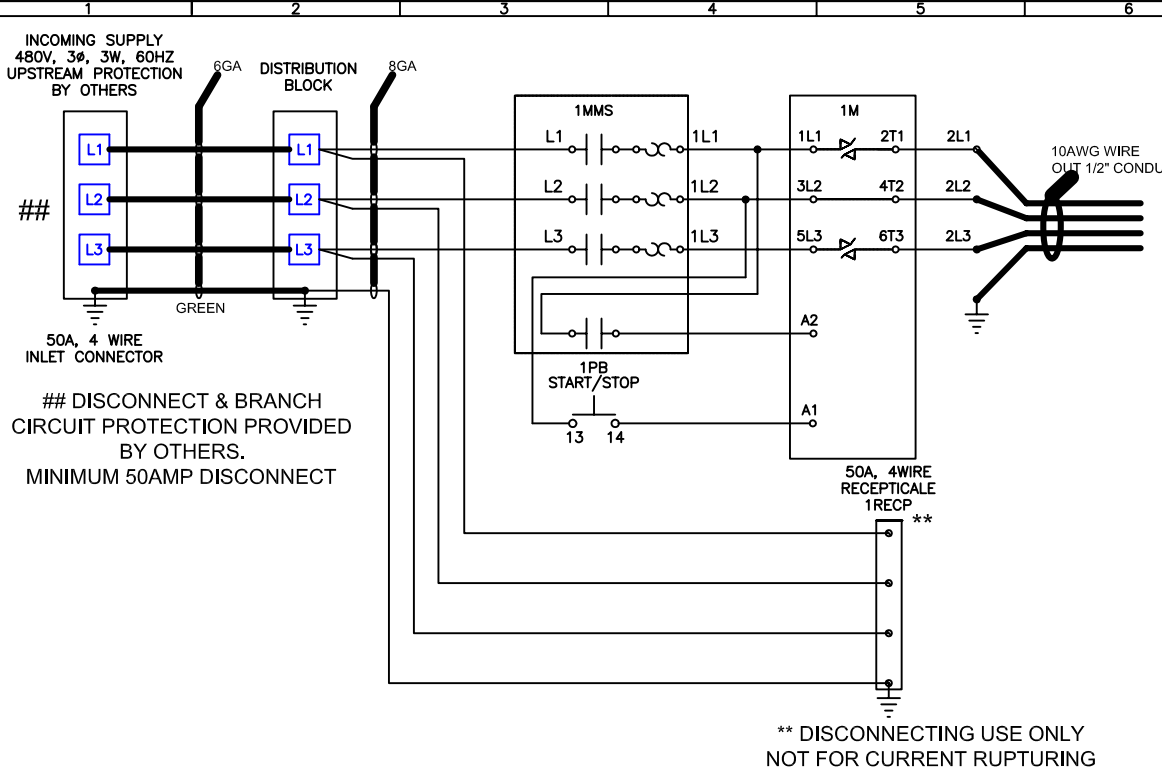
***Width - 2-7/8"***

***Weight - 1.5 Lbs.***

***Thread Size - 2" MPT***

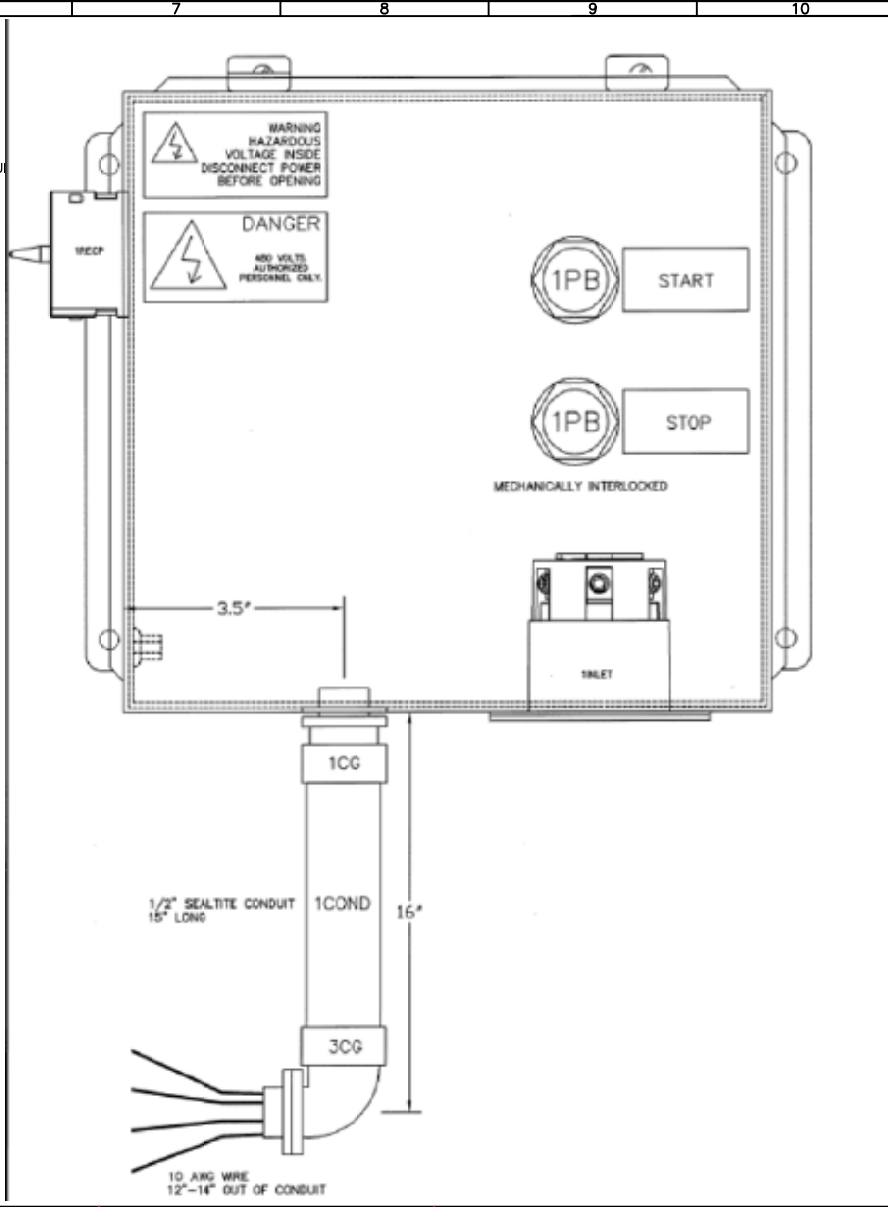
### **Features**

- ◆ ***Brass Construction***
- ◆ ***Adjustable in the field***
- ◆ ***4" to 16" Hg. Range***
- ◆ ***Up to 200 CFM***



## DISCONNECT & BRANCH  
CIRCUIT PROTECTION PROVIDED  
BY OTHERS.  
MINIMUM 50AMP DISCONNECT

\*\* DISCONNECTING USE ONLY  
NOT FOR CURRENT RUPTURING



## START-UP INSTRUCTIONS

# WARNING!

Failure to follow these simple start -up instructions could result in the failure of your new SASE Bull 1250 EBS vacuum

### Start -Up

Open the access door on your new vacuum and inspect all filter bags to assure they are properly seated and did not come loose during shipment. Remove the dirt can and look at the tube sheet from below; all the filters should be installed neatly and evenly. If the filters are not seated tightly, dust will leak by them.

### Leave the access door open.

Place an amp probe on one line of the electrical connections, and “bump” the motor. You should get air **blowing** from the discharge silencer. If you note a vacuum at the discharge silencer, reverse the motor direction.

Start the unit, and allow it to run several minutes with the access door open. Listen for any “unusual” sounds. The system should run quietly, smoothly, and cool.

After a few minutes, feel the casing of the vacuum pump for “hot spots”. It should feel uniformly slightly warm.

With the motor still running, connect a hose into the system, and close the access door.

While watching the amp probe reading, **slowly** close off the end of the hose with a piece of wood. The amperage should climb to within 90 - 95% of the motor’s name plate full amperage rating for the voltage at which you are operating.

If the motor amperage holds at or slightly below the recommended full load with all hoses fully closed, and air is bleeding in through the vacuum relief valves, then unit is ready for full operation.

**NOTE:** The vacuum relief valves are factory set to the proper vacuum relief setting before shipping. If they do not open, or if the amperage exceeds the nameplate motor amperage, shut the unit off and contact the factory IMMEDIATELY.