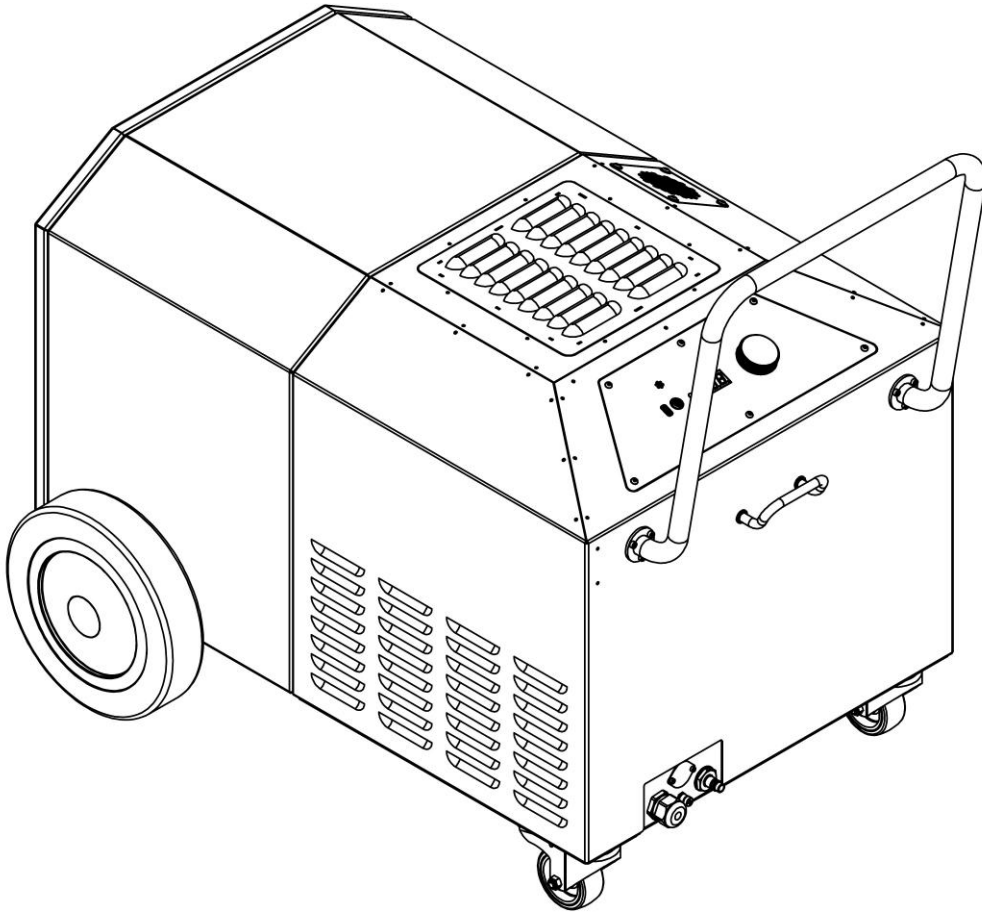




VacuFil Compact Twin

EN – Operating Manual

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1 General

1.1 Introduction

This manual is an essential aid for the proper and safe operation of the product.

These operating instructions contain important information to ensure safe, proper and efficient operation of the product. Observing these instructions helps avoiding danger, reducing repair costs and downtimes and increasing the reliability and service life of the product. The operating instructions must be kept available at all times and have to be read and applied by every person who is assigned to work on or with the product.

These include amongst others:

- the operation and troubleshooting during operation
- the maintenance (care, maintenance, repair)
- the transport
- the assembly
- the disposal

Technical modifications and errors expected.

1.2 References to copyright and industrial property rights

These operating instructions are to be kept confidential and made accessible only to authorised persons. Disclosure to third parties is only permitted with the prior written consent of the manufacturer KEMPER GmbH.

All documents are protected under the Copyright Act. Any form of disclosure, reproduction, or partial use, as well as the communication of its content, is prohibited without express written permission.

Violations will be prosecuted under criminal law and will incur liability for any resulting damages.

Industrial property rights such as patents, trademarks, or designs are exclusively held by the manufacturer.

1.3 Notes for the operating company

The operating instructions are an essential part of the product.

The operating company must ensure that the operating personnel is aware of the contents of this manual.

Based on national regulations for accident prevention and environmental protection, the operating instructions are to be supplemented by the operating company's own operating instructions, including information on regulatory and reporting requirements to meet specific operating requirements, such as work organisation, work flow and staff employed. In

addition to the operating instructions and the relevant obligatory regulations for accident prevention applicable in the country of use, it is also imperative to comply with the recognised technical rules for safe and professional handling.

Without prior consent from the manufacturer, the operating company may not carry out any changes, conversions or additions to the product which may impair safety. Spare parts used must comply with the manufacturer's specified technical requirements. This is always the case with original replacement parts.

Only use trained and instructed staff for the operation, maintenance, repair and transport of the product. Clearly define for staff who is responsible for operation, maintenance and transport.

2 Safety

2.1 General information

The product is designed and built according to state-of-the-art technology and the recognised safety rules and regulations. When operating the product, technical hazards for the operator or impairment of the product as well as other property may occur, if:

- it is not operated by trained or instructed personnel
- it is not used for the purpose intended and/or
- it is improperly maintained

2.2 Information on signs and symbols

⚠ DANGER

This symbol in conjunction with the signal word "Danger" indicates imminent danger. Non-adherence of the safety note leads to death or serious injuries.

⚠ WARNING

The symbol in conjunction with the signal word "Warning" indicates a potentially dangerous situation. Non-adherence to the safety notice may lead to death or serious injuries.

⚠ CAUTION

The symbol in conjunction with the signal word "Caution" indicates a potentially dangerous situation. Non-adherence of the safety note may lead to slight or negligible injuries.

May also be used for warnings against property damage.

NOTE

The general information is simple additional information which does not warn about personal injury or property damage.

1. Enumerations of action steps are marked as numbers with a dot, where the order is important.
- Bullet points indicate lists of parts in a legend or instructions for which the sequence is unimportant

2.3 Markings/signs to be affixed by the operating company

The operating company is obliged to post further markings and signs on the product and the surrounding area if necessary.

Such markings and signs might be related, for example, to the requirement for wearing personal protective equipment.

2.4 Safety instructions for operating staff

Before use, the operator of the product must be instructed through information, instructions and training on the handling of the product and the materials and aids to be used.

The product system may only be used in technically perfect condition, for its intended purpose, in full awareness of the safety aspects and potential dangers and in accordance with these instructions. All errors, especially those that may affect safety, must be removed immediately.

Every person who is charged with commissioning, operation or maintenance must have fully read and understood these operating instructions. This specifically applies to staff who only operate the product occasionally.

The operating instructions must always be within reach of the product.

We accept no liability for any damages or injuries caused by failure to observe these operating instructions.

The relevant accident prevention regulations and other generally recognised safety and occupational health regulations must be observed.

The responsibilities for the various activities included in maintenance and repair must be clearly defined and adhered to. Only then will human error - especially in dangerous situations - be avoided.

The operating company is to enforce wearing of personal protective equipment by operating and maintenance staff. These include in particular safety shoes, safety glasses and gloves.

Do not wear loose, long hair, loose clothing or jewellery. In theory, there is a risk of getting caught on something, or being pulled in or dragged along by moving parts.

If there are any safety-related changes to the product, immediately halt the process, secure it and report the occurrence to the relevant authority/person!

Work on the product may only be carried out by reliable, trained staff. Observe the minimum legal age.

Staff who require training, teaching or instructing or staff who undergo a general apprenticeship may only operate the product under the supervision of an experienced member of staff.

2.5 Safety instructions for maintenance/troubleshooting

Service and maintenance doors must be freely accessible at all times.

Setting up, maintenance and repair work and troubleshooting must only be performed when the product is switched off.

Always tighten bolt connections that have been loosened during repair work. If specified, tighten the relevant bolts with a torque wrench.

In particular, protect connections and screw connections from dirt or care products at the beginning of maintenance/repair/care

The time frames for periodic testing/inspections stipulated or specified in the operating instructions must be observed.

Before disassembling, mark the parts that belong together.

2.6 Notes regarding special types of hazard

⚠ DANGER

Danger of electric shock!

Any work on the electrical equipment of the product must only be performed by a qualified electrician or by operating personnel under the direction and supervision of a qualified electrician in accordance with electronic regulations.

Before opening the product, pull the plug, if available, and secure it against accidental switch-on.

For faults with the product's electrical energy supply, immediately switch the product off at the on/off switch and if available, also pull the plug.

Use only original fuses with the prescribed amperage.

Electrical components, on which inspection, maintenance and repair work must be carried out, must be disconnected from the power supply. Secure equipment that has been used for disconnection against unintentional or automatic reconnection. Firstly check that no voltage is present in activated, electrical components, then isolate adjacent components under voltage. When making repairs, ensure that constructive characteristics are not altered in a way that reduces safety.

Check cables regularly for damage and replace if necessary.



CAUTION: Automatically Operated Device –
To Reduce The Risk Of Injury Disconnect From
Power Supply Before Servicing.

WARNING: To Reduce The Risk Of Electric Shock,
Do Not Expose to Water or Rain.

ATTENTION: Appareil fonctionnant automatiquement
– afin de réduire les risques de blessure, débrancher
l'alimentation électrique de procéder à l'entretien.

AVERTISSEMENT: Pour réduire le risque de choc
électrique, ne pas exposer à l'eau ou à la pluie.

⚠ WARNING

Electric shock if earthing is missing!

If the protective earth connection of devices is missing or incorrectly executed, high voltages may be present on exposed parts or housing parts which, if touched, can lead to serious injury or death.

⚠ WARNING

Electric shock if an unsuitable power supply is connected!

The connection of an unsuitable power supply can cause parts that can be touched to be under dangerous voltage. Contact with dangerous voltage can lead to serious or fatal injury.

For electrical connection data, see the name plate of the product

Power supply

The product is designed for the mains voltage indicated on the name plate. If mains cables or mains plugs are not fitted to the product, they must be fitted in accordance with national standards.

⚠ CAUTION

Insufficiently dimensioned electrical installation can lead to serious damage to property.

The mains supply line and its fuse protection must be designed in accordance with the existing power supply. Observe the technical data on the name plate.

The mains fuse should be equipped with at least a **category C** circuit breaker.

⚠ WARNING

Danger from toppling over during transport!

The product may tilt and topple over when moved. People can be injured due to the high dead weight.

- Before moving, release the brakes on the castors.
- Move and set down the product only on flat, smooth floor coverings.
- Only move the product with the push handle.
- Do not use the push handle to lift the product.
- Do not sit or climb on the product.
- Before moving; if present, fold in suction arm / wind up or dismantle suction hoses

⚠ WARNING**Health hazards caused by welding fume particles**

Do not inhale welding dust / smoke! Serious injury to the lungs and respiratory tract is possible!

Sweat smoke contains substances that can cause cancer!

Skin contact with cutting and welding fumes etc. can cause skin irritation in sensitive persons!

Repair and maintenance work on the product may only be carried out by trained and authorised personnel while complying with the safety rules and the applicable accident prevention regulations.

To avoid contact with and inhalation of the dust particles, wear disposable overalls, protective goggles, gloves and a suitable Class FFP2 respiratory protection filter mask in accordance with EN 149.

The release of hazardous dust particles during repair and maintenance is to be avoided to ensure that persons not charged with the task are not affected.

⚠ WARNING

Work on the compressed air vessel and on the compressed air lines and components may only be performed by persons with expertise in pneumatics.

The pneumatic system must be isolated and depressurised prior to the performance of maintenance and repair work on the external compressed air supply.

⚠ CAUTION**Health hazard due to noise!**

The product can produce noise, please refer to information in the technical data. In connection with other machines and/or local conditions, a higher noise level can occur at the operation site of the product. In this case, the operating company is obliged to provide the operating personnel with the appropriate protective equipment.

3 Product information

3.1 Functional description

The product is a compact welding fume filter unit that extracts the welding fumes generated during welding and separates them with a filter efficiency of more than 99%.

The extracted contaminated air is cleaned using a 1-stage filter method and then fed back into the workspace. Alternatively, it can also be routed outside via an optional outgoing air hose.

The particles separated on the filter cartridge are cleaned by manually or automatically triggered compressed air pulses using a rotating nozzle. A blast of compressed air is precisely distributed across the total filter surface of each filter cartridge via a rotating nozzle. The deposited particles are dislodged and fall into the dust collection container.

The product can be operated with suitable welding fume extraction torches or with funnel nozzles.

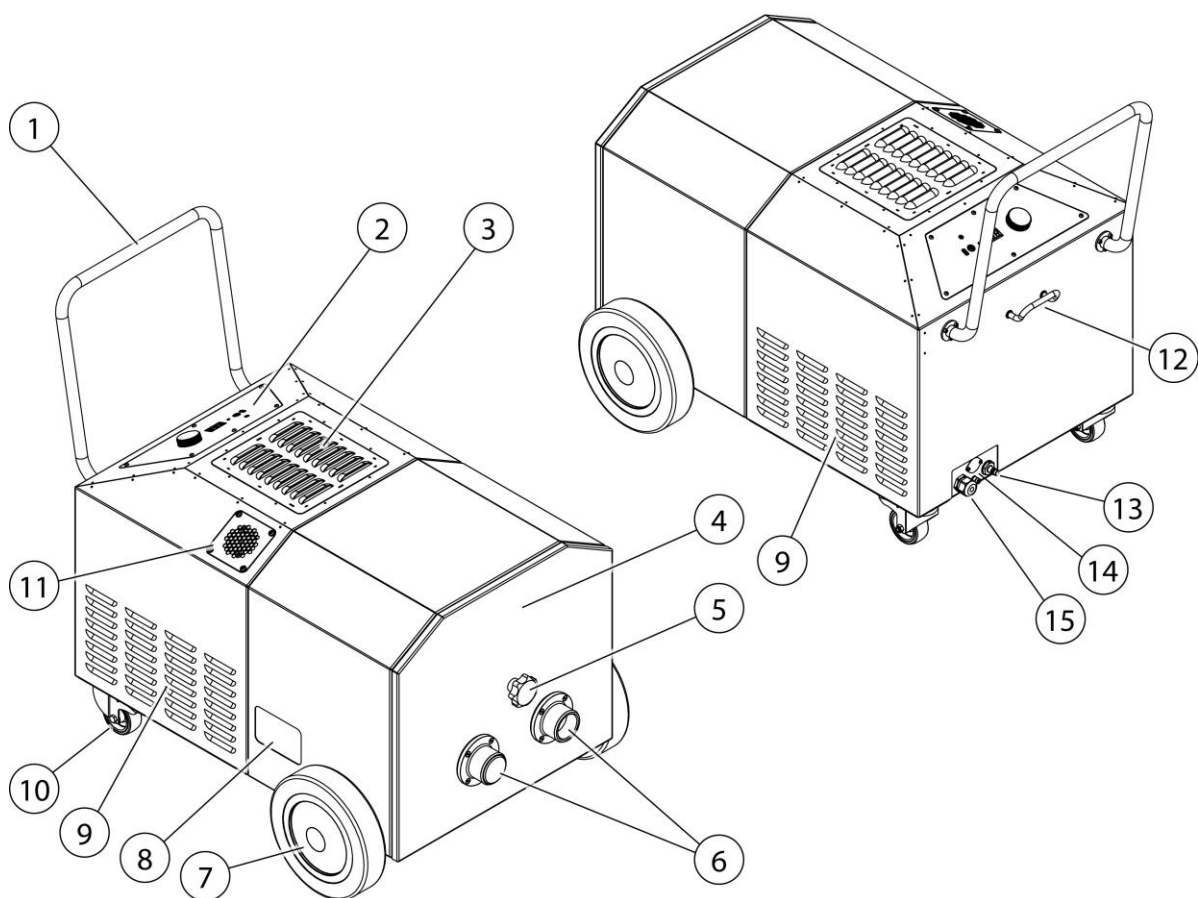


Fig. 1: Functional description – Product

Pos.	Description	Pos.	Description
1	Push handle	9	Cooling air outlet grille
2	Operating control	10	Castor, lockable
3	Air intake grille with filter mat	11	Air outlet grille with connection NW 63
4	Maintenance cover	12	Cable holder
5	Star screw	13	Compressed air connection (only for product with cleaning)
6	Connection for extraction hose NW 45/ NW 63 mm	14	Mains supply connection cable
7	Rear wheel	15	Communication interface (optional)
8	Name plate		

Tab. 1: Functional description – Product

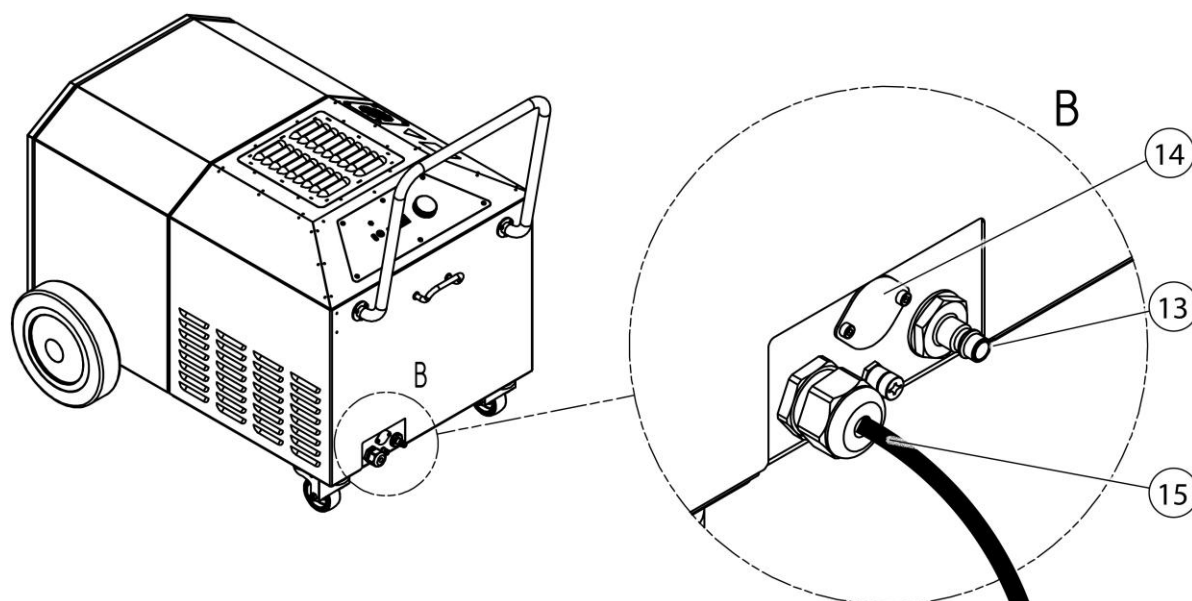


Fig. 2: Connections

3.2 Distinguishing feature – W3 certified

The product is manufactured in two versions:

- **Version – non W3 certified**

- **Version – W3 certified**

Attention

Only products labelled with the W3 sticker have been tested and certified accordingly.

See also chapter technical data: Welding fume class and test standard.

W3-tested:

The product has been tested by the IFA (Institute for Occupational Safety and Health of the German Social Accident Insurance Institutions). It fulfils the requirements of welding fume separation class W3 and conforms to EN ISO 21904-1.

The tested products are labelled with the DGUV test mark and a W3-tested (marking of the welding fume separation class) in the form of a sticker.

Labelling on the product	Meaning/explanation	Reference logo
W3 sticker	Type "W3 certified" according to test standard – see chapter "Technical data"	 The logo is a blue rectangular sticker with a white border. It is divided into three sections. The left section contains the text 'W3' in white. The middle section contains the text 'EN ISO 21904-1' and 'η ≥ 99 %' in black. The right section contains the text 'W3' in white.

Tab. 2: W3 label

3.3 Intended use

The product is designed to extract and filter out the welding fumes produced when welding metallic materials at the point of origin. In general, the product can be used for all work processes in which welding fumes are released. However, care must be taken that no glowing sparks are drawn into the product.

Dimensions and further product details that must be observed can be found in the technical data.

NOTE



Only products labelled with the W3 sticker have been tested and certified accordingly. See also chapter Technical data: Welding fume class and test standard.

NOTE

When welding alloyed or high-alloy steels with filler metals above 5% chromium/nickel, carcinogenic CMR substances (carcinogenic, mutagenic, reprotoxic) are released. In accordance with official regulations, only tested and approved products may be operated in Germany to extract these harmful smoke particles using the so-called recirculation method.

Only products that meet the requirements of welding fume separation class W3/IFA certified may be operated for the aforementioned welding processes using the recirculation method.

When extracting welding fumes with carcinogenic components (e.g. chromates, nickel oxides, etc.), the requirements of TRGS 560 (technical rules for HAZMAT) and TRGS 528 (welding work) must be obeyed.

NOTE

The information in the "Technical data" chapter must be observed and strictly adhered to.

Intended use also includes observation of the instructions and information on

- safety
- operation and control
- maintenance and servicing

contained in this manual.

Any other use or use going beyond this is considered improper use. The company operating the product is solely responsible for any damage resulting from it. This also applies to unauthorised modifications to the product.

3.4 Ambient conditions

Operation or storage of the device outside the specified area is deemed unintended use and may impair the function, the extraction capacity and

the protective effect in accordance with DIN EN ISO 21904. The manufacturer is not liable for any resulting damage.

General:

- Ambient air free from dust, acids, corrosive gases or other aggressive substances.
- Height above sea level: up to 1000 m [3281 ft].
- For accordingly released products only: Indoor or outdoor operation permitted.

Temperature range of the ambient air:

Operating mode	Operation	Transport/ storage
Indoor (Indoor area)	+5 °C to 40 °C [+41 °F to +104 °F]	-20 °C to +50 °C [-4 °F to +122 °F]
Outdoor (For approved products only)	-10 °C to 40 °C [+14 °F to +104 °F]	-20 °C to +50 °C [-4 °F to +122 °F]

Table 3: Temperature range of the ambient air

Relative humidity (non-condensing unless approved otherwise):

- **Indoor:** up to 50% at +40 °C [+104 °F], up to 90% at +20 °C [+68 °F]
- **Outdoor:** up to 100%, including temporary condensation due to weather conditions

3.5 General requirements in accordance with DIN EN ISO 21904

NOTE

Connection of ducting systems, extraction arms and hoses.

Ducting systems, extraction arms and hoses connected to the product can lead to a pressure drop and must be taken into account by the system designer or user.

The connected components must be suitable for the product and ensure the required minimum volume flow (extraction capacity).

A possible design of the ducting can be requested from the manufacturer.

The connected components must be checked regularly for proper seating, leaks and blockages.

The required extraction capacity must be checked at the central extraction element.

NOTE

Returning the air to the workplace atmosphere

In some Federal States, recirculation of air into the workplace atmosphere is not recommended or is prohibited. It may be necessary to conduct the exhaust air to the outside via a duct.

3.6 Reasonably foreseeable misuse

No reasonable, foreseeable misuse is possible that could lead to dangerous situations with personal injury when working with the product whilst adhering to its intended use.

The operation of the product in industrial areas that do not comply with the requirements for explosion protection is not permissible.

Furthermore, the operation is prohibited for:

1. Processes that are not in the intended use list and in which the extracted air is:
 - is mixed with sparks, e.g. from grinding processes, which due to their size and quantity might lead to damage to the filter media or even to a fire;

- mixed with liquids and the resulting contamination of the air flow with vapours containing aerosols and oils;
 - mixed with highly flammable, combustible dust and/or with substances that can form explosive mixtures or atmospheres;
 - is mixed with other aggressive or abrasive dust that could damage the product and the filter elements employed;
 - is mixed with organic, toxic substances or a proportion of substances that are released when cutting the material.
2. Outdoor locations where the product is exposed to weather conditions because the product must only be installed in closed buildings.
If there is an outdoor variant of the product available, this may be installed outside. Please note that additional accessories may be required for the outdoor installation.

3.7 Markings and signs on the product

Various markings and signs are affixed to the product. If these are damaged or removed, please replace them immediately with new ones in the same location.

The operating company is obliged to post further markings and signs on the product and the surrounding area if necessary.

Such notes and signs might be related, for example, to the requirement for wearing personal protective equipment.

In the country of use, additional required safety instructions and pictograms can be provided by the manufacturer in accordance with applicable law.

3.8 Residual Risk

Even when all safety rules are observed, when operating the product a residual risk remains, as described below.

All persons working on and with the product must be aware of these residual risks and follow the instructions that prevent these residual risks from causing accidents or damages.

⚠ WARNING

Danger of serious injury to the lungs and respiratory tract – always wear respiratory protection, Class FFP2 or higher.

Skin contact with welding fume particles may cause skin irritation in sensitive persons – wear protective clothing.

Before starting the welding process, ensure that the product is properly adjusted and in operation. The filter elements must be complete and in undamaged condition.

The connected detection element must reliably detect the welding fumes. For the correct positioning, refer to the documentation of the detection element.

When changing the filter inserts, skin contact with the separated dust particles may occur and parts of the dust particles may also be stirred up by the work. Respiratory protection and protective clothing must be worn.

Embers in the filter elements may cause smouldering fires – switch off the product, close the damper flap in the collection element if fitted and let the device cool down in a controlled manner.

4 Transport and Storage

4.1 Transport

⚠ DANGER

Life-threatening crushing possible when loading and transporting the product!

Improper lifting and transporting may cause the pallet (if present) to tilt and fall!

- Never stand under suspended loads.
- Observe the permissible loads of the transport and lifting aids.
- Observe the applicable accident prevention and occupational safety regulations.

For transporting products with a pallet, use a suitable pallet truck or forklift. The weight of the product can be found on the name plate.

4.2 Storage

The product must be stored in its original packaging at an ambient temperature of 20 °C to +50 °C in a dry and clean place. The packaging must not be loaded by other objects.

The storage duration is not critical for all products.

5 Assembly

Instructions for safe installation of the product

NOTE

The operating company of the product may only assign specialists to carry out independent assembly.

- At least two people are needed to assemble the product.
 - It must be ensured that the installation location and point of use of the product provides sufficient load-bearing capacity and good stability.
-

DANGER

Falling or tipping parts may cause life-threatening injuries!

Tipping or falling loads lead to severe to fatal injuries.

- Observe the total weight, attachment points and centre of gravity of the load.
 - Observe the transport instructions and symbols on the transported goods.
-

WARNING

Incorrect connections may cause serious injuries!

Please note the necessary safeguards and only have the product connected by trained specialists.

NOTE

Ensure that the welding current return line between the workpiece and the welding machine has a low resistance and that connections between the workpiece and the product are avoided so that the welding current cannot flow back to the welding machine via the product's protective conductor.

NOTE

If add-on products are also present, follow the appropriate manuals when assembling them.

The basic product is delivered ready for operation. Remove the outer packaging and the tension straps of the product.

5.1 Note regarding transport

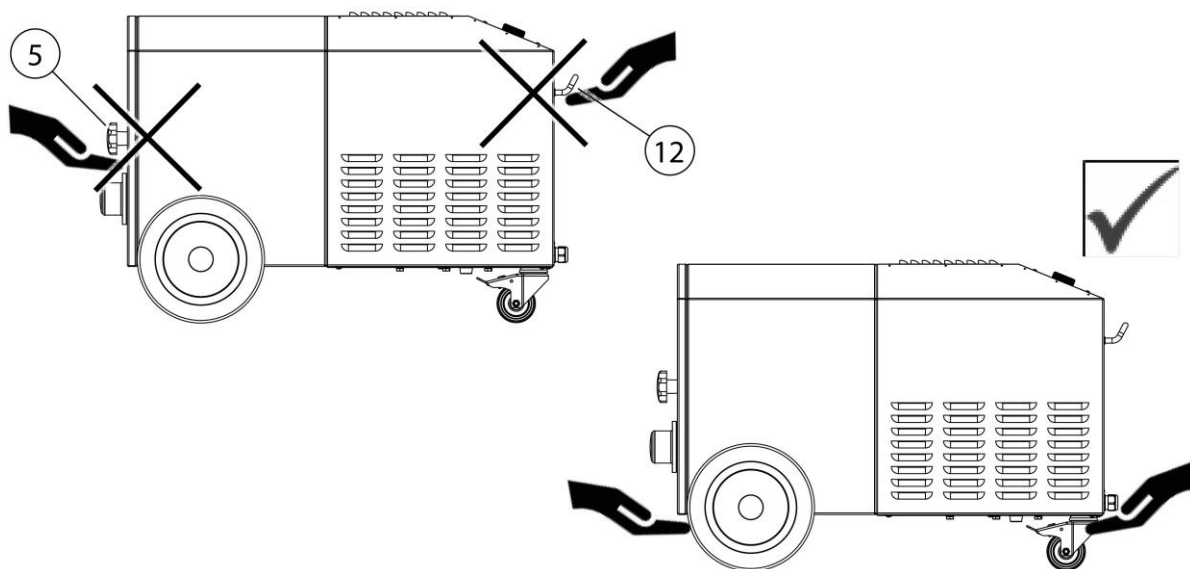


Fig. 3: Note regarding transport

Pos.	Description	Pos.	Description
5	Star screw	12	Cable holder

Tab. 4: Note regarding transport

ATTENTION

Damage during transport of the product!

Do not transport or lift the product by the star screw (Pos. 5) or the cable holder (Pos. 12)!

5.2 Mounting the push handle

The push handle is mounted as follows:

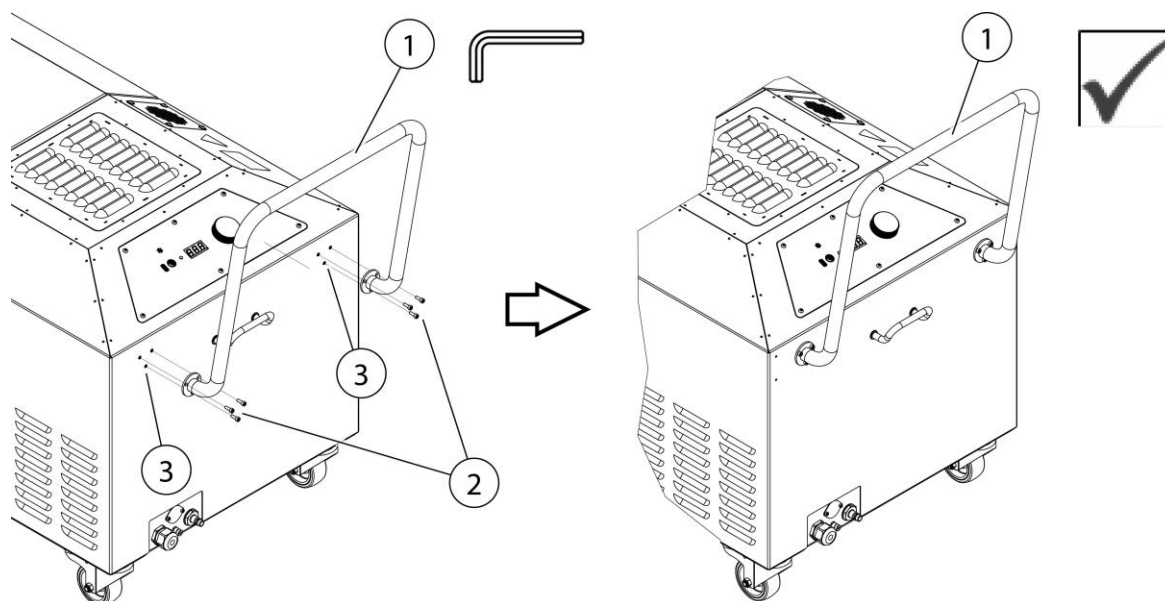


Fig. 4: Mounting the push handle

Pos.	Description	Pos.	Description
1	Push handle	3	Thread – push handle mounting
2	Screws M4 (6 x)		

Tab. 5: Mounting the push handle

1. Screw the push handle (Pos. 1) with the screws (Pos. 2) to the threads (Pos. 3) provided on the product.

⚠ DANGER

Danger of falling or damage to the product!

The push handle (Pos. 1) is only used to push/pull the product.

- Never lift the product by the push handle (Pos. 1)!

6 Use

Every person who deals with use, maintenance and repair of the product must have thoroughly read these operating instructions as well as the instructions for any attachment and accessory products and have understood them.

6.1 Qualification of the operating personnel

The operating company of the product may only commission persons to use the product independently if they are well-versed in this task.

Those familiar with this task includes those who have been instructed appropriately in the task and know the operating instructions as well as the operational issues in question.

The product should only be used by trained or instructed personnel. This is the only way to ensure safety and hazard awareness of all personnel during work.

6.2 Operating elements

Operating controls and connection options are located on the front side of the product:

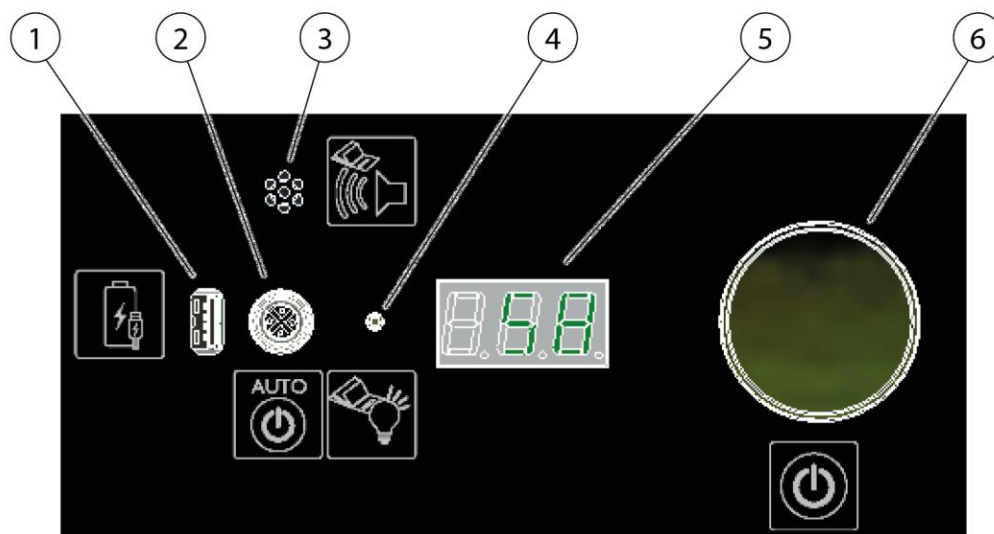


Fig. 5: Operating elements

Pos.	Description	Note
1	USB charging socket	For charging commercially available USB devices
2	Connector socket for start-stop sensor	Optional automatic start/stop. See chapter "Spare parts and accessories"
3	Signal horn	See also chapter "Troubleshooting"
		
4	LED signal lamp	Indicates the current operating status
5	Digital LED display	Indicates settings, parameters, performance values, notes and faults
6	Rotary switch	Switches the product on or off
		Settings and queries can be carried out by turning and pressing the buttons.

Tab. 6: Operating elements

Alarm horn (Pos. 3)

NOTE



Reliable capture of welding fumes is only possible with sufficient extraction capacity. As the dust load on the filter increases, the flow resistance rises and the extraction capacity decreases.

As soon as it drops below a minimum value, the signal horn sounds.

If the integrated cleaning system is no longer sufficient, a filter change is required or the optional cleaning system must be started.

The same happens if the extraction capacity is reduced too much by closing the extraction hose.

A remedy is to check for blockages.

LED signal lamp (Pos. 4)

Signal colours are:

Green – indicates trouble-free operation

White – Menu – Queries and settings

Magenta – indicates one or more warnings (see “Troubleshooting” chapter)

Red – indicates a fault (see “Troubleshooting” chapter)

Digital LED display (Pos. 5)

The digital LED display indicates all settings, parameters and performance values, as well as possible faults and information.

The digital LED display shows [- - -] when switched off.

Rotary switch – Switching the product on/off (Pos. 6)

The rotary switch is used for all menu queries and settings.

- Turn = select, enter
- Press = confirm, acknowledge

As soon as the rotary switch (Pos. 6) is briefly pressed, the product starts and regulates to the last set extraction capacity. Pressing the rotary switch again switches the product off.

After the start-up process, the desired extraction capacity can be set as desired on the rotary switch (Pos. 6).

6.2.1 Menu – Queries and settings

As soon as the rotary switch (Pos. 6) is pressed for approx. 3 seconds, the setting and query menu opens. The LED signal lamp (Pos. 4) lights up white.

In the menu, it is possible to switch between the menu items by turning the rotary switch (Pos. 6). Briefly press to display the value of the respective menu item.

Display	Description 1	Description 2	Setting value
DEL	Delay	Automatic start/stop run-on time	Yes
OPH	Operating hours	Operating hours	
HUS	Hours Until Service	Hours until maintenance	
dP	delta P	Differential pressure of the filter (kPA)	
dPA	Delta P Airflow	Pressure of the extraction volume measurement (kPA)	
tP	torch Pressure	Extraction pipe vacuum (kPA)	
CLE	Cleaning processes	Number of cleaning processes	
rEg	regulation	Extraction volume control is active	
US	1 = US, 0 = Metr.	Displayed units; Metric or US	
FR	Frequency	Motor frequency/motor speed	
Cur	Current	Motor current	
P	Power	Motor power	
°CH	°C Housing	Temperature of the side channel compressor inside the product	
°CA	°C Airflow	Temperature of the extracted air	
°CC	°C CPU	Temperature control	
Li	Limit	Set extraction volume control (optional, only possible with activated regulation) 0 = Extraction volume control off Value = The volume flow is limited to the set value	Yes
SFC	Cleaning	1 = Cleaning start 0 = Cleaning stop	Yes
SEC	Service code	Service codes	Yes

Tab. 7: Menu

6.2.2 Setting the extraction capacity regulation

Automatic extraction capacity regulation is not active

With the standard product, the automatic extraction capacity regulation is deactivated from the factory. If the extraction capacity drops, e.g. when the filter is saturated, the extraction capacity must be corrected manually at the rotary switch. When the rotary switch is turned, the target extraction capacity appears for one second, then the actual extraction capacity appears.

Automatic extraction capacity regulation activated

If the optionally available extraction capacity regulation is activated by means of an activation code, the control constantly monitors the set extraction capacity. If the extraction capacity drops, e.g. when the filter is saturated, the control automatically regulates the speed of the side channel compressors so that the set extraction capacity is guaranteed at the extraction torch.

6.2.3 Activation codes

Advanced functions can be activated by entering activation codes.

Activation codes can be entered a maximum of 5 times in succession. A correct code is signalled by green flashing, an incorrect code by red flashing of the signal lamp (Pos. 4). If an incorrect code has been entered 5 times in succession, the code entry is blocked for 60 seconds. The menu item "SEC" cannot be activated then. Any further incorrect entry will then lock it again for 60 seconds.

6.2.4 Displaying the product ID

To query the three-digit product ID number, press and hold the rotary switch (Pos. 6) for more than 5 seconds.

The ID is required when, for example, the activation codes are to be entered.

6.2.5 Automatic start/stop

As soon as the start/stop module (optional) is connected to the connection socket (Pos. 2), the product switches off and automatically switches to start/stop mode. In start/stop mode, the LED signal lamp flashes green.

When the start/stop module is activated by a welding process, the product starts. After the welding process is finished, the product switches off again after an adjustable run-on time. (Preset run-on time: 30 seconds)

6.2.6 Cleaning (only products with filter cleaning)

Some product variants have a manual cleaning function for the filter cartridge.

When the filter cartridge has reached a certain saturation, the LED display (Pos. 5) shows "CLE". Filter cleaning is required.

To do so, please proceed as follows:

1. Press the rotary switch (Pos. 6) for approx. 3 seconds until "SFC" appears.
2. Press the rotary switch briefly to access the filter cleaning setting.
3. Turn the rotary switch to the right. The setting value changes from 0 to 1. (1 = start of the cleaning)
4. The side channel compressor reduces the extraction capacity, followed by filter cleaning for approx. 15 seconds. The filter cleaning time is running on the digital LED display.
5. If the rotary switch (Pos. 6) is turned to the left during filter cleaning, filter cleaning stops immediately and the product switches to the previously set operating extraction capacity.

6.3 Commissioning

⚠ WARNING

Danger due to faulty product condition.

The product must be fully installed before commissioning begins. All doors must be closed and the necessary connections must have been made.

1. Connect the power supply connection cable of the product to the on-site power supply.
2. Switch on the product by pressing the On/Off switch.
3. The fan starts and the green signal light of the On/Off switch indicates trouble-free operation.

If there is a fault, please refer to the "Troubleshooting" chapter.

7 Maintenance

The instructions in this chapter are intended as minimum requirements. Depending on the operating conditions, further instructions may be required to keep the product in optimal condition.

The maintenance and repair work described in this chapter must only be performed by specially trained repair personnel of the operating company.

Spare parts used must comply with the manufacturer's specified technical requirements.

This is guaranteed if original spare parts are used.

The safe and environmentally friendly disposal of operating materials and replacement parts must be ensured.

The safety instructions in these operating instructions must be observed during maintenance work.

7.1 Care

The care of the product is essentially limited to cleaning all surfaces of the product and – if present – checking the filter inserts.

The warning notices listed in the chapter "Safety notes for maintenance and fault removal" must be observed.

NOTE

The product may not be cleaned with compressed air. This may result in dust and/or dirt particles getting into the ambient air.

Proper care helps to maintain the product in a continuous functional state.

For optimum care and cleaning of the powder-coated surfaces, the following must be observed:

- Thoroughly clean the product monthly or as needed.
- Clean the exterior areas of the product with a suitable industrial vacuum cleaner of dust classification H or with damp soft cloths/industrial cotton wool.
- For stubborn dirt, use commercially available household cleaners. Avoid vigorous rubbing.
- Do not use any abrasive agents that scratch.
- Do not use any acidic or strongly alkaline cleaning agents.
- Do not use organic solvents containing esters, ketones, alcohols, hydrocarbons or similar.

7.2 Maintenance

Regular inspection and servicing have a positive effect on the reliable functioning of the product.

Observe the warning notices for servicing and troubleshooting in the “Safety” chapter.

Maintenance of the product is essentially limited to visual inspection and checking for damage, signs of wear and leaks.

In addition, the following maintenance points must be carried out:

⚠ WARNING

Skin contact with dust particles, etc. may cause skin irritation in sensitive persons.

Serious injury to the lungs and respiratory tract is possible!

To avoid contact with and inhalation of dust particles, wear disposable gloves and disposable respiratory protection, Class FFP2 or higher.

When cleaning, the release of dangerous dust particles must be avoided, so that bystanders are not injured.

NOTE

Do not clean the product with compressed air. This may result in dust particles getting into the ambient air.

Always ensure there is adequate lighting and ventilation for maintenance tasks.

7.2.1 Checking/changing the dust collection container

Depending on usage, the fill level of the dust collection container must be checked once a month and replaced if necessary (approximately 2/3 filled).

The time until dust collection container must be replaced depends on the type and quantity of the dust particles that occur. The operator must check the level by hand at regular intervals to avoid the dust collection container becoming overfull.

The dust collection container must always be exchanged in good time to avoid contamination of the surroundings.

The product must be switched off during a change or when checking the fill level.

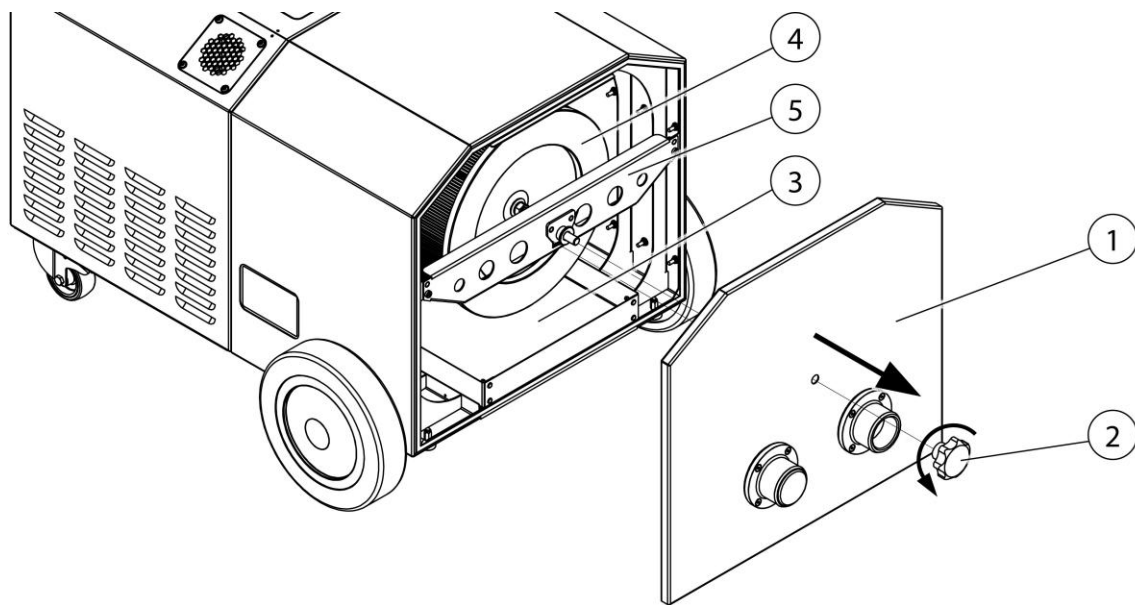


Fig. 6: Access to the dust collection container

Pos.	Description	Pos.	Description
1	Maintenance cover	4	Filter cartridge
2	Star screw	5	U-profile
3	Dust collection container		

Tab. 8: Positions on the product

To replace the dust collection container, please proceed as follows:

1. Switch off the product by pressing the rotary switch.
2. Disconnect the product from the power supply by unplugging.
3. Provide a new dust collection container (Pos. 3) and disposal bag.
4. Dismantle the maintenance cover (Pos. 1) by loosening the star screw (Pos. 2).

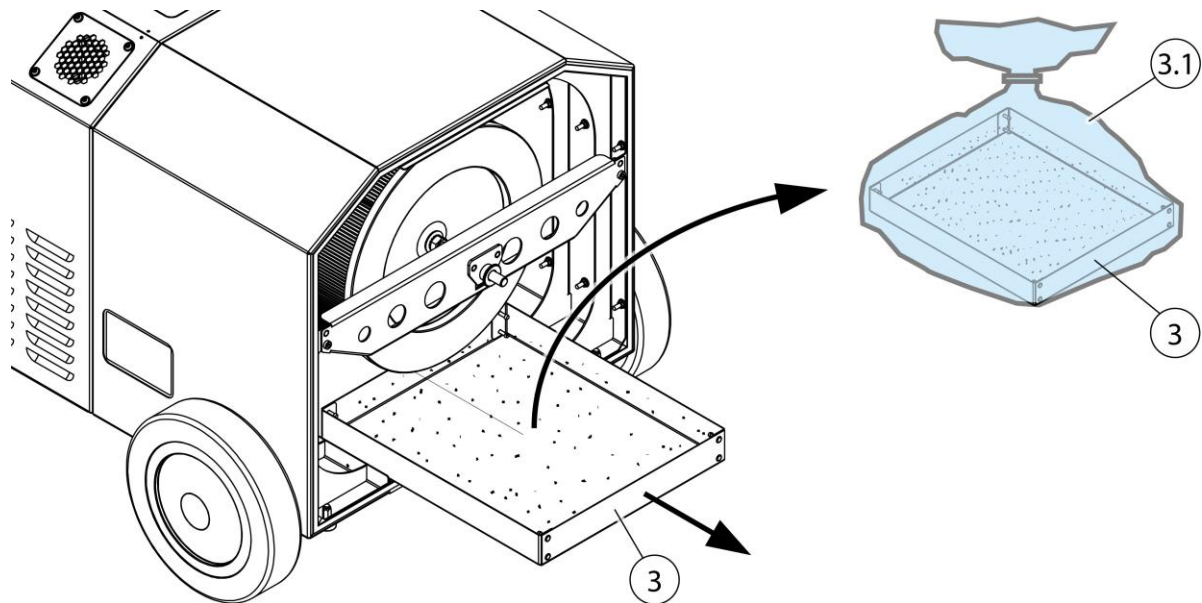


Fig. 7: Changing the dust collection container

Pos.	Description	Pos.	Description
3	Dust collection container	3.1	Disposal bag

Tab. 9: Changing the dust collection container

5. Remove the dust collection container (Pos. 3) from the product and carefully place it in the disposal bag (Pos. 3.1) without stirring up dust.
6. Seal the disposal bag (Pos. 3.1) airtight and dispose of it according to the applicable regulations.
7. Insert the new dust collection container (Pos. 3) into the product and close the maintenance cover (Pos. 1) with the star screw (Pos. 2).
8. Put the product back into operation. See chapter "Commissioning".

7.2.2 Filter mat replacement, motor cooling

Depending on the use, but at least once a month, the filter mat for fan cooling must be replaced.

Perform the filter mat replacement as follows:

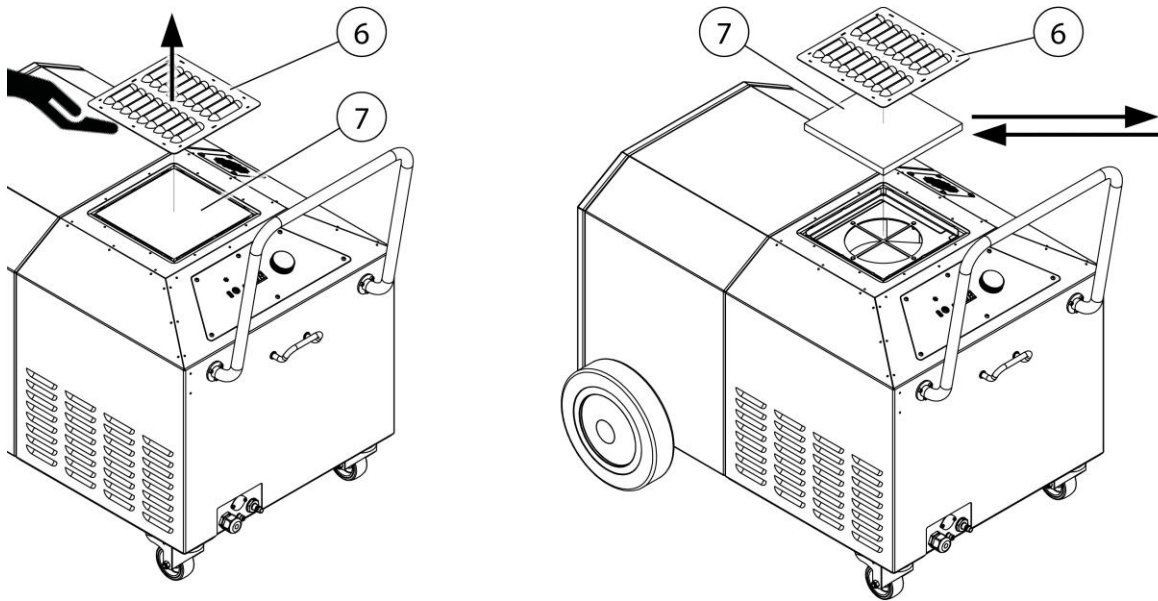


Fig. 8: Filter mat replacement, motor cooling

Pos.	Description	Pos.	Description
6	Vent – motor cooling	7	Filter mat

Tab. 10: Filter mat replacement, motor cooling

1. Switch off the product at the rotary switch.
2. Prepare a new filter mat (Pos. 7).
3. Remove the vent (Pos. 6) from the product by pulling it manually.
4. Remove the contaminated filter mat (Pos. 7) from the holder and dispose of it in accordance with the applicable regulations.
5. Insert the new filter mat (Pos. 7) into the holder.
6. Insert the vent (Pos. 6) onto the holder.
7. Put the product back into operation. See chapter "Commissioning".

7.2.3 Changing the filter – Safety instructions

The life of the filter inserts depends on the type and amount of deposited particles.

As the dust accumulation in the filter increases, its flow resistance increases and the extraction capacity of the product decreases.

Even with products that may have automatic filter cleaning, adhering deposits can reduce the extraction capacity.

A filter change is required.

⚠ WARNING

Health hazards caused by welding fume particles

Do not inhale welding dust / smoke! Serious injury to the lungs and respiratory tract is possible!

Sweat smoke contains substances that can cause cancer!

Skin contact with welding fume particles can cause skin irritation in sensitive individuals.

To avoid contact with and inhalation of these dust particles, wear disposable overalls, protective goggles, gloves and a suitable Class FFP2 respiratory protection filter mask in accordance with EN 149.

**⚠ WARNING**

Cleaning the filter inserts is not permitted. This inevitably leads to damage to the filter element, meaning the filter ceases to function and hazardous substances enter the air.

During the work described in the following section, pay particular attention to the seal on the main filter. Only an undamaged seal allows the product to achieve a high filter efficiency. Main filters with a damaged seal must therefore be replaced every time.

NOTE



Products with W3 certification according to requirements for W3/IFA certified welding fume separation class. (See "Technical data" chapter)

The W3 approval becomes void if:

- The product is used other than as intended or is subject to constructive modifications.
 - Non-original spare parts, in accordance with the spare parts list, are used.
-
- Only original replacement filters, because they guarantee the necessary filter efficiency and are matched to the product and its performance characteristics.
 - Switch the product off using the on/off switch.
 - Secure the product against unintentional switching on. If available, pull out the mains plug or secure the main switch in the 0 position with a padlock.
 - Disconnect the pressure supply, if present, and let the compressed air present in the product flow out via the condensate drain valve.

7.2.4 Main filter change

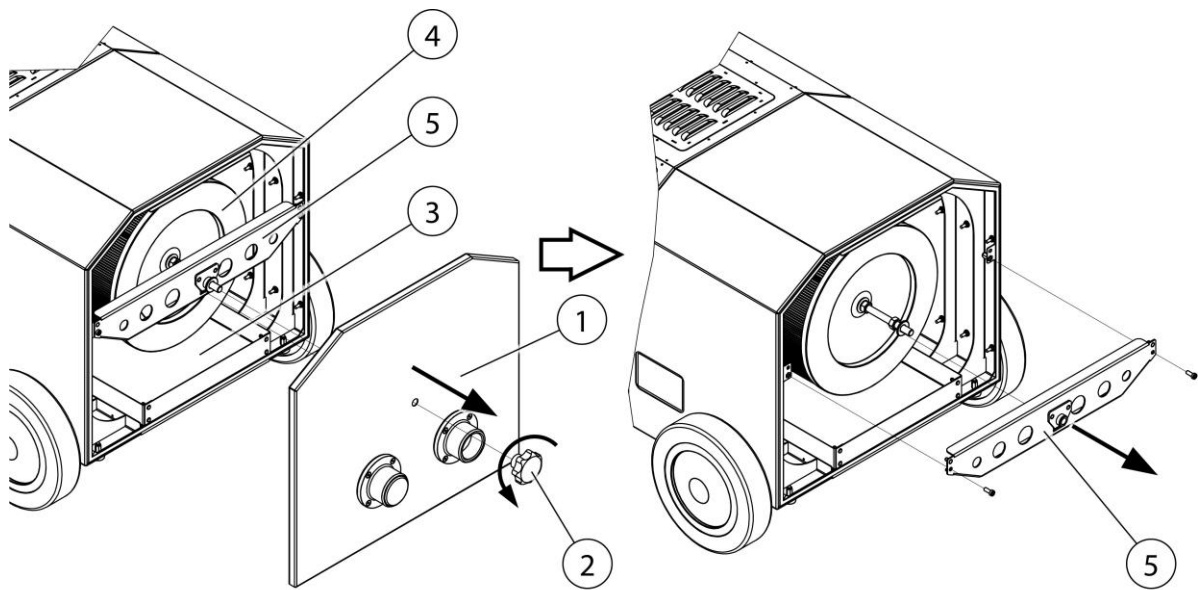


Fig. 9: Access to the main filter

Pos.	Description	Pos.	Description
1	Maintenance cover	4	Filter cartridge
2	Star screw	5	U-profile
3	Dust collection container		

Tab. 11: Access to the main filter

Carry out the main filter replacement as follows:

1. Switch off the product by pressing the rotary switch.
2. Disconnect the product from the power supply by unplugging.
3. Prepare a new filter cartridge (Pos. 4) and the supplied disposal bag (Pos. 4.1).
4. Unscrew the star screw (Pos. 2) and remove the maintenance cover (Pos. 1).
5. Depending on the fill level change the dust collection container (Pos. 3) if necessary.

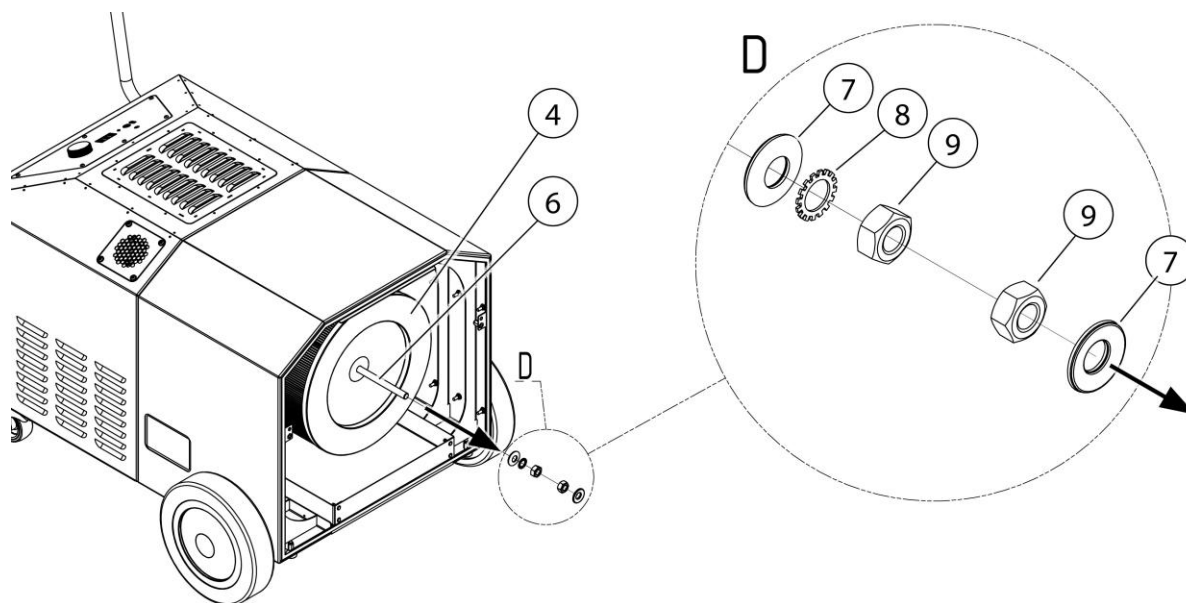


Fig. 10: Dismantling the main filter

Pos.	Description	Pos.	Description
4	Filter cartridge	8	Serrated lock washer
6	Threaded rod	9	Hexagon nut
7	Sealing washer		

Tab. 12: Dismantling the main filter

- Loosen the filter cartridge (Pos. 4) by removing the hexagon nuts, sealing washers and serrated lock washer (Pos. 7 – 9) from the threaded rod (Pos. 6).

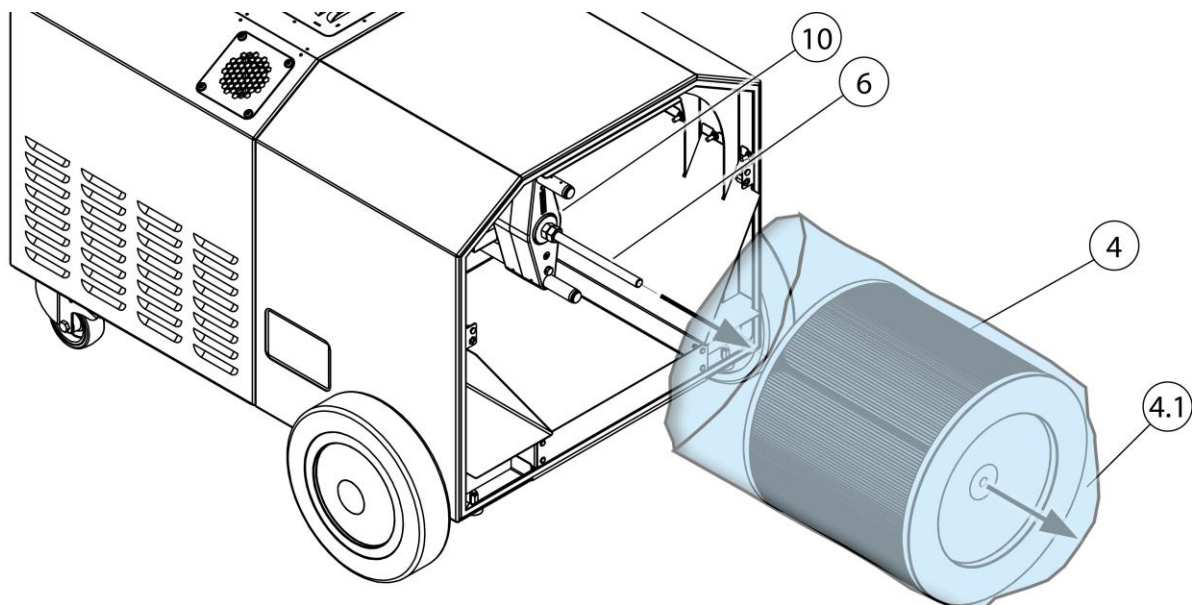


Fig. 11: Removing the main filter

Pos.	Description	Pos.	Description
4	Filter cartridge	6	Threaded rod
4.1	Disposal bag	10	Rotating nozzle

Tab. 13: Removing the main filter

7. Carefully place the disposal bag (Pos. 4.1) over the contaminated filter cartridge (Pos. 4) without raising dust.
8. Remove the disposal bag (Pos. 4.1) with the filter cartridge (Pos. 4) from the product.
9. Seal the disposal bag (Pos. 4.1) with the filter cartridge (Pos. 4) airtight and dispose of it in accordance with applicable regulations.

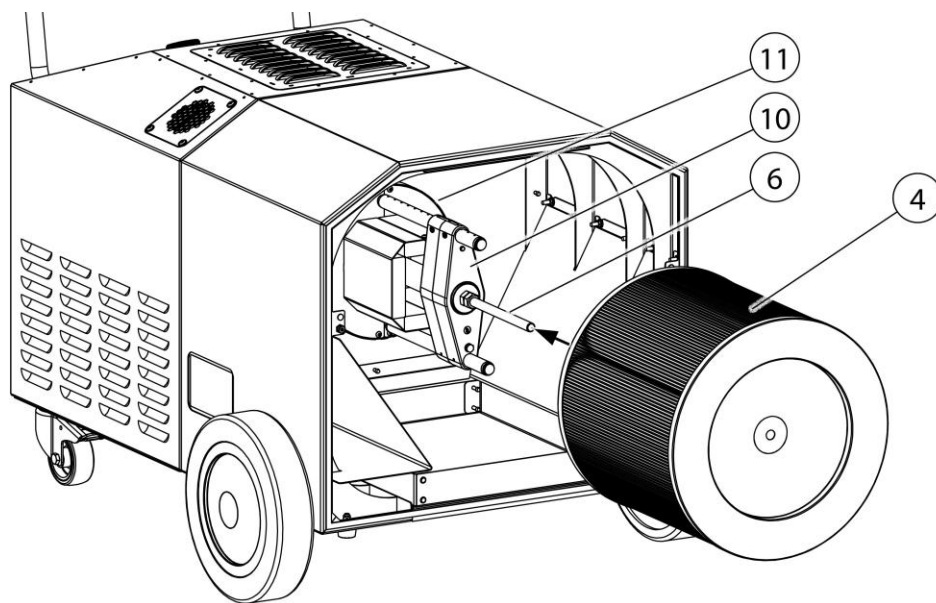


Fig. 12: Inserting new main filter

Pos.	Description	Pos.	Description
4	Filter cartridge (new)	10	Rotating nozzle
6	Threaded rod	11	Sealing surfaces – filter holder

Tab. 14: Inserting new main filter

10. Insert the new filter cartridge (Pos. 4) into the product, pushing the filter cartridge (Pos. 4) over the threaded rod (Pos. 6) of the rotary nozzle (Pos. 10) and making sure that the sealing surfaces in the rear area of the filter cartridge (Pos. 11) are airtight all around.

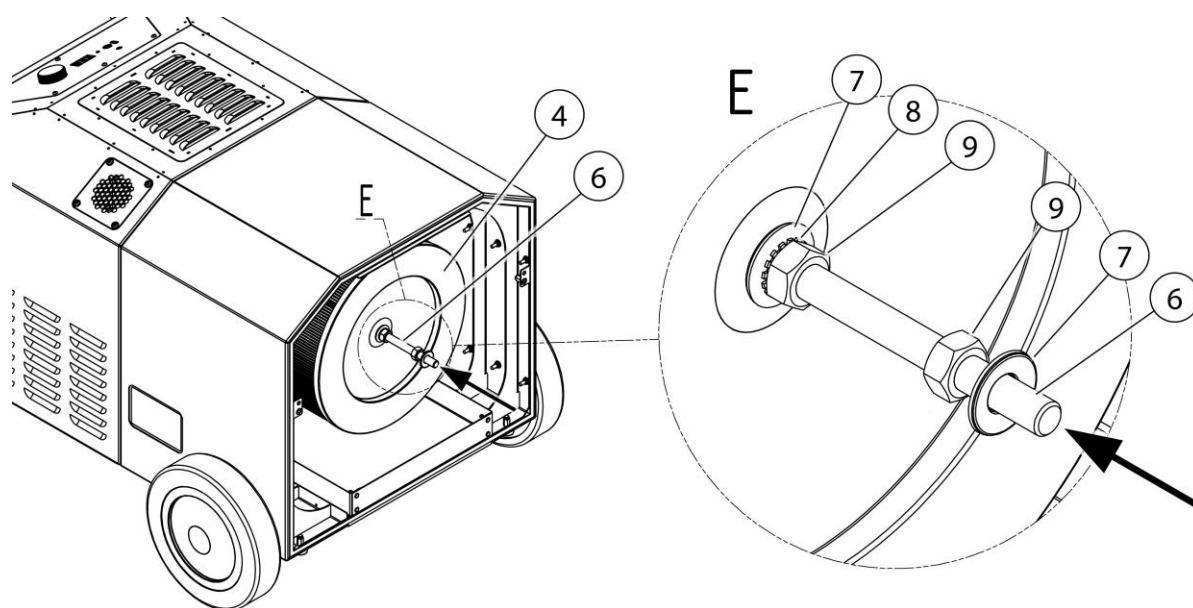


Fig. 13: Fastening the main filter

Pos.	Description	Pos.	Description
4	Filter cartridge	8	Serrated lock washer
6	Threaded rod	9	Hexagon nut
7	Sealing washer		

Tab. 15: Fastening the main filter

11. As shown in the figure, fasten the filter cartridge (Pos. 4) with the sealing washer, serrated washer and hexagon nut (Pos. 7 – 9).

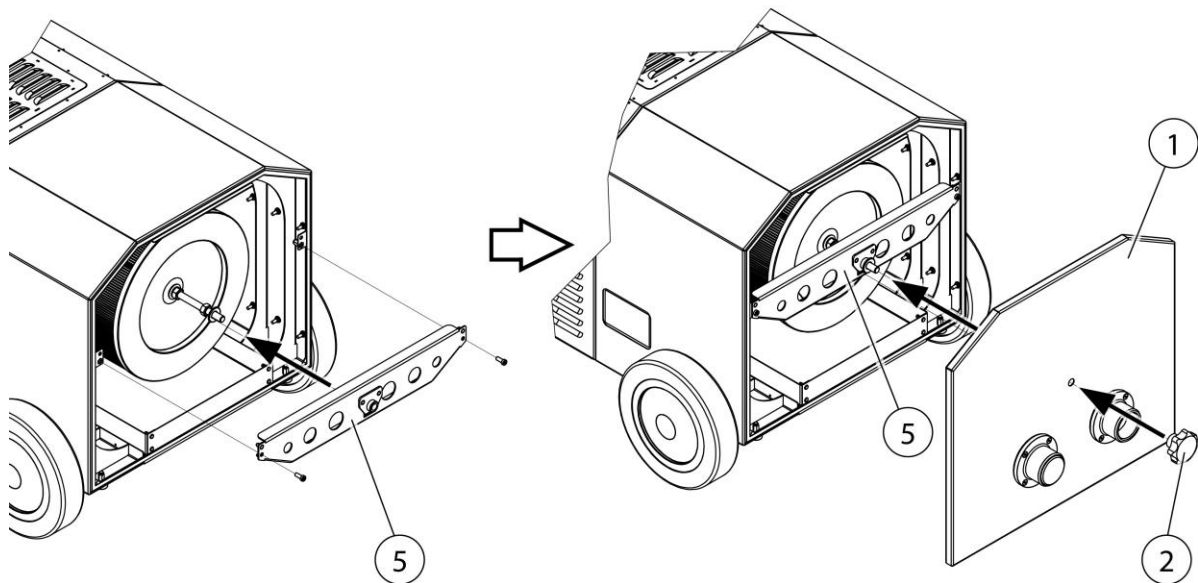


Fig. 14: Mounting the U-profile + maintenance cover

Pos.	Description	Pos.	Description
1	Maintenance cover	5	U-profile
2	Star screw		

Tab. 16: Mounting the U-profile + maintenance cover

12. Mount the U-profile (Pos. 5) to the product using the two screws as shown in the figure.
13. Close the maintenance area again by mounting the maintenance cover (Pos. 1) with the star screw (Pos. 2). When mounting, make sure that the sealing surfaces of the maintenance cover fit evenly all around.
14. Reconnect the product to the power supply by plugging in.
15. Put the product back into operation. See chapter "Commissioning".

7.3 Troubleshooting

Fault	Cause	Note
Product will not start up	No mains voltage	Have it checked by a qualified electrician

	Start/stop sensor (optional fitting) connected but no welding current detected. Welding process not yet started	Start welding process
Not all fumes are being captured	Draught	Avoid draughts
	Incorrect extraction capacity set	Check and correct required extraction capacity
Extraction capacity too low/non-existent	Filter inserts saturated	Replace filter inserts
	Welding burner clogged	Clean the welding burner
Dust escapes on the clean air side	Filter inserts damaged	Replace filter inserts
Product/filter does not clean	No compressed air supply available. Pressure/compressed air quantity not sufficient	(only for products with cleaning filter)
Product switches off	Temperature of a product component too high	See chapter: Error codes – digital LED display
		Allow product to cool down
Signal horn sounds	Extraction capacity too low	Change filter insert
		Clean the welding burner
		Start cleaning (only for product with rotating nozzle + cleaning filter)

Tab. 17: Troubleshooting

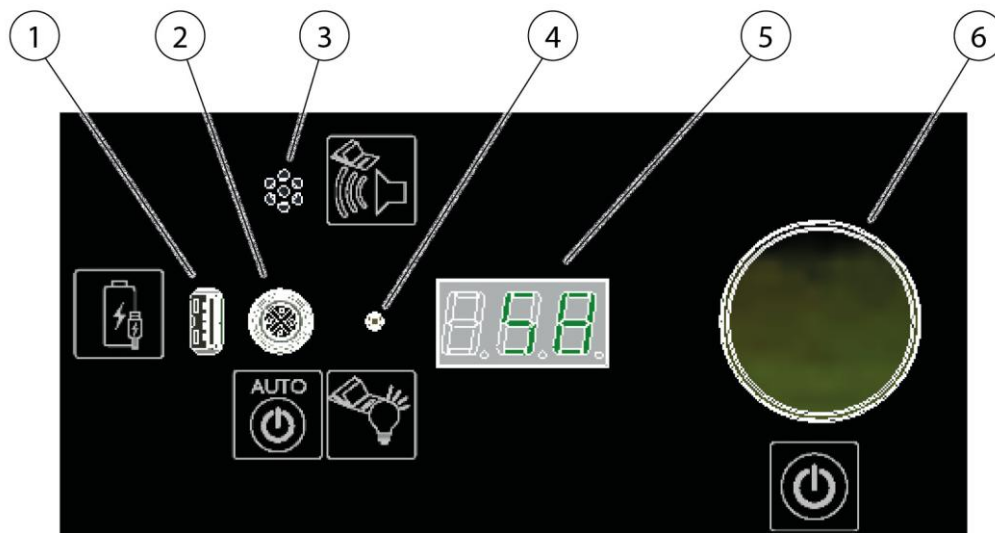


Fig. 15: Operating control

Pos.	Description	Pos.	Description
1	USB charging socket	4	LED signal lamp
2	Connection socket for start/stop sensor	5	Digital LED display
3	Signal horn	6	Inductive one-button operation (rotary switch)

Tab. 18: Operating control

The digital LED display (Pos. 5) shows errors and information codes. A distinction is made between:

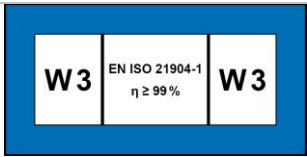
- **Error codes:** In the event of an error, the product switches off immediately. The LED signal lamp (Pos. 4) lights up red. Troubleshooting measures are required
- **Warning codes:** If there are warnings, the product continues to run. The LED signal lamp (Pos. 4) flashes magenta and after 5 minutes a warning tone sounds. Product functions may no longer be active. If several warning codes are active, they are shown one after the other on the digital LED display. After all warning codes have been displayed, they reappear after 5 minutes. Warnings can be called up by turning and pressing the rotary pushbutton (Pos. 6) and hidden for 5 minutes.

7.4 Error codes – digital LED display

Error code	Error cause	Reaction of the control	Note
F01	Frequency converter overcurrent	Product switches off	Check the voltage supply
F02	Frequency converter overvoltage	Product switches off	Check the voltage supply
F03	Frequency converter undervoltage	Product switches off	Check the voltage supply
F04	Frequency converter overtemperature	Product switches off	Check the voltage supply
F60	Internal frequency converter fault	Product switches off	Contact service department
F 90	No communication to the frequency converter	-	Disconnect the product from the power supply for approximately 60 seconds / Contact service
F91	Motor temperature too high	Product switches off	Allow product to cool down
F92	Control temperature too high	Product switches off	Allow product to cool down

Tab. 19: Error codes

7.5 Warning codes – digital LED display

Code	Cause	Note
SER (A01)	Service due	Perform service
CLE (A02)	Differential pressure too high	Clean the filter! (see chapter Use - Cleaning)
A02	Vacuum in extraction pipe too high	Check the extraction pipe for blockage
A03	Extraction volume measurement sensor error	The digital LED display shows the motor frequency, contact service
A05	Extraction capacity not sufficient.	 Horn active
	The required extraction capacity for the connected extraction torch is not reached.	Check the extraction torch for blockage. Carry out a filter change.
A06	Control temperature increased (15 °C below switch-off limit)	No measure required
A07	Temperature in the unit increased (15 °C below switch-off limit)	No measure required

Tab. 20: Warning codes

NOTE

Overload protection

If the vacuum in the extraction pipe rises above 22,000 Pa and the temperature in the product exceeds a certain threshold, the product automatically reduces the extraction capacity to avoid overloading the product.

NOTE

If the fault cannot be corrected by the customer, please contact the manufacturer's service department.

7.6 Emergency measures

In case of fire of the product or its detection elements, the following steps should be taken if necessary:

1. Disconnect the product from the mains! If present; pull out mains plug; set main switch to 0-position; disconnect supply fuses.
2. If present, disconnect the compressed air supply.
3. Fight fire with a commercially available dry powder extinguisher.
4. Notify local fire brigade if necessary.

⚠ WARNING

Do not open products with maintenance door. Flash flame formation!

In the event of a fire, do not touch the product under any circumstances without proper protective gloves. Risk of burns!

8 Disposal

⚠ WARNING

Skin contact with welding fumes, etc. can cause skin irritation in susceptible individuals.

Disassembly work on the product may only be carried out by trained and authorised personnel while complying with the safety rules and the applicable accident prevention regulations.

Serious injury to the lungs and respiratory tract is possible!

In order to avoid contact with and inhalation of dust particles, use protective clothing, gloves and a blower respirator system.

The release of hazardous dust particles must be avoided during dismantling work so that persons in the vicinity are not harmed.

⚠ CAUTION

All work on and with the product must comply with the legal obligations for waste avoidance and proper recycling/disposal.

8.1 Plastics

Plastics, if present, must be sorted as far as possible. Plastics must be disposed of in compliance with the legal requirements.

8.2 Metals

Metals, if present, must be separated and disposed of.
Disposal must be carried out by an authorised company.

8.3 Filter elements

Filter elements, if present, must be disposed of in compliance with the legal requirements.

9 Annex

9.1 EU Declaration of Conformity

Designation: Welding smoke filter unit
 Series: VacuFil Compact Twin
 Type: 82380, 82381, 82382 (possibly different article numbers for other product variants)
 Machine ID: (serial number) see the name plate on the product
 This product is developed, designed and manufactured in accordance with EC directives
 2006/42/EC – Machinery Directive

 The product continues to comply with the provisions of the
 2014/30/EU - EMC Directive
 2011/65/EU – RoHS Directive

 At the sole responsibility of
 Company: KEMPER GmbH
 Von-Siemens-Str. 20, D-48691 Vreden

The following harmonised standards are used:

EN ISO 12100:2010 Safety of machinery - General principles for design
 EN ISO 13857:2019 Safety of machinery - Safety distances
 EN ISO 13854:2019 Safety of machinery - Minimum gaps
 EN ISO 4414:2010 fluid power - General rules and safety requirements for systems and their components
 EN ISO 21904-1:2020 Health and safety in welding and allied processes
 EN IEC 61000-6-2:2019 Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity standard for industrial environments
 EN IEC 61000-6-4:2019 Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments
 EN 60204-1:2018 Safety of machinery - Electrical equipment of machines
 EN ISO 13849-1:2023 Safety of machinery - Safety-related parts of control systems

A complete list of standards, directives and specifications applied is available from the manufacturer. The operating manual belonging to the product is available.

Authorised representative:

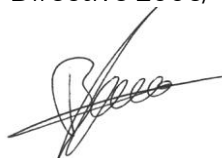
Kemper GmbH, Von-Siemens-Str. 20, 48691 Vreden, Germany

The aforementioned person is authorised to compile the technical documentation in accordance with Annex VII of Directive 2006/42/EC.

Vreden, 24.04.2026

Place, date

B. KEMPER



CEO

Identification of the signatory

9.2 UKCA Declaration of Conformity

Designation: Welding fume filter unit
 Series: VacuFil Compact Twin
 Type: **82380, 82381, 82382** (possibly different article numbers for other product variants)
 Machine ID: (Serial number) see type plate on product
 This product is developed, designed and manufactured in accordance with the UKCA directives
 Supply of Machinery (safety) Regulations 2008

The product continues to comply with the provisions of the
 Electromagnetic Compatibility Regulations 2016
 Electrical Equipment (Safety) Regulations 2016

At the sole responsibility of
 Company: **KEMPER GmbH**
 Von-Siemens-Str. 20, D-48691 Vreden

The following designated standards and technical specifications have been applied:

BS EN ISO 12100:2010 Safety of machinery - General principles for design
 BS EN ISO 13857:2019 Safety of machinery - Safety distances
 BS EN ISO 13854:2019 Safety of machinery
 BS EN ISO 4414:2010 fluid power - General rules and safety requirements for systems and their components
 BS EN ISO 21904-1:2020 Health and safety in welding and allied processes
 BS EN IEC 61000-6-2:2019 Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity standard for industrial environments
 BS EN IEC 61000-6-4:2019 Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments
 BS EN 60204-1:2018 Safety of machinery - Electrical equipment of machines
 BS EN ISO 13849-1:2023 Safety of machinery - Safety-related parts of control systems
 BS EN IEC 63000:2018 Technical documentation for the assessment of electrical and electronic products with respect to the restriction of hazardous substances

A complete list of standards, directives and specifications applied is available from the manufacturer. The operating manual belonging to the product is available.
 Additional information:

UK Authorised Representative:
 United Kingdom KEMPER (U.K.) Ltd.
 Venture Court, 2 Debdale Road, Wellingborough, Northamptonshire NN8 5AA
 The above-mentioned person is authorized to compile the technical documentation in Schedule 2 of the Supply of Machinery (Safety) Regulations 2008.

Vreden, 24.04.2026
 Place, date

B. Kemper

CEO
 Identification of the signatory

9.3 Technical data

Designation	Type		
Filters	82380	82381	82382
Filter stages	1		
Filter method	Cleanable filter		
Cleaning method	Rotating nozzle		
Filter surface m ² [ft ²]	6.7 [72]		
Number of filter elements	1		
Total filter surface m ² [ft ²]	6.7 [72]		
Type of filter	Filter cartridge		
Filter material	ePTFE membrane		
Filter efficiency ≥ %	99.9		
Welding fumes class	--		
Test standard	--		
Filter class/dust classification	M		
Basic data			
Maximum fan capacity m ³ /h [CFM]	280 [165]		
Extraction capacity m ³ /h [CFM]	215 [127]		
Vacuum Pa [inch WC]	32,000 [129]		
Motor power kW [hp]	3.8 [5.1]		
Power supply/rated current/protection type/ISO class	See name plate		
Permissible ambient temperature (operation) °C [°F]	+5 to +40 [+41 to +104]		
Duty cycle %	100		
Noise level dB(A)	75		
Compressed air supply bar [PSI]	6 – 8 [87 – 116]		
Compressed air consumption NI/min [CFM]	400 [14]		
Compressed air class	2:4:2 ISO 8573-1		
Dimensions of the basic product W x H x D	See Dimensions sheet		
Basic product weight kg [lbs]	96 [212]		
Additional information			

Fan type	Side channel blower
Extraction capacity regulation	Manual/optional
Maximum installation environment above sea level m (mean sea level metres) [ft]	1500 [4921]

Table 21: Technical data 82380,82381,82382

Characteristic curve:

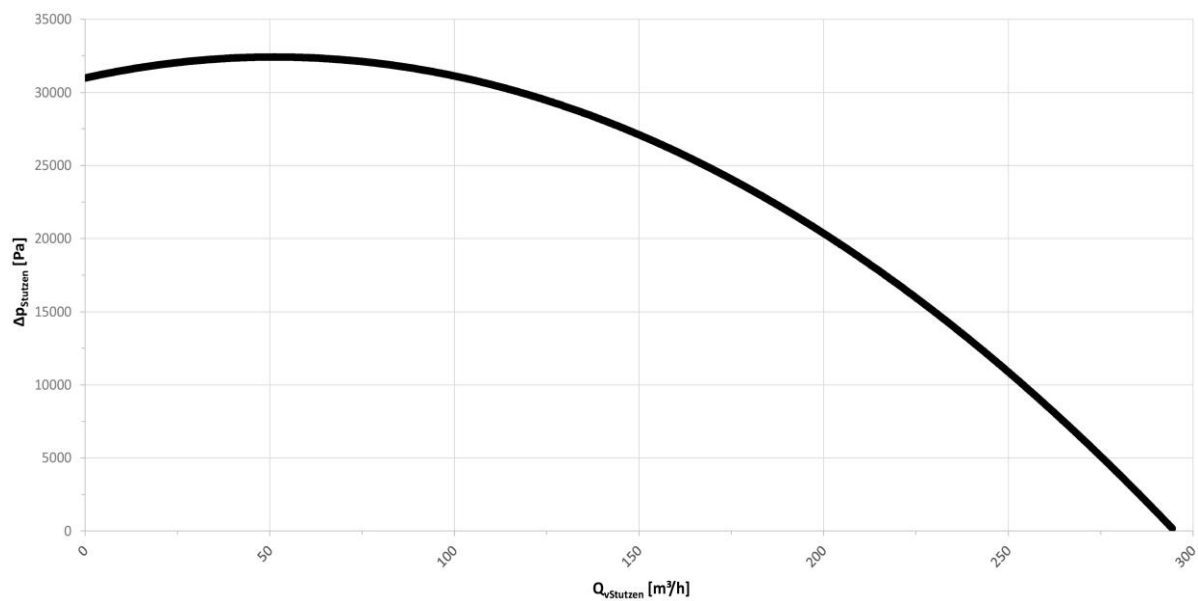


Fig. 16: Characteristic curve

9.4 Dimensions sheet – Product without accessories

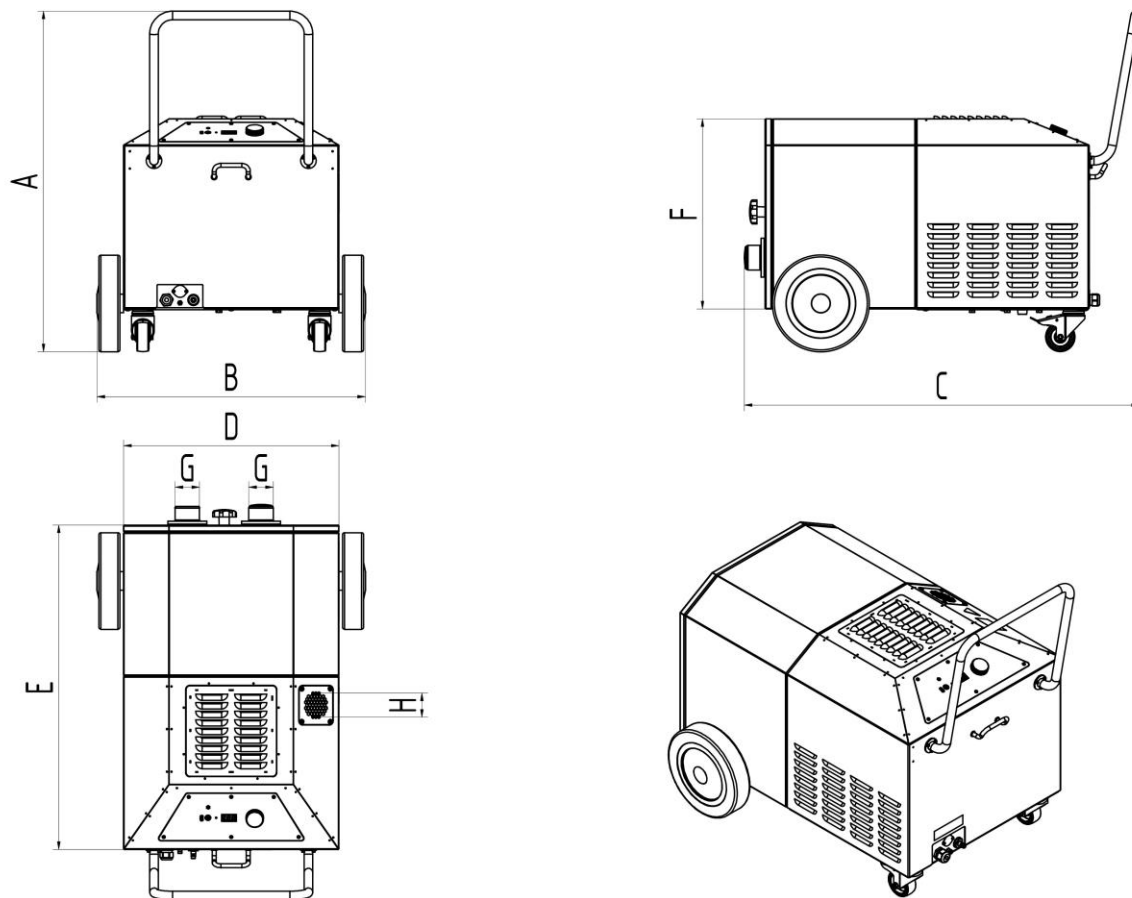


Fig. 17: Dimensions sheet – Product without accessories

Symbol	Dimensions mm [in]	Symbol	Dimensions mm [in]
A	878 [34.6]	E	836 [32.9]
B	691 [27.2]	F	490 [19.3]
C	1018 [40.1]	G	Ø 63 [Ø 2.5]/ Ø 45 [Ø 1.8]
D	555 [21.6]	H	Ø 63 [Ø 2.5]

Tab. 22: Dimensions table

9.5 Spare parts and accessories

Consec. no.	Description	Pos. no.
1	Main filter – disposable filter	1090676
2	Main filter – cleaning filter	1090699
3	Pre-filter mat motor cooling (set of 10)	1090472
4	6-litre disposable disposal container	1490775
5	Extraction hose 2.5 m Ø 45 mm	93070004
6	Extraction hose 5.0 m Ø 45 mm	93070005
7	Extraction hose 10.0 m Ø 45 mm	93070006
8	Suction hose 5,0m Ø 63mm	1140864
9	Suction hose 7,5m Ø 63mm	1140865
10	Suction hose 10,0m Ø 63mm	1140866
11	Connector for suction hose NW 45/ NW63	1061188
12	Funnel nozzle, round, suction opening Ø210 mm	2320006
13	Slit nozzle, width 300 mm, with magnetic base	2320008
14	Slit nozzle, width 600 mm, with magnetic base	2320009
15	Funnel nozzle, flexible with magnetic base	2320010
16	Adapter for welding guns 42–44 mm	1060071
17	Adapter for welding guns 39–42 mm	1060104
18	Adapter for welding guns 30–38 mm	1060084
19	Automatic start/stop	94102702
20	Tool tray with cup holder	1490776
21	Extraction capacity regulation	1180838
22	Bow handle	1490778
23	Wheel set	6430012

Tab. 23: Spare parts and accessories

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