

6337500 - FIELD INSTALLATION OF MASTERCRAFT VACUUM FOR 633

1. Install the Vacuum hose bracket (6509269) on the belt cover for the grinding head housing. Use the second mounting bolt back from the grinding wheel as shown in Figure 1.
2. Secure using the B251018 ¼-20 x 5/8 pan head machine screw in place of the ½ inch long screw used before. Reuse the cable clamp for the proximity sensor that was in that location.

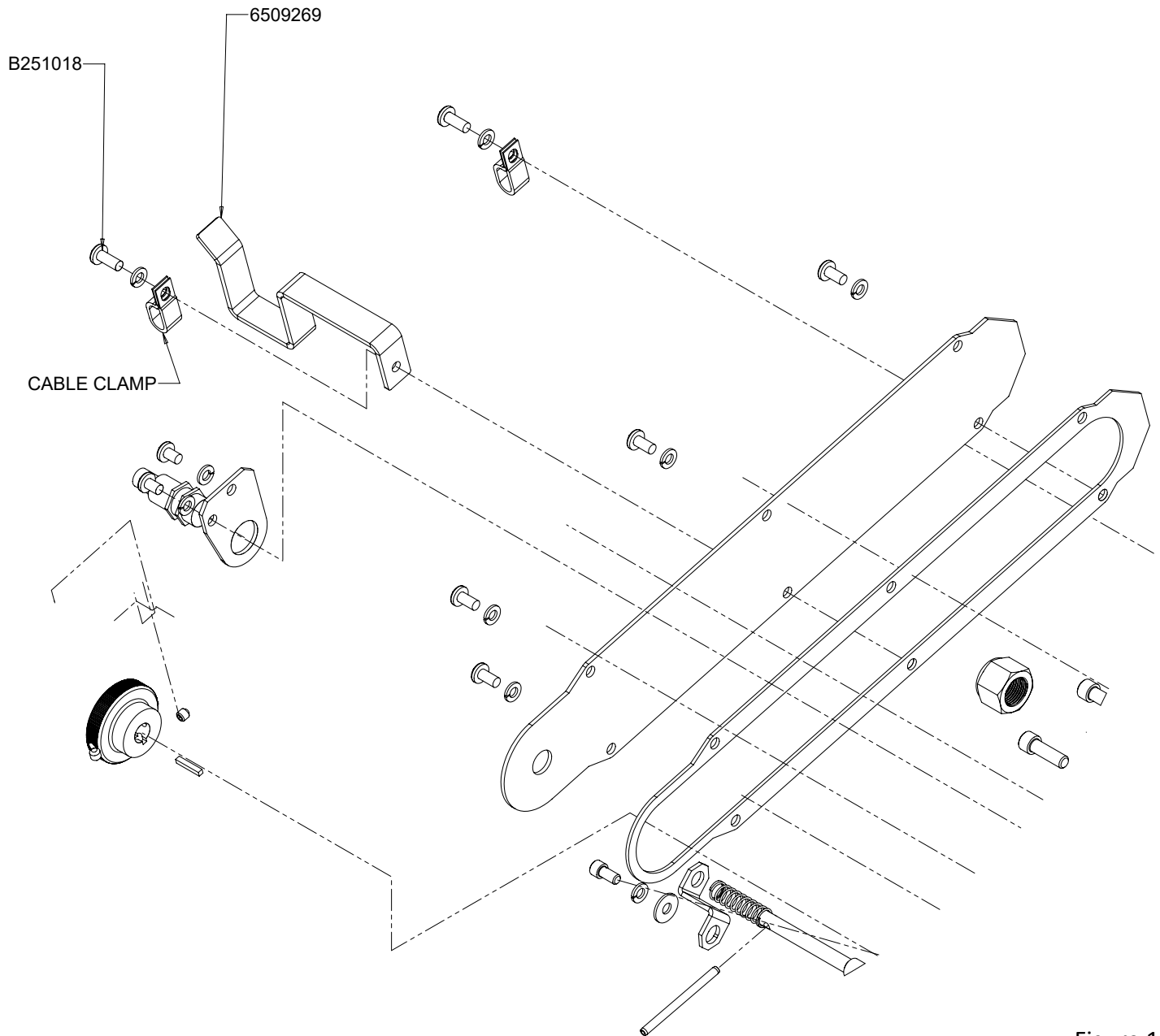


Figure 1

3. Open the Vacuum Door Weldment on rear left hand side of the machine by turning the wing handle cam lock. Swing the door open.
4. Set the vacuum assembly in the compartment next to the left leg of the frame. Align the Pressure Relief Valve of the Vacuum with the Vacuum Access Hole in the Vacuum Door Weldment when the door is closed and locked.
5. Locate the Vacuum Hose and install the Adapter onto the grinding wheel end of the hose. Attach the hose to the top of the vacuum (see Number 2 on Figure 2) and feed it through the Vacuum Hose Bracket (Number 3). Attach the hose to the grinding head. Squeeze the 6509269-hose bracket to tighten it around the vacuum hose so it does not move as the grinding head moves left to right and back again.
6. Connect the electrical power plug on the vacuum to the power cord with a female receptacle labeled VACUUM and route near the vacuum. The power cord's part number is 6329081.
7. Close the Vacuum Door and place the Vacuum Warning Decal (Number 4) on the outside of the Vacuum Door directly above the Vacuum Relief Valve (Number 1).
8. The vacuum will be powered on when the grinding motor is turned ON.

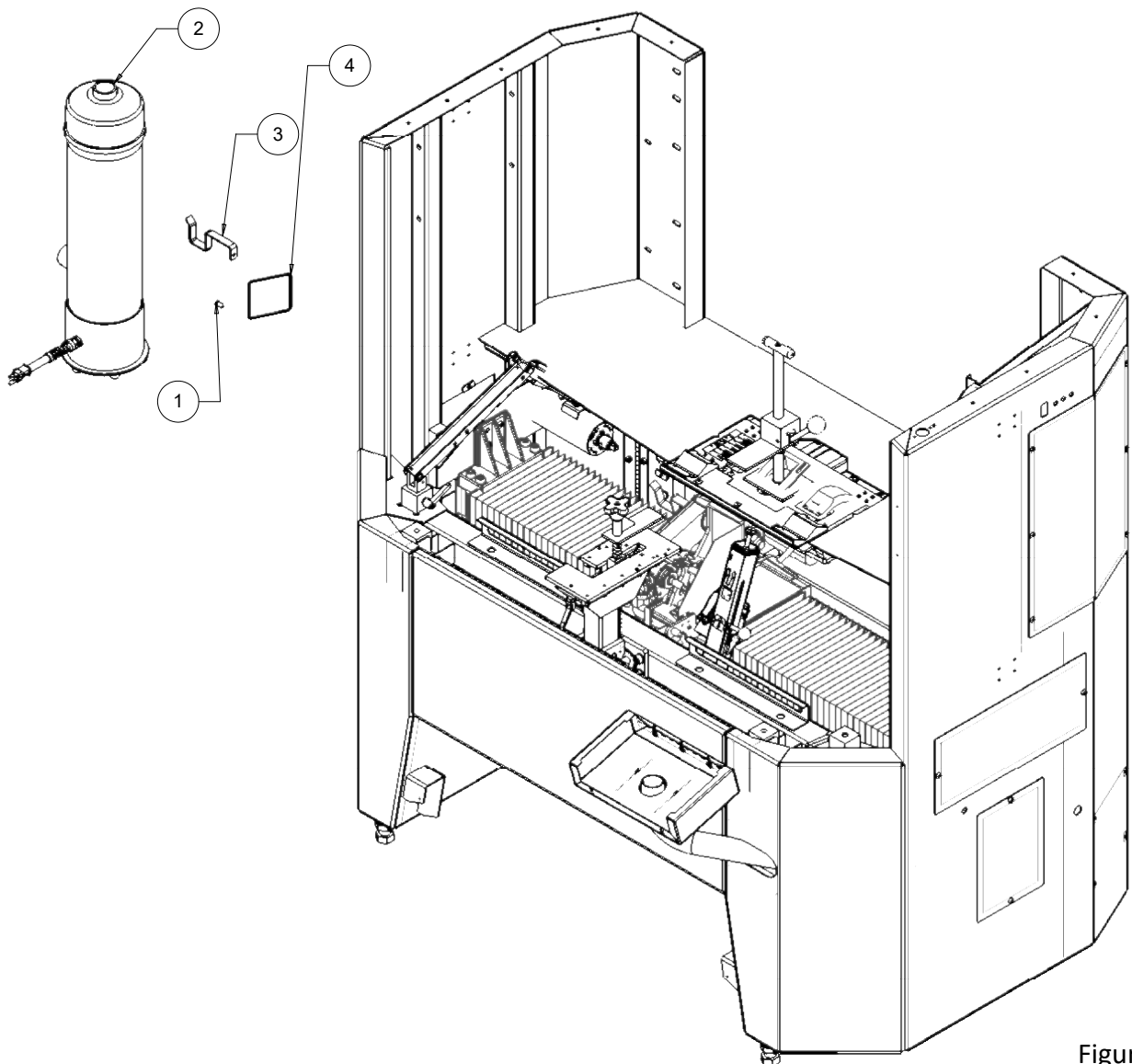


Figure 2