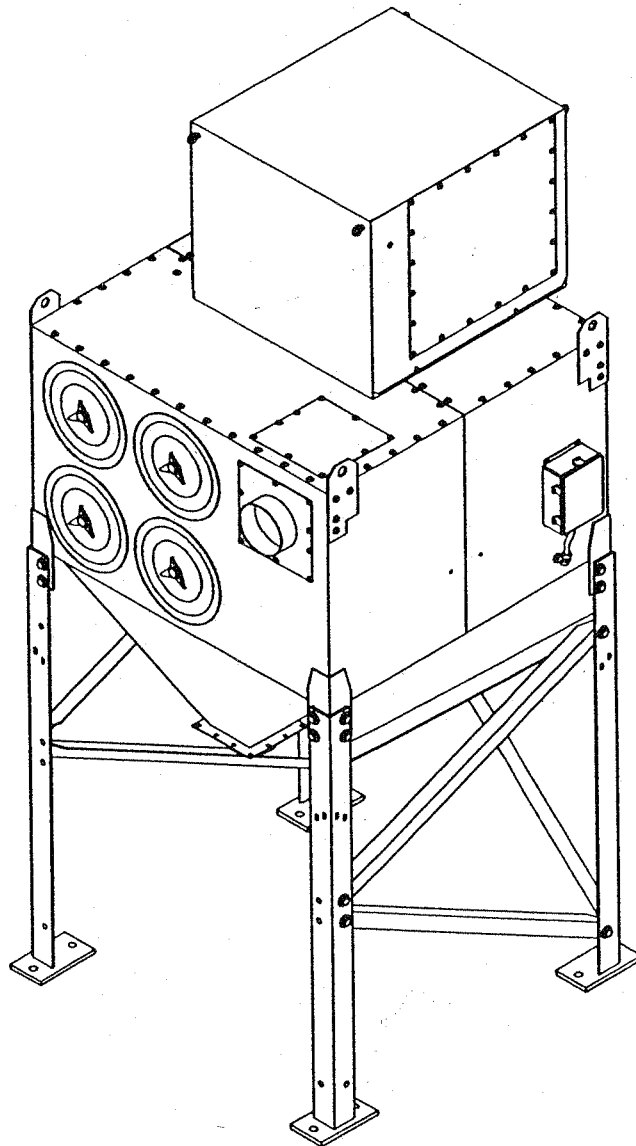


# Empire Abrasive Equipment Company Replacement Parts List

CARTRIDGE FILTER DUST COLLECTOR SYSTEM EM 2-2, EM 2-4



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\*Photohelic is a registered trademarks of Dwyer®  
Instruments, Inc.

### Parts Program

For genuine Empire Abrasive Equipment Company  
replacement filters and parts, call:

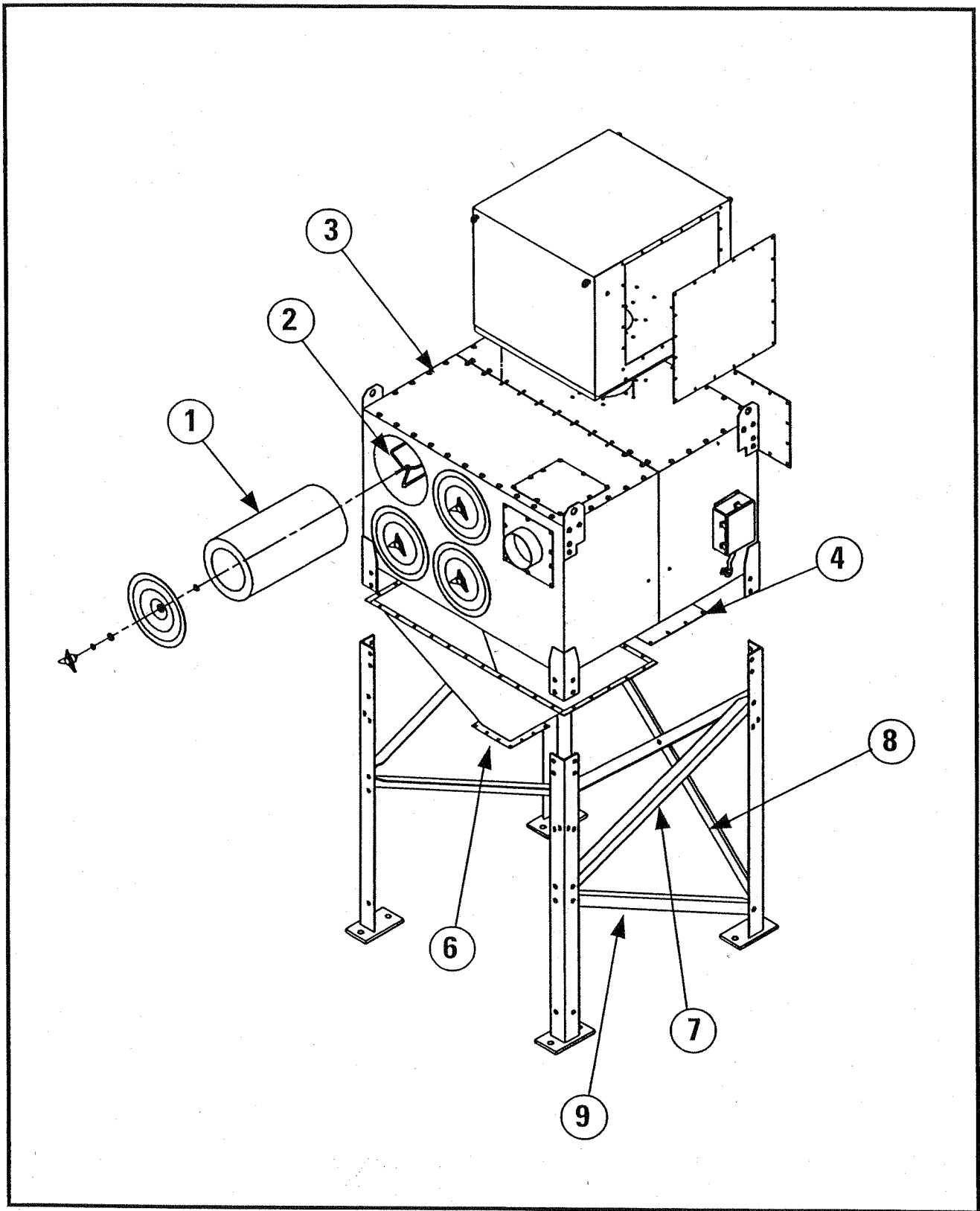
**800-497-4543**

### Parts Ordering Information

When ordering parts, give model number and serial  
number of dust collector, part number, description  
and quantity of parts desired.

## DATA SHEET

Customer Name _____	
Address _____	
Shipping Date _____	Installation Date _____
Model Number _____	Serial Number _____
Filter Medium _____	
Accessories _____	
Other _____	



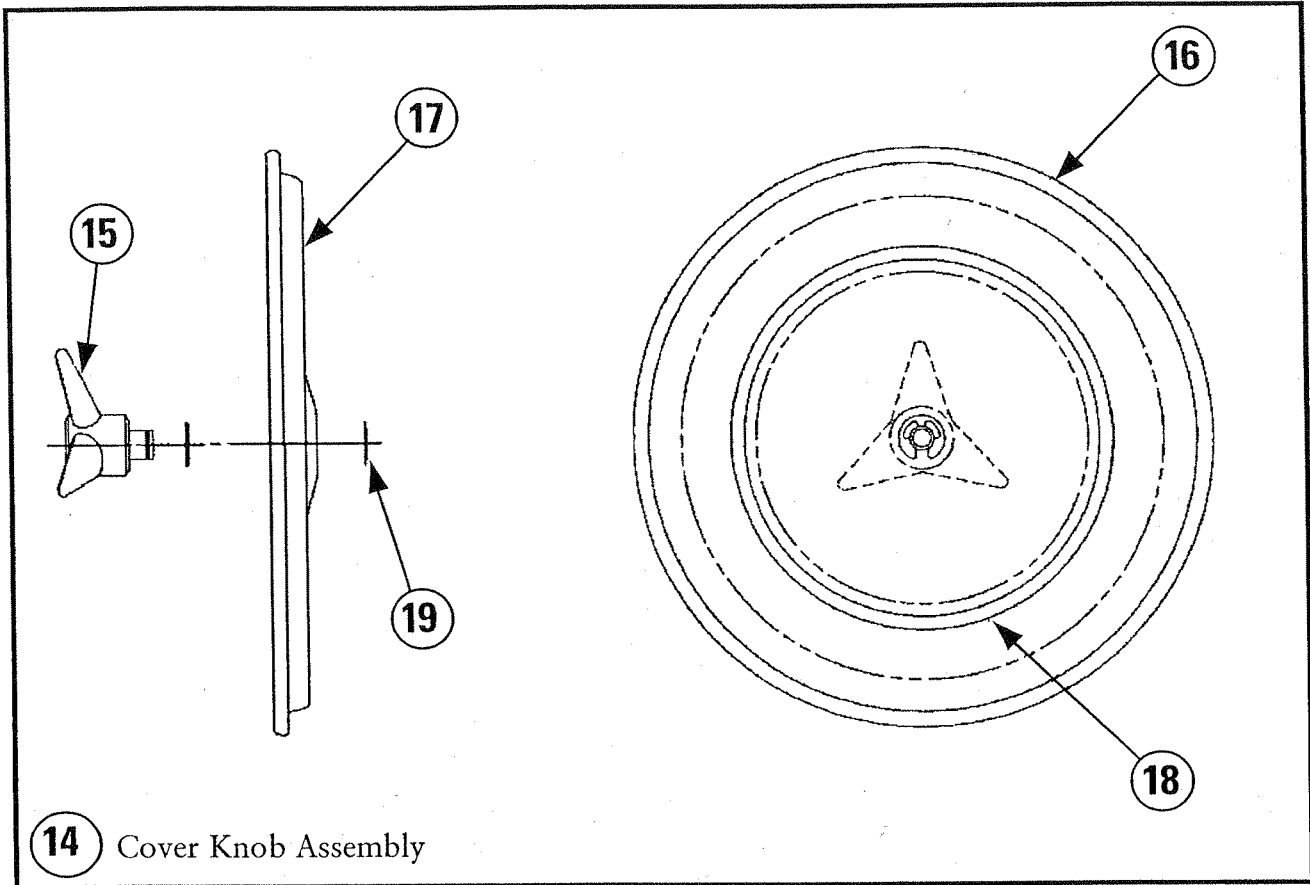
**Parts Drawing 1**  
**Empire Dust Collector**  
**(Model EM 2-4)**

# Replacement Parts List

Parts Dwg. No.	Ref. No.	Part No.	Description	Model
----------------------	-------------	-------------	-------------	-------

1	1	515522	Filter Element .....	All
	2	4MA-57023-01	Yoke .....	All
	3	6MM-58527-01	Cover, D.A. Plenum .....	EM 2-2
	3	6MM-56967-01	Cover, D.A. Plenum .....	EM 2-4
	4	6MM-57111-01	Bottom Outlet Cover Pack .....	All
	6	2SG-57086-01	Hopper Pack .....	EM 2-2
	6	2SG-58515-01	Hopper Pack .....	EM 2-4
	7	6MM-57010-04	Upper Sidebrace .....	All
	8	6MM-57011-01	Backbrace.....	EM 2-2
	8	6MM-57011-02	Backbrace.....	EM 2-4
9	6MM-57010-01	Lower Sidebrace .....	All	

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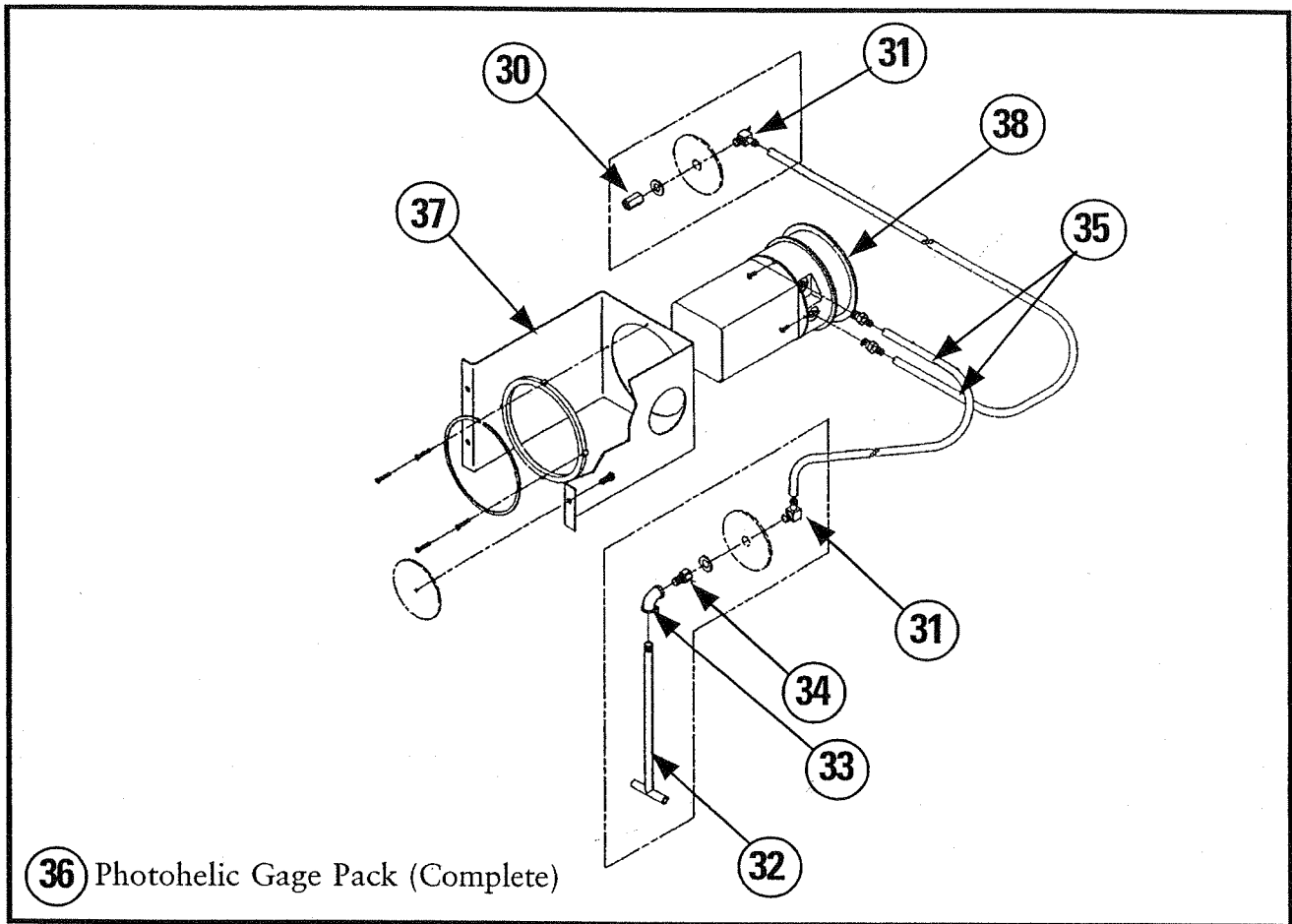


Parts Drawing 2  
Cover Knob Assembly

## Replacement Parts List

Ref. No.	Part No.	Description	Model
14	3EA-31233-01	Cover Knob Assembly .....	All
15	516320	Knob 3 Lobe with Washer .....	All
16	516321	Gasket Cover Filter Access .....	All
17	6MM-31757-00	Cover, Element Filter Access .....	All
18	516322	Gasket 3/8" x 1/2" - 10.12" I.D. ....	All
19	516323	Clip 0.668" I.D. ....	All

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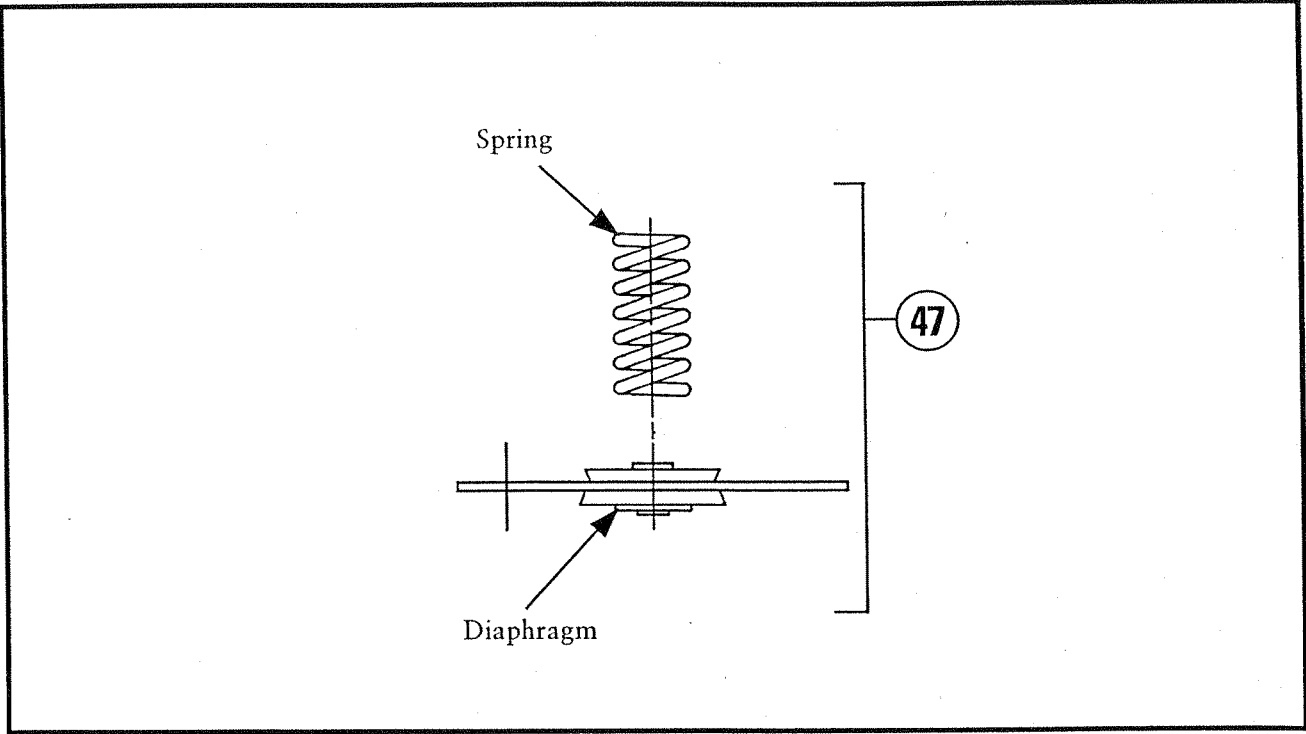
**Parts Drawing 3  
Photohelic Pack**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
----------	----------	-------------	-------

30	8PP-18463-00	Coupling Female 1/8" .....	All
31	8PP-16477-00	Elbow 90° Male Tube to Pipe .....	All
32	8PP-23245-01	Static Pressure Tip T Brass .....	All
33	8PP-23260-00	Elbow 90° Brass Female 1/8" NPT .....	All
34	8PP-21574-00	Adapter 1/8" NPT x 1/8" FPT .....	All
35	516324	Plastic Tubing (Clear) (35 Feet) .....	All
36	516325	Photohelic Gage (Complete) .....	All
37	515523	Panel Mounting .....	All
38	550074	Photohelic Gage Only .....	All

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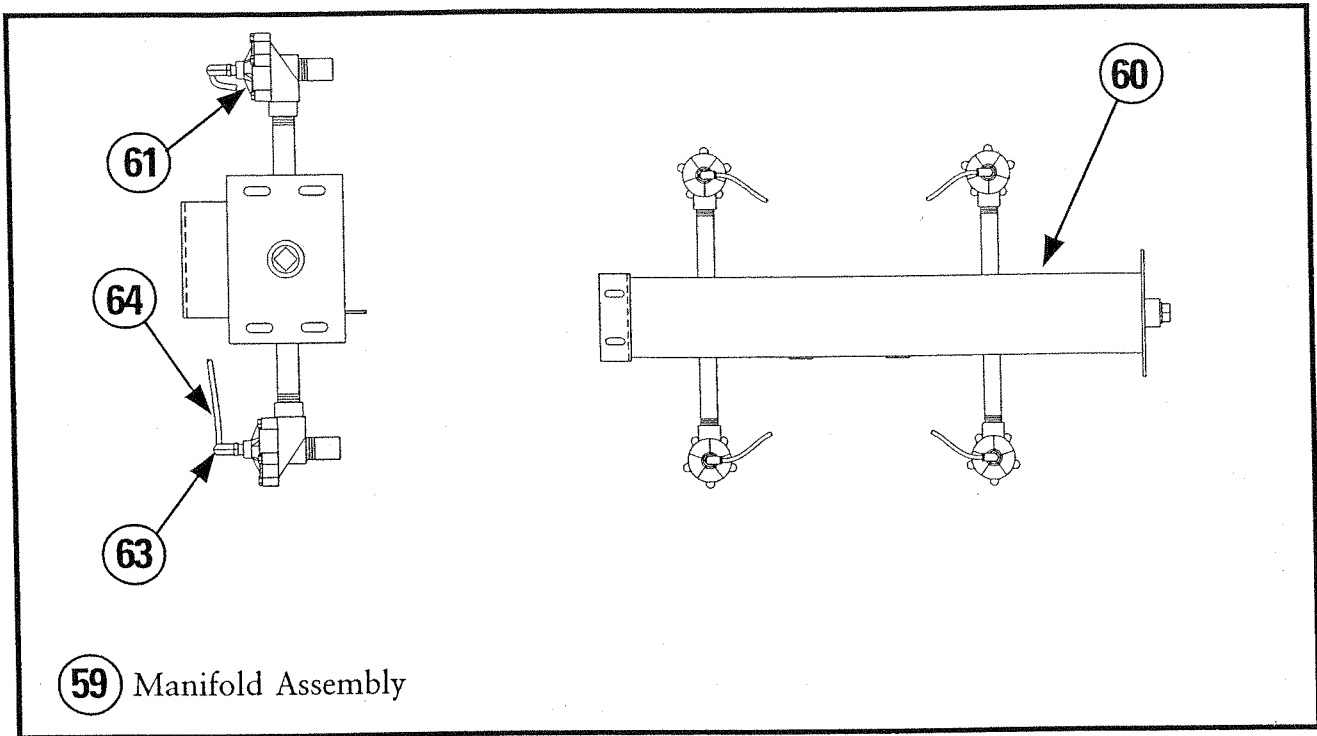


**Parts Drawing 4  
Spare Parts Kit**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
47	516328	Diaphragm Valve Rebuild Kit RCA 20T .....	All

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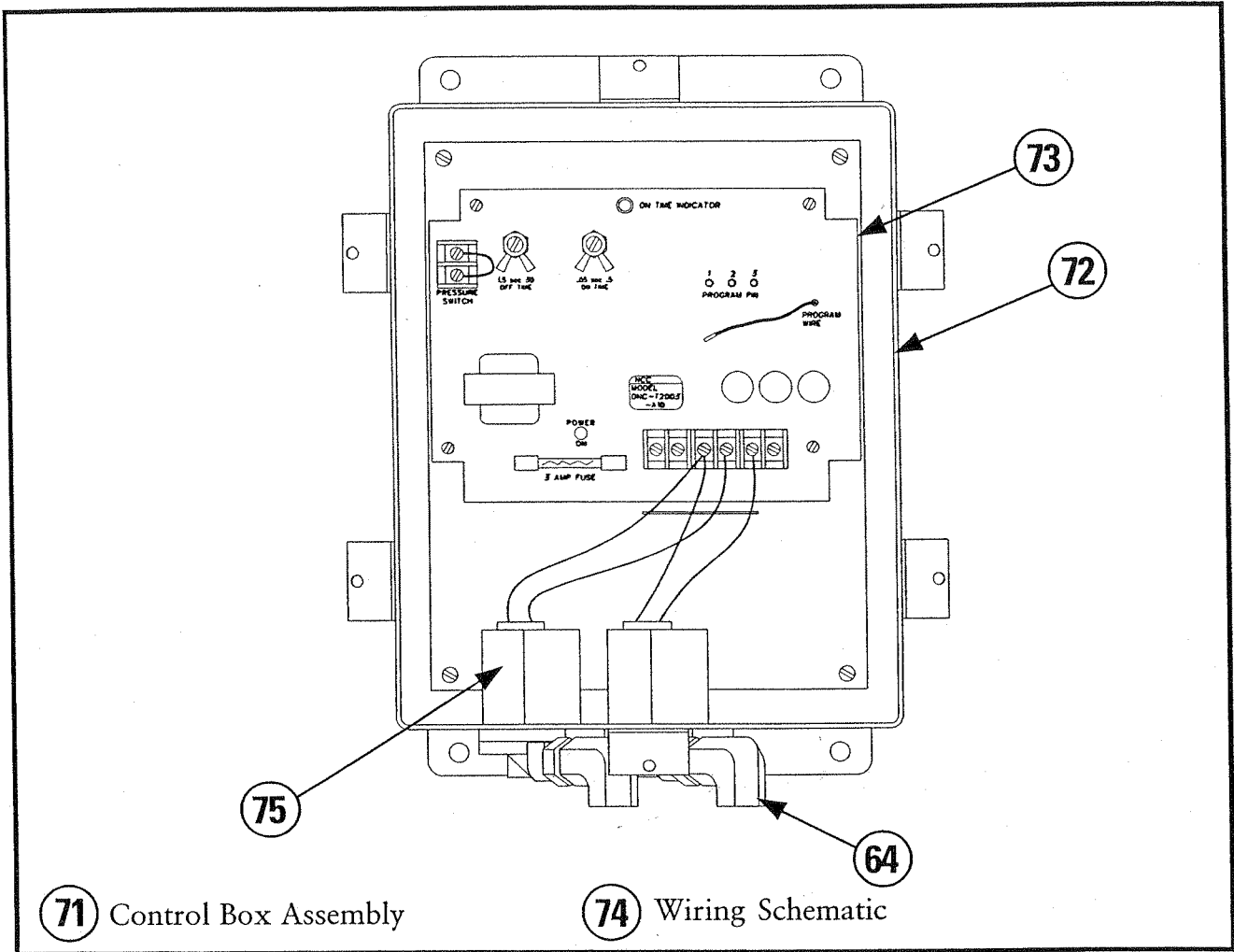
**Parts Drawing 5  
Manifold Assembly**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
59	3EA-57046-01	Manifold Assembly .....	EM 2-2
59	3EA-58516-01	Manifold Assembly .....	EM 2-4
60	4MA-57027-01	Manifold Weldment .....	EM 2-2
60	4MA-58519-01	Manifold Weldment .....	EM 2-4
61	516329	Diaphragm Valve RCA 20T .....	All
63	8PP-21462-00	Connector Elbow 1/4" OD X 1/8" NPT .....	All
64	8PP-21464-00	Tubing Poly 1/4" OD, Black .....	All

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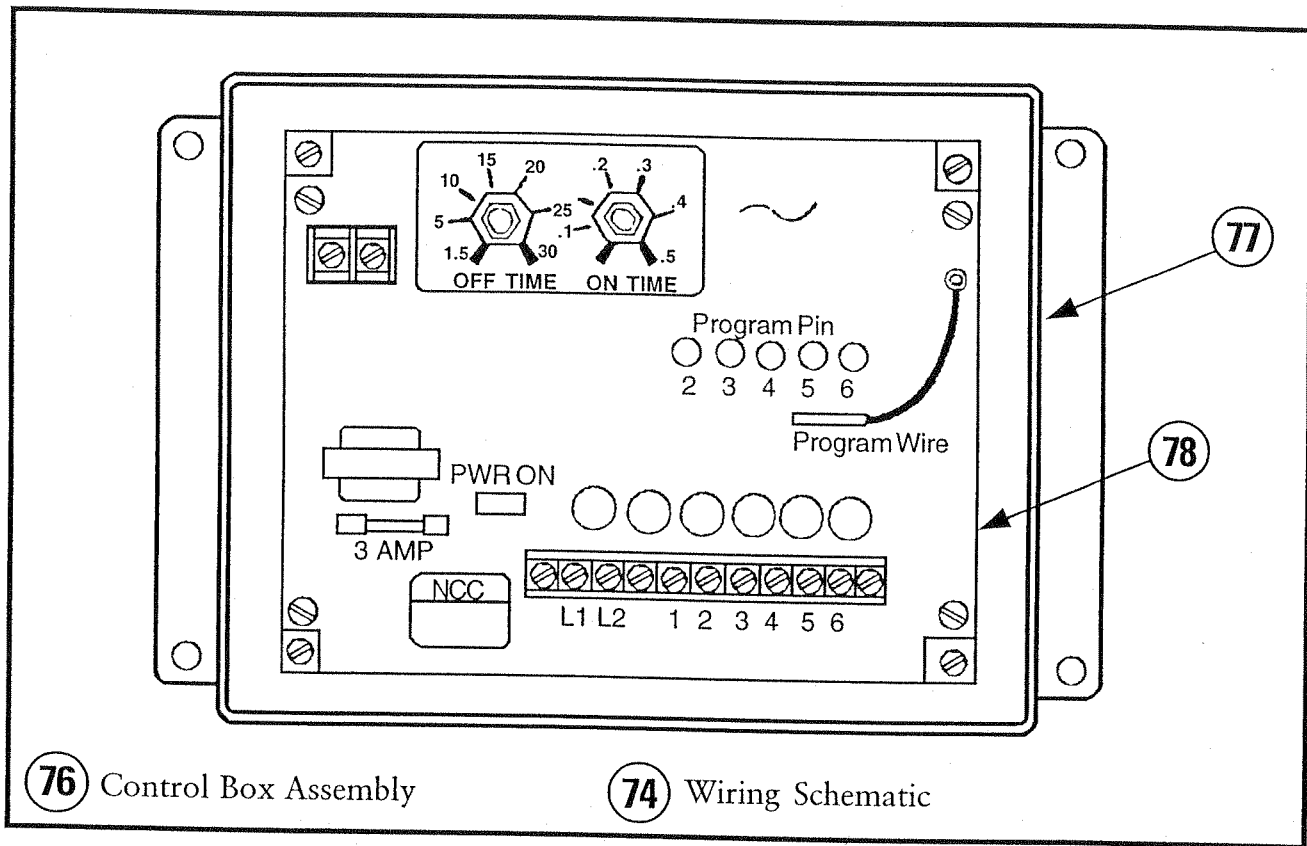


**Parts Drawing 6  
Control Box Assembly EM 2-2**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
64	8PP-21462-00	Connector Elbow 1/4 O.D. Plastic 1/8 NPT .....	EM 2-2
71	3EA-57142-01	Control Box Assembly .....	EM 2-2
72	5PM-57143-01	Box 10 X 8 NEMA 4 .....	EM 2-2
73	516330	Timer Board 3 PIN .....	EM 2-2
74	SIS-74918-01	Wiring Schematic .....	EM 2-2
75	516335	Solenoid Pilot Valve with Leads (Includes Fitting) .....	EM 2-2

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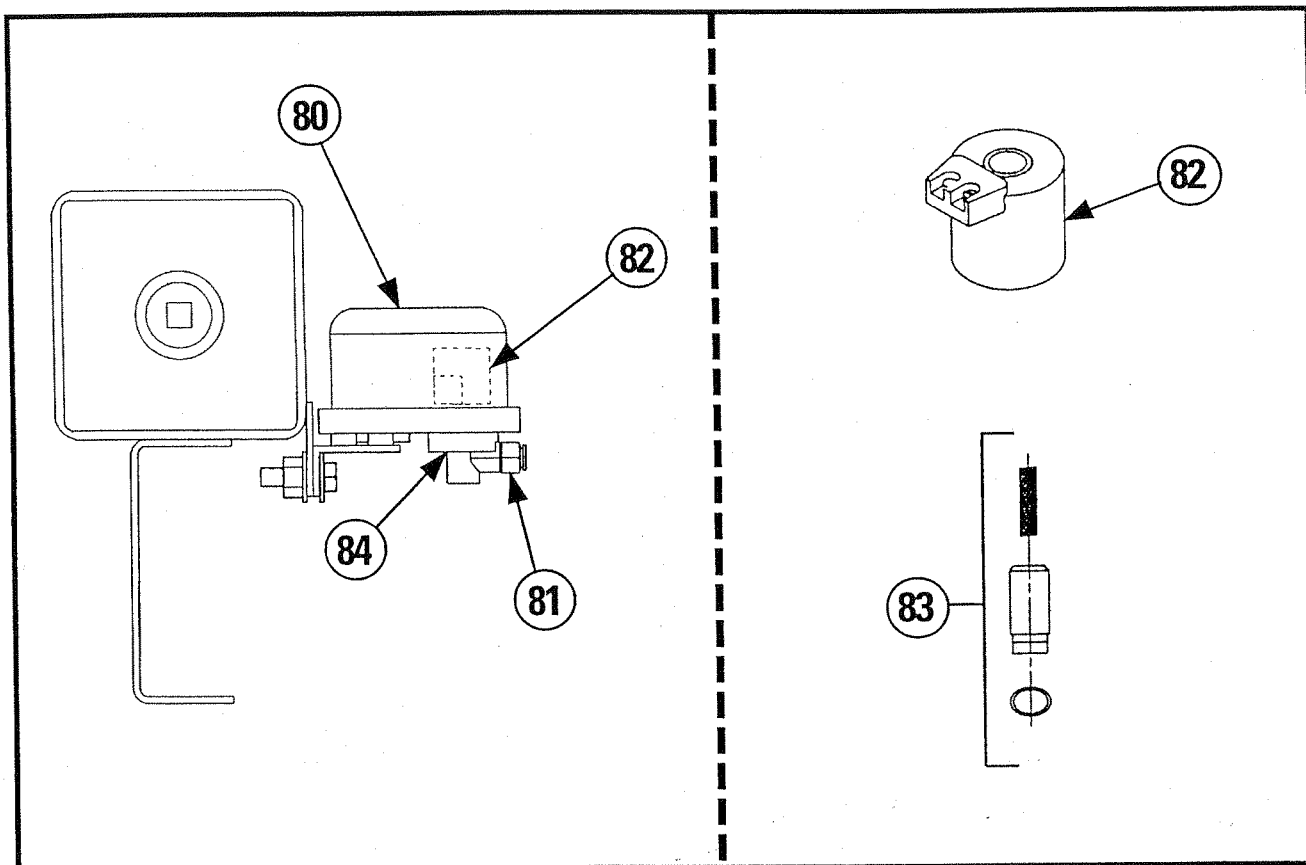


**Parts Drawing 7**  
**Control Box Assembly EM 2-4**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
74	SIS-74918-01	Wiring Schematic 6 PIN .....	EM 2-4
76	3EA-58534-01	Control Box Assembly .....	EM 2-4
77	8PP-19057-00	Box 10 X 8 NEMA 4 .....	EM 2-4
78	516331	Timer Board 6 PIN .....	EM 2-4

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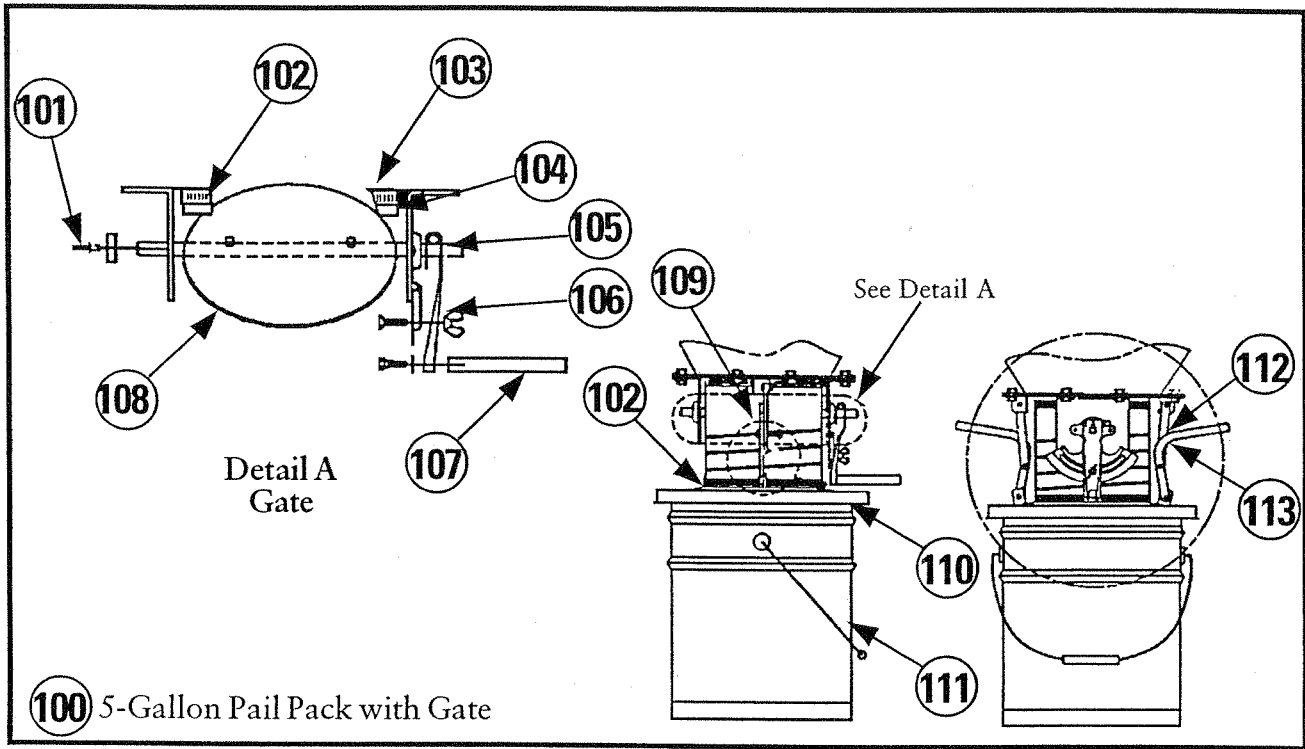


**Parts Drawing 8**  
**Solenoid Pack Assembly NEMA 4 EM 2-4**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
74	SIS-74918-01	Wiring Diagram (NEMA 4).....	EM 2-4
80	8PP-48948-03	Enclosure Solenoid (NEMA 4) (Includes Solenoid Valves) .....	EM 2-4
81	516333	Connector Male 1/4" O.D. ....	EM 2-4
82	516336	Replacement Solenoid Coil Type QT .....	EM 2-4
83	516337	Solenoid Valve Rebuild Kit (NEMA 4) (3D2) .....	EM 2-4
84	516338	Solenoid Valve (Complete) .....	EM 2-4

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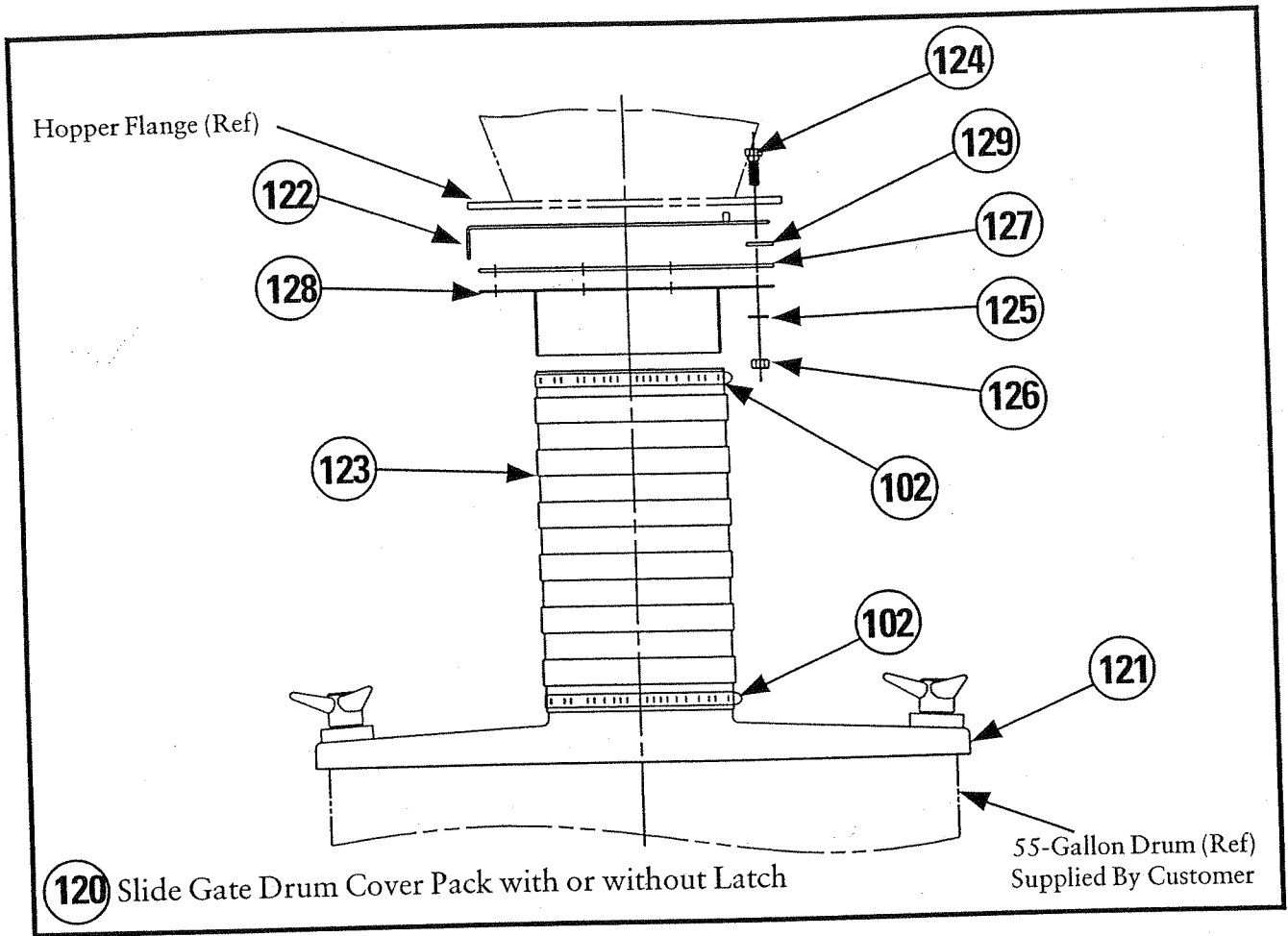
**Parts Drawing 9**  
**5-Gallon Pail Pack**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
----------	----------	-------------	-------

100	2SG-27819-02	5-Gallon Pail Pack with Gate .....	All
101	6MM-00119-02	Bracket Support Pivot .....	All
102	516339	Clamp Hose 7 Inch .....	All
103	4MA-27258-00	Adaptor Pivot Weld .....	All
104	6MM-27282-00	Plate Gate Support .....	All
105	6MM-27284-00	Shaft Gate .....	All
106	5PM-27327-00	Shaft Lock .....	All
107	6MM-27285-00	Handle .....	All
108	6MM-27324-00	Plate Gate 7.06 O.D. ....	All
109	5PM-27329-01	Hose 7 x 7 with Hole .....	All
110	3EA-24949-00	Cover .....	All
111	8PP-24954-00	Pail 5 Gallon .....	All
112	6MM-24957-00	Bar Lift Link .....	All
113	6MM-24956-00	Bar Lift Handle .....	All

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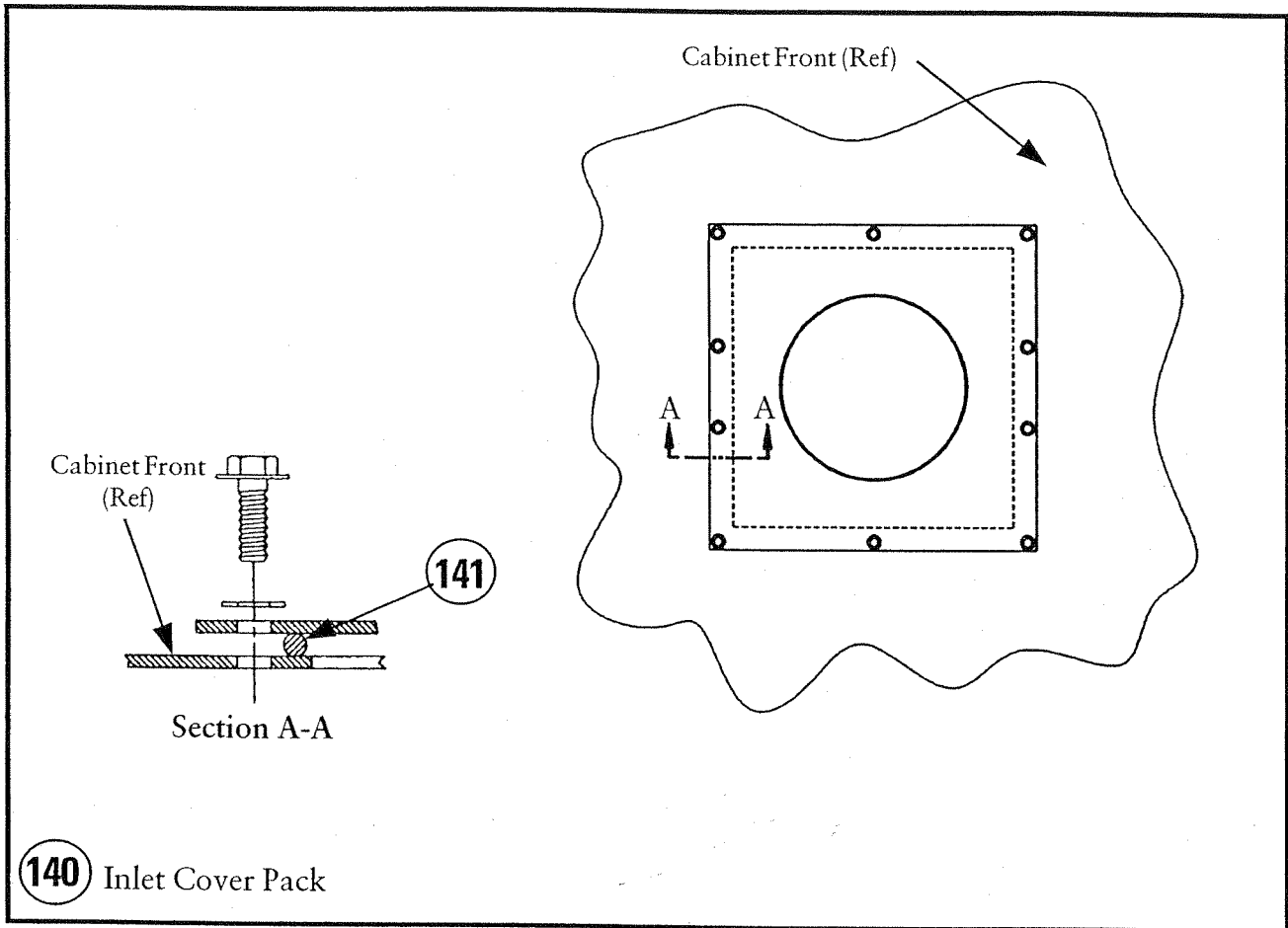


**Parts Drawing 10**  
**Slide Gate Drum Cover Pack**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
102	516339	7" Flexible Hose Clamp .....	All
120	2SG-23919-01	Drum Cover/Slide Gate Pack without Latch .....	All
120	2SG-23919-02	Drum Cover/Slide Gate pack with Latch .....	All
121	3EA-20622-01	Drum Cover Assembly without Latch .....	All
121	3EA-23603-01	Drum Cover Assembly with Latch .....	All
122	4MA-11425-05	7" Slide Gate .....	All
123	516334	Flexible Hose 7.0" I.D. ....	All
124	8PP-09008-03	Bolt, Hex, Stl Zp G2 3/8-16 x .75 .....	All
125	8PP-09006-08	Flat Washer, Stl Zp Type A 3/8 .....	All
126	8PP-09011-10	Hex Nut, Stl Zp G2 3/8-16 .....	All
127	6MM-11410-03	Spacer, Slide Gate Adapter Side (2 Required) .....	All
128	6MM-26024-00	7" Hopper Adapter .....	All
129	6MM-11410-04	Spacer, Slide Gate Adapter Back (1 Required) .....	All

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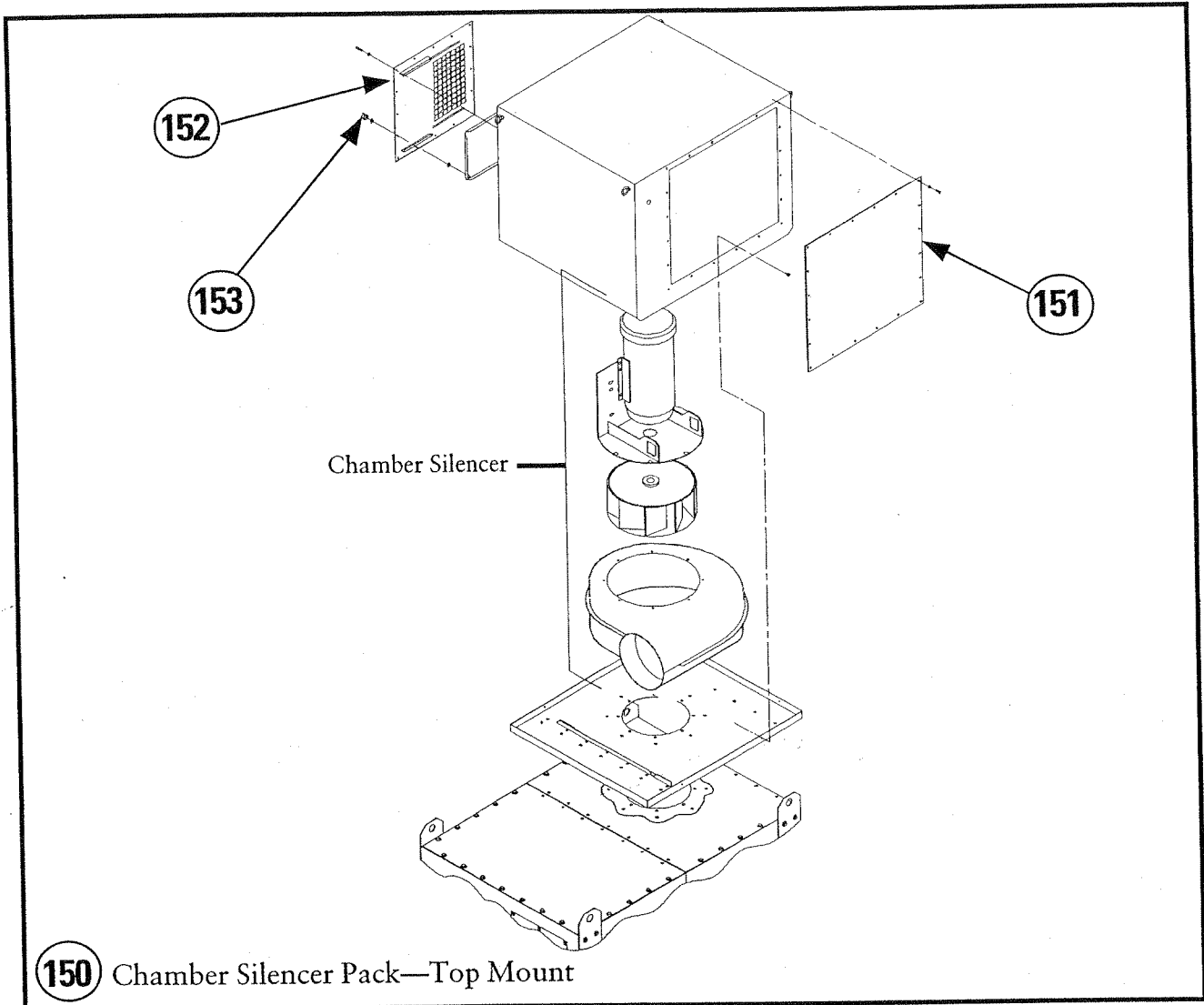
**Parts Drawing 11  
Inlet Cover Pack**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
----------	----------	-------------	-------

140	2SG-57091-03	12" O.D. Inlet Cover Pack with Sealer .....	EM 2-4
140	2SG-57091-02	10" O.D. Inlet Cover Pack with Sealer .....	EM 2-2
141	8PP-05097-00	Sealer 1/4" Dia. ....	All

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**Parts Drawing 12**  
**Chamber Silencer Pack—Top Mount**  
**(10HP TRB Blower Configuration Only)**

## Replacement Parts List

Ref. No.	Part No.	Description	Model
150	3EA-57052-01	Chamber Silencer Pack - Top Mount .....	All
151	6MM-53133-00	Cover & Power Enclosure .....	All
152	2SG-57135-01	Damper Pack Silencer Outlet .....	All
153	516340	Knob .....	All

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## Parts and Service Program

For genuine Empire Abrasive Equipment Company  
replacement filters and parts, call:

**800-497-4543**

### PARTS ORDERING INFORMATION

When ordering parts, give model number  
and serial number, parts number, description  
and quantity of parts desired.

# EMPIRE

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