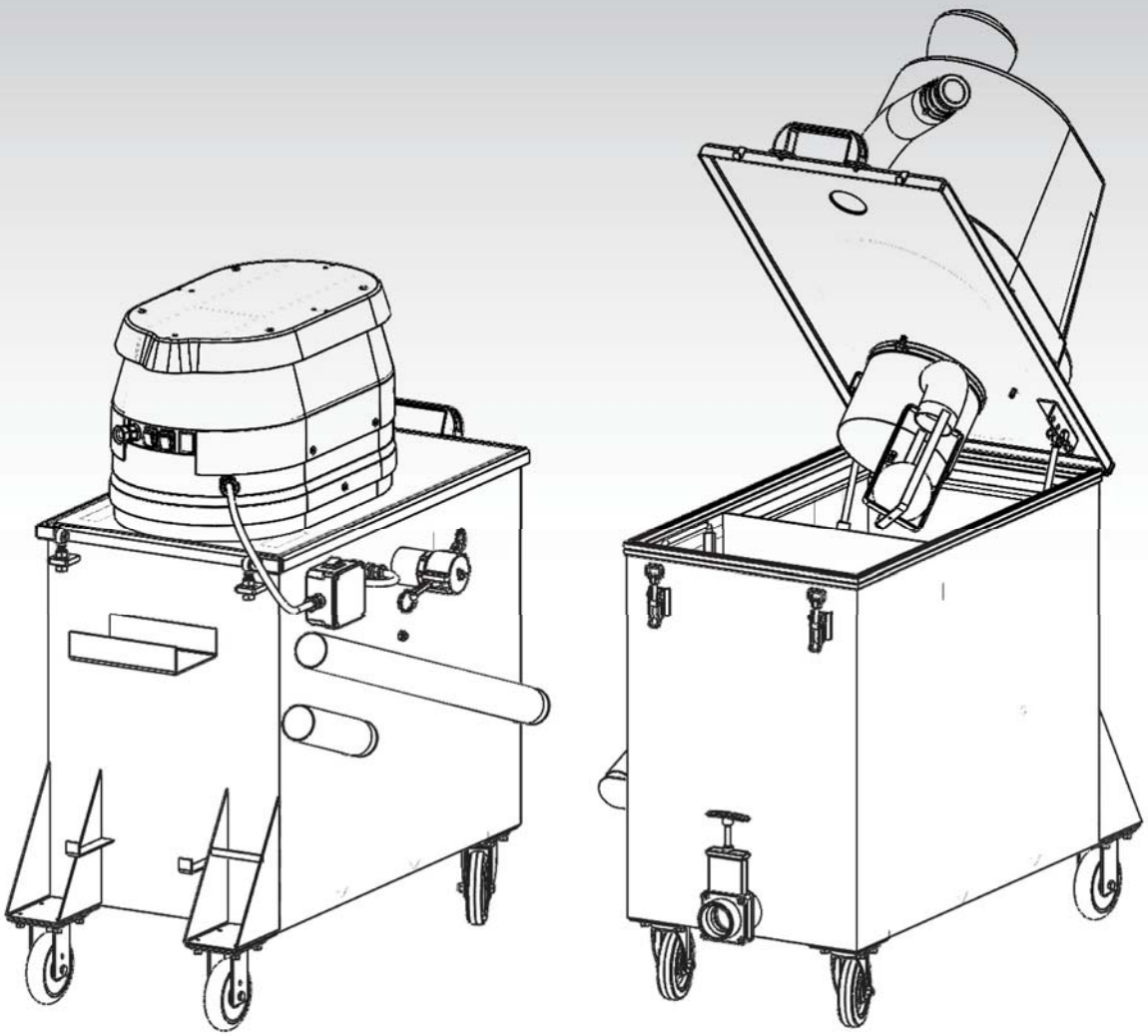
Ruwac USA Industrial Vacuums

SPS250 Series

Parts Manual

Model No.	
Serial No.	
Filter No.	
Start-Up Date	

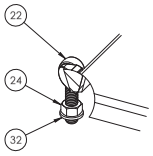


MADE IN THE USA

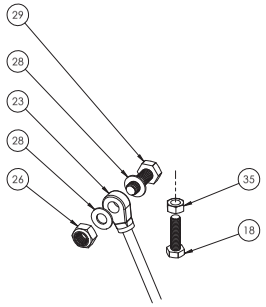
Version: V2.4 4/5/20

54 Winter St. • Holyoke, MA 01040 • (413) 532-4030 • info@ruwac.com

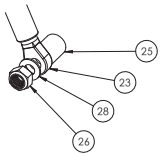
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	INITIAL RELEASE, NO ECO	3/29/2017	DJE
	B	ECO 1578- ADDED HW FOR FILTER HOUSING	3/25/2019	DB



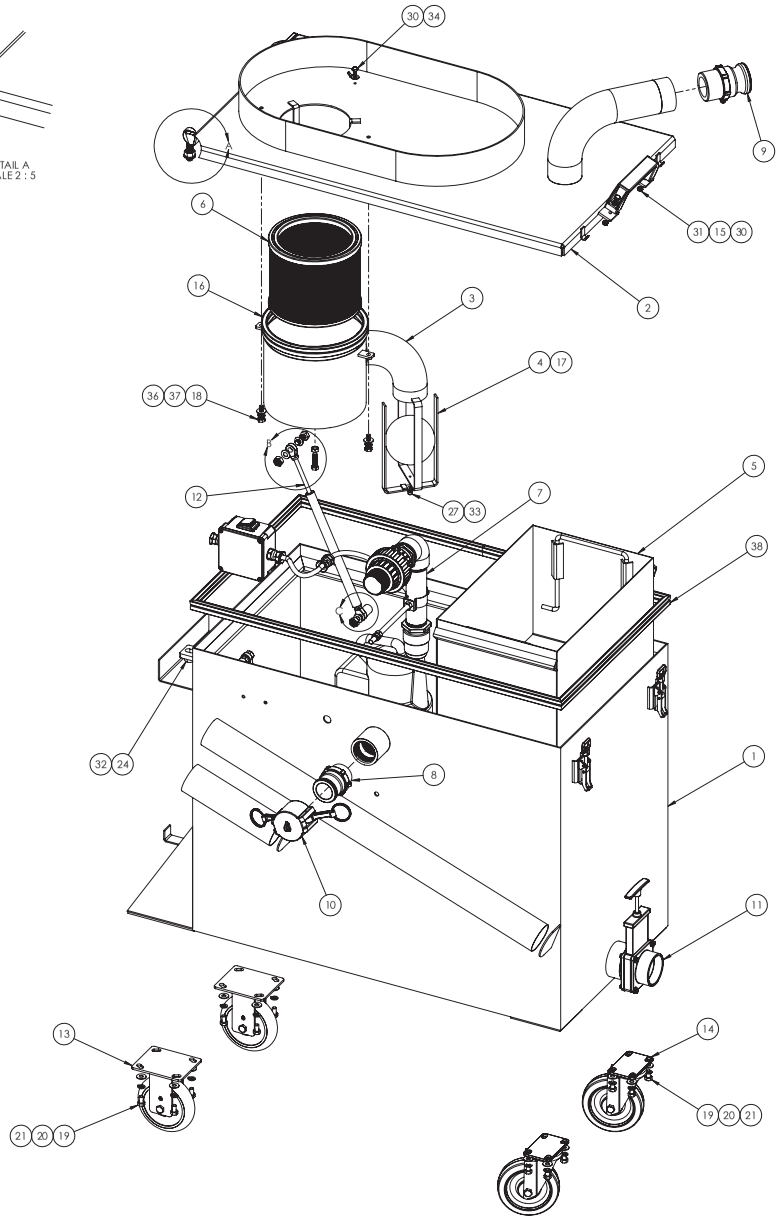
DETAIL A
SCALE 2 : 5



DETAIL B
SCALE 1 : 2



DETAIL C
SCALE 1 : 2



ITEM NO.	PART NO.	DESCRIPTION	DRAWING NO.	CLOSED/QTY.
1	9300A	SPS250, TANK, 40GAL, RED	480 G 0003 US	1
2	9300B	SPS250, LID, RED	480 G 0003 US	1
3	9300C	SPS250, FILTER HOUSING, RED		1
4	9300D	SPS250, FLOAT BRACKET, RED		1
5	9300E	SPS250, CHIP BASKET, RED		1
6	9932000	OIL MIST FILTER, COALESCING		1
7	9316A	SPS250, RETURN PUMP ASM		1
8	27906	CAMLOCK, 1.5MNPT, POLY		1
9	27930	CAMLOCK ADAPTER, 2IN X 2IN MALE NPT, POLY		1
10	27910	DUSTCAP, 1.5IN, CAMLOCK		1
11	31910	GATE VALVE, 2IN MNPT X FNPT, PVC, BLK		1
12	34856	GAS SPRING, M6, MALE, 18.22IN		2
13	30203	CASTER, 5IN, RIGID, RUBBER WHEEL		2
14	30202	CASTER, 5IN, SWIVEL, BRAKE		2
15	21658	HANDLE, BLACK, ABS		1
16	3133307	GASKET, SELF GRIP, FOR SPS250 FILTER		1
17	31391	FLOAT BALL		1
18	328660	HEX BOLT M8 X 30 SS		3
19	34894	BOLT, HEX, M8 X 14, ZINC		16
20	20050	WASHER SPLIT LOCK M8		16
21	34882	WASHER FLAT/THIN M8 ZINC		16
22	35120	EYE BOLT, M12X70MM, DIN 444		2
23	34855	M6 EYELET, ZINC		4
24	3512002	NUT HEX M12-1.75		4
25	2258001	SPACER, ABS, 3/4 X 1/2 X 1"		2
26	21551	NUT, LOCK, M10, ZINC		4
27	32871	SCREW, SOC, M5 X 10, SS		1
28	20192	WASHER FLAT M10		6
29	21556	BOLT, HEX, M10 X 30, ZINC		2
30	32903	BOLT HEX M6-20, ZINC		3
31	34876	M6 LOCK NUT		2
32	3512001	WASHER, FLAT, M12, ZINC		4
33	32867S	WASHER, STAR, M5, SS		1
34	34998	GROUND CONNECTOR		1
35	20044	HEX NUT M8, ZINC		1
36	312055	FLAT WASHER SS 5/16		2
37	20050S	WASHER SPLIT LOCK M8, SS		2
38	3133306	GASKET, SELF GRIP FOR SPS250 TANK		1

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TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASSY | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	3/16/17
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

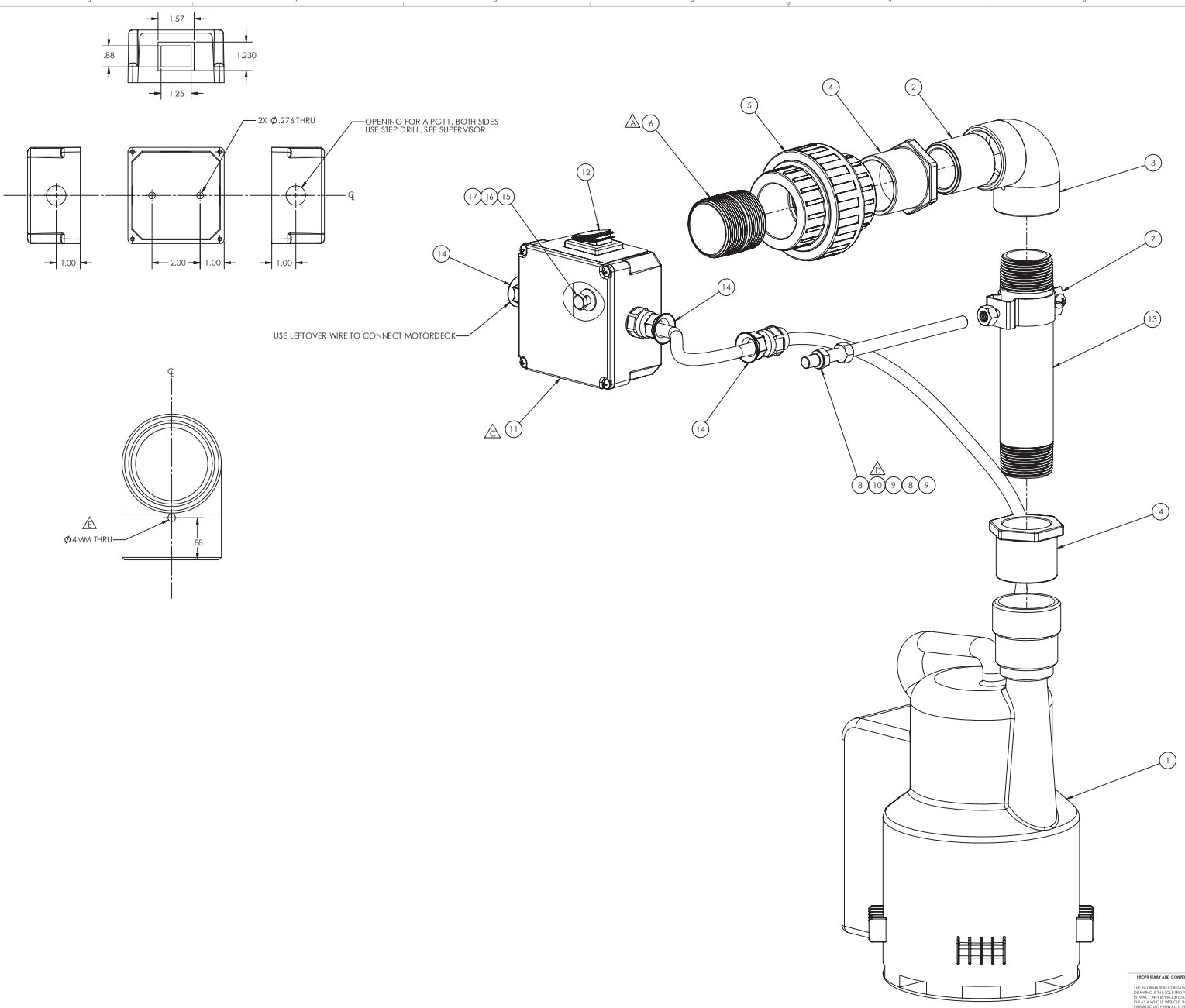
COMMENTS:
9300ASM

RUWAC
54 Winter St.
Holyoke, Ma. 01040

TITLE:
SPS250 HOUSINGS, ASSEMBLED

SIZE	DWG. NO.	REV
D	480 E 0020 US	B

SCALE: 1:8 | WEIGHT: | SHEET 1 OF 1



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
D.5	A	ECO 1427- REPLACE PVC NIPPLE WITH SS	11/21/2017	JJF
	B	ECO 1580- ADDED MOUNTING HW FOR ENCLOSURE	3/25/2019	DB
C.6	C	ECO 1595- CHANGED PVC ENCLOSURE TO MACHINED	4/25/2019	DB
C.4	D	ECO 1616- CHANGED THREADED ROD TO SS	6/14/2019	DB
B8	E	ECO 1691- HOLE/NOTE/ELECTRICAL DIAGRAM ADDED	1/2/2020	DB

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	9316	PUMP, SUBMERSIBLE, .25 HP, 115V	1
2	279190	NIPPLE, 1.25" CLOSE	1
3	31616	ELBOW, 90, 1.25, PVC, SCH 80	1
4	31615	REDUCER, 1.5 SLIP X 1.25 NPT, PVC	2
5	27902	UNION, 1.5IN SLIP, 1.5NPT, PVC	1
6	27929S	NIPPLE, 1.5 NPT, CLOSE, SS	1
7	90858	TUBE HANGER, 1.5IN OD TUBE, ZINC	1
8	37506	LOCK NUT 3/8-16	2
9	37502	NUT HEX 3/8-16	2
10	90875001	THREADED ROD, .375-16 X 7" LG, SS	1
11	E989NNJ03	ENCLOSURE, PVC, 4IN X 4IN X 2.5IN, SPS250	1
12	27017L	SWITCH, WS	1
13	279216	NIPPLE, 1.25NPT, 7IN LG, PVC	1
14	34862	PG11 CABLE GLAND	3
15	200179	HEX BOLT 1/4-20 X 3/4" SS	2
16	200180	WASHER FLAT .25 (.688OD) SS	2
17	250025S	NUT LOCK .25-20, SS	2

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FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASSY | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	3/17/17
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

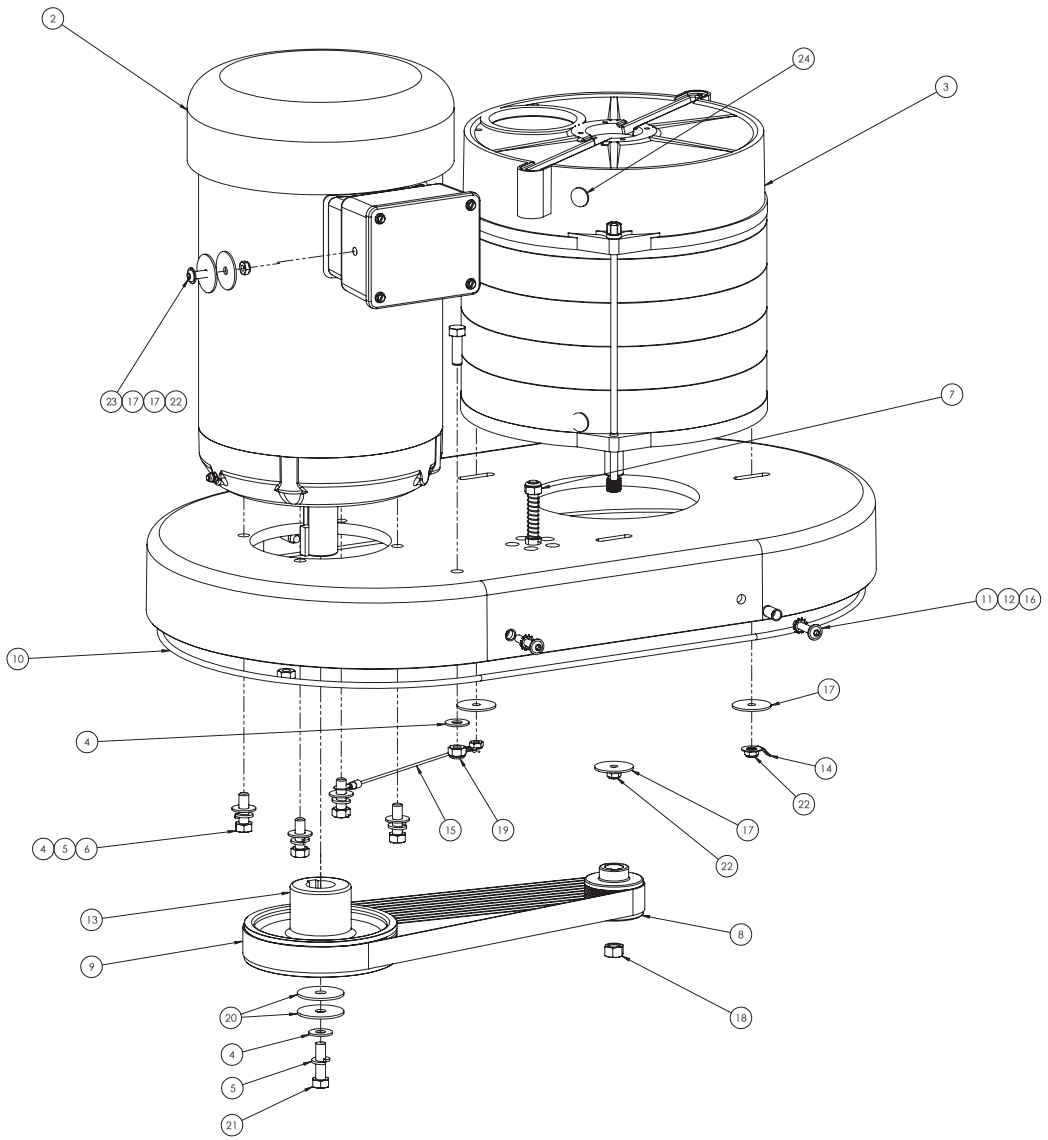
COMMENTS: 9316A

RUWAC 54 Winter St. Holyoke, Ma. 01040

TITLE: SPS250, RETURN PUMP ASM

SIZE	DWG. NO.	REV
D	480 E 0019 US	E

SCALE: 2:3 WEIGHT: SHEET 1 OF 1



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	D	ECO 137: PRINTREVED	8/17/2003	DJE
	E	ECO 425: PRINTREVED	12/12/2006	DJS
	F	ECO 1252: PRINTREVED	8/8/2016	DJE
	G	ECO 1371: CHANGED GASKET, ADDED HARDWARE	8/1/2017	DJE
	H	ECO 1390: ADDED 22120 PLUGS TO DRAWING, CHANGED TURBINE HARDWARE FROM 20040 TO 34876	9/6/2017	DJE
	J	ECO 1414: TURNED MOTOR 90°	10/18/2017	DJE

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	90228009	LID, BLK, DS1150-1220	1
2	25006	MOTOR, 3HP, NON-EX, 3 PHASE	1
3	22220	TURBINE, 5 STAGE, 2.2 KW	1
4	34882	WASHER FLAT/THIN M8 ZINC	7
5	31206	WASHER LOCK 5/16	5
6	25054	BOLT HEX M8 X 25	6
7	96960080	RELIEF VALVE ASM, 2"	1
8	33057	PULLEY, 48MM, 10 GROOVE, POLY V	1
9	35014	BELT, 330 J, 10 GROOVE, POLY-V	1
10	31376002	GASKET, NEOPRENE, .188", 5.4FT LG	1
11	21464	SCREW M6 X 30 SOC HD, FLANGED	4
12	25000	WASHER EXT STAR .25IN	4
13	33051	SHEAVE, 125MM, 10 GROOVE	1
14	34998	GROUND CONNECTOR	1
15	GWR008	GROUND WIRE, MOTOR TO TURBINE	1
16	34817A	M6 BLIND PEM	4
17	20031	WASHER, FENDER, 1/4 X 1 1/4	5
18	32827	NUT, HEX, LH, M12, 1 3/4"	1
19	30029	NUT LOCK M8	2
20	20032	WASHER, FENDER, 5/16-1 1/2", ZINC	2
21	25031	BOLT HEX M8 X 30	1
22	34876	M6 LOCK NUT	4
23	34817	SCREW U/S SOC HD M6 X 20	1
24	22120	PLUG, 8MM, BLK	2

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TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .015
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASSY | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	8/2/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS:
25006AB

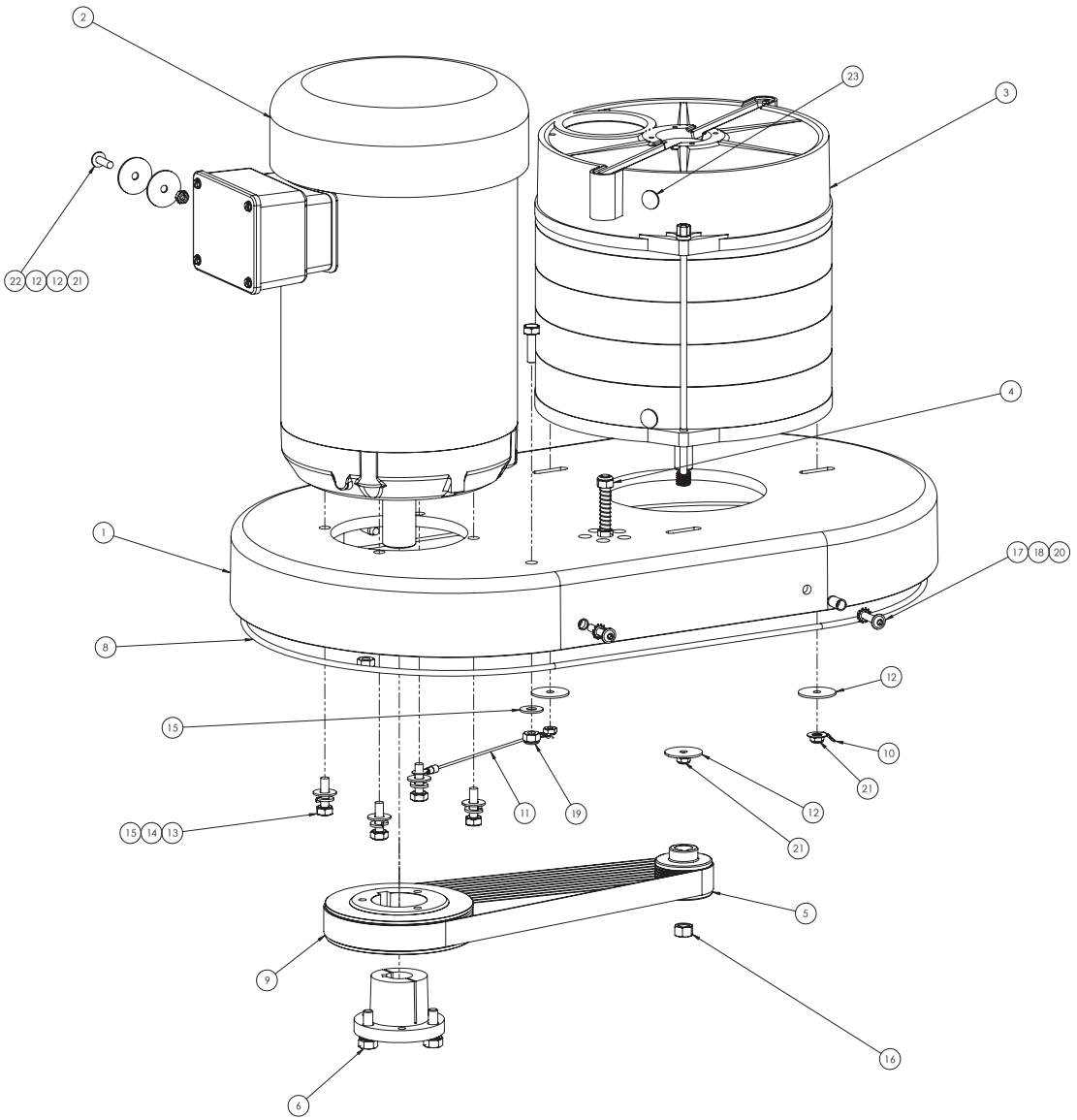
FLOWAC
54 Winter St.
Holyoke, Ma. 01040

TITLE:
DS1220 MOTORDECK NON-EX
THREE-PHASE

SIZE	DWG. NO.	REV
D	270 E 0005 US	J

SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	ECO 1371: CHANGED GASKET, ADDED HARDWARE	8/1/2017	DJE
	B	ECO 1390: ADDED 22120 PLUGS TO DRAWGING. CHANGED TURBINE NUTS TO 34876 LOCK NUTS	9/6/2017	DJE



ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	90228009	LID, BLK, DS1150-1220	1
2	25006-1	MOTOR, 3HP, NON-EX, 1 PHASE	1
3	22220	TURBINE, 5 STAGE, 2.2 KW	1
4	96960080	RELIEF VALVE ASM, 2"	1
5	33057	PULLEY, 48MM, 10 GROOVE, POLY V	1
6	3305205US	BUSHING, P1, 7/8"	1
7	35014	BELT, 330 J, 10 GROOVE, POLY-V	1
8	31376002	GASKET, NEOPRENE, .188", 5.4FT LG	1
9	33052US	SHEAVE, 125MM, 10 GROOVE, POLY-V	1
10	34998	GROUND CONNECTOR	1
11	GWR008	GROUND WIRE, MOTOR TO TURBINE	1
12	20031	WASHER, FENDER, 1/4 X 1 1/4	5
13	25054	BOLT HEX M8 X 25	6
14	31206	WASHER LOCK 5/16	4
15	34882	WASHER FLAT/THIN M8 ZINC	6
16	32827	NUT, HEX, LH, M12, 1 3/4"	1
17	21464	SCREW M6 X 30 SOC HD, FLANGED	4
18	25000	WASHER EXT STAR .25IN	4
19	30029	NUT LOCK M8	2
20	34817A	M6 BLIND PEM	4
21	34876	M6 LOCK NUT	4
22	34817	SCREW ULS SOC HD M6 X 20	1
23	22120	PLUG, 8MM, BLK	2

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TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y
USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	8/2/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

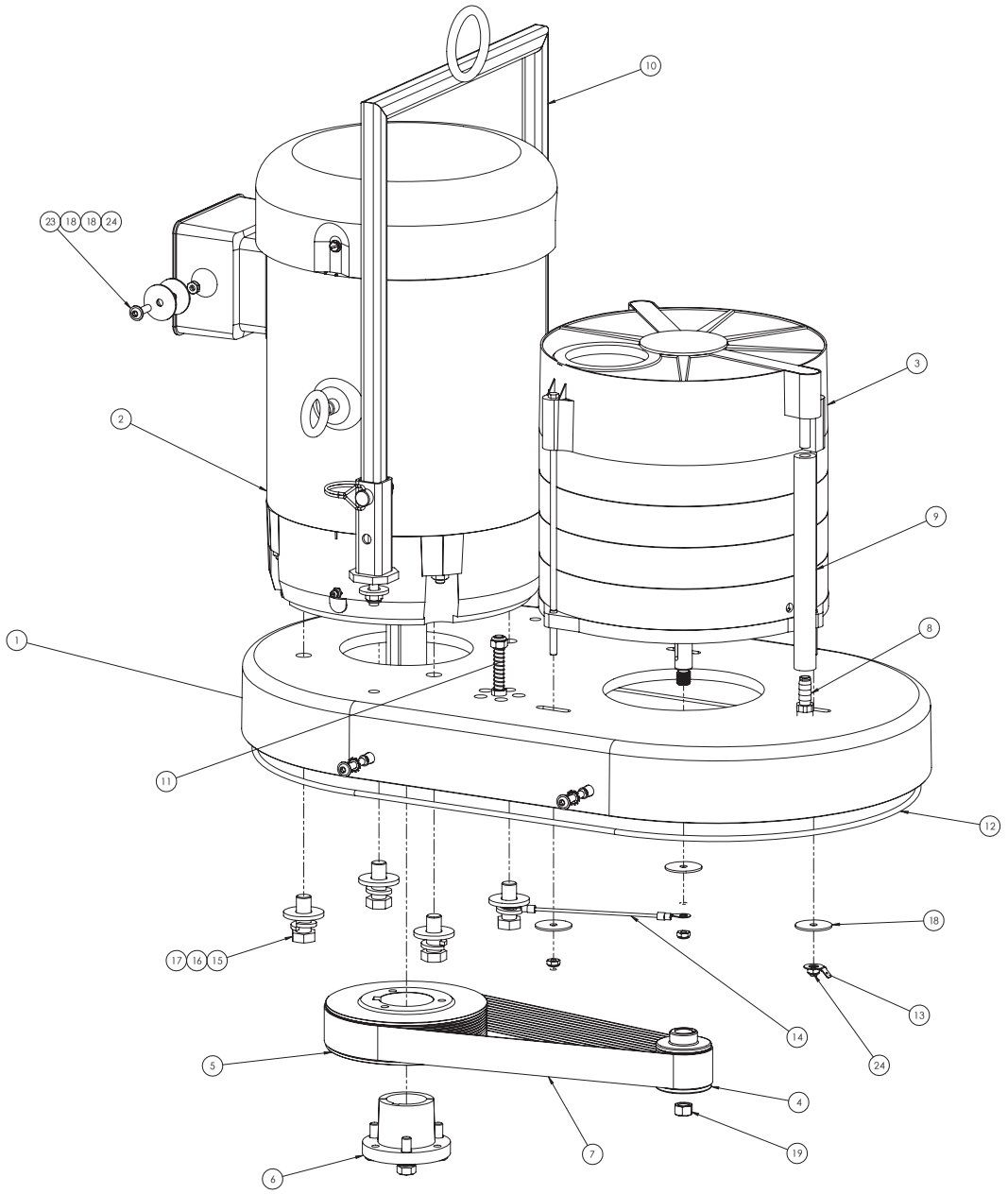
25006AB-220-1

54 Winter St.
Holyoke, Ma. 01040

TITLE:
DS1220 MOTORDECK ASM, SINGLE PHASE, NON-EX

SIZE	DWG. NO.	REV
D	270 E 0007 US	B

SCALE: 1:2 WEIGHT: SHEET 1 OF 1



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	D	ECO 330	9/7/2006	DJS
	E	ECO 425	12/12/2006	DJS
	F	ECO 1344: UPDATED PRINT, CHANGED MOTORDECK, P1 BUSHING	5/19/2017	DJE
	G	ECO 1358: UPDATED SHEAVES AND BELT	6/21/2017	DJE
	H	ECO 1371: UPDATED GASKET AND HARDWARE	8/1/2017	DJE
	J	ECO 1390: CHANGED TURBINE HARDWARE FROM 20040 TO 34876	9/6/2017	DJE

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	90228006	LID, BLK, DS1400EX	1
2	25010	MOTOR, 10HP, NON-EX, 3-PHASE	1
3	21661000	TURBINE, 5 STAGE, 7.5 KW	1
4	33058	PULLEY, POLY-V, 14 GROOVE, 48MM DIA	1
5	32922US	140MM SHEAVE, 14 GROOVE	1
6	3292201US	BUSHING, P1, 1 3/8"	1
7	35020	BELT, 340, J, 14 GROOVE, POLY-V	1
8	200630	HOSE BARB, 1/4"NPTx3/8" BARB	1
9	20044601	AIR LINE HOSE, .375 ID, 200PSI, RED, 7.5IN	1
10	25092A	DS1 DECK LIFTING ASM	1
11	96960080	RELIEF VALVE ASM, 2"	1
12	31376002	GASKET, NEOPRENE, .188", 5.4FT LG	1
13	34998	GROUND CONNECTOR	1
14	GWR017	GROUND WIRE, DS1750 MOTORDECK	1
15	50003	BOLT, HEX, 1/2-13 X 1 1/4	4
16	50002	WASHER, LOCK 1/2"	4
17	50001	FLAT WASHER 1/2"	4
18	20031	WASHER, FENDER, 1/4 X 1 1/4	5
19	32827	NUT, HEX, LH, M12, 1 3/4"	1
20	21464	SCREW M6 X 30 SOC HD, FLANGED	4
21	34817A	M6 BLIND PEM	4
22	25000	WASHER EXT STAR .25IN	4
23	34817	SCREW ULS SOC HD M6 X 20	1
24	34876	M6 LOCK NUT	4

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FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL: SEE BOM
FINISH
NEXT ASSY | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	5/19/2017
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

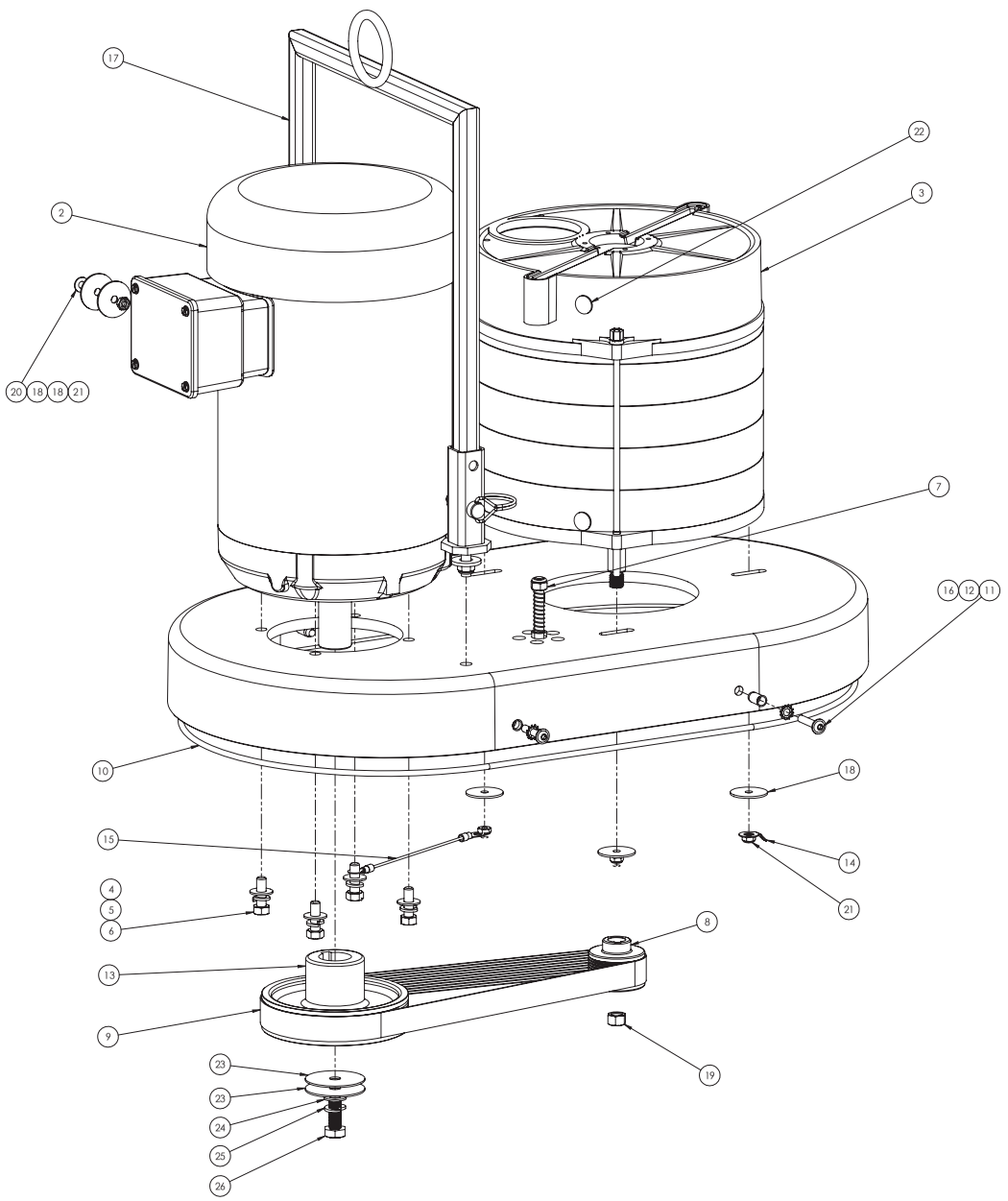
COMMENTS: 25010AB

RUWAC
54 Winter St.
Holyoke, Ma. 01040

TITLE: DS1750 MOTORDECK ASM

SIZE: D | DWG. NO.: 290 E 0001 US | REV: J

SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	F	ECO 139: UPDATED PRINT	8/14/2003	DJS
	G	ECO 425: UPDATED PRINT	12/12/2006	DJS
	H	ECO 1252: UPDATED HARDWARE	8/8/2016	JJF
	J	ECO 1371: UPDATED GASKET, HARDWARE	8/2/2017	DJE
	K	ECO 1392: ADDED 22120 PLUGS TO DRAWING. CHANGED TURBINE HARDWARE FROM 20040 TO 34876. CHANGED PULLEY AND HARDWARE ON DRAWING	9/6/2017	DJE
	L	ECO 1416 CORRECTED REV K ERROR. REVISION K SHOULD SHOW ECO 1392, NOT 1390.	10/26/2017	DJE

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	90228009	LID, BLK, DS1150-1220	1
2	25093	MOTOR, 5HP, NON-EX, 3 PHASE	1
3	22221	TURBINE, 5 STAGE, 4.0 KW	1
4	34882	WASHER FLAT/THIN M8 ZINC	4
5	20050	WASHER SPLIT LOCK M8	4
6	25054	BOLT HEX M8 X 25	4
7	96960080	RELIEF VALVE ASM, 2"	1
8	33057	PULLEY, 48MM, 10 GROOVE, POLY V	1
9	35014	BELT, 330 J, 10 GROOVE, POLY-V	1
10	31376002	GASKET, NEOPRENE, .188", 5.4FT LG	1
11	21464	SCREW M6 X 30 SOC HD, FLANGED	4
12	25000	WASHER EXT STAR .25IN	4
13	33052	SHEAVE, POLY V, 10 GROOVE, 125MM	1
14	34998	GROUND CONNECTOR	1
15	GWR008	GROUND WIRE, MOTOR TO TURBINE	1
16	34817A	M6 BLIND PEM	4
17	25092A	DS1 DECK LIFTING ASM	1
18	20031	WASHER, FENDER, 1/4 X 1 1/4	5
19	32827	NUT, HEX, LH, M12, 1 3/4"	1
20	34817	SCREW ULS SOC HD M6 X 20	1
21	34876	M6 LOCK NUT	4
22	22120	PLUG, 8MM, BLK	2
23	30045	WASHER, M10, FENDER, 2IN	2
24	20192	WASHER FLAT M10	1
25	300452	WASHER, SPLIT LOCK, M10, ZINC	1
26	21557	BOLT, HEX, M10-1.25, 25MM, ZINC	1

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BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y
USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	8/2/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS:
25093AB

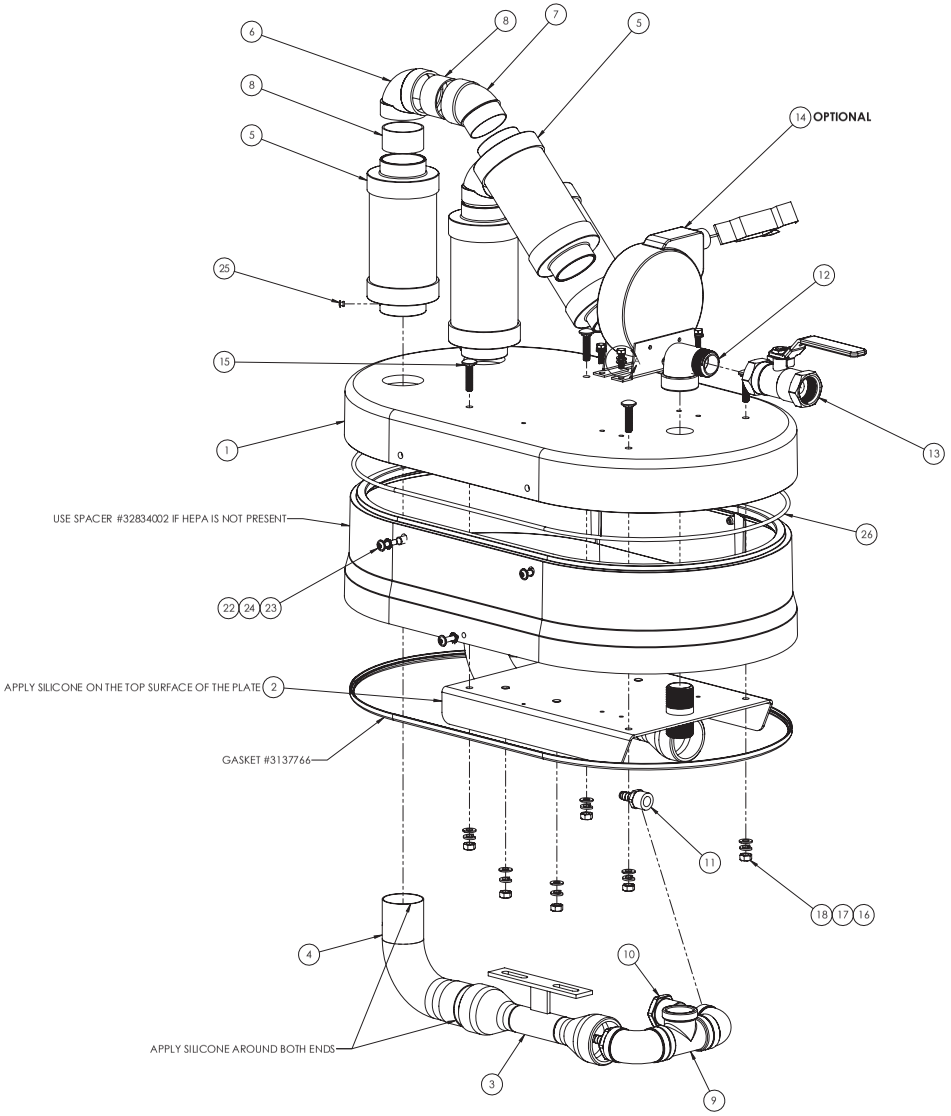
FLOWAC 54 Winter St. Holyoke, Ma. 01040

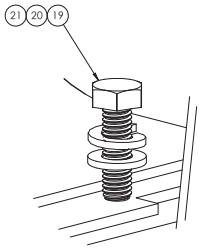
TITLE:
DS1400 MOTORDECK ASM, NON-EX

SIZE	DWG. NO.	REV
D	280 E 0002 US	L

SCALE: 1:2 WEIGHT: SHEET 1 OF 1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	N	PRINT REVISED, ECO 787	3/17/11	DJS
	O	PRINT REVISED, ECO 904	3/16/12	DJS
	P	REVISED ASM PER ECO 1287	11/28/16	DJE
	R	ECO 1371: GASKET CHANGED	8/7/2017	DJE
	S	ECO 1452: SWITCHED CY01403 FOR CY01403O1	12/20/2017	DJE
	T	ECO 1563: ADDED SMALL SPACER WITH GASKET	1/16/2019	DB





DETAIL A
SCALE 2 : 1

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	90228-2	MOTOR DECK FOR AV2000	1
2	31810	AIR VAC PLATE, DUAL VENTURI, AV2000	1
3	31663	AIR VENTURI	2
4	90183S1	ELBOW, 90, 2IN, SS, FOR AV	2
5	CY802350	EXHAUST MUFFLER, 6IN	4
6	CY701585	ELBOW, 2IN, 90, PVC	2
7	CY701588	STREET ELBOW, 45, 2IN, PVC	2
8	CY70140301	TUBING, 2IN, PVC, 1.5LG	4
9	31652SA	DUAL VENTURI TEE ASM, SS	1
10	31650S	REDUCING BUSHING, 1IN X .5IN, SS, HEX	2
11	31623	HOSE BARB, .375 X .5NPT, BRASS	2
12	34916S	ELBOW, 90, STREET, 1IN NPT, SS	1
13	31625S	BALL VALVE, 1IN, FULL PORT, SS	1
14	34878	GROUNDING REEL	1
15	25030	CARRIAGE BOLT M8-30, ZINC	4
16	25061	M8 FLAT WASHER	8
17	20050	WASHER SPLIT LOCK M8	8
18	20044	HEX NUT M8, ZINC	8
19	32903	BOLT HEX M6-20, ZINC	4
20	20039	WASHER LOCK M6	4
21	25067	WASHER FLAT M6	4
22	34817A	M6 BLIND PEM	4
23	3481701	SCREW, SOC BH, FLANGED, M6-25	6
24	25000	WASHER EXT STAR .25IN	6
25	3299001	RIVET, BLIND, .25 LONG	4
26	31376002	GASKET, NEOPRENE, .188", 5.4FT LG	1

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TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .03
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	11/28/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS: 90228A2

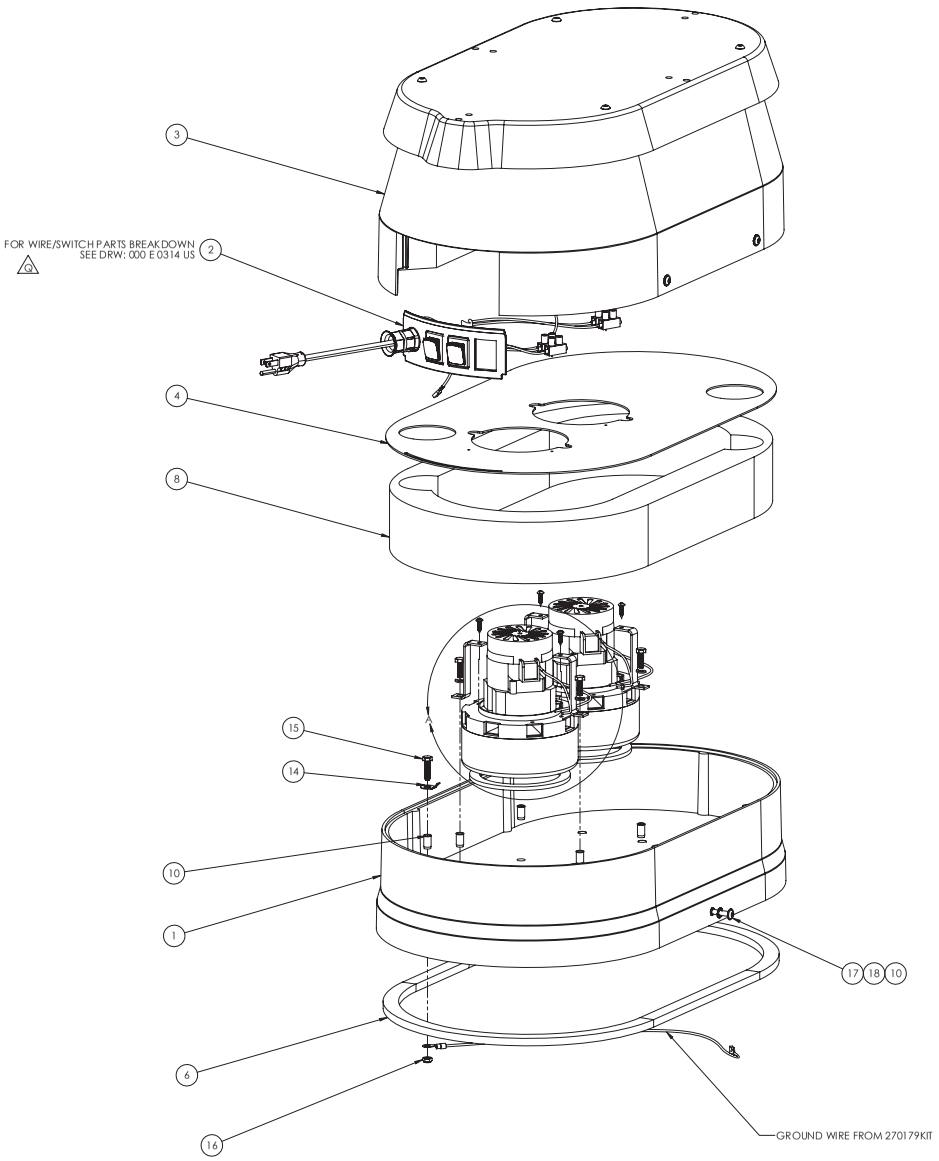
RUWAC 54 Winter St. Holyoke, Ma. 01040

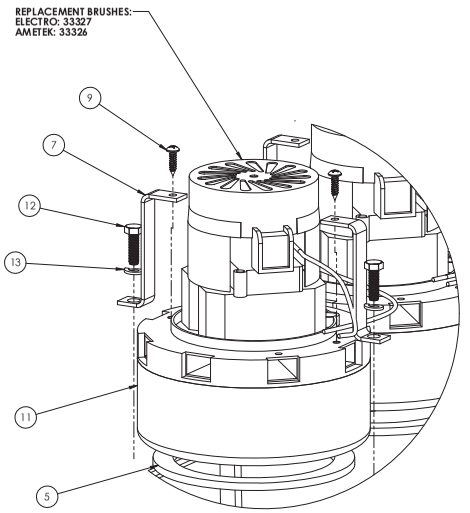
TITLE: AV2000 MOTORDECK ASM

SIZE D | DWG. NO. 000 E 0056 US | REV T

SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	N	ECO 1200: UPDATED ASSEMBLY	4/4/2016	DJE
	P	ECO 1395: CHANGED G ASKET, ADDED REPLACEMENT BRUSH NOTE	9/20/2017	DJE
C8	Q	NO ECO: ADDED NOTE	10/26/2017	DJE
	R	ECO 1443: CHANGED MOTOR SCREWS	12/12/2017	DJE





DETAIL A
SCALE 2 : 3

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	34983001	WS MOTOR DECK, 2 HOLES, GROOVE, RED	1
2	27017A	WS 2 MOTOR SWICH ASM 120V	1
3	PH34980ARG	WS SILENCER ASM	1
4	34985	WS DIFFUSER PLATE, 2 MOTOR	1
5	32967	MOTOR HEAD GASKET	2
6	32934002	GASKET, .375IN X .75IN, 63IN LG	1
7	34826	MOTOR HOLD DOWN- BRACKET	4
8	34984	SILENCER FOAM, W2, LOWER	1
9	25064	SCREW PHIL PH #8 X 5/8" ZINC	4
10	34817A	M6 BLIND PEM	7
11	27002	MOTOR, 2 STAGE, PD 1000W, 120V	2
12	32903	BOLT HEX M6-20, ZINC	4
13	20039	WASHER LOCK M6	4
14	34998	GROUND CONNECTOR	1
15	34854	BOLT, HEX, M6-25	1
16	34876	M6 LOCK NUT	1
17	3481701	SCREW, SOC BH, FLANGED, M6-25	2
18	25000	WASHER EXT STAR .25IN	2

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TOLERANCES:
FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL: SEE BOM
FINISH
NEXT ASS'Y | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	4/4/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS:
27002A

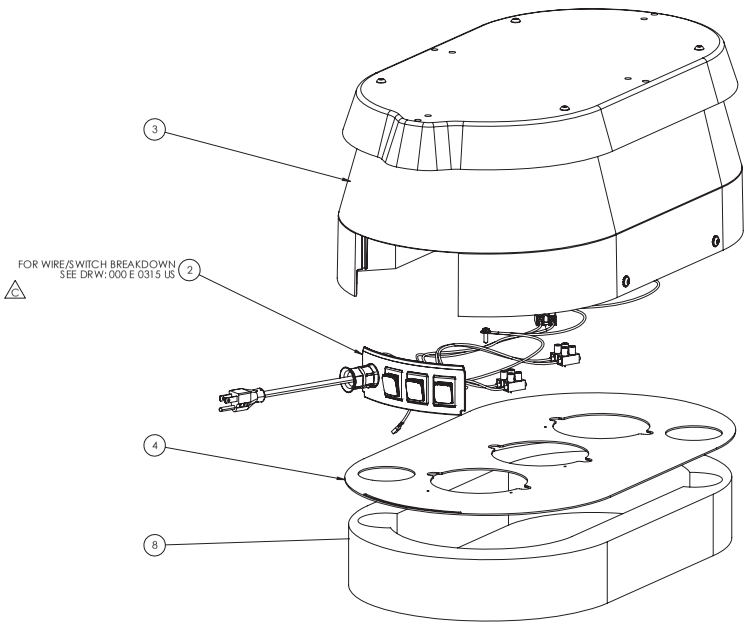
RUWAC
54 Winter St.
Holyoke, Ma. 01040

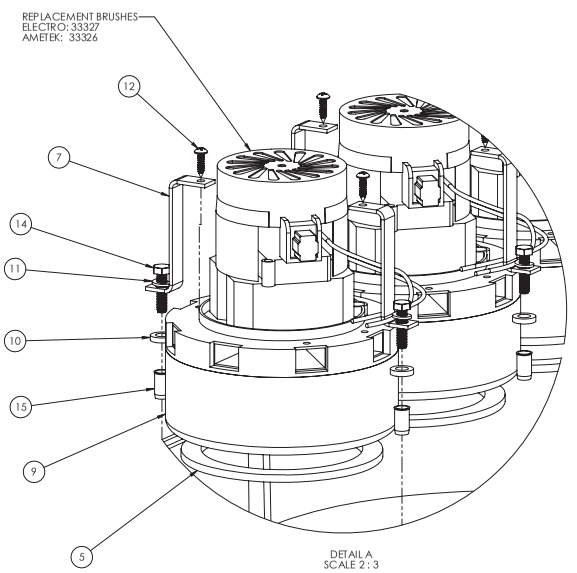
TITLE:
WS2220, 2 MOTOR ASM, 120V

SIZE	DWG. NO.	REV
D	000 E 0021 US	R

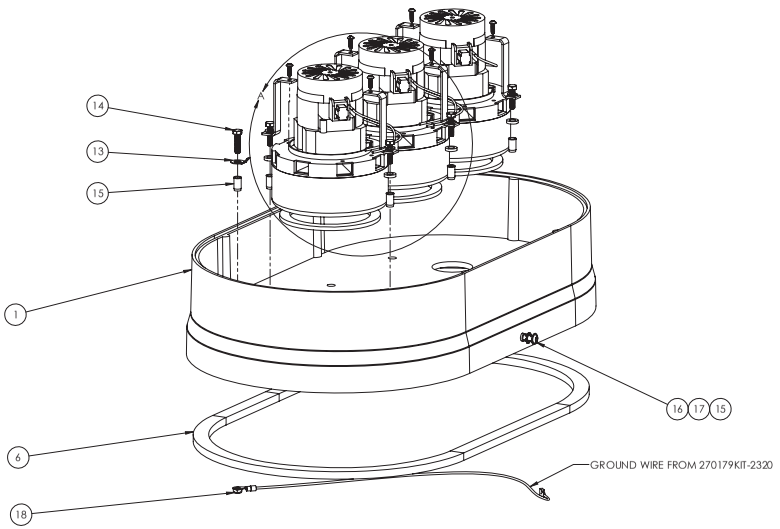
SCALE: 1:3 | WEIGHT: | SHEET 1 OF 1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	ECO 1205: RELEASED AT REV A	4/14/2016	DJE
	B	ECO 1395: ADDED REPLACEMENT MOTOR BRUSH NOTE, CHANGED GASKET	9/19/2017	DJE
C8	C	NO ECO: ADDED NOTE	10/26/2017	DJE
	D	ECO 1443: CHANGED MOTOR SCREWS	12/12/2017	DJE





DETAIL A
SCALE 2 : 3



ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	34983002	WS MOTOR DECK, 3 HOLES, RED	1
2	27017LA3	WS 3 MOTOR SWICH ASM, 120V	1
3	PH34980ARG	WS SILENCER ASM	1
4	34986	AIR CHANNEL PLATE, 3 MOTOR, METAL	1
5	32967	MOTOR HEAD GASKET	3
6	32934002	GASKET, .375IN X .75IN, 63IN LG	1
7	34826	MOTOR HOLD DOWN- BRACKET	6
8	34984	SILENCER FOAM, W2, LOWER	1
9	119514	MOTOR, 2 STAGE, PD 800W, 120V	3
10	200432	NYLON WASHER/SPACER	6
11	20039	WASHER LOCK M6	6
12	25064	SCREW PHIL PH #8 X 5/8" ZINC	6
13	34998	GROUND CONNECTOR	1
14	34854	BOLT, HEX, M6-25	7
15	34817A	M6 BLIND PEM	9
16	3481701	SCREW, SOC BH, FLANGED, M6-25	2
17	25000	WASHER EXT STAR .25IN	2
18	34876	M6 LOCK NUT	1

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ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .015
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	4/14/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS:
119514A

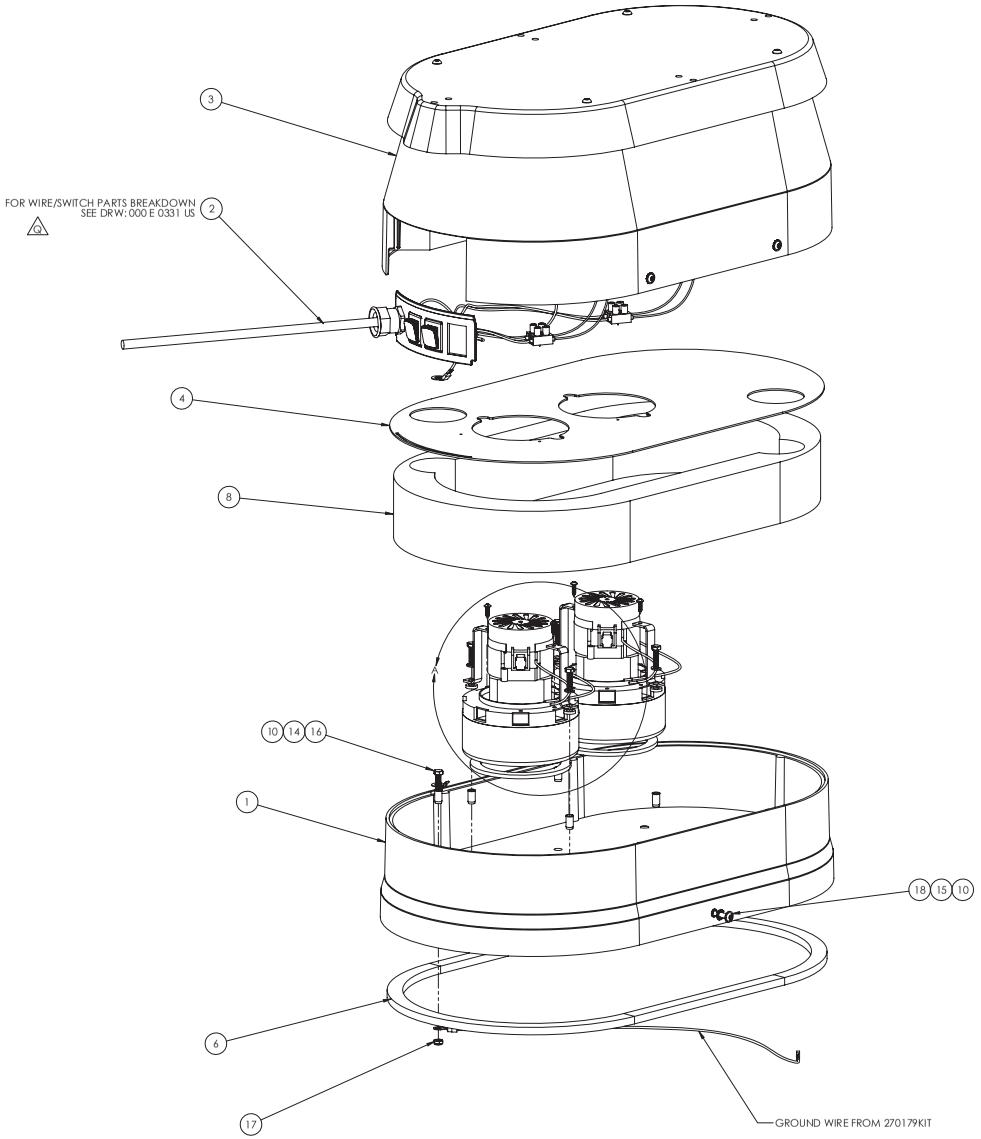
54 Winter St.
Holyoke, Ma. 01040

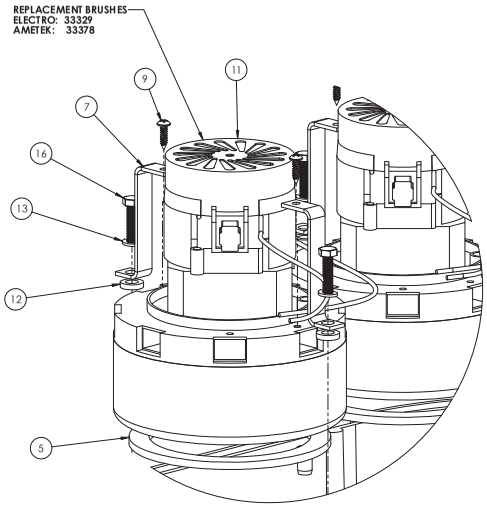
TITLE:
WS2320 MOTOR DECK ASM, 3MTR, RED

SIZE	DWG. NO.	REV
D	000 E 0317 US	D

SCALE: 1:8 | WEIGHT: | SHEET 1 OF 1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	P	ECO 1395: ADDED REPLACEMENT BRUSH NOTES, CHANGED GASKET TO 32934002	9/19/2017	DJE
C8	Q	NO ECO: ADDED NOTE	10/26/2017	DJE
	R	ECO 1443: CHANGED MOTOR SCREWS	12/12/2017	DJE





DETAIL A
SCALE 2 : 3

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	34983001	WS MOTOR DECK, 2 HOLES, GROOVE, RED	1
2	PH27017A	WS 2 MOTOR SWICH ASM, 240V	1
3	PH34980ARG	WS SILENCER ASM	1
4	34985	WS DIFFUSER PLATE, 2 MOTOR	1
5	32967	MOTOR HEAD GASKET	2
6	32934002	GASKET, .375IN X .75IN, 63IN LG	1
7	34826	MOTOR HOLD DOWN- BRACKET	4
8	34984	SILENCER FOAM, W2, LOWER	1
9	25064	SCREW PHIL PH #8 X 5/8" ZINC	4
10	34817A	M6 BLIND PEM	7
11	116549-13	MOTOR, 2 STAGE, 1200W, 240V	2
12	200432	NYLON WASHER/SPACER	4
13	20039	WASHER LOCK M6	4
14	34998	GROUND CONNECTOR	1
15	25000	WASHER EXT STAR .25IN	2
16	34854	BOLT, HEX, M6-25	5
17	34876	M6 LOCK NUT	1
18	3481701	SCREW, SOC BH, FLANGED, M6-25	2

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FRACTIONAL ± 1/16"
ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .010
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y
USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	5/24/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

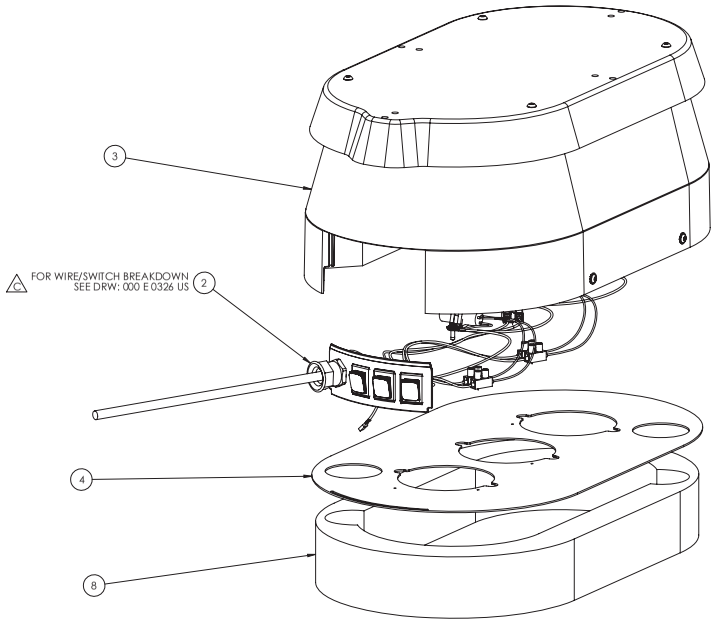
COMMENTS:
116353A

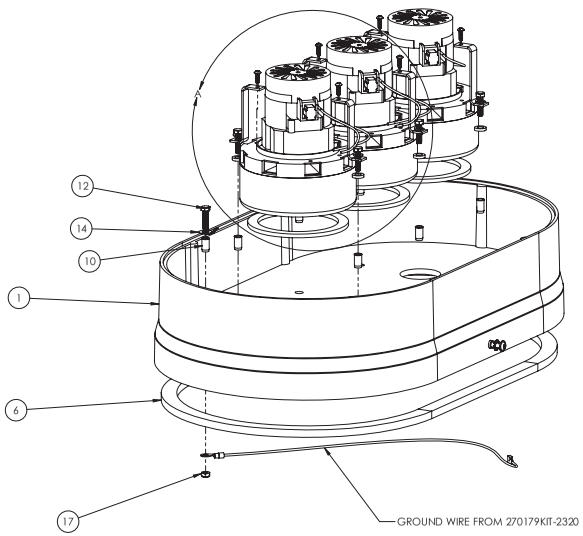
RUWAC 54 Winter St. Holyoke, Ma. 01040

TITLE:
WS2220, 2 MOTOR ASM, 240

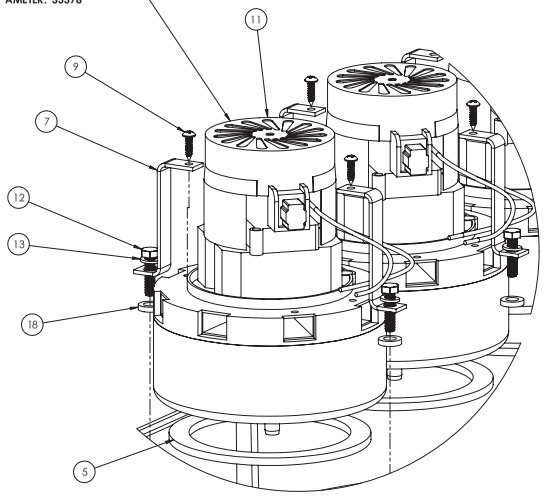
SIZE D | DWG. NO. 000 E 0332 US | REV R
SCALE: 1:12 | WEIGHT: | SHEET 1 OF 1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	B	ECO 1395: ADDED MOTOR BRUSH NOTES, CHANGED GASKET TO 32934002	9/19/2017	DJE
C8	C	NO ECO: ADDED NOTE	10/26/2017	DJE
	D	ECO 1443: CHANGED MOTOR SCREWS	12/12/2017	DJE





REPLACEMENT BRUSHES
ELECTRO: 33329
AMETEK: 33378



DETAIL A
SCALE 2 : 3

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	34983002	WS MOTOR DECK, 3 HOLES, RED	1
2	PH27017LA3	WS 3 MOTOR SWICH ASM, 220V	1
3	PH34980ARG	WS SILENCER ASM	1
4	34986	AIR CHANNEL PLATE, 3 MOTOR, METAL	1
5	32967	MOTOR HEAD GASKET	3
6	32934002	GASKET, .375IN X .75IN, 63IN LG	1
7	34826	MOTOR HOLD DOWN- BRACKET	6
8	34984	SILENCER FOAM, W2, LOWER	1
9	25064	SCREW PHIL PH #8 X 5/8" ZINC	6
10	34817A	M6 BLIND PEM	9
11	116549-13	MOTOR, 2 STAGE, 1200W, 240V	3
12	34854	BOLT, HEX, M6-25	7
13	20039	WASHER LOCK M6	6
14	34998	GROUND CONNECTOR	1
15	3481701	SCREW, SOC BH, FLANGED, M6-25	2
16	25000	WASHER EXT STAR .25IN	2
17	34876	M6 LOCK NUT	1
18	200432	NYLON WASHER/SPACER	6

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ANGULAR: MACH ± 30' BEND ± 30'
TWO PLACE DECIMAL ± .015
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	5/10/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:	116549A	

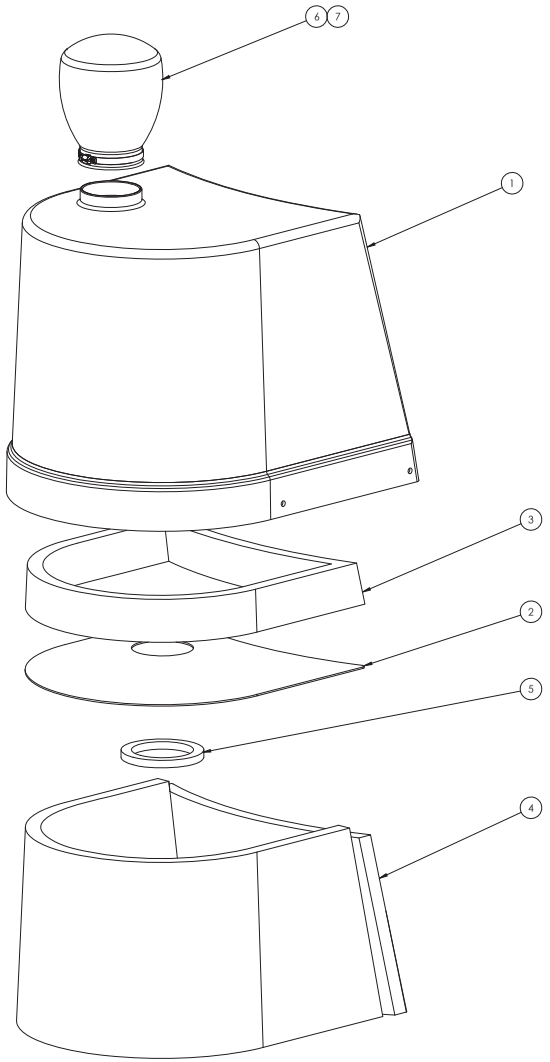
54 Winter St.
Holyoke, Ma. 01040

TITLE:
WS2320 MOTOR DECK ASM, 3MTR, RED, 220V

SIZE	DWG. NO.	REV
D	000 E 0327 US	D

SCALE: 1:8 | WEIGHT: | SHEET 1 OF 1

REVISIONS			
REV	DESCRIPTION	DATE	NAME
E	E.C.O. #603	10/24/08	D.J.S.
F	E.C.O. #616	12/2/08	D.J.S.
G	E.C.O. #1250	7/26/16	DJE



ITEM NO.	PART NO.	DESCRIPTION	DRAWING NO.	QTY.
1	34976	Silencer Hood, Black, D1		1
2	32853R	DIFFUSER LID PLATE, D1		1
3	3286201	FOAM, SILENCER HOOD, .75 X 2.25 X 49		1
4	3286202	FOAM, SILENCER HOOD, .75 X 8 X 52.5		1
5	2509812	GASKET, 4" ODx 3" IDx 3/8" THICK		1
6	30058	AIR DIFFUSER BAG DS1 LID		1
7	4019	HOSE CLAMP 2.31-3.25", SS		1

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TWO PLACE DECIMAL ± .03
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	7/26/16
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

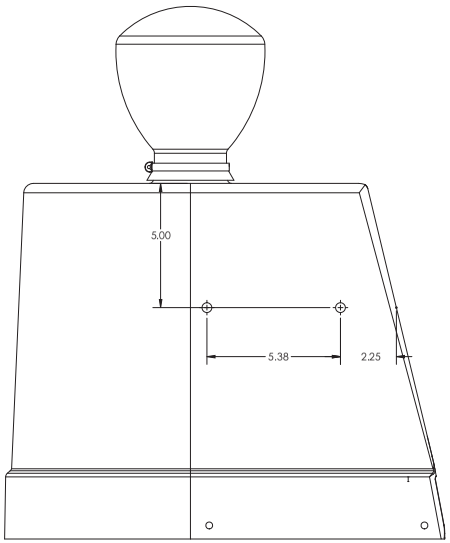
COMMENTS:
34976A

54 Winter St.
Holyoke, Ma. 01040

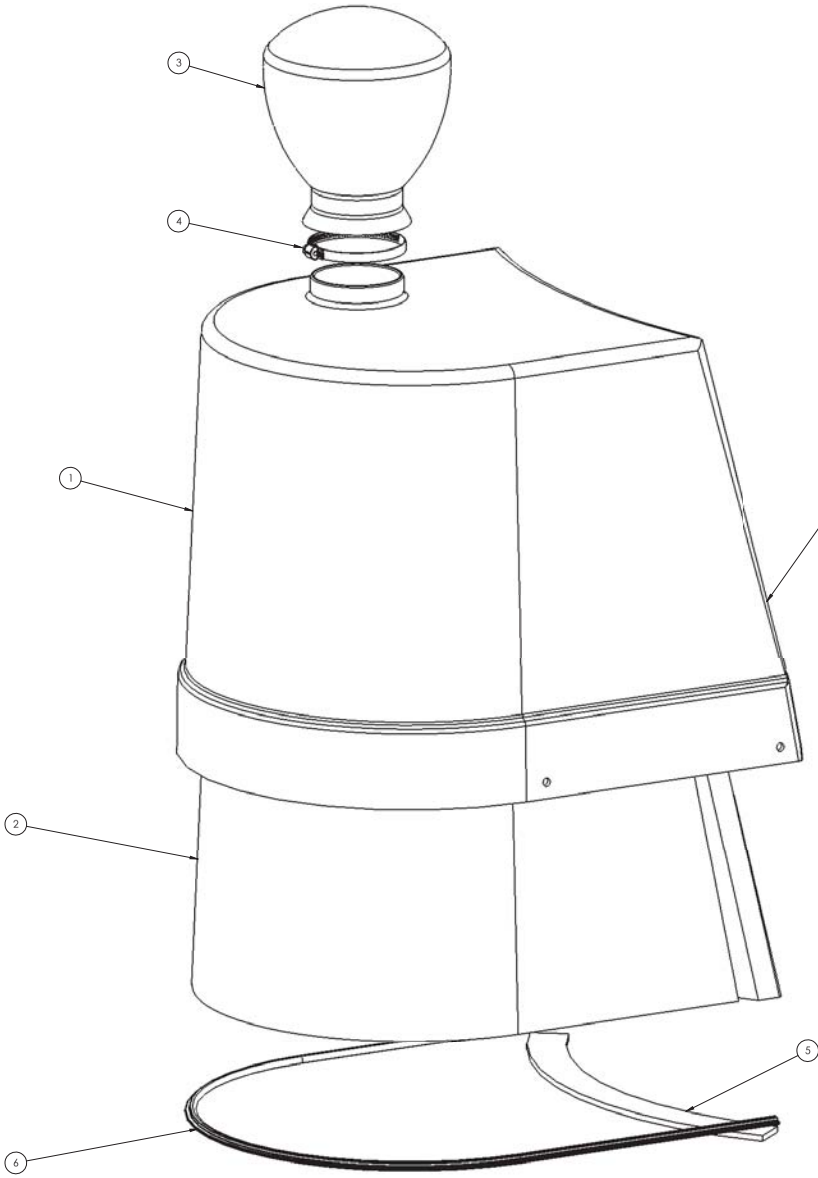
TITLE:
DIFFUSER ASM, D1, BLK

SIZE	DWG. NO.	REV
D	000 E 0128 US	G

SCALE: 1:3 | WEIGHT: | SHEET 1 OF 1



HOLE LOCATIONS FOR HOSE HANGER



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	D	ECO 799	3/8/2011	DJS
	E	ECO 964	3/20/2013	DJS
	F	ECO 1342: REMOVED HARDWARE, UPDATED PRINT	5/18/2017	DJE
	G	ECO 1689- HOLE LOCATIONS ADDED FOR HOSE HANGER	12/20/2019	DB

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	34976	SILENCER HOOD, BLACK, D1	1
2	3286202	FOAM, SILENCER HOOD, .75 X 8 X 52.5	1
3	30058	AIR DIFFUSER BAG DS1 LID	1
4	4018	HOSE CLAMP 2.31-3.25", SS	1
5	34934	GASKET, 1.25IN X .1875 THICK, FOR AV DIFFUSER	1 FT
6	31377	GASKET, NITRILE SPONGE, FOR AV DIFFUSER	3.35 FT

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TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005
BREAK SHARP EDGES
MATERIAL
FINISH
NEXT ASS'Y | USED ON
APPLICATION

	NAME	DATE
DRAWN	DJE	5/18/17
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		

COMMENTS:
PH34974AIRVAC

RUWAC 54 Winter St. Holyoke, Ma. 01040

TITLE:
DIFFUSER ASM FOR AIR VACS DS1, BLACK

SIZE	DWG. NO.	REV
D	000 E 0148 US	G

SCALE: 1:2 | WEIGHT: | SHEET 1 OF 1