MODEL
#XF-XC602000AJ
60 GALLON

MODEL
#XF-XC802000AJ
80 GALLON

ELECTRIC AIR COMPRESSORS

Service questions? Missing Parts? Problems?
Call our customer service department at 1-800-551-2406, 8 a.m. - 4:30 p.m. (CST)
Monday - Friday

ATTACH YOUR RECEIPT HERE

Serial Number _____

Purchase Date _____

TABLE OF CONTENTS

PRODUCT SPECIFICATIONS

60 GALLON

COMPONENT	SPECIFICATIONS
Model	XF-XC602000AJ
HP	3.5
Number of Cylinders	2
Number of Stages	2
Air Delivery @ 90 PSI	11 CFM
Voltage	230 Volts/16.2 Amps
Max Pressure	175 PSI
Oil Capacity	47.4 oz
Tank Outlet Size	3/4 NPT
Depth	21.9 in.
Width	27.5 in.
Height	69.6 in.
Weight	270 lbs.

80 GALLON

COMPONENT	SPECIFICATIONS
Model	XF-XC802000AJ
HP	5
Number of Cylinders	2
Number of Stages	2
Air Delivery @ 90 PSI	15.8 CFM
Voltage	230 Volts/22 Amps
Max Pressure	175 PSI
Oil Capacity	47.4 oz.
Tank Outlet Size	3/4 NPT
Depth	26.4 in.
Width	27.97 in.
Height	69.6 in.
Weight	410 lbs.

SAFETY GUIDELINES

Please read and understand this entire manual before attempting to assemble, operate or install the product. If you have any questions regarding the product, please call customer service at 1-800-551-2406, 8:00 a.m. - 4:30 p.m. (CST), Monday - Friday.

This manual contains information that is very important to know and understand. This information is provided for SAFETY and to PREVENT EQUIPMENT PROBLEMS. To help recognize this information, observe the following symbols.

⚠ DANGER

Danger indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.

⚠ WARNING

Warning indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.

CAUTION

Caution indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury.

NOTICE

Notice indicates important information, that if not followed, may cause damage to equipment.

SAFETY INFORMATION

CALIFORNIA PROPOSITION 65

⚠ WARNING

This product can expose you to chemicals including lead, which are known to the state of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

⚠ WARNING

Wear Eye and Mask Protection. You can create dust when you cut, sand, drill or grind materials such as wood, paint, metal, concrete, cement, or other masonry. This dust often contains chemicals known to cause cancer, birth defects, or other reproductive harm. Wear protective gear.

GENERAL SAFETY

Since the air compressor and other components (material pump, spray guns, filters, lubricators, hoses, etc.) used, make up a high pressure pumping system, the following safety precautions must be observed at all times:

1. Read all manuals included with this product carefully. Be thoroughly familiar with the controls and the proper use of the equipment.
2. Follow all local electrical and safety codes as well as in the United States, the National Electrical Codes (NEC) and Occupational Safety and Health Act (OSHA).
3. Only persons well acquainted with these rules of safe operation should be allowed to use the compressor.
4. Keep visitors away and NEVER allow children in the work area.
5. Wear safety glasses and use hearing protection when operating the unit.

⚠ SAFETY INFORMATION

GENERAL SAFETY (Continued)

6. Do not stand on or use the unit as a handhold.
7. Before each use, inspect compressed air system and electrical components for signs of damage, deterioration, weakness or leakage. Repair or replace defective items before using.
8. Check all fasteners at frequent intervals for proper tightness.
9. Do not wear loose clothing or jewelry that will get caught in the moving parts of the unit.
10. Keep fingers away from a running compressor; fast moving and hot parts will cause injury and/or burns.
11. If the equipment should start to vibrate abnormally, STOP the motor and check immediately for the cause. Vibration is generally a warning of trouble.
12. To reduce fire hazard, keep motor exterior free of oil, solvent, or excessive grease.
13. Never attempt to adjust ASME safety valve. Keep safety valve free from paint and other accumulations.
14. Tanks rust from moisture build-up, which weakens the tank. Make sure to drain tank daily and inspect periodically for unsafe conditions such as rust formation and corrosion.
15. Fast moving air will stir up dust and debris which may be harmful. Release air slowly when draining moisture or depressurizing the compressor system.

⚠ DANGER

Risk of Personal Injury. This compressor/pump is NOT equipped and should NOT be used "as is" to supply breathing quality air. For any application of air for human consumption, you must fit the air compressor/pump with suitable in-line safety and alarm equipment. This additional equipment is necessary to properly filter and purify the air to meet minimal specifications for Grade D breathing as described in Compressed Gas Association Commodity Specification G 7.1, OSHA 29 CFR 1910. 134, and/or Canadian Standards Associations (CSA).

DISCLAIMER OF WARRANTIES
In the event the compressor is used for the purpose of breathing air application and proper in-line safety and alarm equipment is not simultaneously used, existing warranties are void, and the Manufacturer disclaims any liability whatsoever for any loss, personal injury or damage.

⚠ WARNING

Risk of Personal Injury and/or Equipment Damage. Never install a shut-off valve between the compressor pump and the tank.

⚠ DANGER

Risk of Explosion. Never attempt to repair or modify a tank! Welding, drilling or any other modification will weaken the tank resulting in damage from rupture or explosion. Always replace worn, cracked or damaged tanks.

⚠ WARNING

Risk of Fire. Motors, electrical equipment and controls can cause electrical arcs that will ignite a flammable gas or vapor. Never operate or repair in or near a flammable gas or vapor. Never store flammable liquids or gases in the vicinity of the compressor.

⚠ WARNING

Risk of Explosion. Never use plastic (PVC) pipe for compressed air. Serious injury or death could result.

GENERAL SAFETY (Continued)

⚠ WARNING

Risk of Personal Injury. Never operate compressor without a beltguard. This unit can start automatically without warning. Personal injury or property damage could occur from contact with moving parts.

⚠ WARNING

Risk of Explosion. An ASME code safety relief valve with a setting no higher than the maximum allowable working pressure (MAWP) MUST be installed in the tank for this compressor. The ASME safety valve must have sufficient flow and pressure ratings to protect the pressurized components from bursting.

⚠ WARNING

Risk of Personal Injury. This compressor is extremely top heavy. The unit must be bolted to the floor with isolation pads before operating to prevent equipment damage, injury or death.

CAUTION

Do Not Overpressure. See compressor specification decal for maximum operating pressure. Do not operate with pressure switch or pilot valves set higher than the maximum operating pressure.

CAUTION

Risk of Personal Injury. Compressor parts may be hot even if the unit is stopped.

NOTICE

Unit Care and Maintenance. Drain liquid from tank daily.

SPRAYING PRECAUTIONS

1. Do not smoke when spraying paint, insecticides, or other flammable substances.
2. Use a face mask/respirator when spraying and spray in a well-ventilated area to prevent health and fire hazards.
3. Do not direct paint or other sprayed material at the compressor. Locate compressor as far away from the spraying area as possible to minimize overspray accumulation on the compressor.
4. When spraying or cleaning with solvents or toxic chemicals, follow the instructions provided by the chemical manufacturer.

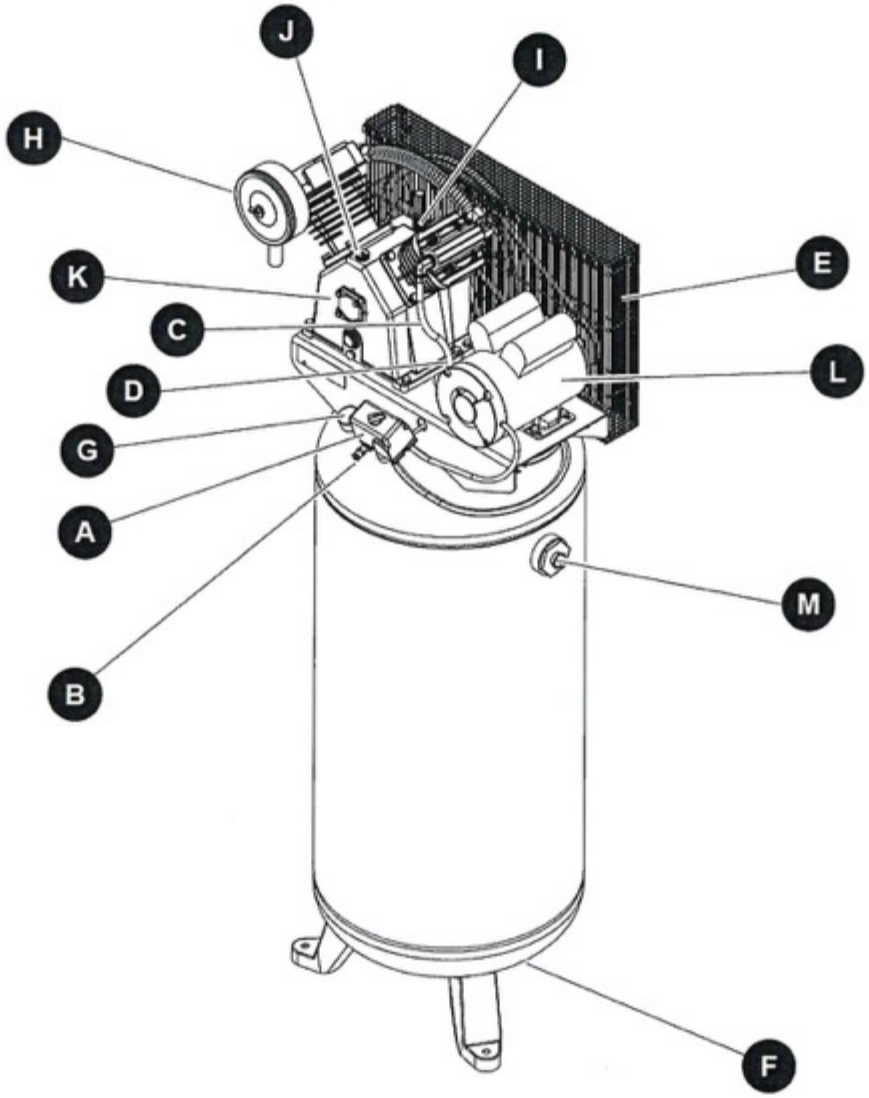
⚠ WARNING

Risk of Fire. Do not spray flammable materials in vicinity of open flame or near ignition sources including the compressor unit.

NOTICE

The **DANGER**, **WARNING**, **CAUTION**, and **NOTICE** notifications and instructions in this manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that caution is a factor which cannot be built into this product, but must be supplied by the operator.

PACKAGE CONTENTS



PART	DESCRIPTION	QTY.
A	**Pressure Switch -** AUTO/OFF Switch - In the AUTO position, the compressor shuts off automatically when tank pressure reaches the maximum preset pressure. After air is used from the tank and drops to a preset low level, the pressure switch automatically turns the motor back on. In the OFF position, the compressor will not operate. This switch should be in the OFF position when connecting or disconnecting the power from the unit. When the pressure switch turns the motor off you will hear air leaking out of the pressure switch unloader valve for a short time. This releases the air pressure from the discharge tube and allows the compressor to restart easier.	1
B	**ASME Safety Valve -** This valve automatically releases air if the tank pressure exceeds the preset maximum.	1
C	**Discharge Tube -** This tube carries compressed air from the pump to the check valve. This tube becomes very hot during use. To avoid the risk of severe burns, never touch the discharge tube.	1

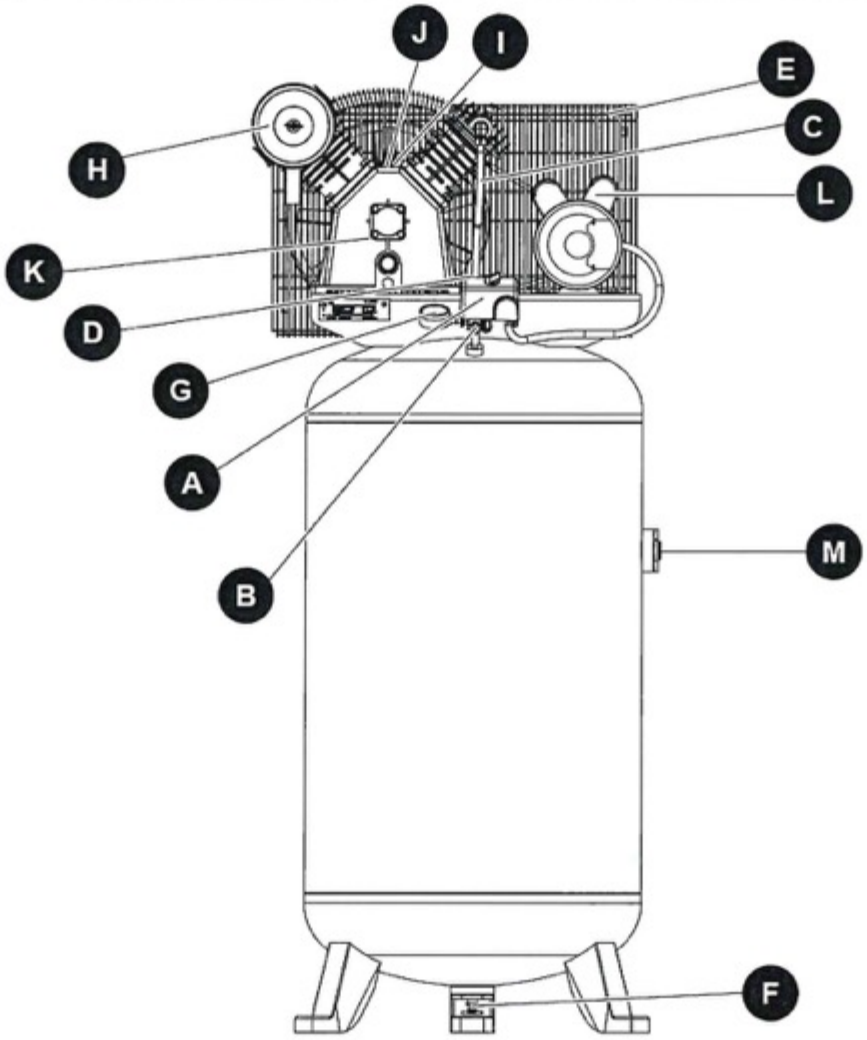
60 GALLON

PACKAGE CONTENTS

PART	DESCRIPTION	QTY.
D	**Check Valve -** One-way valve that allows air to enter the tank, but prevents air in the tank from flowing back into the compressor pump.	1
E	**Belt Guard -** Covers the belt, motor pulley and flywheel.	1
F	**Bottom Drain Valve -** Use this valve to drain moisture from the tank daily to reduce the risk of corrosion.	1
G	**Tank Pressure Gauge -** Indicates amount of air pressure stored in tank.	1
H	**Air Filter -** Keeps large particulates out of the air flowing into the compressor.	2
I	**Breather -** Vent for crankcase.	1
J	**Oil Fill Port** - Port used to refill the oil in the pump after oil changes or when oil is low.	1
K	**Pump** - Cast Iron 2-Stage air compressor pump that generates compressed air.	1
L	**Motor** - Power source that drives the pump to create compressed air.	1
M	**Tank Outlet** - This is where you plumb into to get compressed air from the pressure vessel. An isolation valve should be installed here to be able to shut off the air supply from the tank.	1

80 GALLON

PACKAGE CONTENTS



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80 GALLON

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M	**Tank Outlet** - This is where you plumb into to get compressed air from the pressure vessel. An isolation valve should be installed here to be able to shut off the air supply from the tank.	1

PREPARATION

Before beginning installation and/or assembly of product, make sure all parts are present. Compare parts with package contents list. If any part is missing or damaged, do not attempt to assemble or use the product.

⚠ WARNING

Risk of Personal Injury. Do not operate unit if damaged during shipping, handling or use. Damage may result in bursting and cause injury or property damage.

Estimated Installation and Assembly Time: 120 minutes

Tools Required for Installation and Assembly (not included): Safety Glasses; Work Gloves; 9/16 in. Socket and Ratchet; Tape measure; Hammer Drill and Masonry Bit; Hammer; Phillips Screwdriver; Flathead Screwdriver; Pipe Wrench; Two Adjustable Wrenches; 1/4 in. Nut Driver, Socket or Wrench; 240 Volt, 30 Amp Double Pole Circuit Breaker; Voltage Meter; Vibration Pads; 3/8 in. x 5 in. Wedge Anchors (for concrete installation)

INSTALLATION INSTRUCTIONS

UNIT INSTALLATION

⚠ WARNING

Risk of Personal Injury. Do not lift or move unit without appropriately rated equipment. Be sure the unit is securely attached to lifting device used. Do not lift unit by holding onto tubes or coolers. Do not use unit to lift other attached equipment.

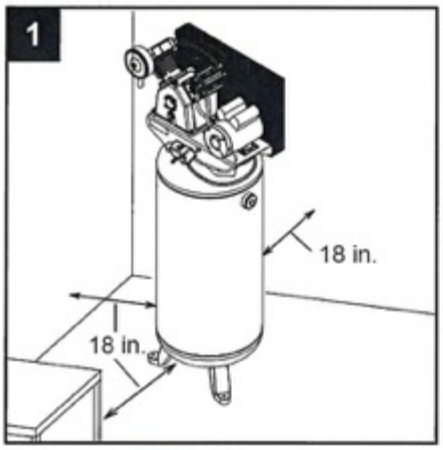
NOTICE

Unit Care and Maintenance. This compressor is not intended for outdoor installation.

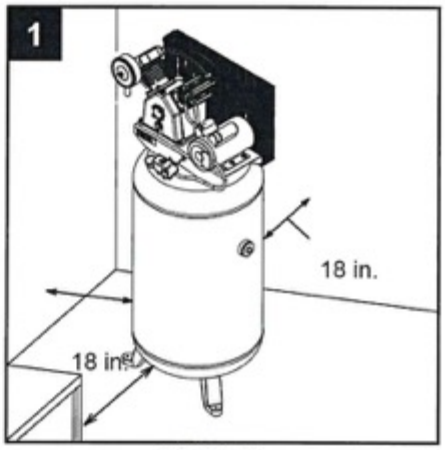
It is extremely important to install the compressor in a clean, well-ventilated area where the surrounding air temperature will not be more than 100°F. Do not locate the compressor air inlet near steam, paint spray, sandblast areas or any other source of contamination.

INSTALLATION INSTRUCTIONS

1. Unbolt the unit from the shipping skid. Use a ratchet with a 9/16 in. socket. Remove the unit from the skid. This requires at least two people - one person to walk the unit off the skid and one to help maintain balance so the unit does not topple. Place the unit where you plan to install it (at least 18 in. from any wall or surface).



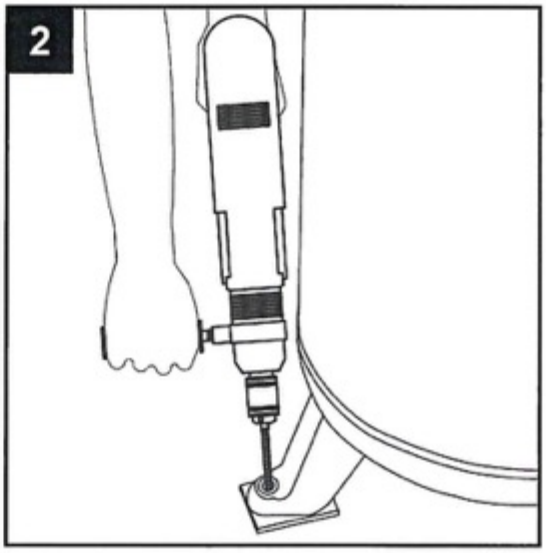
60 Gallon



80 Gallon

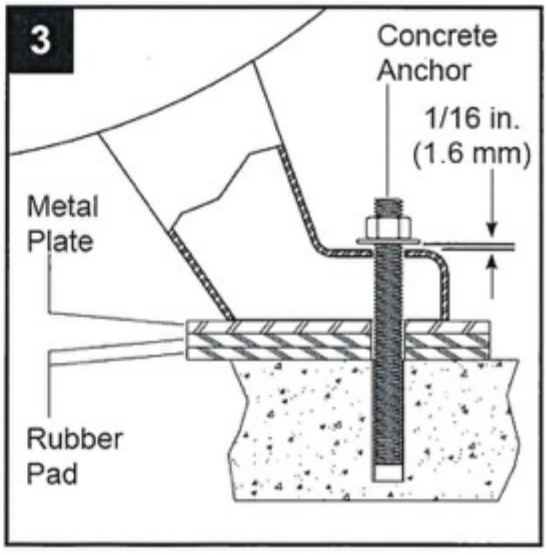
2. Place pre-drilled vibration pads (sold separately) under each foot to avoid unnecessary vibration which could damage the unit.

   Using the mounting holes and the holes of the vibration pads as a guide, drill holes into concrete using a 3/8 in. masonry bit. Holes drilled must be at least 5 in. into the concrete.



3. Insert mounting bolts. Use 3/8 in. x 5 in. wedge anchors (not included) to secure the unit. Place nut and washer on bolt. Thread nut onto bolt until tops are flush. Strike bolt with hammer until nut and washer are setting on top of the compressor foot.

   Tighten nut using ratchet with a 9/16 in. socket until anchor is set (using installation torque specifications of bolt being used). Loosen nut to leave a 1/16 in. (1.6 mm) gap for stress relief during unit operation.



ELECTRICAL INSTALLATION

⚠ DANGER

Risk of Shock. Improperly grounded motors are shock hazards. Make sure all the equipment is properly grounded.

⚠ WARNING

Risk of Personal Injury or Damage to Personal Property. Overheating, short circuiting and fire damage will result from inadequate wiring.

⚠ WARNING

Risk of Shock. All wiring and electrical connections must be performed by a qualified electrician familiar with industrial motor controls. Installations must be in accordance with local and national codes.

⚠ WARNING

Risk of Explosion. Disconnect, tag and lock out power source, then release all pressure from the system before attempting to install, service, relocate or perform any maintenance.

NOTICE

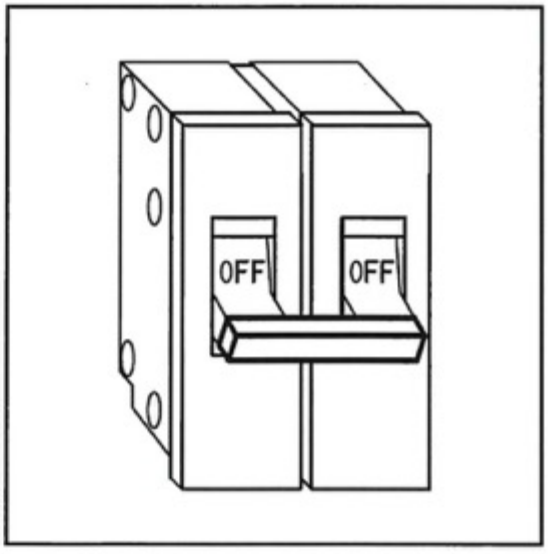
Unit Care and Maintenance. Damage to the motor from improper electrical voltage or connection will void the warranty.

GROUNDING

This product must be grounded. Install permanent wiring from the electrical source to the pressure switch with a ground conductor connected to the grounding screw on the pressure switch. A properly sized cord with a ground conductor and plug may also be installed by the user.

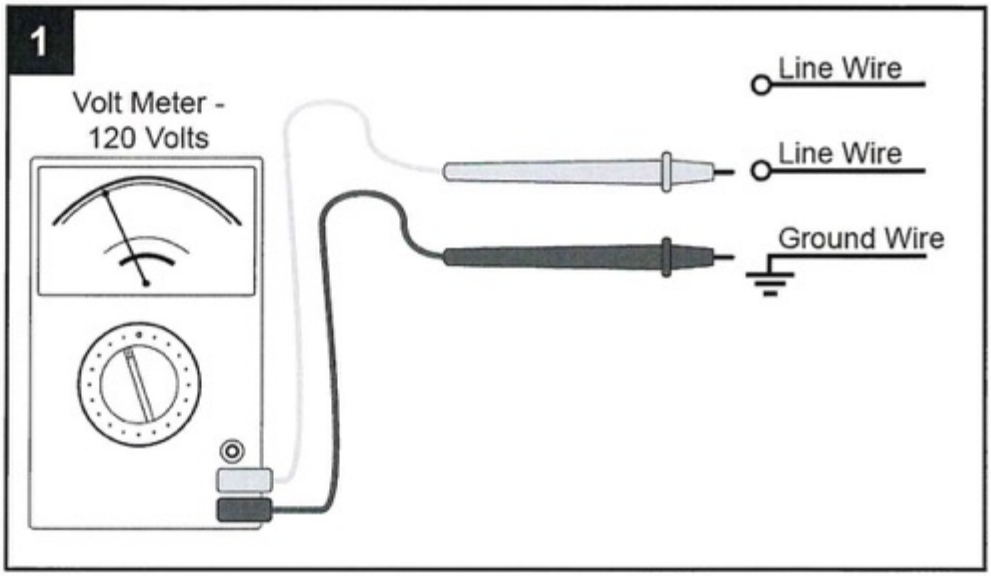
WIRING

Local electrical wiring codes differ from area to area. Source wiring and protector must be rated for at least the amperage and voltage indicated on the motor nameplate and meet all electrical codes for this minimum. Use a slow blow fuse type T or a 240 Volt double pole circuit breaker.

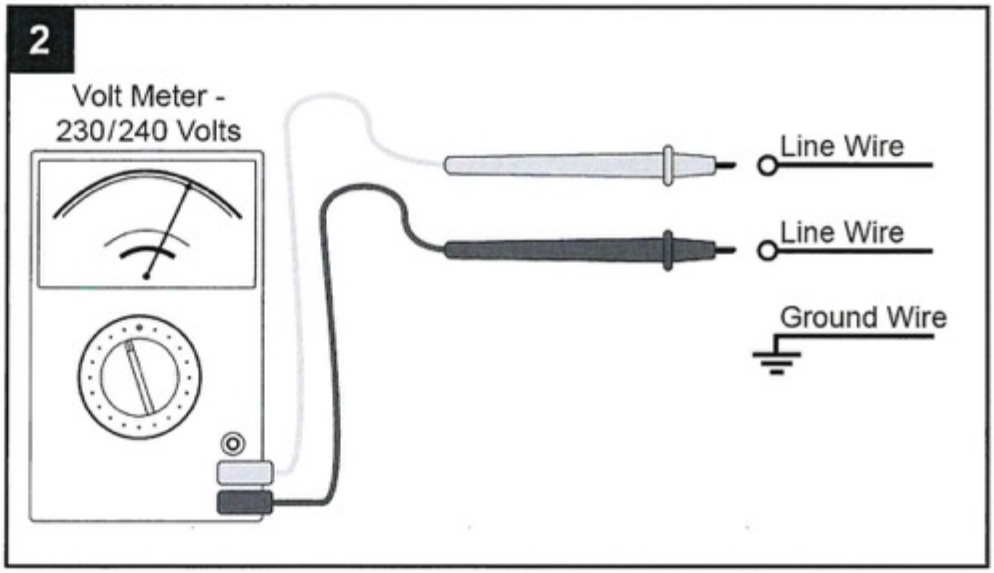


MINIMUM WIRE SIZES (must meet all codes)		
60 Gallon	Up to 75 ft. long	12 AWG
80 Gallon	Up to 75 ft. long	10 AWG

1. Inspect the source wiring before continuing with installation. Confirm voltage with volt meter line-to-ground (see Figure 1). Volt meter should read 120 Volts.



Confirm voltage with volt meter line-to-line Volt meter should read 230/240 Volts (see Figure 2).

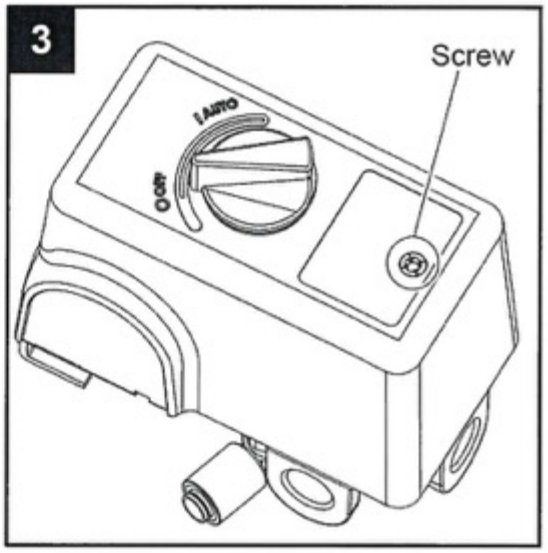


2. Remove the pressure switch cover by loosening the screw (see Figure 3). Use a Phillips screwdriver (not included). Pressure switch styles may vary.

⚠ WARNING

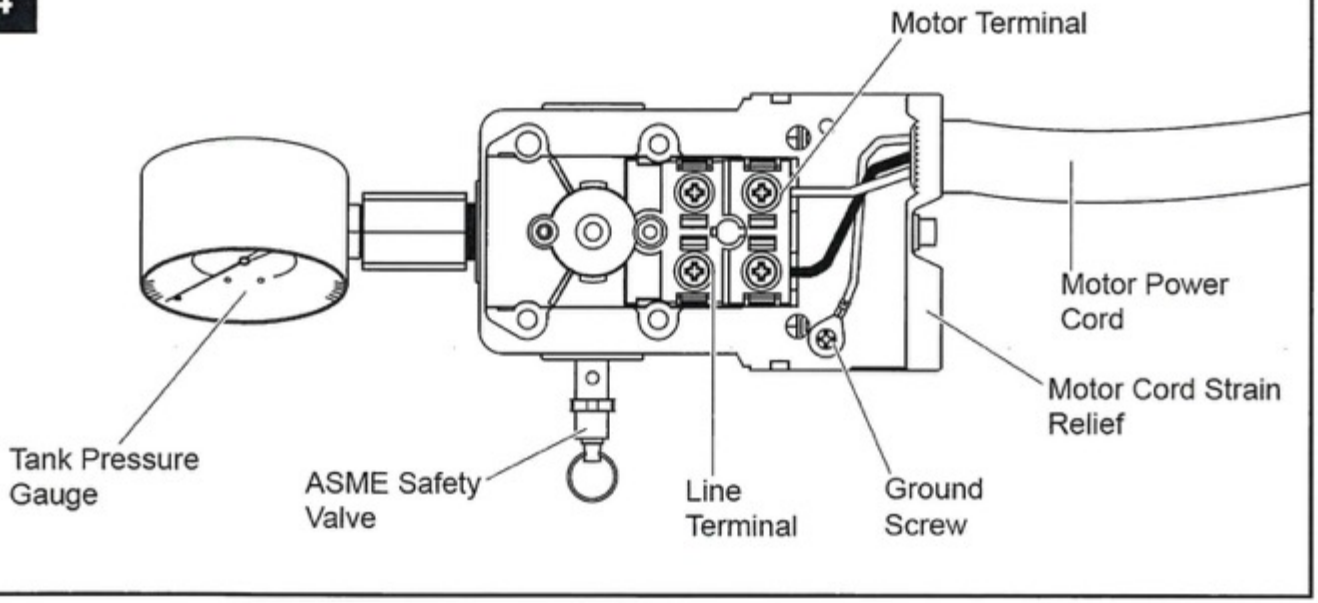
Risk of Shock. All wiring and electrical connections must be performed by a qualified electrician familiar with industrial motor controls. Installations must be in accordance with local and national codes.

3



3. Familiarize yourself with the pressure switch once cover is removed.

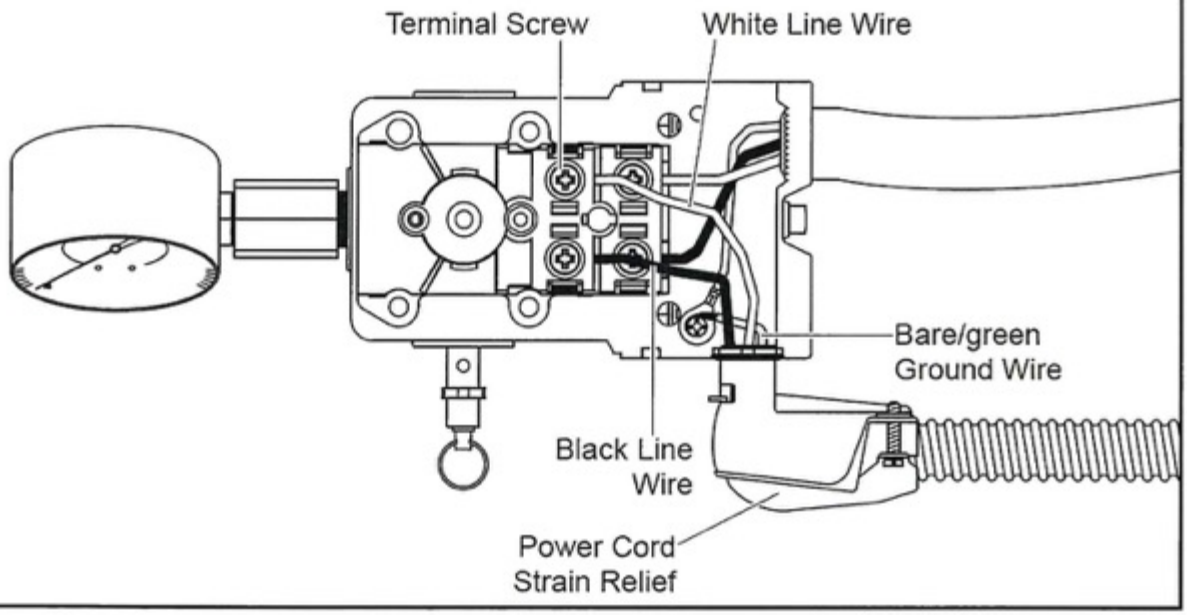
4



4. Remove ground screw. Install strain relief on pressure switch. **DO NOT** tighten strain relief on power cord until wiring is complete. Insert the bare wires (black, white, bare/green) through the strain relief.

   Attach bare/green ground wire first to ground screw on pressure switch body.
   Look for the "Line" markings on pressure switch. Install Line wires and tighten terminal screws.

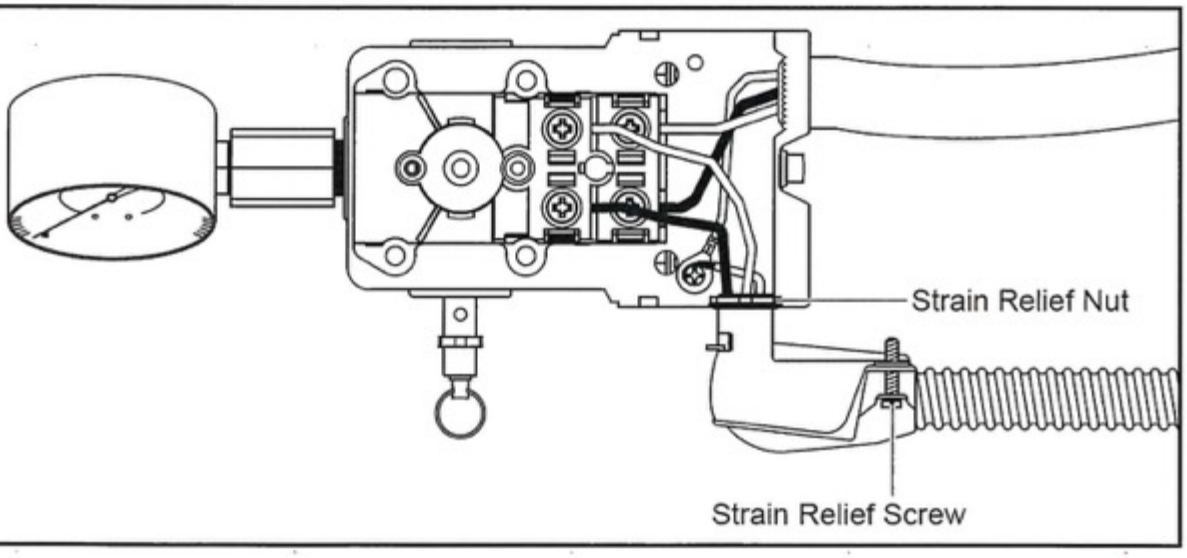
5



5. Tighten strain relief nut. Place a flathead screwdriver (not included) into raised notch and tap screwdriver with hammer (not included) until tight.

   Tighten strain relief screws to hold power cord securely. Replace the pressure switch cover (knob must be in the same position as when removed to sit correctly in place). Tighten the pressure switch screw with Phillips screwdriver. Check that switch is in the **OFF** position. Follow break-in procedure starting on page 18.

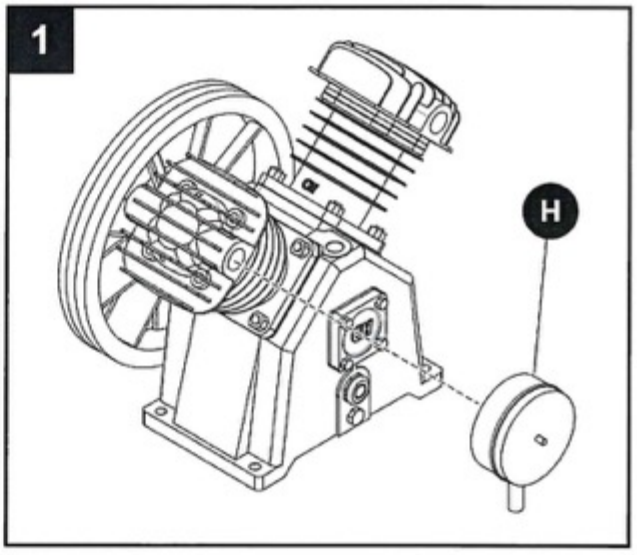
6



ASSEMBLY INSTRUCTIONS

FILTER

Install air filter (H) on pump (see Figure 1).
Filter styles may vary.



LUBRICATION

CAUTION

Inspect Before Use. Check for proper oil level before operating!

Remove oil fill plug on pump. Check oil level; some models are shipped with oil in the pump. See specification label on compressor pump for the proper oil capacity and oil type. Add oil if needed. Place oil fill plug back on pump.

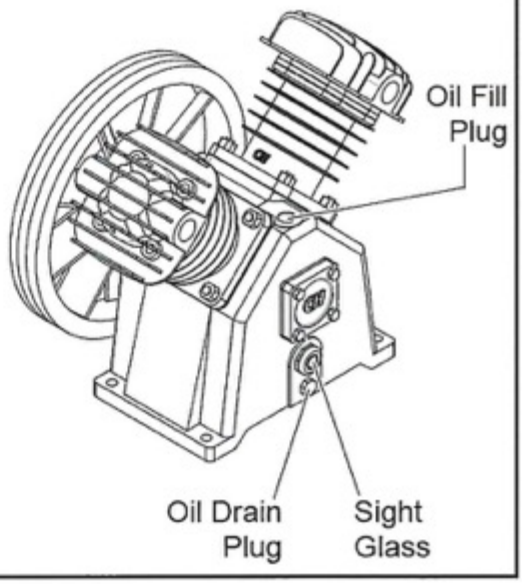
OIL INFORMATION	
X-Force Compressor Oil	R068
Oil Capacity	Approximately 47.4 ounces

Do not use regular automotive oil. Additives in regular motor oil can cause valve deposits and reduce pump life.

For maximum pump life, drain and replace oil after the first 50 hours of run time and then follow the regular maintenance schedule outlined later in the manual.

This pump has an oil sight glass as shown in Figure 1. Oil level can be monitored and maintained as shown in Figure 2.

1



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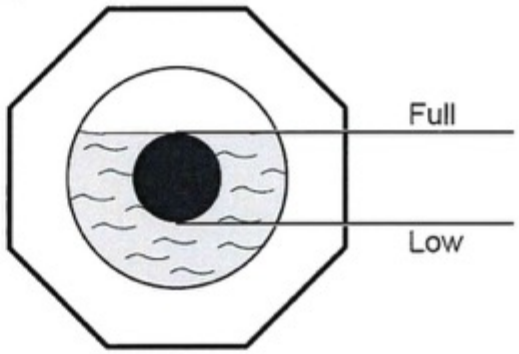


Sight Glass

PIPING

⚠ WARNING

Risk of Personal Injury. Never use plastic (PVC) pipe for compressed air. Serious injury or death could result.

Any tube, pipe, or hose used must have a pressure rating higher then 200 PSI. Minimum recommended pipe size is 3/4 in. Larger diameter pipe is always better.

START-UP/BREAK-IN PROCEDURE

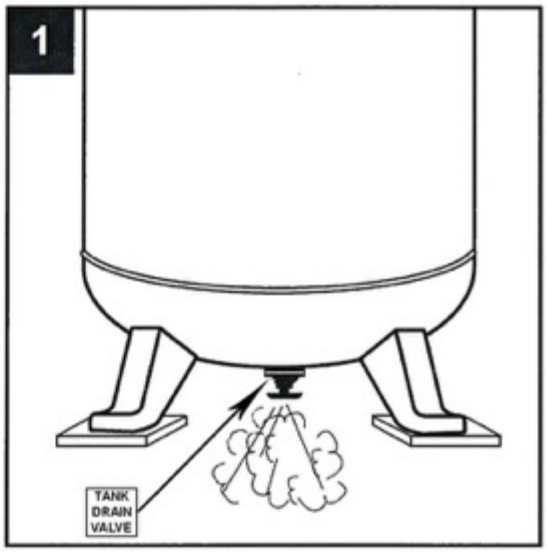
⚠ WARNING

Risk of Personal Injury. Do not attach air tools to open end of the hose until start-up is completed and the unit checks okay.

⚠ WARNING

Risk of Personal Injury. Never disconnect threaded joints with pressure in tank!

1. Return power to unit from main.
2. Check oil level per the Lubrication Section of this manual.
3. Open the tank drain valve (see Figure 1). Turn outlet valve to open air flow.



4. Move pressure switch to the **AUTO** position to run the unit (see Figure 2).
5. Run the unit for thirty (30) minutes at zero (0) PSI (under no load) to break in pump parts.
6. Move the pressure switch lever or knob to **OFF** and turn tank drain valve to shut off air flow. The compressor is now ready for use.
7. Change oil after first fifty (50) hours of operation. Perform oil changes every three (3) months or two hundred (200) hours of run time, whichever comes first.

OPERATING INSTRUCTIONS

ON/OFF CYCLING OF COMPRESSOR

⚠ WARNING

Risk of Bursting. Drain tank every day to prevent corrosion and possible injury due to tank damage. For optimal performance of tank drain, tank pressure should be between 10 - 40 PSI. Do not operate drain with more than 40 PSI in tank or drain valve may be damaged. Drain tank of moisture daily using the drain valve in the bottom of the tank.

NOTICE

Unit Care and Maintenance. Drain liquid from tank daily.

In the **AUTO** position, the compressor pumps air into the tank. When a shut-off (preset "cut-out") pressure is reached, the compressor automatically shuts off.

If the compressor is left in the **AUTO** position and air is depleted from the tank by use of a tire chuck, tool, etc., the compressor will restart automatically at its preset "cut-in" pressure. When a tool is being used continuously, the compressor will cycle on and off automatically.

In the **OFF** position, the compressor will not operate.

CARE AND MAINTENANCE

⚠ WARNING

Risk of Explosion. Disconnect, tag and lock out power source, then release all pressure from the system before attempting to install, service, relocate or perform any maintenance.

NOTICE

Unit Care and Maintenance. Drain liquid from tank daily.

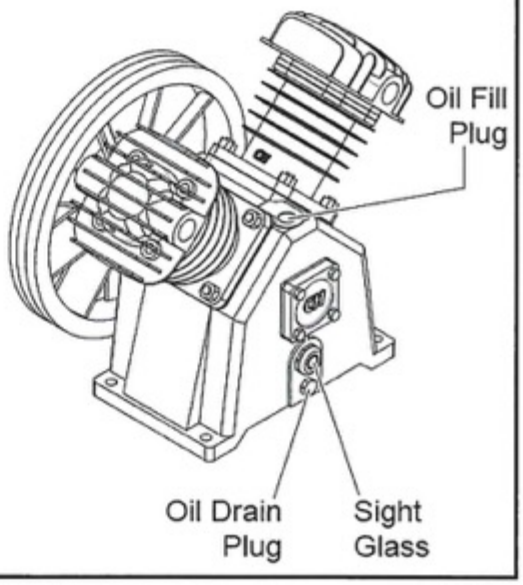
All repairs should be performed by an authorized service representative.

CARE AND MAINTENANCE

For efficient operation, perform the following maintenance.

1. Disconnect, tag and lock out power source; clean debris from motor, flywheel, tank, air lines and pump cooling fins.
2. Maintain proper oil level. Refer to Lubrication section for details.
3. Change oil.
   a. Allow compressor to run and warm up oil. Disconnect, tag and lock out power source.
   b. Position a pan under pump.
   c. Remove oil drain plug (See Figure 1). Allow oil to collect in pan.
   d. Replace drain plug, fill pump to full level (See Figure 1). See Lubrication section of this manual.
4. Drain Tank. Disconnect, tag and lock out power source; release pressure. Drain moisture from tank by opening drain valve underneath tank once tank pressure is less than 40 psi. (See Figure 2).
5. Check air filter to be sure it is clean. Replace filter if filter is dirty.

1



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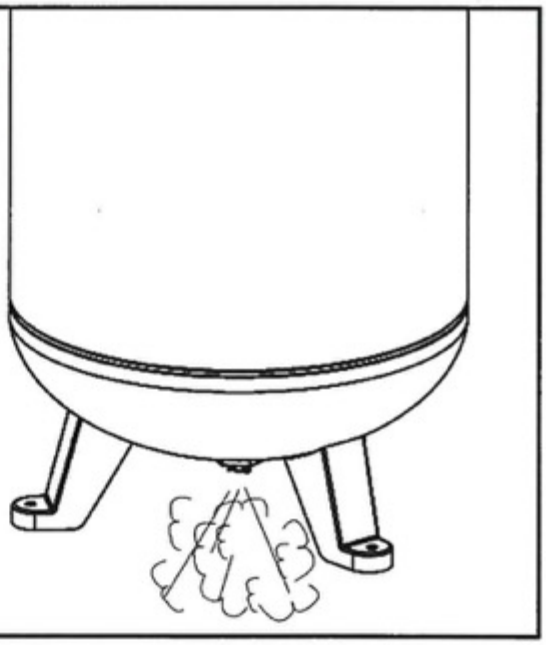


MOISTURE IN COMPRESSED AIR

Moisture in compressed air will form into droplets as it comes from an air compressor pump. When humidity is high or when a compressor is in continuous use for an extended period of time, this moisture will collect in the tank. When using a paint spray or sandblast gun, this water will be carried from the tank through the hose, and out of the gun as droplets mixed with the spray material.

IMPORTANT: This condensation will cause water spots in a paint job, especially when spraying other than water based paints. If sandblasting, it will cause the sand to cake and clog the gun, rendering it ineffective. A filter in the air line, located as near to the gun as possible, will help eliminate this moisture.

6. Check the safety valve by performing the following steps:
   a. Restore power to unit; turn pressure switch to the **AUTO** position. Run until unit reaches 90 PSI. Turn pressure switch to **OFF** position.
   b. Wearing safety glasses and hearing protection, pull the ring on the safety valve to release pressure from compressor tank. Protect yourself from fast-moving air being released; do not allow fast-moving air to be directed toward your face (See Figure 3).
   c. The safety valve should automatically close at approximately 40-50 PSI. If the safety valve does not allow air to be released when you pull on the ring, or if it does not close automatically, it MUST be replaced.
7. Check belt for signs of excessive wear. If belt shows signs of wear, replace it. Check belt for proper tension/alignment.

TECHNICAL SERVICE

For information regarding the operation or repair of this product, please call 1-800-551-2406.

MAINTENANCE SCHEDULE				
OPERATION	**DAILY**	**WEEKLY**	**MONTHLY**	**3 MONTHS**
CHECK OIL LEVEL	●			
DRAIN TANK	●			
CHECK AIR FILTER		●		
CHECK SAFETY VALVE		●		
CLEAN UNIT			●	
CHECK BELT TIGHTNESS			●	
CHANGE OIL*				●

* Change oil after first fifty (50) hours of operation then perform oil changes every three (3) months or two hundred (200) hours of run time, whichever comes first.

PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Low discharge pressure.	1. Air demand exceeds pump capacity.	1. Reduce air demand or use a compressor with more capacity.
	2. Restricted air intake.	2. Clean or replace the air filter element.
	3. Air leaks (fittings, tubing on compressor, or plumbing outside of system).	3. Listen for escaping air. Apply soap solution to all fittings and connections. Bubbles will appear at points of leakage. Tighten or replace leaking fittings or connections. Use pipe thread sealant.
	4. Blown gaskets.	4. Replace any gaskets proven faulty on inspection.
	5. Leaking or damaged valves.	5. Remove head and inspect for valve breakage, misaligned valves, damaged valve seats, etc. Replace defective parts and reassemble. **CAUTION** **Unit Care and Maintenance.** Install a new head gasket each time the head is removed.
Excessive noise (knocking).	1. Loose motor pulley or flywheel.	1. Tighten pulley/flywheel clamp bolts and set-screws.
	2. Loose fasteners on pump or motor.	2. Tighten fasteners.
	3. Lack of oil in crankcase.	3. Check for proper oil level; if low, check for possible damage to bearings. Dirty oil can cause excessive wear.
	4. Worn connecting rod.	4. Replace connecting rod. Maintain oil level and change oil more frequently.
	5. Worn piston pin bores.	5. Remove piston assemblies from the compressor and inspect for excess wear. Replace excessively worn piston pin or pistons, as required. Maintain oil level and change oil more frequently.
	6. Piston hitting the valve plate.	6. Remove the compressor head and valve plate and inspect for carbon deposits or other foreign matter on top of piston. Replace head and valve plate using new gasket. See Lubrication section for recommended oil.
	7. Noisy check valve in compressor system.	7. Replace check valve. **⚠ DANGER**  **Risk of Explosion.** Do not disassemble check valve with air pressure in tank.

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Large quantity of oil in the discharge air NOTE: In an oil lubricated compressor there will always be a small amount of oil in the air stream.	1. Worn piston rings.	1. Replace with new rings. Maintain oil level and change oil more frequently.
	2. Compressor air intake restricted.	2. Clean or replace filter. Check for other restrictions in the intake system.
	3. Excessive oil in compressor.	3. Drain down to full level.
	4. Wrong oil viscosity.	4. Use X-Force Compressor Oil R068.
Water in discharge air/tank.	Normal operation. The amount of water increases with humid weather.	1. Drain tank more often. At least daily. 2. Add a filter to reduce the amount of water in the air line.
Motor hums and runs slowly or not at all.	1. Low voltage.	1. Check incoming voltage. It should be approximately 230 volts. Motor will not run properly on 208 volts. Low voltage could be due to wires (from electrical source to compressor) being too small in diameter and / or too long. Have a qualified electrician check these conditions and make repairs as needed.
	2. Too many devices on same circuit.	2. Limit the circuit to the use of compressor only.
	3. Loose electrical connections.	3. Check all electrical connections.
	4. Malfunctioning pressure switch - contacts will not close.	4. Replace pressure switch.
	5. Malfunctioning check valve.	5. Replace check valve. **⚠ DANGER** **Risk of Explosion.** Do not disassemble check valve with air pressure in tank.
	6. Defective unloader valve on pressure switch.	6. Replace unloader valve.
	7. Defective motor capacitor(s).	7. Replace capacitor(s).
	8. Defective motor.	8. Replace motor.

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Reset mechanism cuts out repeatedly or circuit breaker trips repeatedly.	1. Lack of proper ventilation/room temperature too high.	1. Move compressor to well-ventilated area.
	2. Too many devices on same circuit.	2. Limit the circuit to the use of only the air compressor.
	3. Restricted air intake.	3. Clean or replace filter element.
	4. Loose electrical connection.	4. Check all electrical connections.
	5. Pressure switch shut-off pressure set too high.	5. Replace pressure switch.
	6. Malfunctioning check valve.	6. Replace check valve. **⚠ DANGER**  **Risk of Explosion.** Do not disassemble check valve with air pressure in tank.
	7. Defective unloader valve on pressure switch.	7. Replace unloader valve.
	8. Defective motor capacitor(s).	8. Replace capacitor(s).
	9. Malfunctioning motor.	9. Replace motor.
Tank does not hold pressure when compressor is off and the shut off valve is closed.	1. Air leaks (fittings, tubing on compressor, or plumbing outside system).	1. Check all connections with soap and water solution. Tighten; or remove and apply sealant to threads, then reassemble.
	2. Worn check valve.	2. Replace check valve. **⚠ DANGER**  **Risk of Explosion.** Do not disassemble check valve with air pressure in tank.
	3. Check tank for cracks or pin holes.	3. Replace tank. Never repair a damaged tank.

PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Pressure switch continuously blows air out the unloader valve.	Malfunctioning check valve.	Replace the check valve if the unloader valve on the pressure switch bleeds off constantly when unit shuts off. **⚠ DANGER**  **Risk of Explosion.** Do not disassemble check valve with air pressure in tank.
Pressure switch does not release air when the unit shuts off.	Malfunctioning unloader valve on pressure switch.	Replace the unloader valve if it does not release the pressure for a short period of time when the unit shuts off. **⚠ DANGER**  **Risk of Explosion.** Do not disassemble unloader valve with air pressure in tank.
Excessive vibration.	1. Loose fasteners on pump or motor. 2. Belt needs replaced. 3. Belt alignment.	1. Tighten fasteners. 2. Replace with correct size. 3. Align flywheel and pulley.

WARRANTY

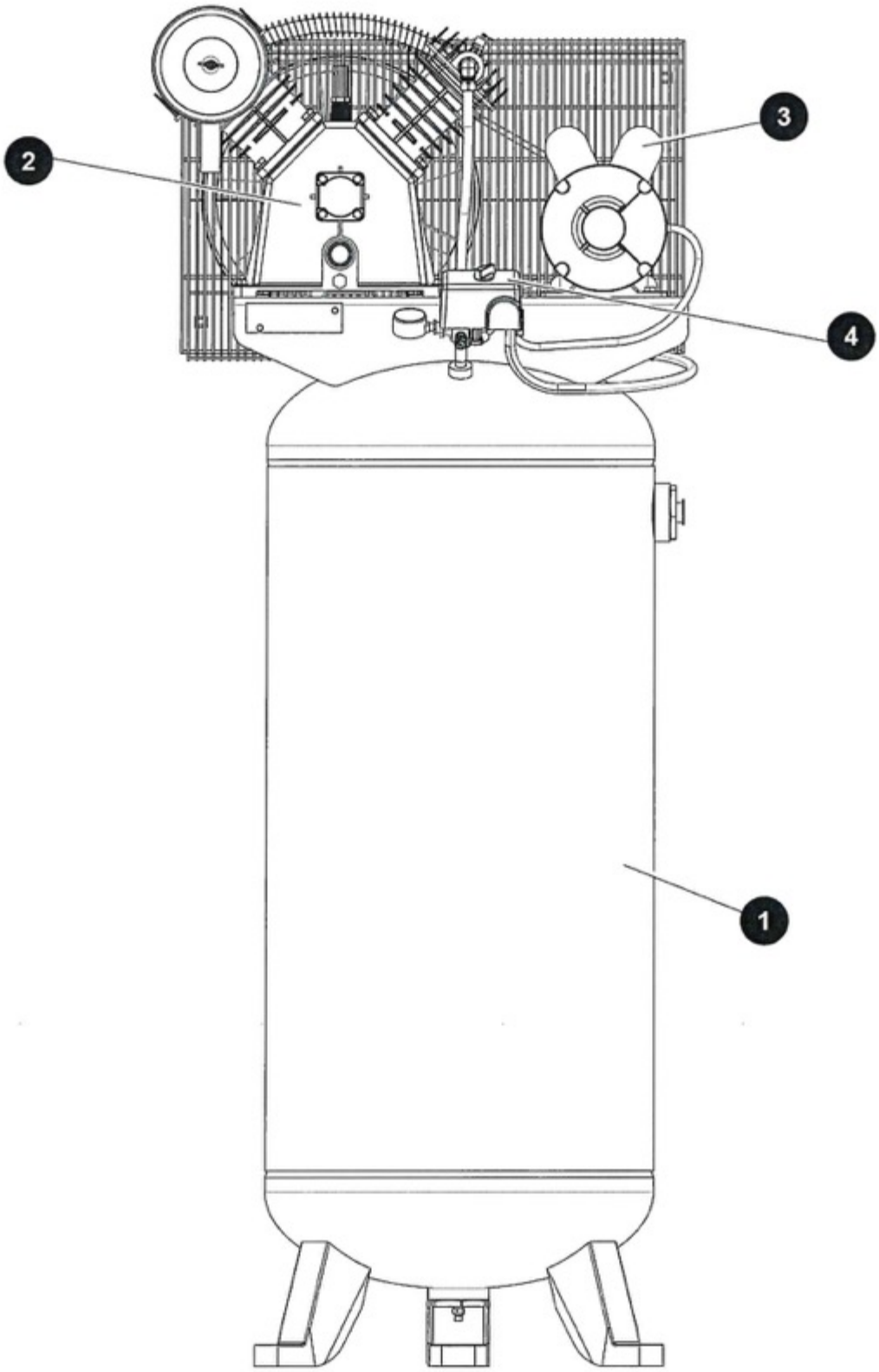
1. DURATION: From the date of purchase by the original purchaser as follows: 1 year - PARTS ONLY.
2. WHO GIVES THIS WARRANTY: Wood Industries, Inc. 21 Front Street, Belmont, MS. 38827
3. WHO RECEIVES THIS WARRANTY (PURCHASER): The original purchaser (other than for purposes of resale) of the compressor.
4. WHAT PRODUCTS ARE COVERED BY THIS WARRANTY: Parts Only
5. WHAT IS COVERED UNDER THIS WARRANTY: Parts to remedy substantial defects due to material and workmanship during the first year of ownership with the exceptions noted below. Parts only to remedy substantial defects due to material and workmanship during remaining term of coverage with exceptions noted below.
6. WHAT IS NOT COVERED UNDER THIS WARRANTY:
   A. Implied warranties, including those of merchantability and FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED FROM THE DATE OF ORIGINAL PURCHASE AS STATED IN THE DURATION. Some States do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply to you
   B. ANY INCIDENTAL, INDIRECT, OR CONSEQUENTIAL LOSS, DAMAGE, OR EXPENSE THAT MAY RESULT FROM ANY DEFECT, FAILURE, OR MALFUNCTION OF THE PRODUCT. Some States do not allow the exclusion or limitations of incidental or consequential damages, so the above limitation or exclusion may not apply to you.
   C. Any failure that results from an accident, purchaser's abuse, neglect or failure to operate products in accordance with instructions provided in the owner's manual(s) supplied with compressor.
   D. Pre-delivery service, e.g. assembly, oil or lubricants, and adjustment.
   E. Items or service that is normally required to maintain the product, i.e. lubricants, filters and gaskets, etc.
   F. Additional items not covered under this warranty:
      1. Excluded items pertaining to All Compressors
         a. Any component damaged in shipment or any failure caused by installing or operating unit under conditions not in accordance with installation and operation guidelines or damaged by contact with tools or surroundings.
         b. Pump or valve failure caused by rain, excessive humidity, corrosive environments or other contaminants.
         c. Cosmetic defects that do not interfere with compressor functionality.
         d. Rusted tanks, including but not limited to rust due to improper drainage or corrosive environments.
         e. Tank drain valves.
         f. Damage due to incorrect voltage or improper wiring.
         g. Other items not listed but considered general wear parts.
         h. Pressure switches, air governors, load/unload devices, throttle control devices and safety valves modified from factory settings.
         i. Damage from inadequate filter maintenance.
         j. Induction motors operated with electricity produced by a generator.

2. Excluded items specific to Lubricated Compressors:
   a. Pump wear or valve damage caused by using oil not specified.
   b. Pump wear or damage caused by any oil contamination.
   c. Pump wear or damage caused by failure to follow proper oil maintenance guidelines, operation below proper oil level or operation without oil.

7. RESPONSIBILITIES OF WARRANTOR UNDER THIS WARRANTY: Replace parts, at Warrantor's option, which are defective, malfunctioned and/or failed to conform within the duration of the specific warranty period.
8. RESPONSIBILITIES OF PURCHASER UNDER THIS WARRANTY:
   A. Provide dated proof of purchase and maintenance records.
   B. Call customer service at 1-800-551-2406 to obtain your warranty service options. Freight costs must be borne by the purchaser.
   C. Use reasonable care in the operation and maintenance of the products as described in the owner's manual(s).
   D. Repairs requiring warranty repair labor reimbursement rate.

This Limited Warranty applies in the U.S., Canada and Mexico only and gives you specific legal rights. You may also have other rights which vary from state to state or country to country.

60 GALLON REPLACEMENT PARTS LIST



60 GALLON REPLACEMENT PARTS LIST

Model # XF-XC602000AJ

For replacement parts, call our customer service department at 1-800-551-2406
8:00 a.m - 4:30 p.m. (CST) Monday - Friday.

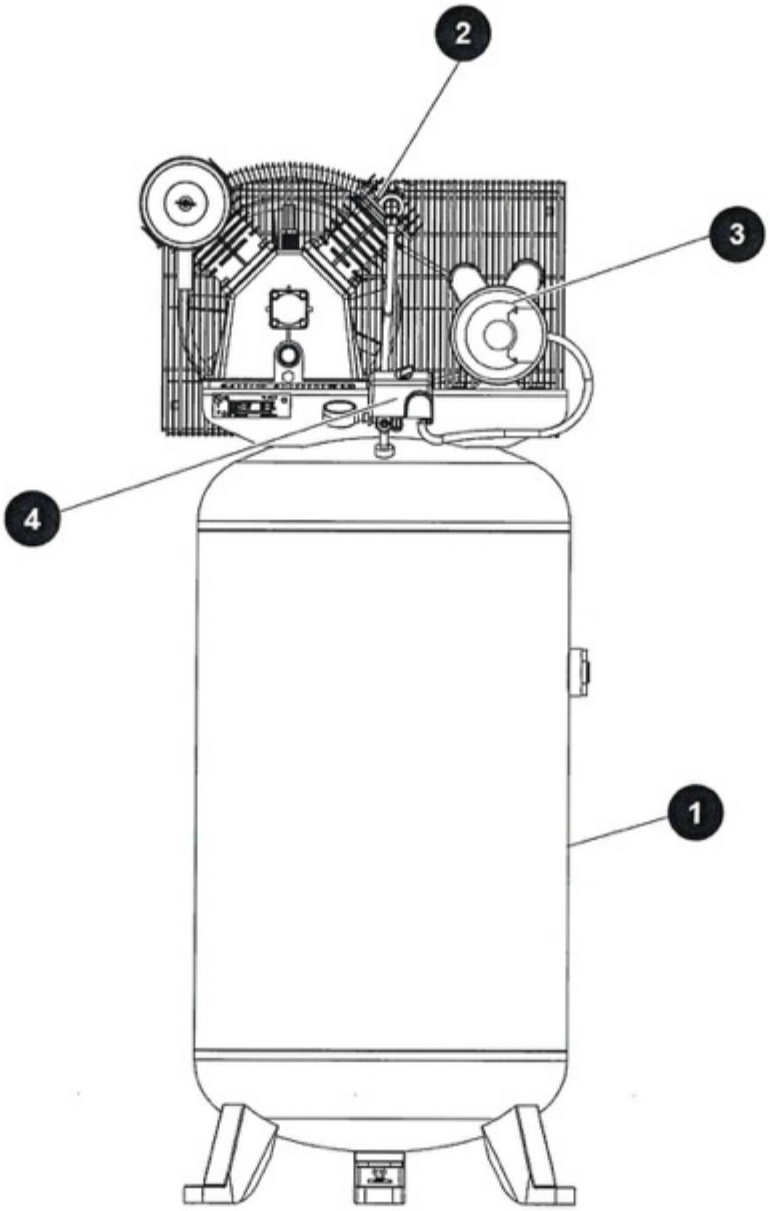
WARRANTY PARTS

PART	DESCRIPTION	PART NUMBER	QTY.
1	TANK, 60 GALLON	XF-60GB-07	1 each
2	COMPRESSOR PUMP	XF-60GB-05	1 each
3	MOTOR 3.7 HP 240 V	EM05.0-36-10SPLWEG	1 each
4	PRESSURE SWITCH 120/155	21UCBDB-CH150	1 each

UNIT SERVICE PARTS

DESCRIPTION	PART NUMBER	QTY.
AIR FILTER ELEMENT	101000-310	1 each
BALL VALVE	BV3/4MF	1 each
BELT GUARD BACK	XF-60GB-01	1 each
BELT GUARD BRACKET	XF-60GB-02	1 each
BELT GUARD FRONT	XF-60GB-03	1 each
BELT, AX48	B54	1 each
BRASS FERRULE 1/2" TUBE	XF-80GB-04	1 each
CHECK VALVE	XF-60GB-04	1 each
COMPRESSION FITTING	68-4A	1 each
COMPRESSION NUT, 1/2"	XF-80GB-06	1 each
DRAIN VALVE	240-B	1 each
EXHAUST TUBE 1/2"	XF-80GB-08	1 each
FILTER ASSEMBLY	XF-80GB-09	1 each
HEAD TO TUBE CONNECTOR	XF-80GB-10	1 each
LABEL-2 STAGE 175 PSI	999999-XF05	1 each
LABEL-HEAVY DUTY 2 STAGE	999999-XF06	1 each
LABEL-MODEL LABEL	999999-102	1 each
LABEL-PROP 65 HANGTAG	999999-136	1 each
LABEL-PROP 65 LABEL	999999-137	1 each
LABEL-SERIAL LABEL	999999-102	1 each
LABEL-SERVICE LABEL RED	999999-SVCXF	1 each
LABEL-X-FORCE ITEM LABEL	999999-XF60	1 each
MOTOR CORD	12/3-13-PT	1 each
MOTOR PULLEY	MB33X5/8	1 each
NIPPLE	NI1/4X2	1 each
OIL	COMP68	47.4 OZ
PLASTIC RETAINING CLIP	XF-80GB-15	4 each
PRESSURE GAUGE	PG200-2.0RSM1/4	1 each
PUMP FLYWHEEL 14.5 INCH	XF-80GB-16	1 each
RUBBER FERRULE, 1/2" TUBE	XF-80GB-11	1 each
SAFETY RELIEF VALVE	PSV1/4-170	1 each
TUBE BLACK 10 INCH	XF-80GB-13	1 each
TUBE COPPER DISCHARGE 1/2 X 18	XF-80GB-14	1 each

80 GALLON REPLACEMENT PARTS LIST



80 GALLON REPLACEMENT PARTS LIST

Model # XF-XC802000AJ

For replacement parts, call our customer service department at 1-800-551-2406
8:00 a.m - 4:30 p.m. (CST) Monday - Friday.

WARRANTY PARTS

PART	DESCRIPTION	PART NUMBER	QTY.
1	TANK, 80 GALLON	XF-80GB-12	1 each
2	COMPRESSOR PUMP	XF-80GB-07	1 each
3	MOTOR 3.7 HP 240 V	EM05.0-36-10	1 each
4	PRESSURE SWITCH 120/155	21UCBDB-CH150	1 each

UNIT SERVICE PARTS

DESCRIPTION	PART NUMBER	QTY.
AIR FILTER ELEMENT	101000-310	1 each
BALL VALVE	BV3/4MF	1 each
BELT GUARD BACK	XF-80GB-01	1 each
BELT GUARD BRACKET	XF-80GB-02	1 each
BELT GUARD FRONT	XF-80GB-03	1 each
BELT, AX48	B56	1 each
BRASS FERRULE 1/2" TUBE	XF-80GB-04	1 each
CHECK VALVE	XF-80GB-05	1 each
COMPRESSION FITTING	68-4A	1 each
COMPRESSION NUT, 1/2"	XF-80GB-06	1 each
DRAIN VALVE	240-B	1 each
EXHAUST TUBE 1/2"	XF-80GB-08	1 each
FILTER ASSEMBLY	XF-80GB-09	1 each
HEAD TO TUBE CONNECTOR	XF-80GB-10	1 each
LABEL-2 STAGE 175 PSI	999999-XF05	1 each
LABEL-HEAVY DUTY 2 STAGE	999999-XF06	1 each
LABEL-MODEL LABEL	999999-102	1 each
LABEL-PROP 65 HANGTAG	999999-136	1 each
LABEL-PROP 65 LABEL	999999-137	1 each
LABEL-SERIAL LABEL	999999-102	1 each
LABEL-SERVICE LABEL RED	999999-SVCXF	1 each
LABEL-X-FORCE ITEM LABEL	999999-XF80	1 each
MOTOR CORD	12/3-13-PT	1 each
MOTOR PULLEY	MB50X5/8	1 each
NIPPLE	NI1/4X2	1 each
OIL	COMP68	47.4 OZ
PLASTIC RETAINING CLIP	XF-80GB-10	4 each
PRESSURE GAUGE	PG200-2.0RSM1/4	1 each
PUMP FLYWHEEL 14.5 INCH	XF-80GB-16	1 each
RUBBER FERRULE, 1/2" TUBE	XF-80GB-11	1 each
SAFETY RELIEF VALVE	PSV1/4-170	1 each
TUBE COPPER DICHARGE 1/2 X 18	XF-80GB-14	1 each
TUBE BLACK 10 INCH	XF-80GB-13	1 each