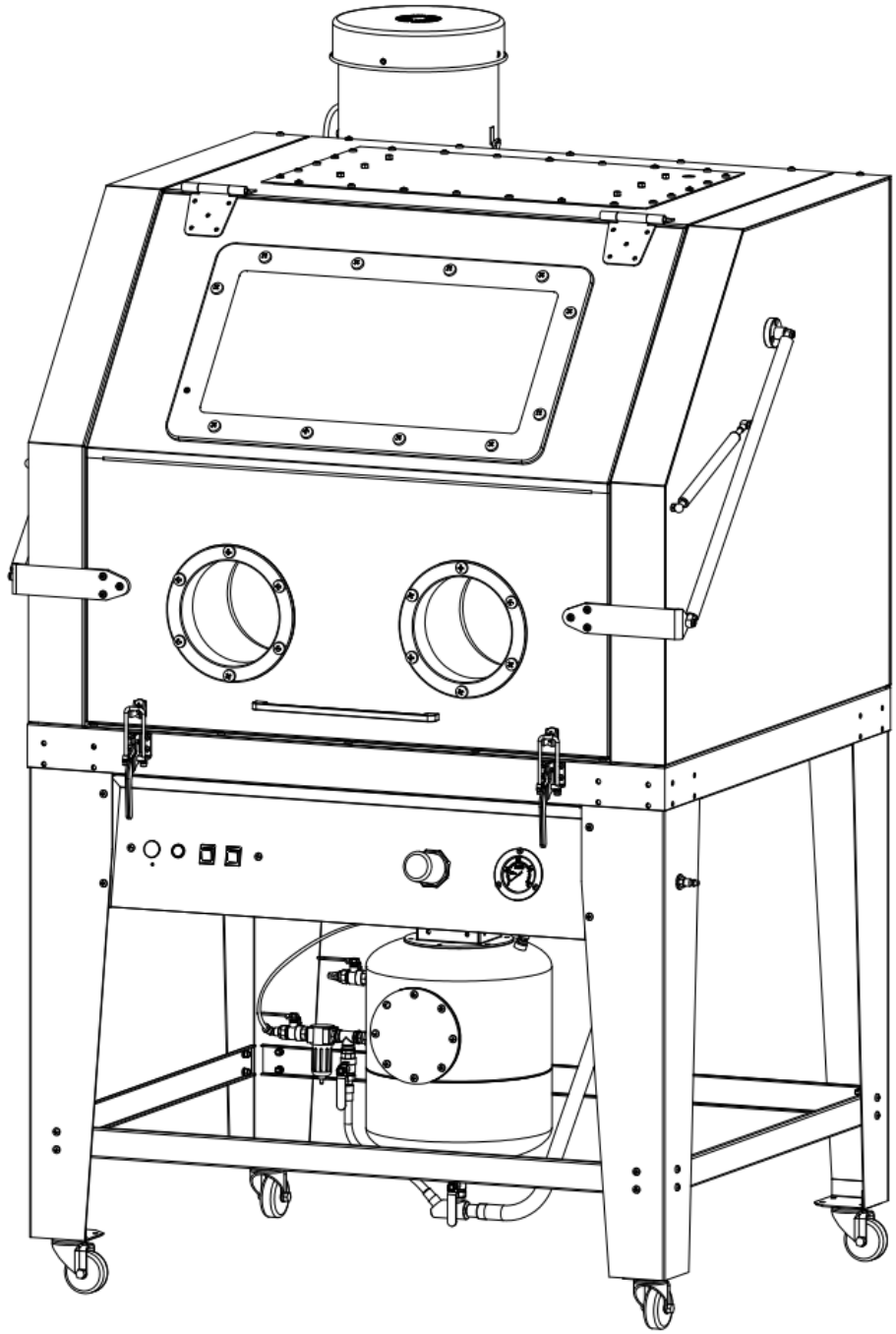
ABRASIVE BLAST CABINET SBC1000P

OPERATING AND MAINTENANCE INSTRUCTIONS



TECHNICAL SPECIFICATIONS

Rating:110-120V， 60Hz; (220-240V， 50Hz); 420W

Maximum Work Pressure：125PSI（8.6Bar）

Air Consumption: 24CFM @ 125PSI（680L / Min）

Work Light: Led tube:3PCS

Tube size：16X60

Each rate：110～120V，60Hz（220-240V，50Hz），26W

Motor Rating: 110-120V，60Hz（220-240V，50Hz），1100W

Overall Dimensions: L124.6XW95XH178.5cm

Packing dimension：129X100X107（CM）

Net Weight:168Kg

Gross Weight:206Kg

IMPORTANT WARNING

Do not use a Cabinet Blaster until you have read this manual and you understand its contents and warnings. These warnings are included for the health and safety of the operator and those in the immediate vicinity. Keep this manual for future reference.

WARNING AND SAFETY INFORMATION

- Do not operate cabinet or airflow with cabinet door Open or with cabinet lens removed.
- Do not use fluids or mix fluids with blast media. This cabinet is designed for dry blasting only.
- Do not exceed maximum operating pressure of 125PSI.
- Disconnecting hose while Unit is under pressure could cause serious injury. Use safety lock pins and safety cables in all coupling connections to help prevent hose couplings from accidental disconnection.
- Failure to observe the following before performing any maintenance could cause serious injury or death from the sudden release of compressed air:
    - Disconnect power supply
    - Lockout and tagout the compressed air supply

- Bleed the air supply line to the blast gun. Immediate replacement of worn components is required. Failure to replace worn components could expose the operator or bystanders to high speed media and compressed air could cause death or serious injury. Leaks around couplings and nozzle holders indicate worn or loose fitting parts. Nozzle holders and couplings that do not fit tightly on hose and nozzles that do not fit tightly in nozzle holders could disconnect while under pressure. Impact from nozzles, couplings, hoses, or abrasive, and parts disconnected while under pressure could cause severe injury. The threads on the nozzle holder must be inspected each time the nozzle is secured to the holder. Check the threads for wear, and make sure nozzle screw securely grips the nozzle. The nozzle washer must also be inspected for wear. Worn nozzle washers cause erosion. A loose-fitting nozzle may eject from the holder under pressure and could cause severe injury.

IMPORTANT INFORMATION

Read all instructions before using this equipment. Save these instructions for future reference. Remember:

1. Start up preparation:

Supply air line should be sized appropriately (bigger than 8mm). All hoses should be rated at least 125 PSI.and an isolation valve should be installed so that supply air can be turned off and then disconnected from blast machine for servicing.

Supply air should be dry and clean from oil and other contaminants. (i.e. use air dryer, coalescent filter, or moisture separator as needed.)

Blast machine must be grounded to avoid shock.

Electric extension cords should be three wire grounded, and rated for the amperage of the blaster. Check nameplate for rated amps.

2. Operator's responsibilities before starting:

Inspect fittings and hoses for damage and wear. Check the seal on all doors. Only operate the blast cabinet with all doors securely closed and dust collection system running.

Clean dust from dust collector and clean filter as needed.

3. Caution:

Unless otherwise specified, working pressure of blast machine and related components must not exceed 125 PSI.

Keep blast nozzle controlled and aimed at the work.

4. Maintenance:

Keep your machine in good repair.

IMPORTANT NOTICE

TO DISTRIBUTORS, PURHCASERS AND END USERS OF THIS PRODUCT

The information provided described and illustrated in this material is intended for experienced, knowledgeable users of abrasive blasting equipment and supplies (products).

The products described in this material may be combined as determined solely by the user in a variety of way and purposes. However no representations are made as to intended use, performance standards, engineering suitability, safe practices or compliance with government regulation and laws that apply to these products, products of others, or a combination of various products of third parties, and a combination of various products chosen by the user or others. It is the responsibility of the users of these products, products of third parties, and a combination of various products, to exercise caution and familiarize themselves with all applicable laws, government regulations and safety requirements.

Nor are representations made or intended as to the useful life, maintenance cycles, efficiency or performance of the referenced products or any combination of products.

This material must not be used for estimating purpose. Production rates, labor performance or surface finishes are the sole responsibility of the user based on the user’s expertise, experience and knowledge of industry variables.

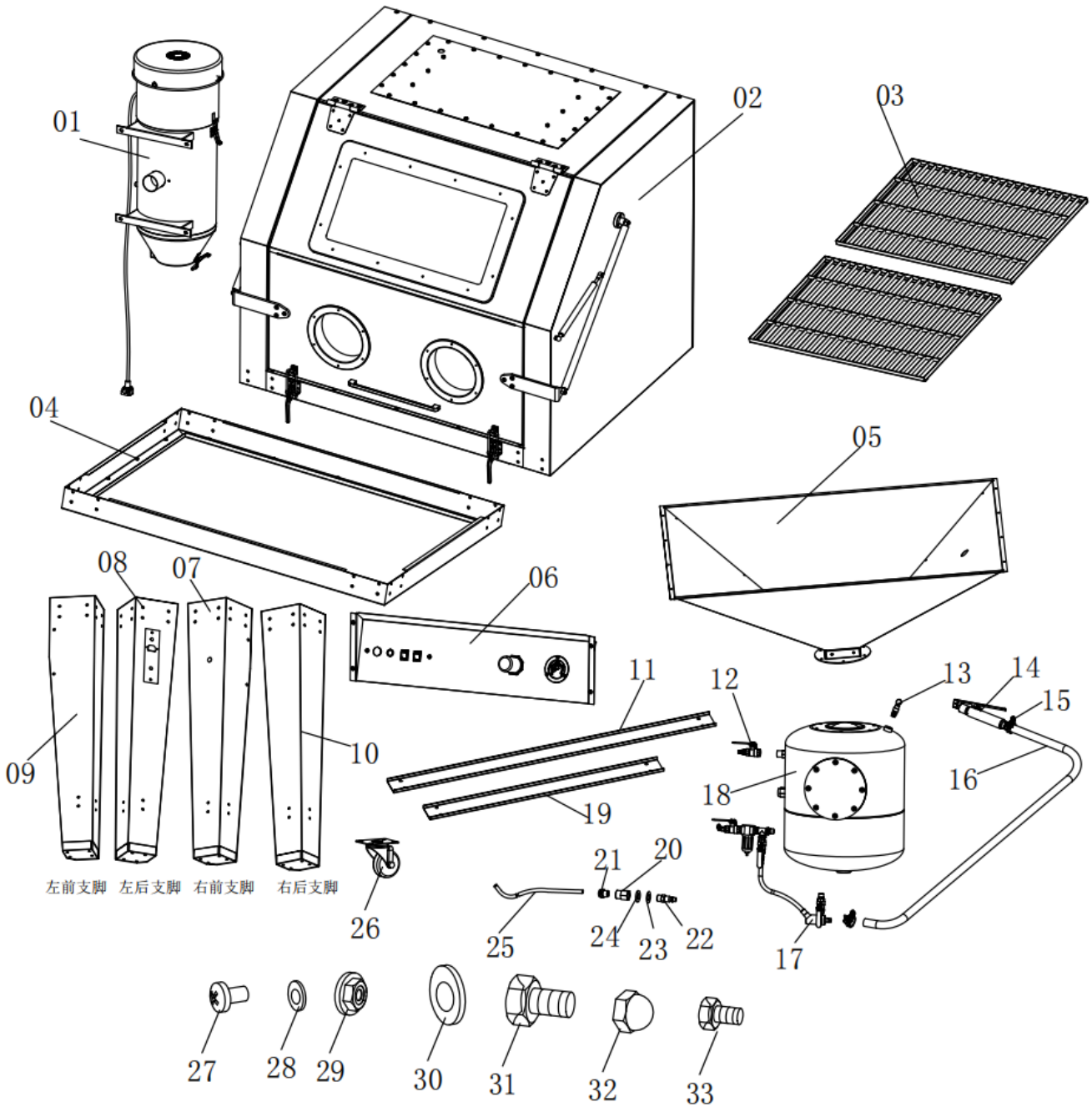
It is the responsibility of the user to insure that proper and comprehensive training of operators has been performed and all environmental and safety precautions observed.

We provides a variety of excellent products to the surface preparation industry, and we are confident that all proficient users, operators and contractors in this industry will continue to use our products in a safe and knowledge manner.

Before using this product, read all instructions, literature, labels, specifications and warnings sent with and affixed to the unit. If operation of the unit is unclear after reading this manual, contact your supervisor for instructions. It is the responsibility of the employer to read the following instructions to users of this equipment, who are unable to read. Periodic inspection at the work site should be made by supervisory personnel to ensure the blast machine is being properly used and maintained. A copy of this owner's manual must be kept with the blast machine and readily accessible to the blast machine operators at all times.

ASSEMBLY INSTRUCTIONS

PARTS DIAGRAM



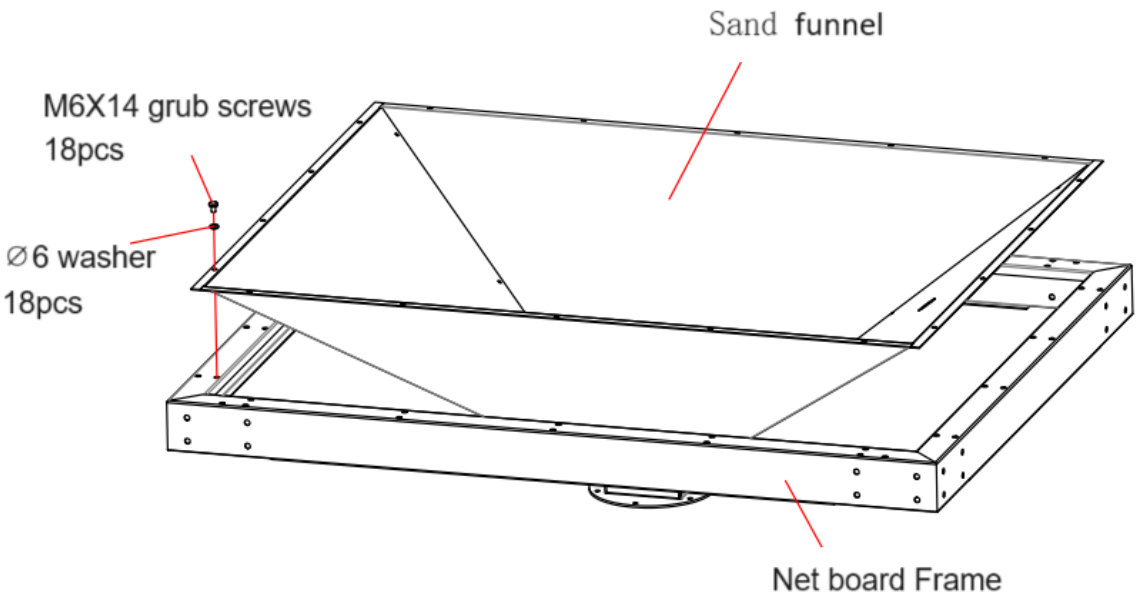
PARTS LIST

Parts No.	Description	Qty
1	Dust collector	1
2	Blasting cabinet	1
3	Working net board	2
4	Net board Frame	1
5	Sand funnel	1
6	Control Panel	1
7	Right front leg	1
8	Left rear leg	1
9	Left front leg	1
10	Right rear leg	1
11	Long leg connect bar	2
12	Pressure released valve	1
13	Safety valve	1
14	Blasting gun	1
15	Clamp	2
16	Sand hose	1
17	Sand hose set	1
18	Blasting pot	1
19	Short leg connect bar	2

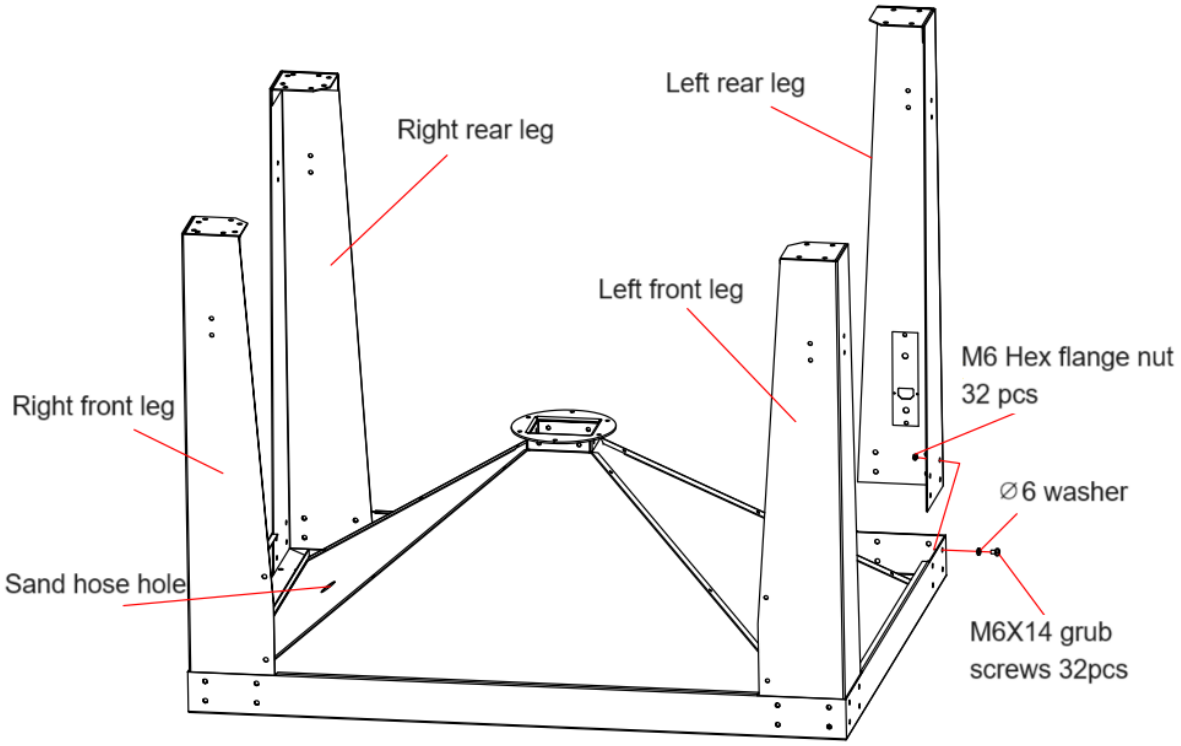
20	Connector	1
21	Air hose connector	1
22	Quick coupling	1
23	Ø18 washer	1
24	Sealing washer	1
25	Air hose	1
26	Universal wheel	4
27	M6X14 grub screws	100
28	Ø6 washer	106
29	M6 Hex flange nut	100
30	Ø8 washer	16
31	M8X12 hex head bolt	16
32	M8 Nut	16
33	M6X12 hex head bolt	6

ASSEMBELY STEPS

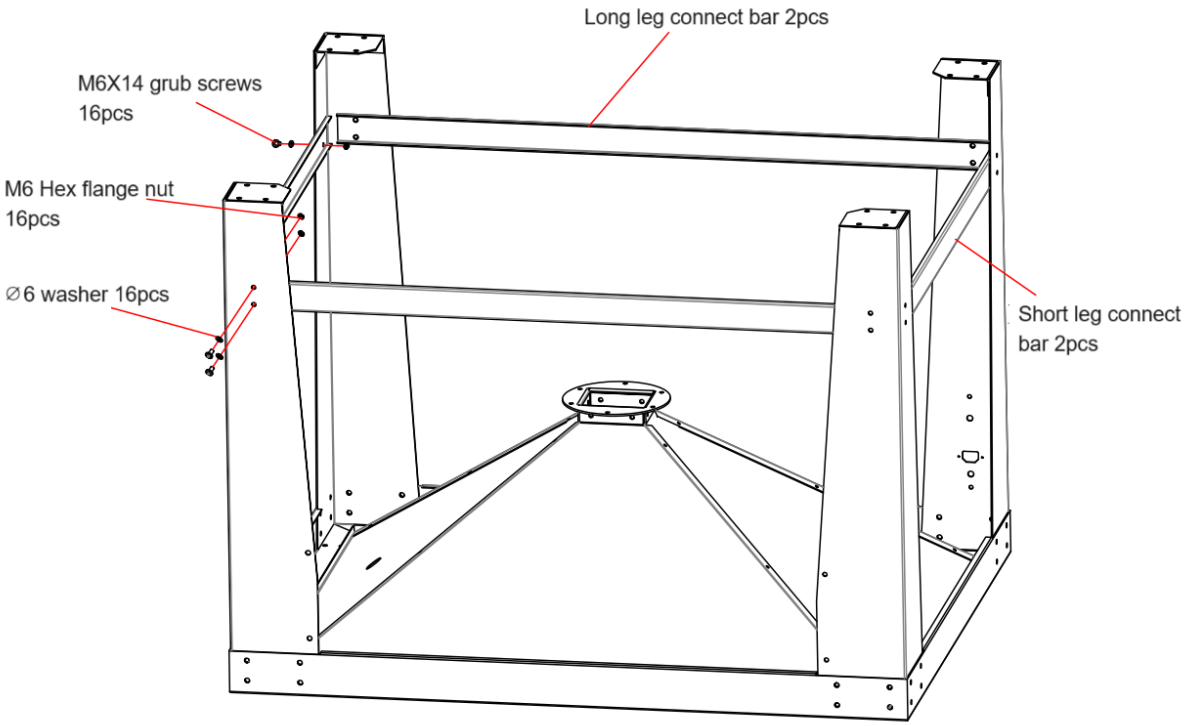
Step 1: Connect sand funnel and net board frame



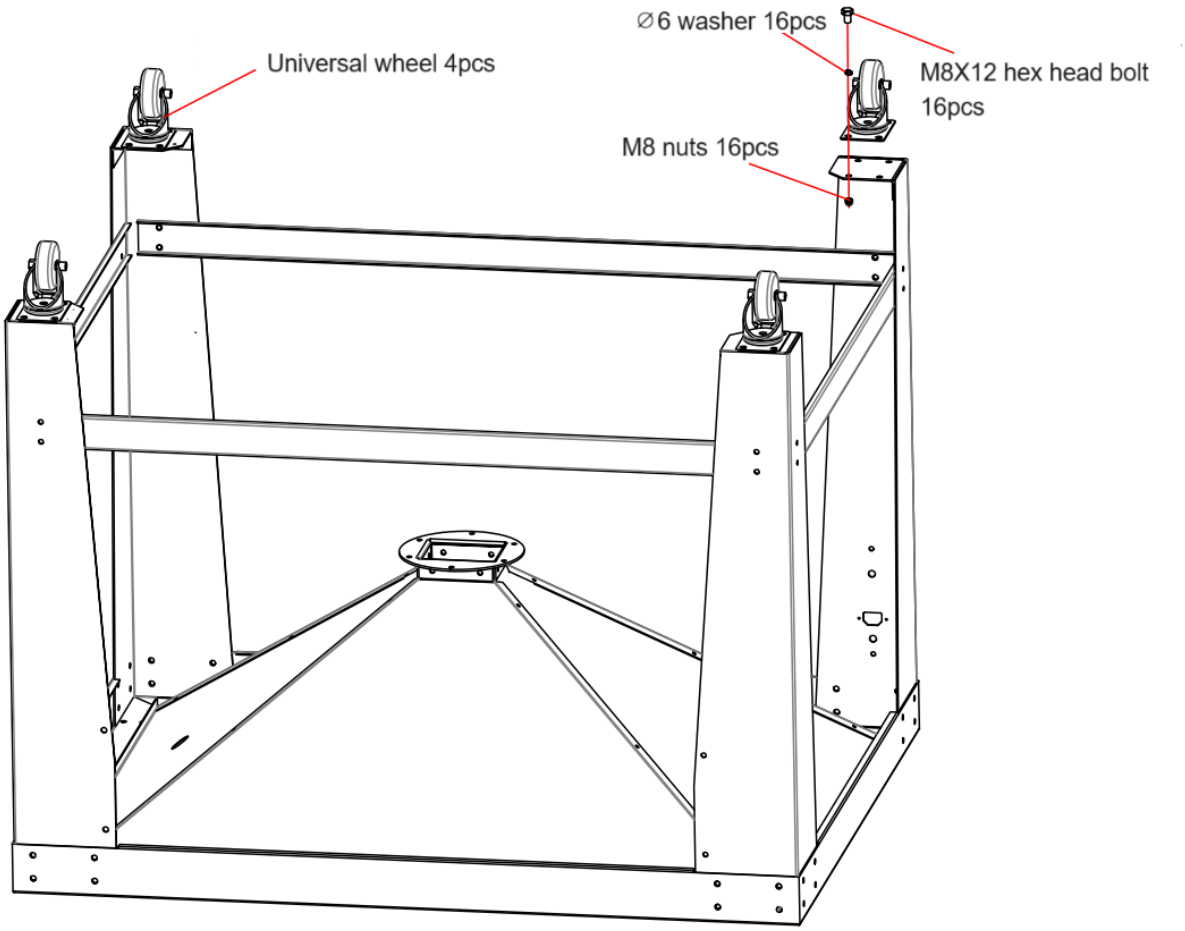
Step 2: Assemble 4 legs



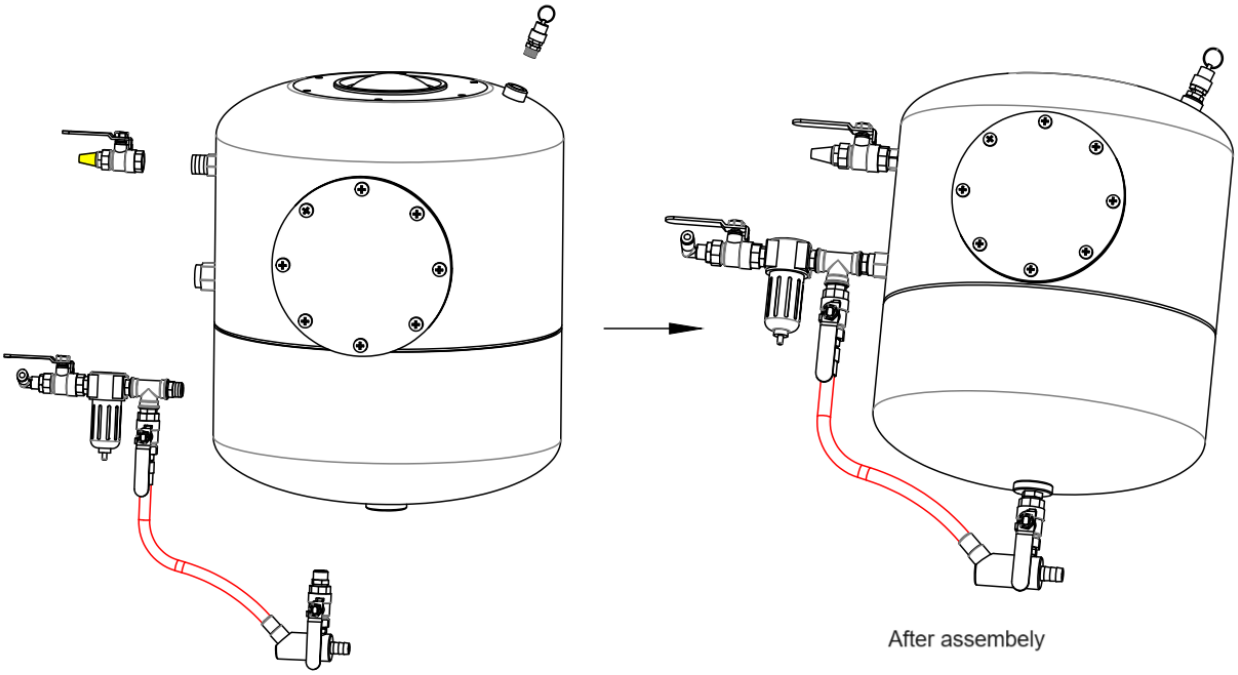
Steps3: Assemble leg connect bar 4pcs



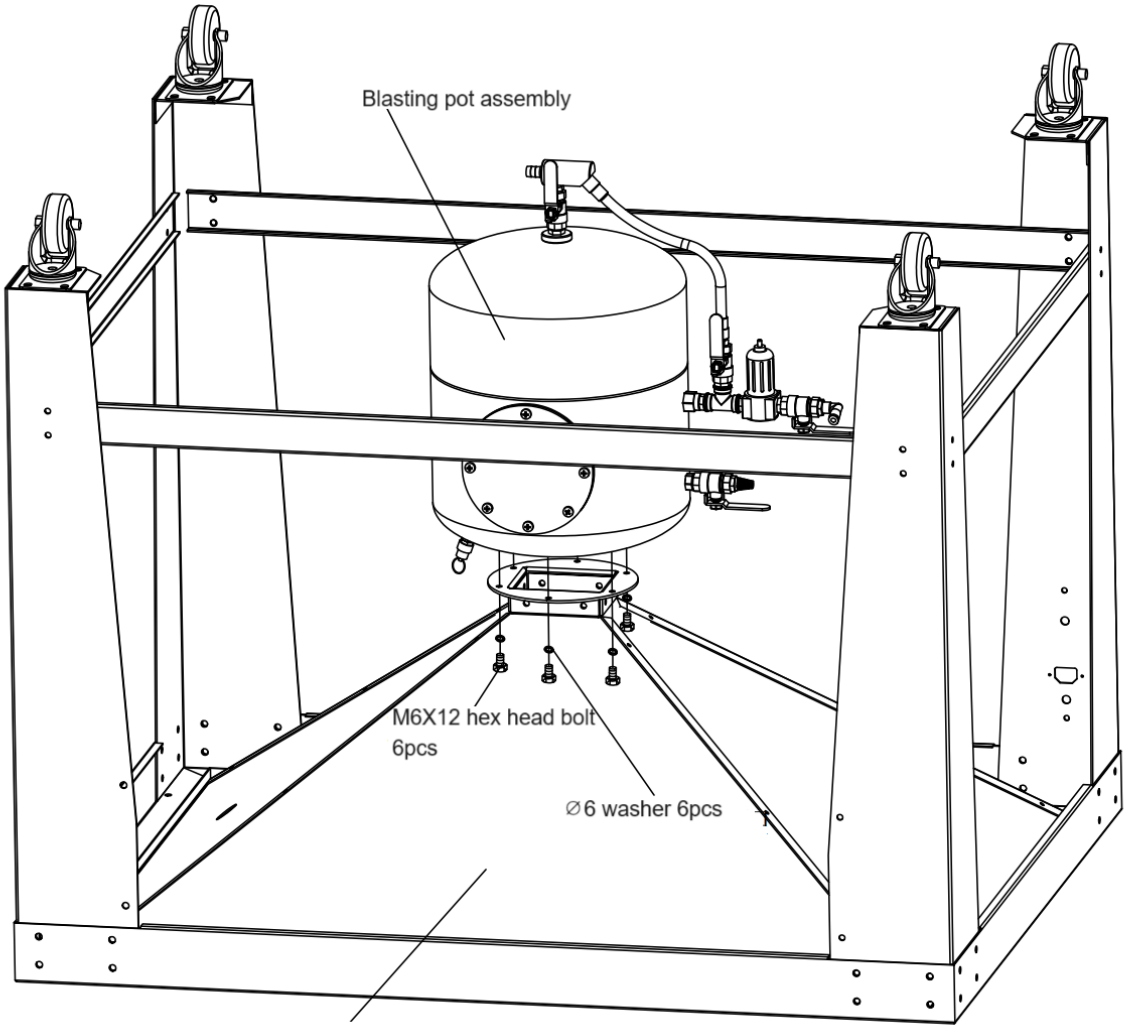
Steps 4: Assemble universal wheels 4pcs



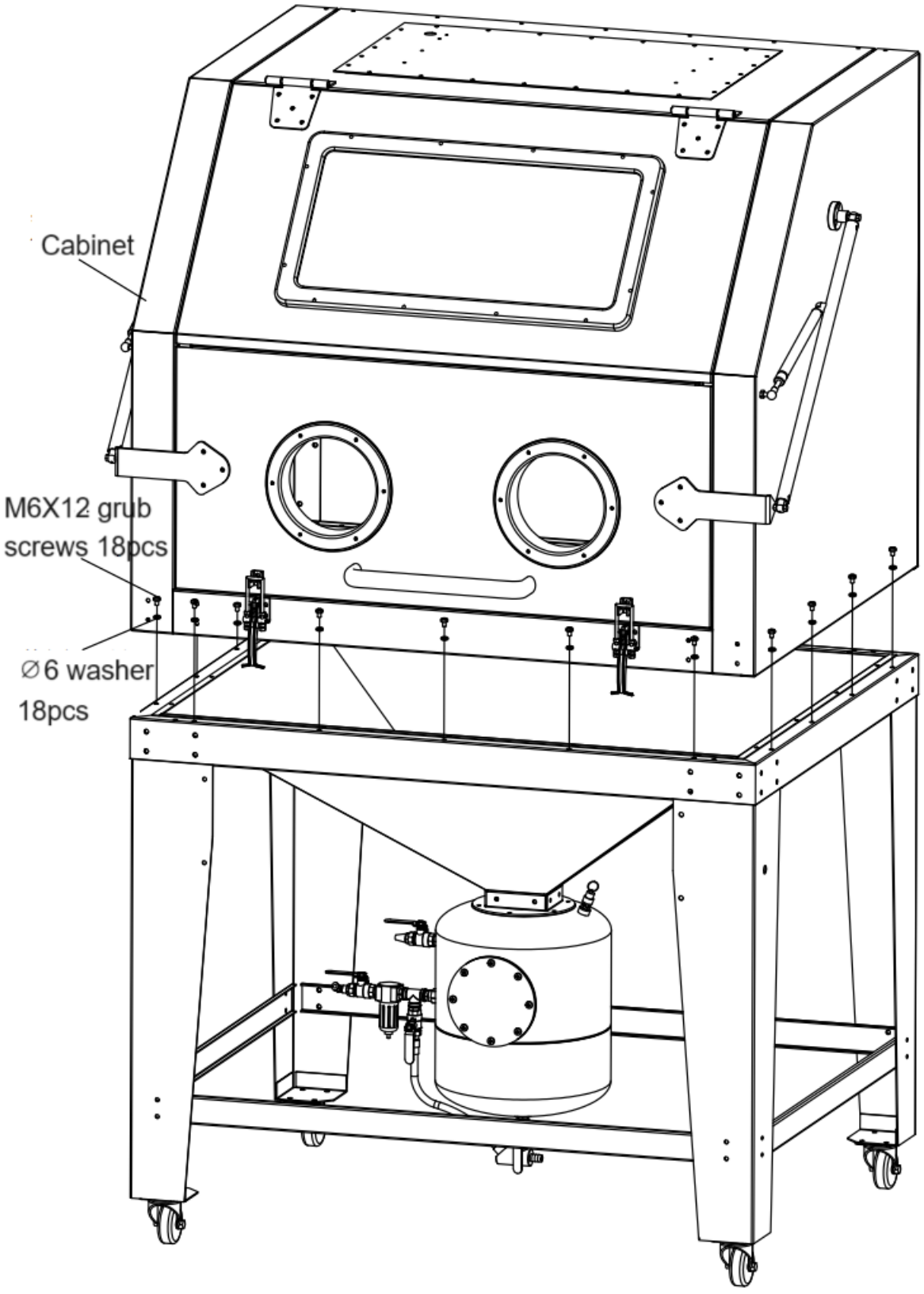
Steps 5: Assemble blasting pot.Please note wrap the sealing tape around the thread to avoid air leaking.



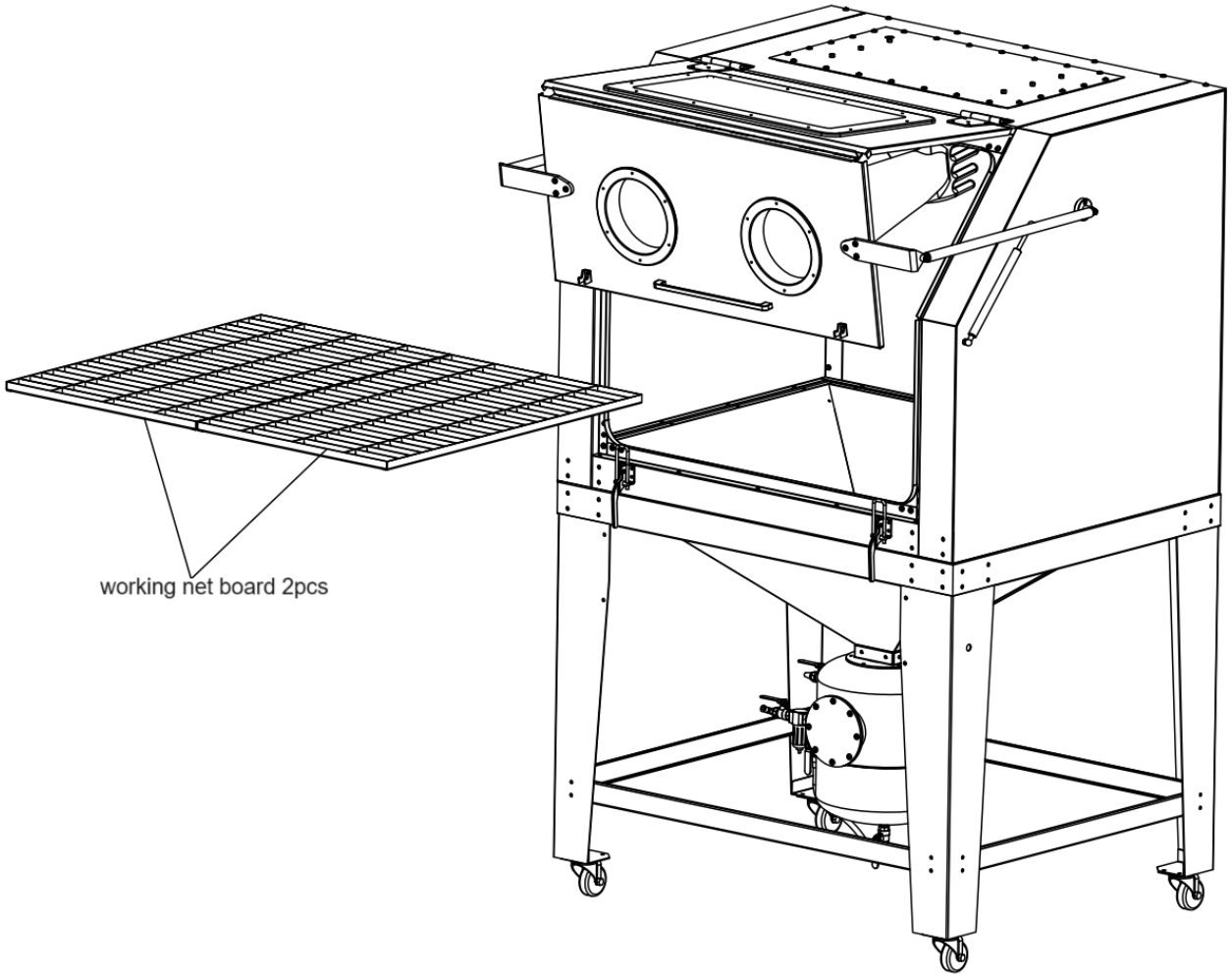
Steps6: Connect the blasting pot set with sand funnel.



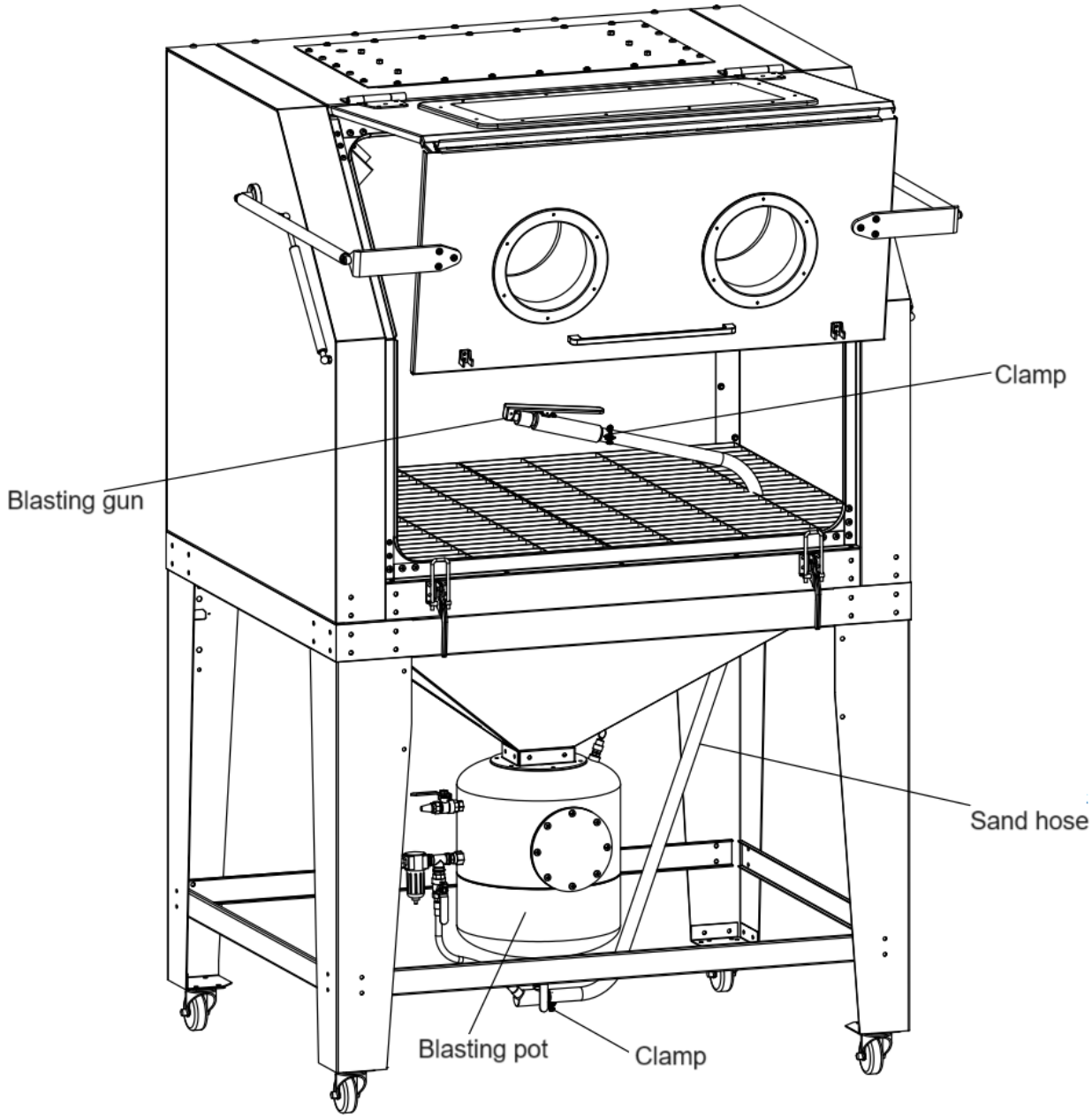
Steps7: Connect cabinet and funnel assembly.



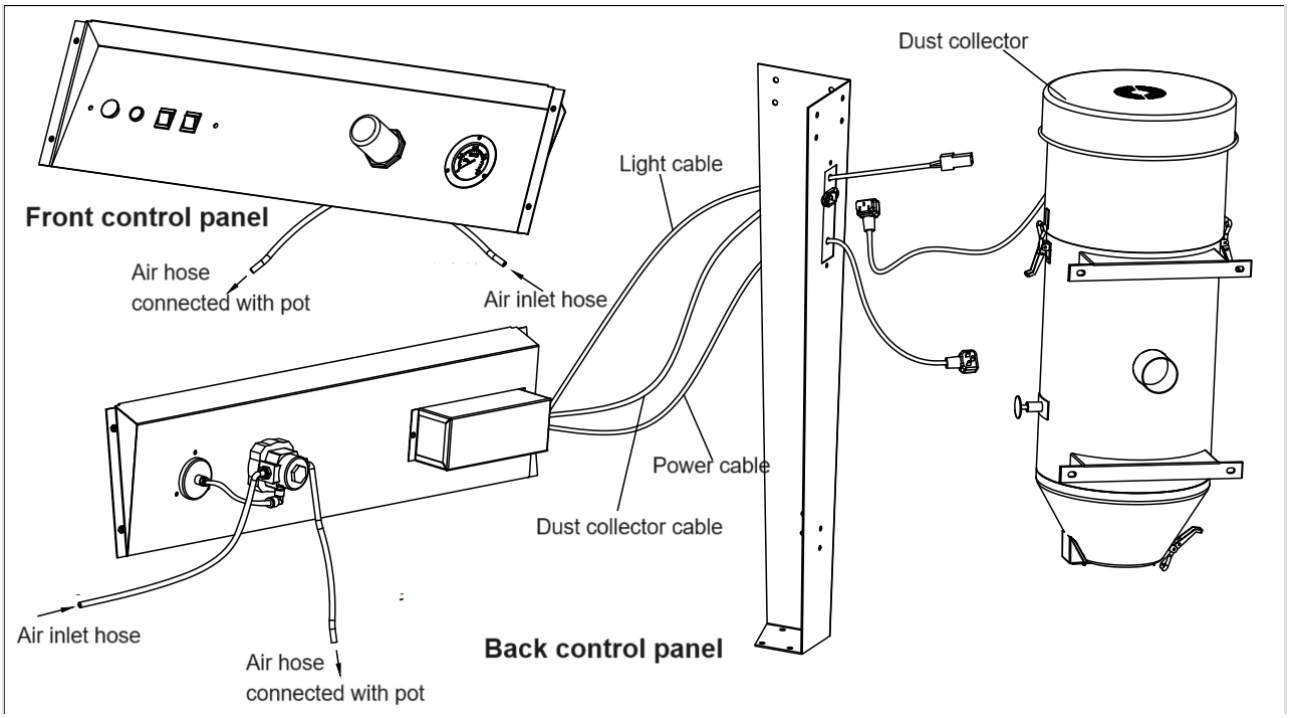
Steps 8: Put working net board into cabinet.



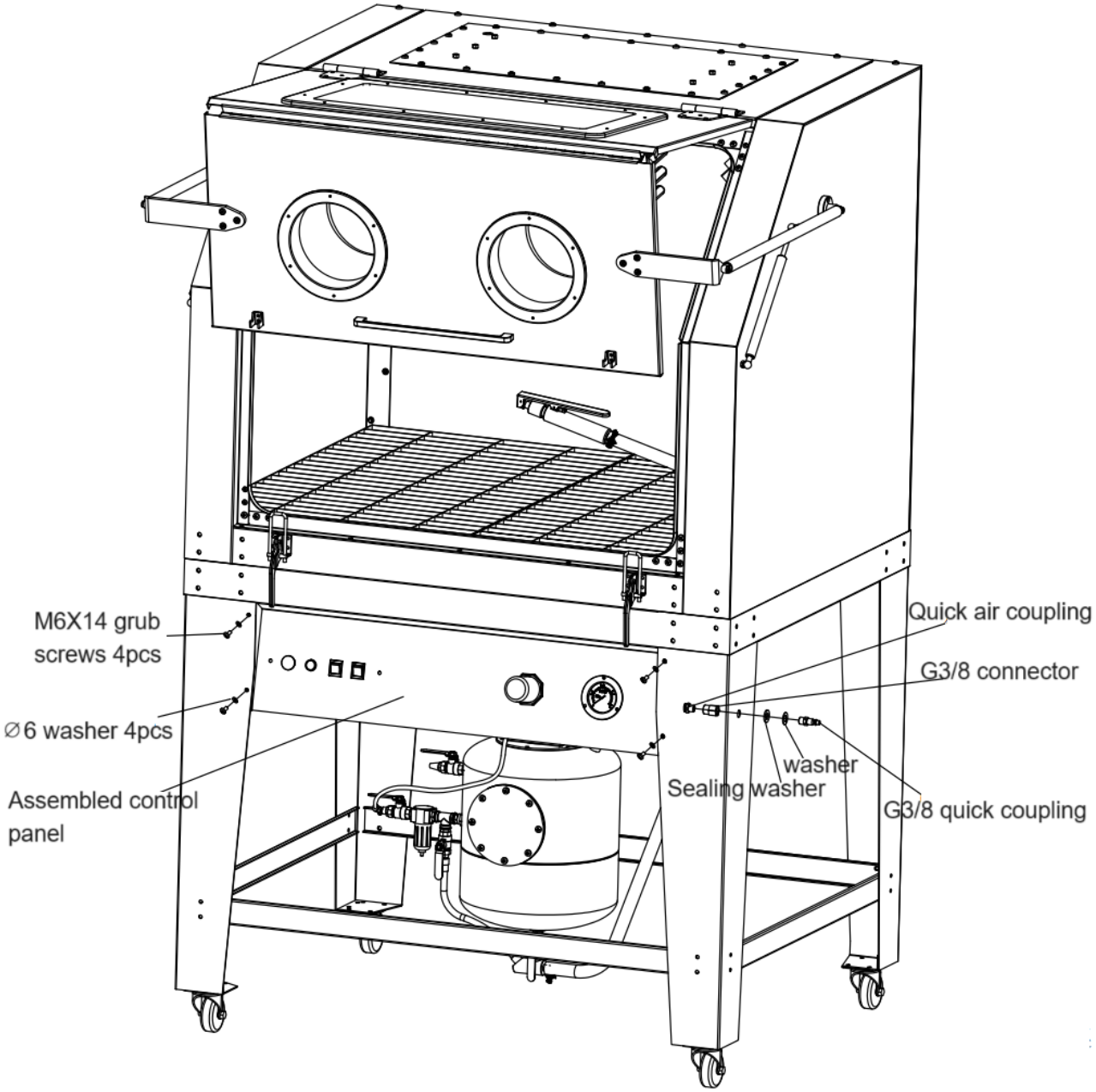
Steps 9: Connect blasting gun and pot with sand hose by the funnel hole. Tight them with clamps.


Clamp
Blasting gun
Sand hose
Blasting pot
Clamp

Steps 10: Connect electrical parts and air hose with blasting pot.



Steps 11: Connect electrical parts and quick air couplings. Please note wrap the sealing tape when assemble connector and quick air coupling to avoid air leaking.



OPERATING INSTRUCTIONS

PREPARING PARTS FOR BLASTING

All parts processed must be free of oil, grease and moisture. Make sure parts are dry before putting into the cabinet for cleaning.

AIR PRESSURE Operating pressure: from 80 to 110 PSI (pounds per square inch) higher pressure, up to 125 PSI can be used, but this breaks down some types of media prematurely.

Set air pressure to 80 PSI. Most parts for blast cleaning can be blasted at 80 PSI, for light gauge steel, aluminum, and other more delicate parts, start at lower pressure and gradually increase the pressure until the desired finish is achieved.

WARNING:

Do not connect to high pressure bottle gas; rupture and explosion can occur.

GUN ANGLE AND DISTANCE

Direct the blast gun at parts at 45-60 degree angle with ricochet towards the back of the cabinet. Do not hold gun at 90 degree angle to parts being processed. This will cause the media blast to bounce back into the blast stream and slow blasting action. Also 90 degree angle will cause excessive wear on gun and viewing window. Hold gun approximately 6 inches form parts being blasted.

WARNING:Gun must always be pointed away from the operator and towards items being processed. Never blast with any of the cabinet doors open, while loading and unloading. No one should be at the operator station, at the front of the blast cabinet.

MEDIA

Media should be of good quality and dry. Moisture will cause the media to not flow and will clog metering valve and hopper.

NOZZLE SIZE

By changing to the next larger size of nozzle, production can increase significantly. Larger size nozzles produce a large cleaning pattern. This, however, requires more air (your compressor must be able to provide this)

MAINTENANCE INSTRUCTIONS

1. BLASTING GUN

After 10-12 hours of blasting time, the nozzle should be checked. If it shows uneven wear it should be turned 1/4 turn every 10 hours of use.

2. CAKING OF MEDIA

Media caking is caused by moisture in the air supply from oily and greasy parts. If this is not corrected media will not flow evenly and will plug up in the metering valve and the gun. Check air supply; if water is present install a good moisture trap. If oily or greasy parts are being blasted, you should degrease and dry the parts first.

3. REVERSE PRESSURE

If media stops flowing occasionally, place cover over nozzle (hold tight) and push foot pedal down for a couple of seconds. This will cause the system to back blast through the gun and up the media hose. This will help loosen any clogs.

4. GUN AIR PRESSURE DROP

Set the air pressure to 80 PSI on the air gauge at regulator. Push the foot pedal while holding gun and see if the gauge pressure drops significantly. If the pressure drops, this indicates that there is a restriction in the supply line. This could be that hose is too small, a reducer of quick coupler, a plugged filter, or other piping that doesn't allow enough air through. Also if the cabinet is too far from the air compressor, a pressure drop will occur. Air supply line should be 1⁄2" or larger.

5. POOR VISIBILITY-EXCESSIVE DUST

Air inlet at front left above regulator, should be free to allow air into cabinet.

Dust container full and needs to be cleaned and emptied. (latch at bottom of dust collector) Dust cartridge contaminated. (clean or replace filter in dust collector, part#19)

Media breakdown; eventually the media becomes so small that it is essentially dust. Replace media and clean dust collector.

6. POOR VISIBILITY-VIEWING WINDOW

Viewing windows come with a clear plastic protector on them. As these become pitted they can be easily replaced to extend the life of the window. The window can also be easily replaced

7. POOR MEDIA FLOW

Check for moisture as indicated above. Install moisture trap as needed, replace damp media and clean hoses and pump.

Holes in media hose will cause poor media delivery. Replace hose.

Debris in media. Replace or screen media.

MAINTAIN SUCTION EFFICIENCY WITH SIMPLE STEPS

The most common problem customers have with their suction (venture) blast cabinets is a decrease in production rates. A properly maintained suction cabinet should provide years of constant service. When production rates fall the operator can usually locate the problem by checking

1. AIR SUPPLY

If the pressure gauge on the regulator shows an adequate no-load supply (when the blaster is not running), press the foot pedal. If the pressure drops more than a few PSI your air supply is restricted or inadequate. Clean filters and moisture separators all the way back to the air compressor. Straighten any kinky lines. Use a master gauge to check the air pressure or replace existing gauge if you suspect it is giving you false readings.

2. BLAST GUN

The nozzle will wear out eventually. Replace it if it's measured 1/16” over its original size or if it shows uneven wear. Adjust as needed for different media and conditions. A properly working gun will pull 13-17 inches of vacuum.

3. DUST COLLECTOR

Inadequate cabinet ventilation results in reduced cleaning power at the nozzle as well as diminished view of the work in progress. Use the dust collector, shake every 20-30 minutes when the cabinet is turned off, (more often in dusty conditions.) Empty dust collector at least once a day. Remove filter and blow out occasionally to keep the dust collector or vacuum working efficiently. Replace as needed.

4. MEDIA

Use quality blast media sized to the job. Damp to dirty media can bring blasting to an instant halt. Store media in a dry area and load the appropriate quantity. Add enough media through the flooring to have 6” deep of media on top of the metering valve. If you run out of media as you are blasting add enough so it keeps circulating

to the gun. The media will eventually breakdown or get too contaminated to use. The less there is in the system, the less you will have to replace.

5. MEDIA DELIVERY

Replace any media hose that has soft spots or visible wear. Adjust the metering valve to provide adequate flow. A mixture that is too rich will cause pulsating at the gun. An unusually loud noise while blasting means the mixture is too lean. A rich mixture can result in lower impact velocities. While a lean mixture reduces the number of impacts. Both reduce your cleaning rate.

If everything is adjusted right and you are still not getting the production levels needed, contact your distributor.

RECOMMENDATIONS

AIR COMPRESSOR RECOMMENDATION:

To permit efficient operation of your air compressor, follow these guidelines:

1. Use a smaller size nozzle to control the demand of air.

2. Do not blast continuously. Stop blasting operation periodically to allow the compressor to cool. No compressor is designed to constantly run at full RPM. Use 70% of the rated output.

3. Use a minimum 1⁄2" air hose or metal piping from your air compressor to the blaster. If your compressor is creating an excessive amount of moisture, we recommend using a water trap or a moisture separator.

4. The air compressor should be drained at the bottom of the supply tank through a drain valve and should be blown down daily. It is not unusual to drain three or four gallons of water from the supply tank on a high humidity day. An additional supply tank will help.

5. Keep dust and media created by blasting away from the air compressor unit. Observe maximum air pressure requirements for the blaster and either set your compressor to run within these limits or use a pressure regulator valve to reduce the air pressure to the appropriate range.

ABRASIVE (MEDIA) USAGE:

1. If moisture is in the media it will eventually damage the blaster or plug the system. Keep the media and compressor air dry to avoid this problem.

2. If media is moist, screen it and dry it before using.

3. Store media in a dry place; keep media off the ground or concrete floors. Put it on a wooden skid.

4. If the humidity is excessively high, it may not be advisable to blast at that time.

5. Consider using different grades or different types of media to prevent nozzle clogging due to high moisture content.

6. Do not use common sand.

MEDIA

Steel Grit Steel Grit is extremely fast cutting on rusty metal and hard to remove paint. Steel Grit is popular because it leaves a very smooth finish. It is also comparable in price to most other specialty abrasives. Steel Grit is recommended in reclaim systems or cabinets. (25 lbs. container)

Glass Bead Glass Bead is used in creating a satin or matte finish. Glass Bead is recommended in reclaim systems or cabinets. (25 lbs. container)

Aluminum Oxide Aluminum Oxide is a high quality abrasive that is sharper than sand (not recommended) and cuts twice as fast as sand. It leaves a smooth textured finish with no pits or burrs. Aluminum Oxide is rougher than glass bead and can be used over and over again. It is one of the most economical abrasives you can use in any reclaim systems or cabinets. (25 lbs. container)

Plastic Grit Plastic Grit is primarily used to strip aluminum and fiberglass. It is great for stripping paint, light oxidation and surface rust. Plastic Grit is recommended for use in blast cabinets because it creates very little dust. Works quickly, lasts a long time and increases visibility within the cabinet. (10 lbs container)

Walnut Shells Walnut Shells are recommended for use on “soft” surfaces such as aluminum, glass, wood, and other areas where no pitting is desired. Walnut Shells leaves a smooth, dull finish. (10 lbs container)

Corn Cob abrasive is used on soft applications such as wooden surfaces, aluminum, brass and other surfaces where no pitting is desired. Corn Cob leaves a smooth, dull finish. (50 lbs container)