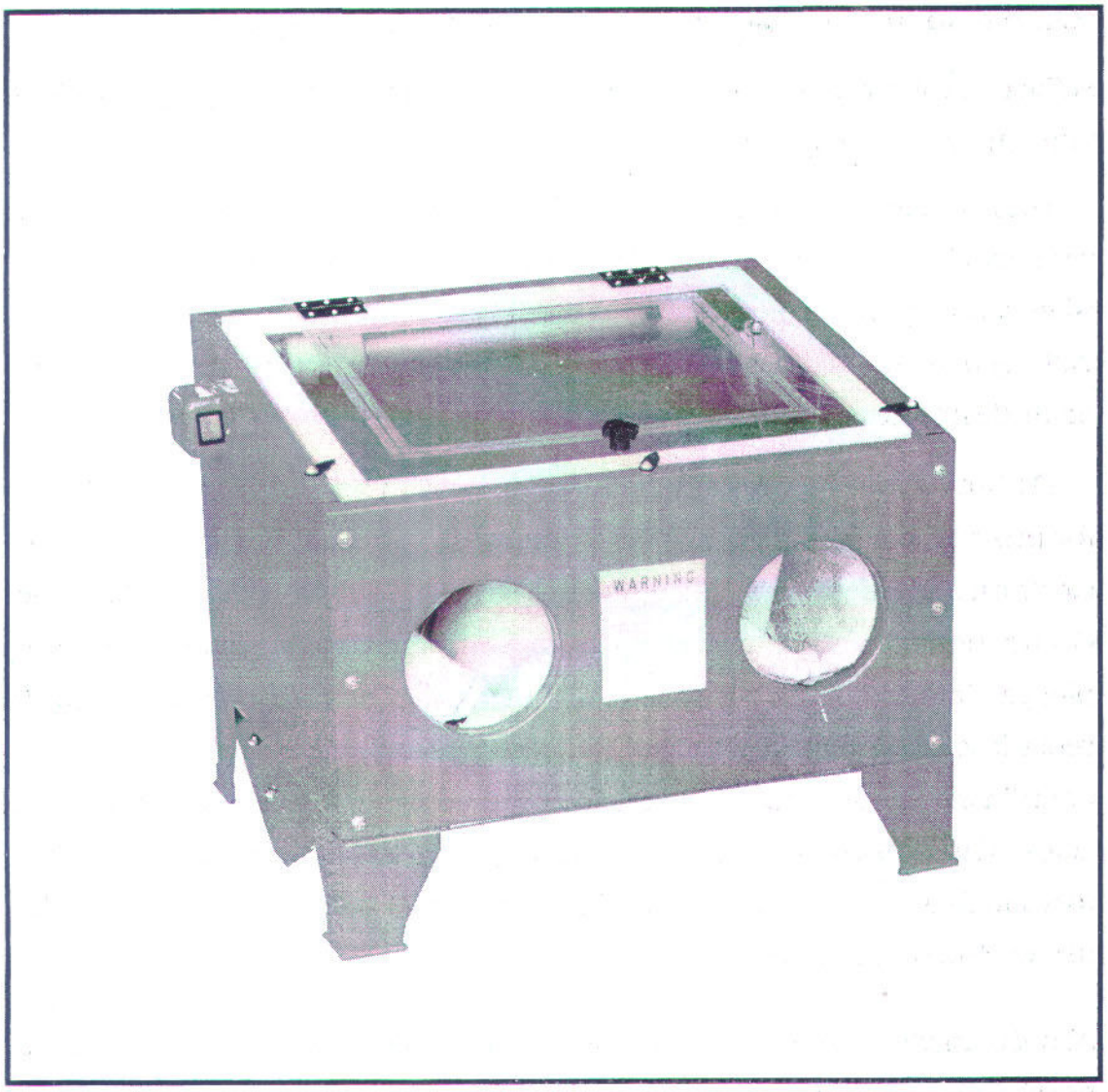
# SANDBLAST CABINET



# Operation Manual and Part List
# Model SBC Abrasive Finishing Blast Cabinet

Notice:Any blast cabinet will produce a powerful flow of abrasive particles.To avoid personal injury and property damage.Study this manual thoroughly before assembling,operating or servicing this blast cabinet.

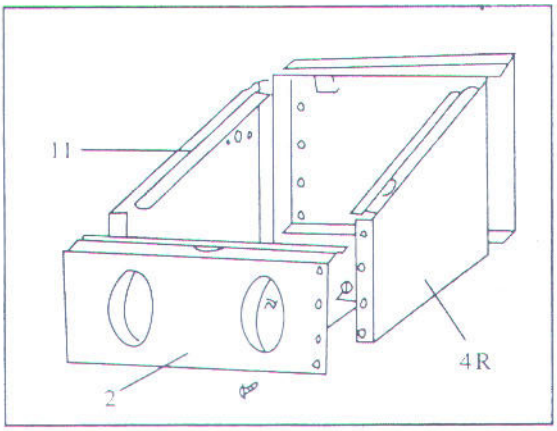
Please read instructions before operation the blasting system!

Failure to follow these instructions could result in operator injury as well as void the blasting system.

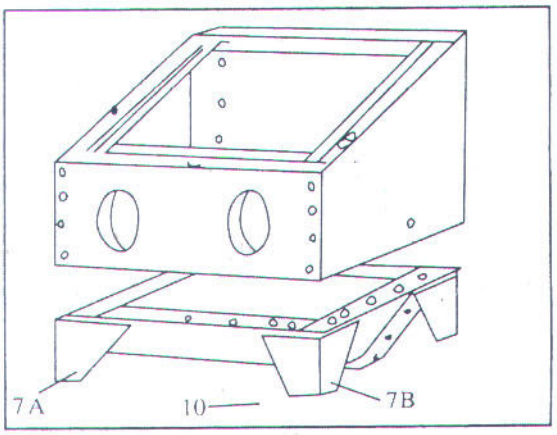
Your SBC Blast cabinet is designed for cleaning,polishing and finishing with dry abrasive ONLY,such as glass bead or plastic granule abrasives.The finishes can vary from course to fine according to the sizing of the glass bead.on delicate parts,start out with minimal air preesure to avoid unnecessary peening or undesired,excessive abrasion.

Do Notice your blasting system is equipped with a 3-prong grounded plug for protection against shock.When connecting your unit obey all applicable electrical and safety codes including the National Electric Code (NEC)and the Occupational Safety and Health Act(OSHA).The blasting system should be plugged into an adequately grounded 3-prong receptacle.If only a 2-prong receptacle is available,have it replace with the applicable national and local codes or ordinances.Only a qualified electrician should perform this work.A grounded adapet Can be used.Make sure the green lead from adaptor is properly attached to a suitable electric ground Note:The Canadian Electrical code prohibits the use of 3-prong adaptors.

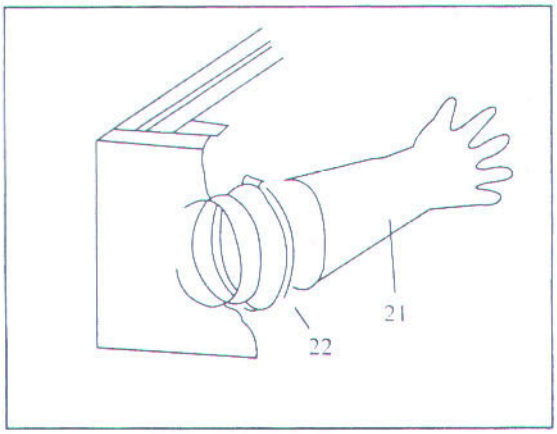
Abrasive media is very slippery and should be cleaned up immediately to avoid possible operator injury.



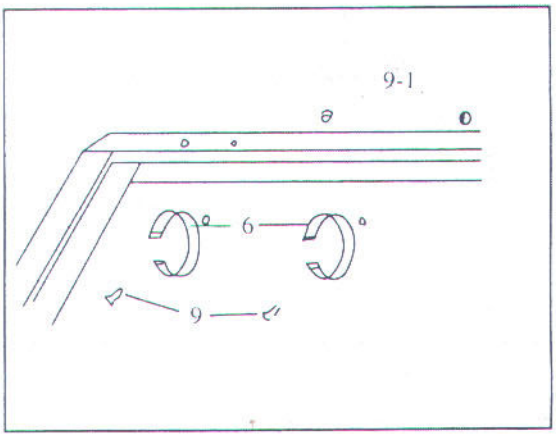

Step 1.Connect front panel(2),rear panel(3),right panel Left panel(4L)and screw up all of the screws.



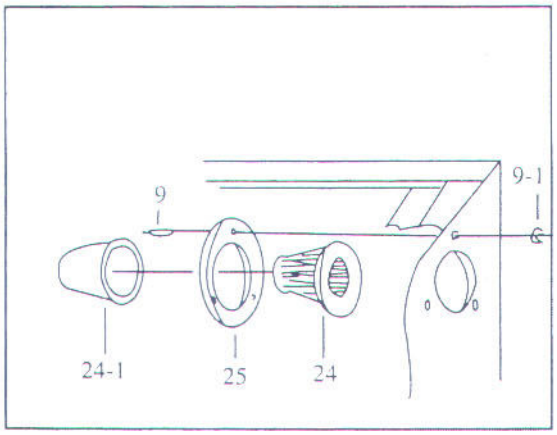

Step 2.Connect the Base to the four legs(7A and 7B),then put screen (23) in the cabinet.



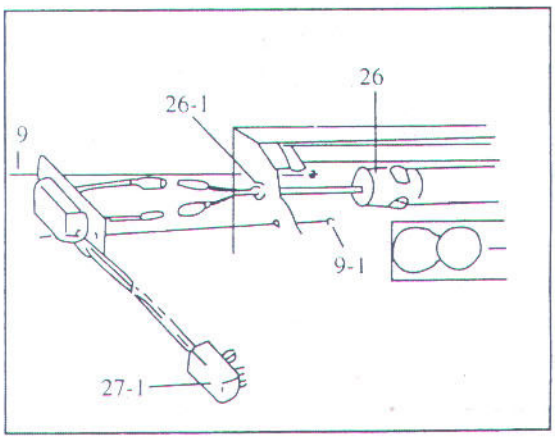

Step 3.Secure the glove(21)with glove clamp(22) onto the front panel as illustrated.




Step 4.Connect the lamp clamp(6)as illustrated.

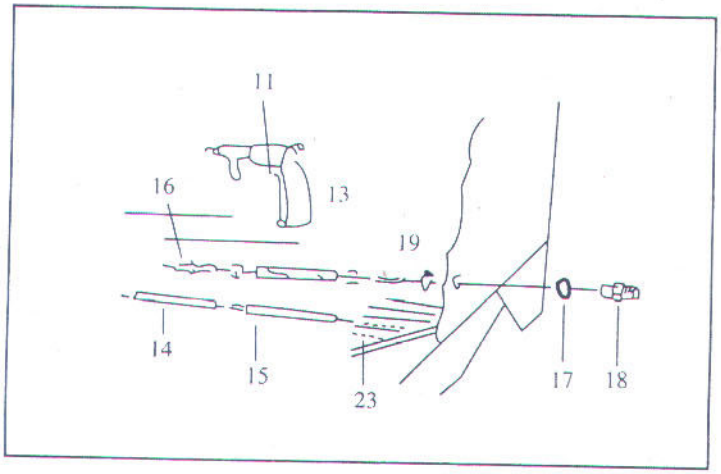


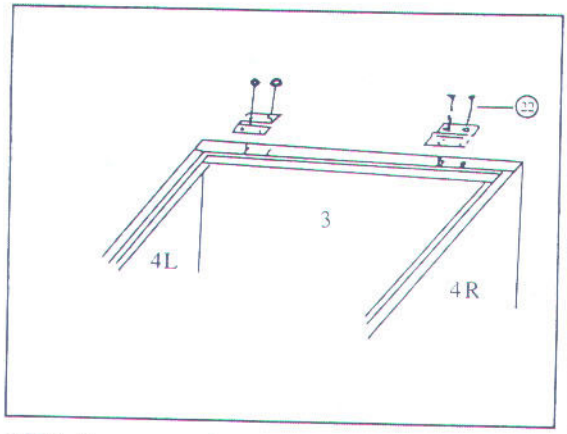

Step 5.Assemble the filter



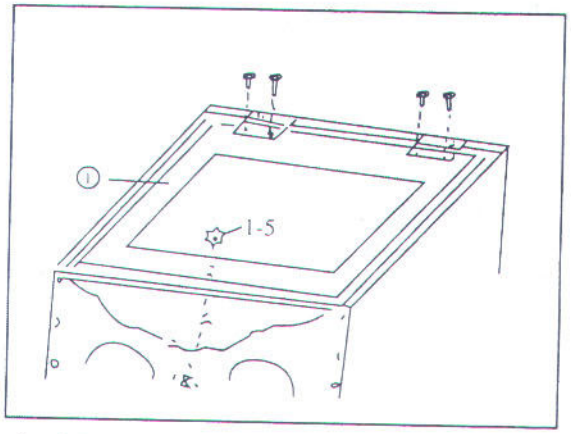

Step 6.Push the fluorescent lamp(26)forward into lamp clamp(6),then put the electric cord outside the hole through 4L,use screw nut(26-1)which is enclosed on the cord to secure,then combine with the circuit inside the wire connection box (27)and screw up tight at left panel(4L).

Step 7.Assemble the blast gun.

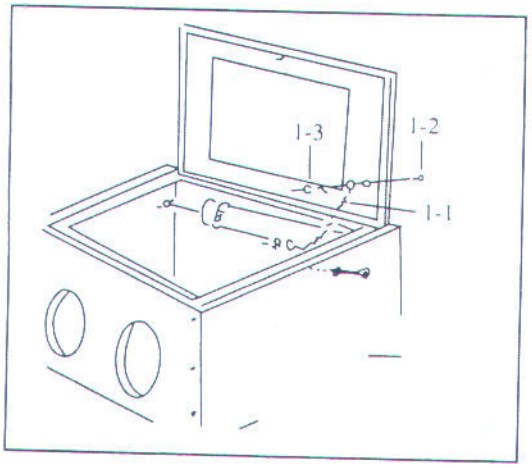



Step 8: After you complete the assembly of SBC,then you shall assemble the transparent to lid(01),please lock up up the movable leaf above the rear panel(03).




Step 9: Upon locking up the movable leaf,put the transparent top lid under the movable leaf.to lock up the bandle first then put item(22)through the holes on the movable leaf.press hard to lock onto the oop lid.




Step 10: Open up the top lid and connect the positioning chain.please connect the two ends of the chain with the screw and screw nut as illustrated.this with prevent the top lid from falling off and has a suiking forer when it is opened.(if the striking is too big may cause the damage of the top lid.)

2.Plase the blast system near a 115V/60Hz(240V/50Hz)AC electrical outlet Make sure the receptacle will accept the 3-prong plug,so that the unit will be properly grounded.Also make sure to check the power source is adequate for use with this blast system,An electrician should be consulted if the proper outlet is not available or is the user in any way questions the condition of the electrical circuit (see note on the manual).

3.Attach the air supply line from a compressor capable of maintaining 5 cfm at 80 psi to the inlet connection found on the right side of the cabinet,Because of variation in air supply systems,the air inlet coupling is not provided.Use the particular fitting that is compatible with your air supply system

Do Not Operate the Blasting System At over 100 psi.

4.Check the air supply line fittings and hose attachments to the rear of the gun.Also make sure the media supply hose is attached tightly on the nipple on the underside of the gun.

5.Place no more than 10 pounds of abrasive media into the center of the cabinet.Excessive amounts will create clouded cabinet conditions,blow by of media through the exhause,or sluggish and ineffective blasting performance.

6.With the air supply connected,all fittings and joints not leaking and the unit is plugged in,you are ready to test the blasting system.Now.follow these steps for startup operation

a.Place the part in the cabinet.Always close and latch the lid after placing the part in the cabinet prior to blasting.Severe injury to the skin and eyes may result from exposure to the blast stream.

b.After putting your hands into the gloves,grasp the gun and depress the trigger.This should begin the blasting flow.If no flow is seen you may need to clear the tube by covering the gun nozzle momentarily.

c.Now you may begin finishing the part.You should move the blast.stream continuously over the part in an even and circular motion. The flow should not be too hard or coneentrated to avoid undersirable peening.

# MAINTENACE

Note:Disconnect power and air before any maintenance!

All blasting system is prone to plugging or wear because of the abrasive material used and the applications.The followig items should be checked for wear as indicated:

## Plugged Conditions

The blast nozzle may become plugged from moist media.Try dislodging the media with a drill bit held in your hand.You need to get rid of the mosit media.

if the abrasive pick-up hose appears plugged,cover the gun tip and force the air back through this hose.Dust may fly up when you do this so make sure the lid is down!

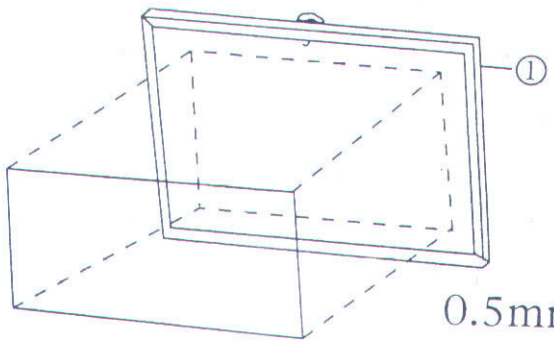
## Wear conditions

This is usually noted when an excessive amount of dust appears in the cabinet.Dust will occur if:

1. The abrasive blasting media is worn out .If it has lost its granular or spherical appearance or has a lot of debris from the parts being blasted and mixed in,replace it.This is usually noticed when the abrasive media that exits the nozzle looks like a smoke cloud coming instead of a stream
2. The air outlet vent is lugged or air flow out is blocked. Cleaning this vent should help reduce dust in the cabinet. This gun parts may wear may wear out.This is usually evident when the blast pattem is too wide and ineffective,simply replace nozzle or orifice

## To replace the transparent PVC board

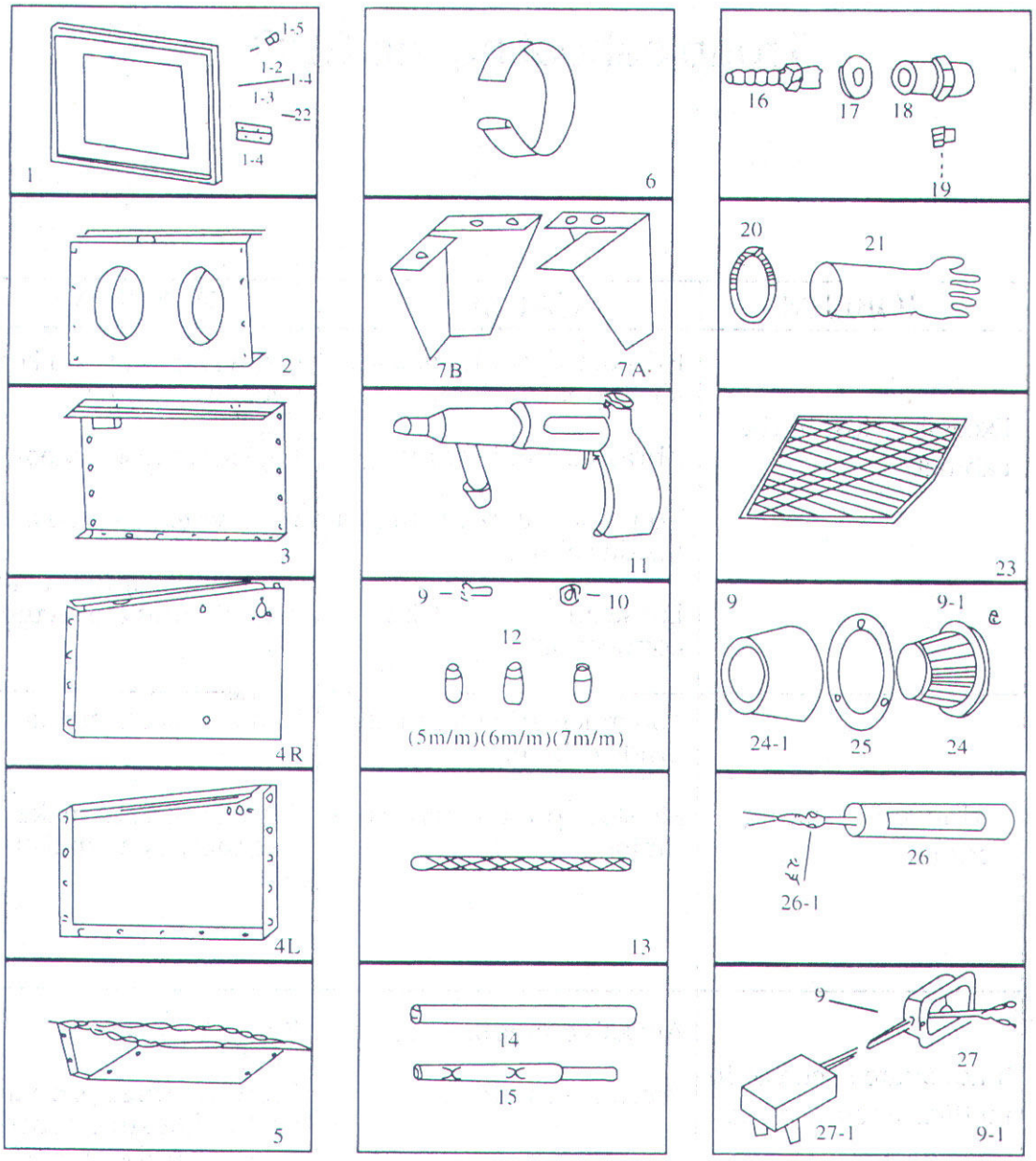
At the bottom of parts No.1 transparent top lid ,there is a 0.5mm rleplaceable transparent PVC board,when at work,if the transparent PVC board is getting unclear,it may be replaced with a new one to avoid affecting the sight during work.




0.5mm PVC board

# Troubleshooting the SBC

| PROBLEM | CAUSE | REMEDY |
|---|---|---|
| Excessive dust in the cabinet | Exhaust vent plugged or air flow is blocked.<br><br>Abrasive media worn.<br><br>Too much abrasive media inside cabinet.<br><br>Loose air line or fitting connections | Clean rear vent and keep vent away from any wall.<br>Replace abrasive media<br><br>Remove excess media<br><br>Tighten fitting and make sure air lines are secure. |
| Uneven blasting actions | Too much abrasive media inside cabinet.<br><br>Moisture present inside the cabinet. | Remove excess media<br><br>check air line to make sure there is no moisture in it. |
| Inadequate speed or in inefficisiency of blast. | Abrasive media worn.<br><br>Pressure too low. | Replace abrasive media.<br>Increase inlet pressure and make sure control valve is fully opened. |
| Static electrcity | Dry weather conditions | Leave the item being cleaned on the grating |




PARTSLIST

1 Transparent top lid
1-1 Top lid positioning chain
1-2 Screw
1-3 Nut
1-4 Movable leaf
1-5 Plastic screw
2 Front Panel
3 Rear Pancl
4R Right Panel
4L left Panel
5 Base
6 Lamp clamp
7A Left front leg,right rear leg
7B Right front leg,left rear leg
8 Screw 1/4" x 3/8" screw
9 5/32" x 3/8" screw
9-1 5/32" Nut
10 Nut
11 sanding gun
12 Nozzle
13 Air supply hose
14 Plastic suction hose
15 Steel suction hose
16 Air hose connector
17 Washer
18 Air supply connection interior screw thread
19 1/4" hose clamp
20 Giove clamp
21 Gloves
22 Self drilling screw
23 Screw
24 Air cleaner
24-1 Filter
25 Anchor plate
26 Lamp
26-1 Feed thru
27 Wire connection box
27-1 AC-DC ADAPTOR