



INFA-BLAST

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A DIVISION OF BLAST-IT-ALL, INC.

OPERATION AND PARTS MANUAL

MANUAL NO. 222

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**SET-UP INSTRUCTIONS
FOR MACHINES WITH CANISTER TYPE DUST COLLECTORS**

READ BEFORE OPERATING EQUIPMENT

1. Remove all shipping protection: plastic wrapping, shipping pallet, box's inside, etc. Check for any concealed shipping damage; if any damage, report to your freight carrier within 24 hours.
2. Blast Cabinet and Canister Collector should be placed in a desired location, away from any water or liquid environment such as cleaning vats, etc., where the air supply is not restricted and dry. If moist compressed air is present at this location, install a good moisture separator. This will assure that the media is not contaminated with moisture. (The dust collector should be placed slightly behind and to the right side of the cabinet. Attach flex hose to bottom of canister dust collector, then to cabinet hole located at top back side of cabinet.)
3. Connect your air supply line to machine regulator. We recommend using 1/2" minimum supply line. (Again, make sure your air supply line is free from oil and moisture. If not, install a good separator, before connecting to cabinet regulator.)
4. Connect electrical cord from Dust Collector to receptacle located on right side of light box. Connect electrical cord from light box to a grounded electrical source, 110 volt/60 cycle, single phase.
5. Charge blast machine with abrasive. Pour media into cabinet through one of the doors, fill to bottom of screen in sump of cabinet. **DO NOT FILL ABOVE SCREEN.** This will cause packing and media will not flow properly.

CAUTION

Do not use sand blasting sand. This will cause silica dust which is the cause of silicosis disease, a condition of massive fibrosis of the lungs.

SET-UP INSTRUCTIONS
FOR MACHINE WITH RECLAIMERS

READ BEFORE OPERATING EQUIPMENT

1. Remove all shipping protection: plastic wrapping, shipping pallet, box's inside, etc. Check for any concealed shipping damage; if any damage, report to your freight carrier within 24 hours.
2. Blast Cabinet and Canister Collector should be placed in a desired location, away from any water or liquid environment such as cleaning vats, etc., where the air supply is not restricted and dry. If moist compressed air is present at this location, install a good moisture separator. This will assure that the media is not contaminated with moisture. (The dust collector should be placed slightly behind and to the right side of the cabinet. Attach flex hose to bottom of canister dust collector, then to cabinet hole located at top back side of cabinet.)
3. Connect your air supply line to machine regulator. We recommend using 1/2" minimum supply line. (Again, make sure your air supply line is free from oil and moisture. If not, install a good separator, before connecting to cabinet regulator.)
4. Bolt IR-12-300 CFM reclaimer to back of machine. Refer to template on reclaimer. IR-18-600 CFM reclaimer is mounted on its own tripod.
5. Remove media valve on bottom of sump and screw on bottom of reclaimer. Attach media hose back onto media valve. Screw cap plug on sump outlet on bottom of blast cabinet. Install washer plug in back side of blast cabinet. Use caulking if necessary to make air tight.
6. Remove cover plate on back bottom of sump. Install with same bolts, the sump outlet adaptor, where cover plate was removed. Make sure caulking is used between the sump and sump outlet adaptor. Connect flex hose to sump outlet with clamp. Connect other end of the flex hose to reclaimer inlet (bottom hole, same size of flex hose), clamp securely. Securely clamp dust bag to reclaimer, making sure it hangs straight.
7. Connect electrical cord from reclaimer to receptacle located on right side of light box. connect electrical cord from light box to a grounded electrical source, 110 volt, 60 cycle, single phase.
8. Charge blast machine with abrasive. Pour media into reclaimer through fill door. DO NOT FILL ABOVE FILTER SCREEN IN RECLAIMER. Approximately one gallon in 300 CFM reclaimer, two gallons in 600 CFM reclaimers is required.

Reclaimer Conversion Kit - To change from canister dust collector to reclaimer and dust collector. Follow above instruction 4 through 8.

CAUTION

Do not use sand blasting sand. This will cause silica dust which is the cause of silicosis disease, a condition of massive fibrosis of the lungs.

OPERATING INSTRUCTIONS

1. Preparing parts for blasting:

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

2. Air Pressure:

WARNING: NO NOT CONNECT TO HIGH PRESSURE BOTTLE GAS. RUPTURE AND EXPLOSION CAN OCCUR.

Operating Pressure: 5 PSI to 80 PSI

Set air pressure at 80 PSIG. Most parts for blast cleaning can be blasted at 80 PSI. Designate parts to be processed, start at lower pressures and work up the PSI scale to obtain desired finish.

3. Gun Angle and Distance:

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

WARNING

Gun must always be pointed away from the operator and toward item being processed. Never blast with any of the cabinet doors open. While loading and unloading, no one should be at the operator station at front of the blast cabinet.

4. Media:

Media should be of good quality and dry. Damp media will cause the media not to flow and will clog abrasive flow. NEVER USE SAND. See "CAUTION", pages 1 & 2. If you are having a problem selecting a media for a specified job, contact your selling distributors for their recommendations.

MAINTENANCE INSTRUCTIONS

1. Blasting Gun:

After 10 - 12 hours of blasting time the air orifice and nozzle should be checked. If either shows wear, they should be turned 1/4 turn to prevent uneven wear. If this is not checked, it could result in destruction on nozzle and damage to the gun housing.

2. Caking of Media:

A. The result of media caking is caused by moisture in air supply and oily or greasy parts. If this is not corrected, media will not flow and will clog gun. Check air supply. If water or moisture is present, install a good moisture trap. If oily or greasy parts are being blast treated, you should first degrease and dry parts.

B. If blast gun should occasionally clog, place thumb over nozzle (hold tightly) and push foot valve down for 3 to 4 seconds. This will cause the system to back blast through the gun and media hose and clear the system.

3. Gun Air Pressure Drop:

Set air regulator at 80 PSIG on air gauge. Push foot valve and if gauge should drop in pressure reading, check the air supply pipe or hose. This will cause a pressure drop to the machine if the air supply line is too small; a restriction in the supply line such as reducers or quick couplers can also cause pressure drop. Also if the blast cabinet is too far from the air compressor, a pressure drop can occur. We recommend 1/2" - 1" ID air supply line. The bigger the better.

4. Poor Visibility - Excessive Dust:

- A. Air inlet damper or side of cabinet not open enough, check for blockage.
- B. Vacuum canister full and needs cleaned and emptied.
- C. Filter bag contaminated. Clean and shake bag, or replace.
- D. Media breakdown - replace media and clean dust filter.

5. Poor Media Flow:

- (a) Wet or damp media caused from moisture or oil in compressed air line.
- (b) Use dry air or install moisture filter.
- (c) Replace media and clean media sump and hose.
- (d) Media level should be below media filter screen.
- (e) Hole in media hose from wear, replace hose assembly.
- (f) Air orifice assembly in gun I.D. worn, replace assembly.

CAUTION

DO NOT OPEN ANY OF THE DOORS WHEN MACHINE IS IN OPERATION

MAINTENANCE INSTRUCTIONS
MACHINES WITH RECLAIMERS

1. Fogging Cabinet:

- (a) Reclaim not operating, activate reclaim switch and check electrical source.
- (b) Dirty or contaminated dust bag, clean or replace dust bag.
- (c) Air inlet damper on side of cabinet not open enough, check for blockage and adjust for proper air flow into cabinet.
- (d) Blockage in sump of cabinet or flex hose to reclaim.

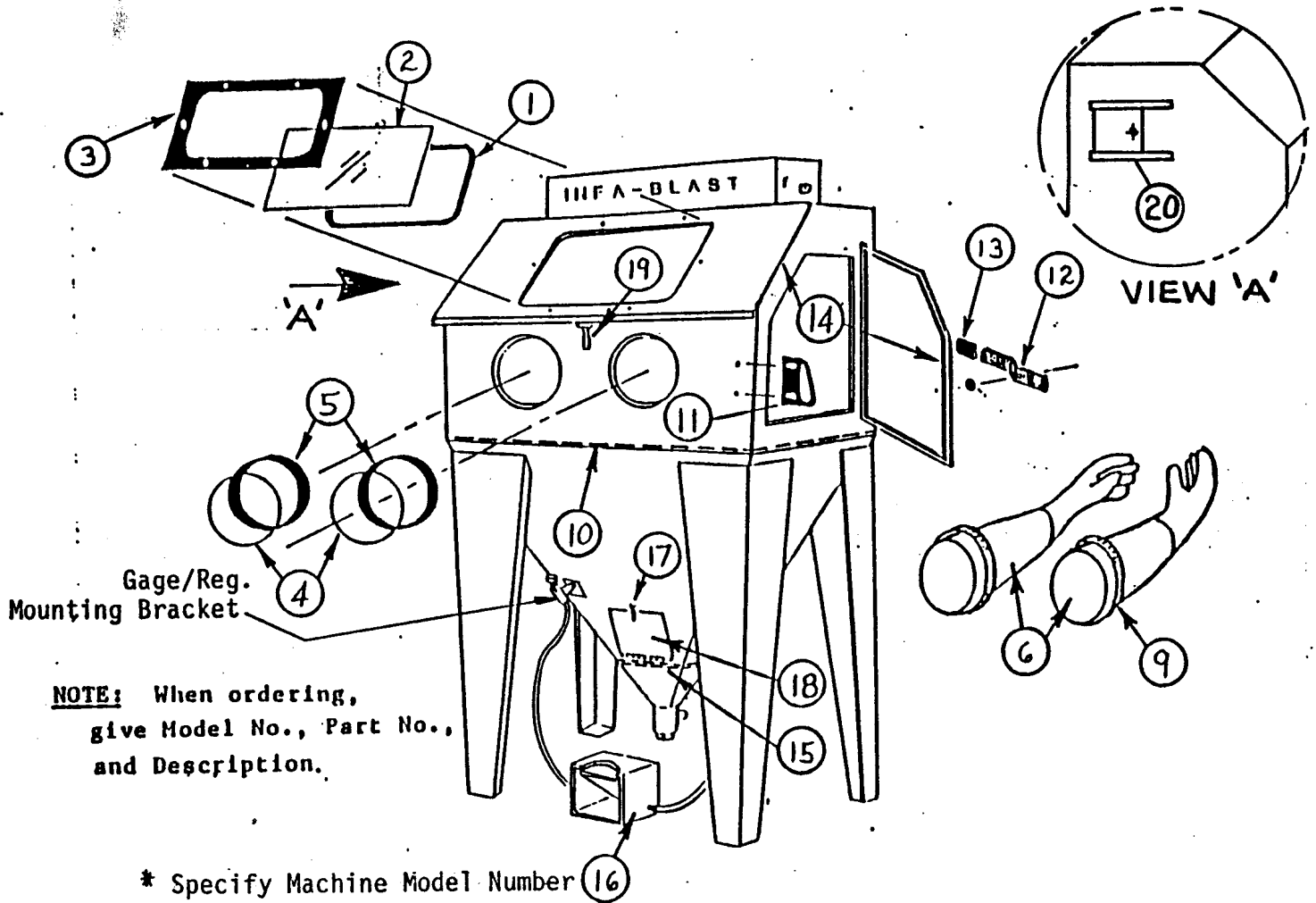
2. Abnormal Media Consumption:

- (a) Air leaking into reclaim at reclaim door. Reclaim door must be tight. If reclaim door gasket is worn, replace.
- (b) Improper exhaust hookup is caused if reclaim is exhausted into a bag or dust collector not of our manufacture, or if the bag is not used and reclaim is exhausted outside without a damper. Never connect to any other system such as an in-plant exhaust, roof vents or any system that will reduce the exhaust pressure at the reclaim outlet; this can effect the operation of the reclaim system and cause good media to be lost. Contact selling agent for factory recommendation.

Blasting with too high pressure can fracture media prematurely.

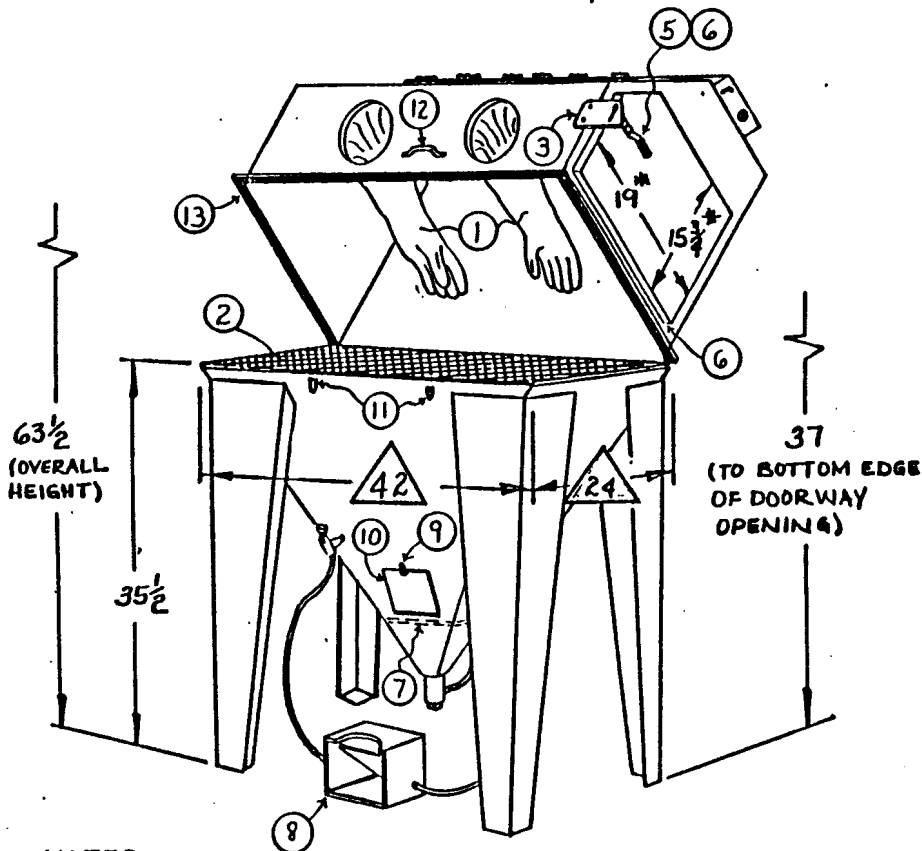
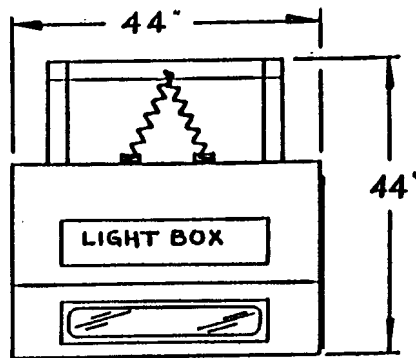
3. Reduction of Cleaning:

- (a) Low bead level, fill as required.
- (b) Low air pressure, adjust regulator to 80 PSI.
- (c) Air pressure drop - When regulator is set at 80 PSI and pressure reading drops 10 or more psi at start of blasting. This can be caused by restrictions in the compressed air line; eliminate all restrictions. If regulator pressure drops after a few minutes of blasting, this indicates that there is not enough air CFM.
- (d) Media hose clogged - check for worn, soft spots or holes. Replace as required. If media hose is packed from contamination, back blast as described on page 5,2b.
- (e) Dirty exhaust filter or bag:
Filter or bag should be emptied and cleaned daily by shaking. If machine is used in continuous production. If this is not maintained, flow of air will back up in machine and cleaning will be reduced.
- (f) Wet Media:
If media is wet, damp or oily, media will not flow. Purge system and refill with new media.
- (g) Worn Gun Part:
Inspect and replace when there is indication of wear. Adjust part as described on page 5, #1.



Item No.	Part No.	Description
1	001499	Window Seal
2	000302	Window
3	000303	Window Frame
4	000308	Arm Hole Trim (Pair)
5	000307	Arm Hole Gasket
6	000309	Gloves (Pair)
7	002854	Glove (Right)
8	002854	Glove (Left)
9	000310	Clamp
10	*	Grate
11	001945	Door Striker
12	001946	Door Cam
13	001947	Door Cam Rubber Grip
14	001500	Door Gasket
15	001501	Sump Trash Screen
16	001502	Foot Pedal Assy.
17	001948	Latch (Clean out door)
18	001504	Clean Out Door Gasket
19	001505	Latch (Face Lid)
20	001993	Slide Air Inlet

SHIPPING WEIGHT
INCLUDING DUST CANISTER:
372 LBS



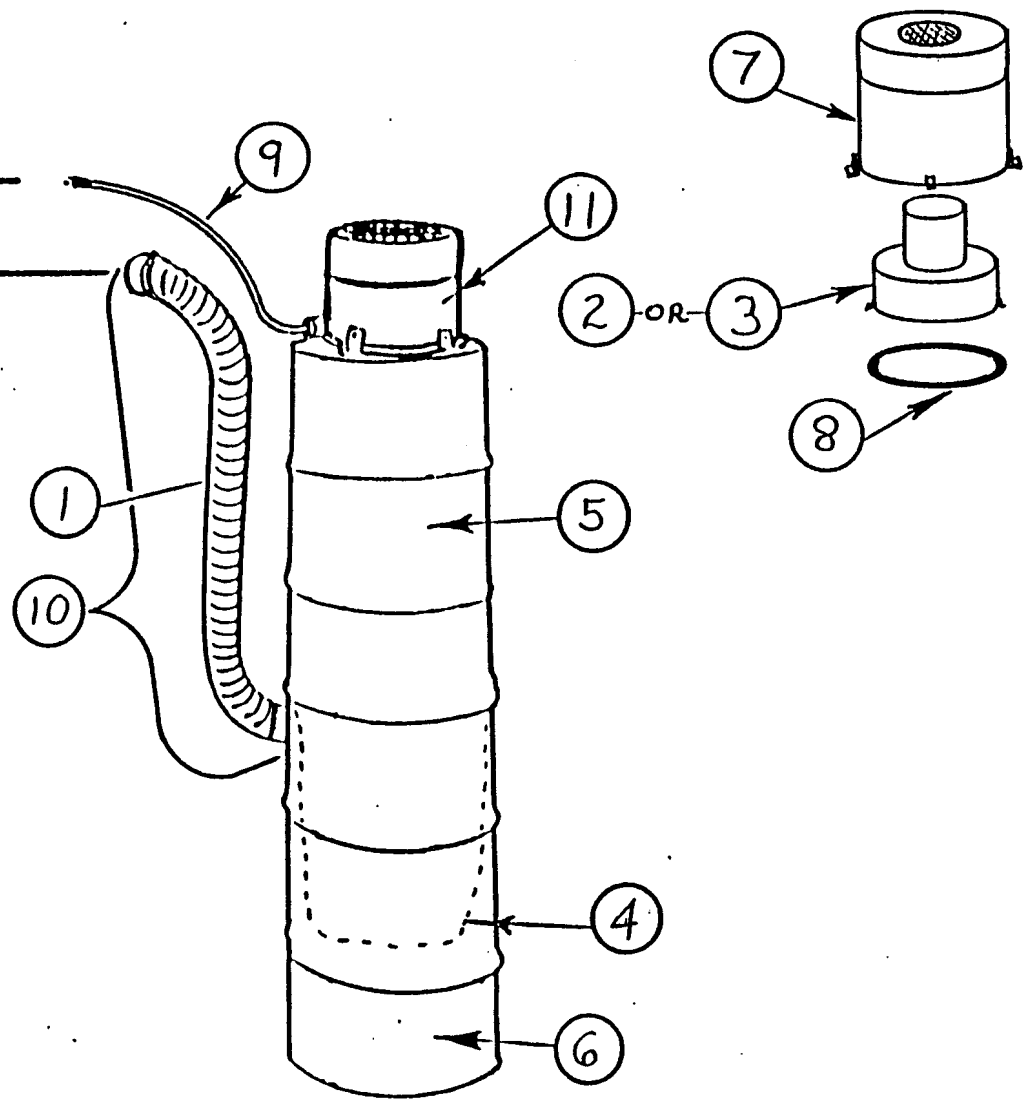
NOTES

- 1 - DIMENSIONS MARKED WITH AN ASTERISK (*) DENOTE ACTUAL DOORWAY OPENING.
- 2 - DIMENSIONS IN TRIANGLE DENOTE ACTUAL WORK SURFACE DIMENSIONS.

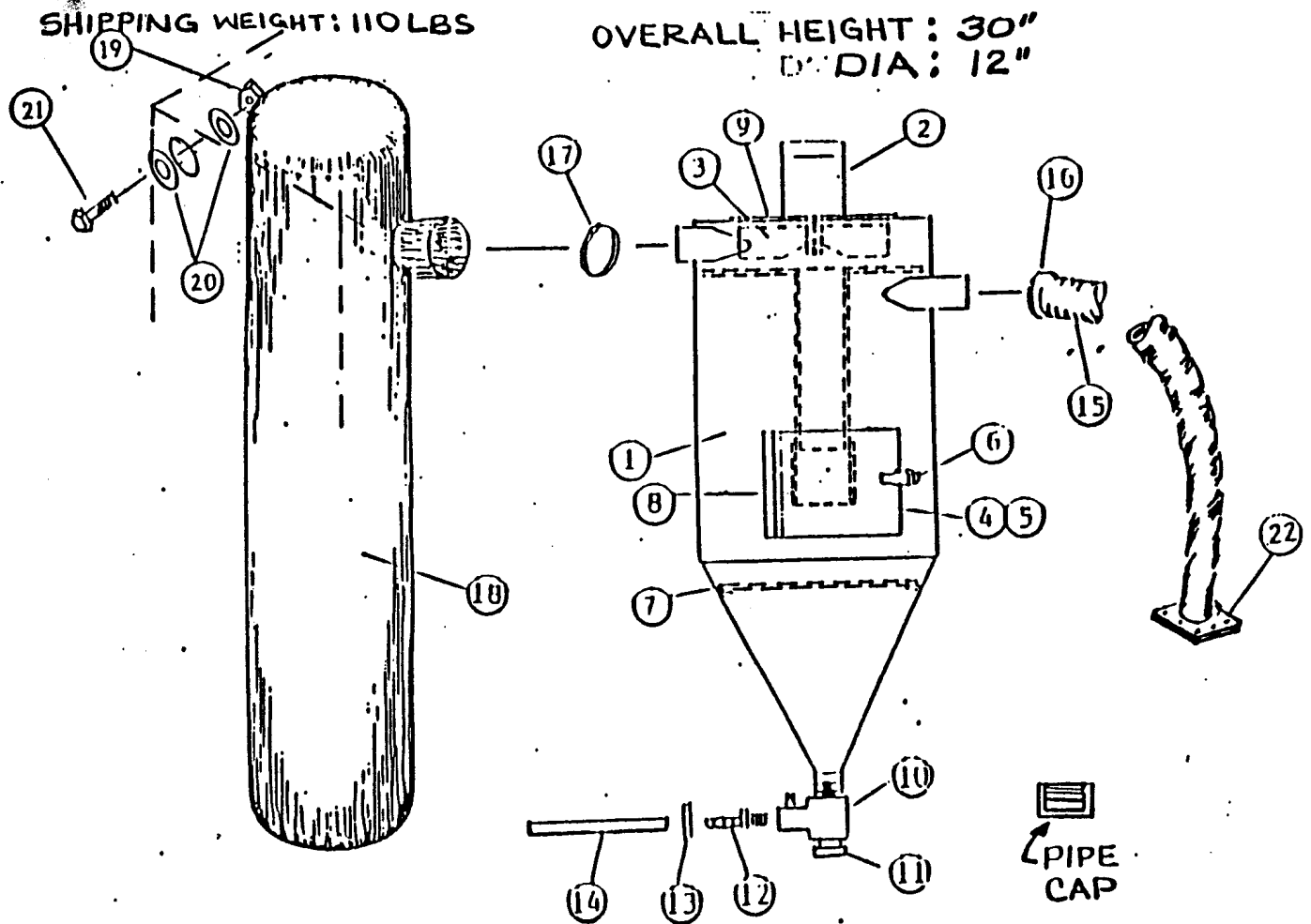
Item No.	Part No.	Description
1	000309	Gloves (pair)
2	*	Grate
3	001945	Door Striker
4	001946	Door Cam
5	001947	Door Cam Rubber Grip
6	001500	Door Gasket
7	001501	Sump Trash Screen
8	001502	Foot Pedal Assembly
9	001948	Latch (clean out door)
10	001504	Clean Out Door Gasket
11	001505	Latch (Face Lid)
12	002884	Handle, Flip Top
13	002923	Gasket, Flip Top

Connect Into Receptacle
On Light Box.

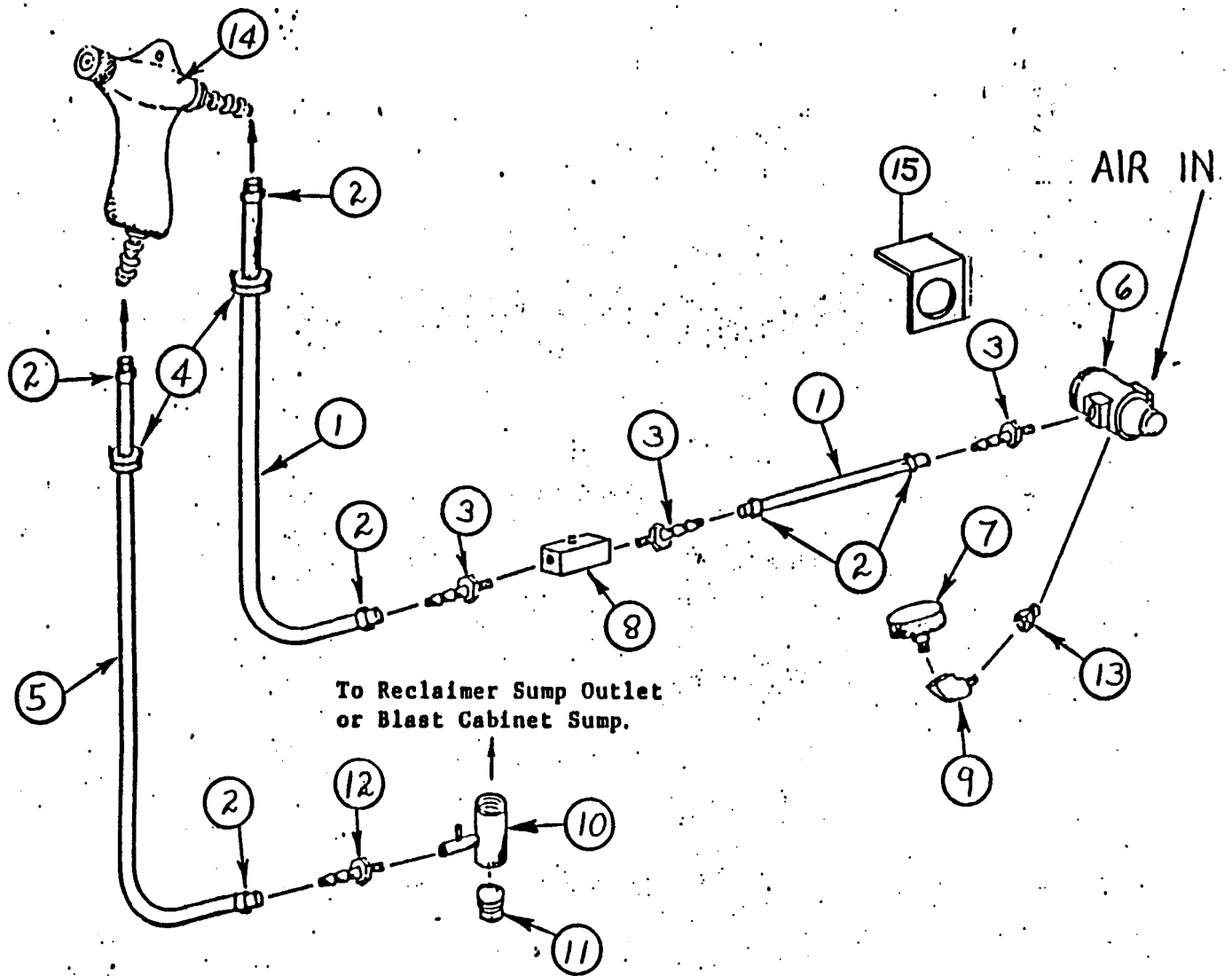
Connect Into Opening
In Blast Cabinet.



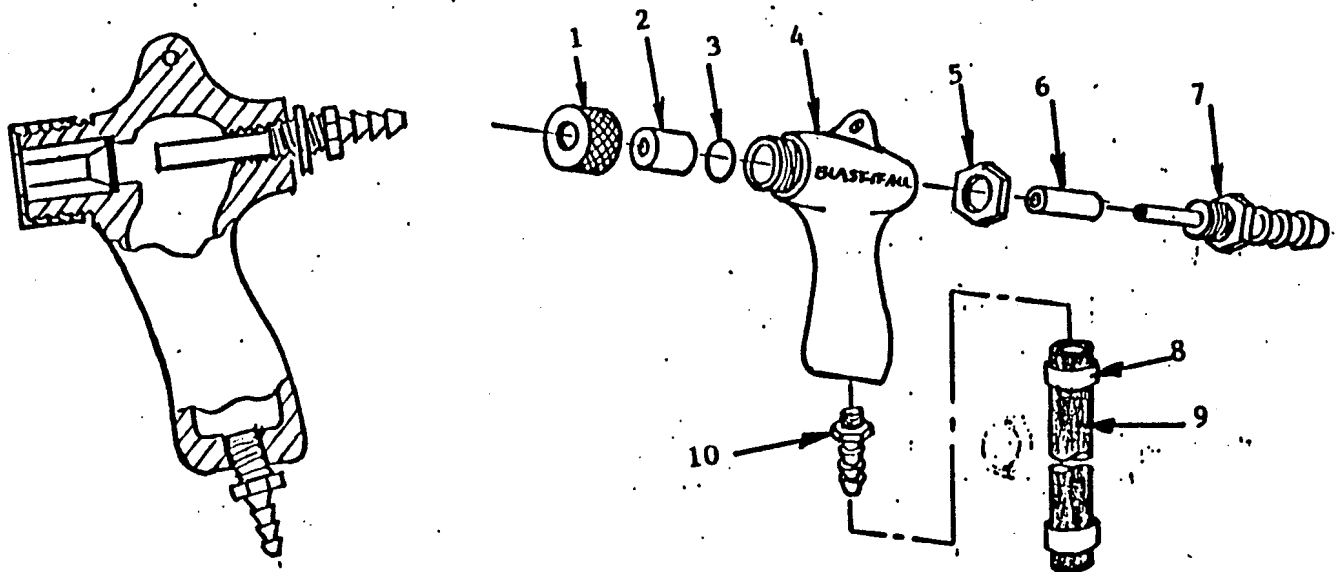
Item	Part No.	Description
1	002860	Flex Hose
2	001233	Motor 115 V AC
3	002932	Motor 240 V AC
4	000663	Dust Bag
5	002885	Canister, Upper
6	002886	Canister, Lower
7	001994	Cover, Motor
8	002928	Gasket, Motor
9	002859	Power Cord
10	002927	Hose and Cuff Assembly
11	002929	Complete Motor and Cover Assembly
12	002358	Complete D/C with 115 V, 1 PH Motor
13	002359	Complete D/C with 240 V, 1 PH Motor



Item No.	Part No.	Description
1	B 1003	Recloim Housing
2	000100	Motor
3	A12062	Blade Assembly
4	A1012(6)	Door
5	A1012(9)	Door Gasket
6	001948	Latch
7	A1012(5)	Trash Screen
8	000728	Slide Tube Assembly
9	A12059(2)	Motor Plate
10	002790	Media Valve
11	002791	Plug
12	000353	Fitting
13	000815	Clomp
14	000354	Hose
15	002792	Flex hose
16	000816	Clamp
17	000817	Clomp
18	000564	Dust Bag
19	000988	3/8 Nut
20	002930	Drop
21	000322	3/8 Bolt
22	002931	Sump Adapter



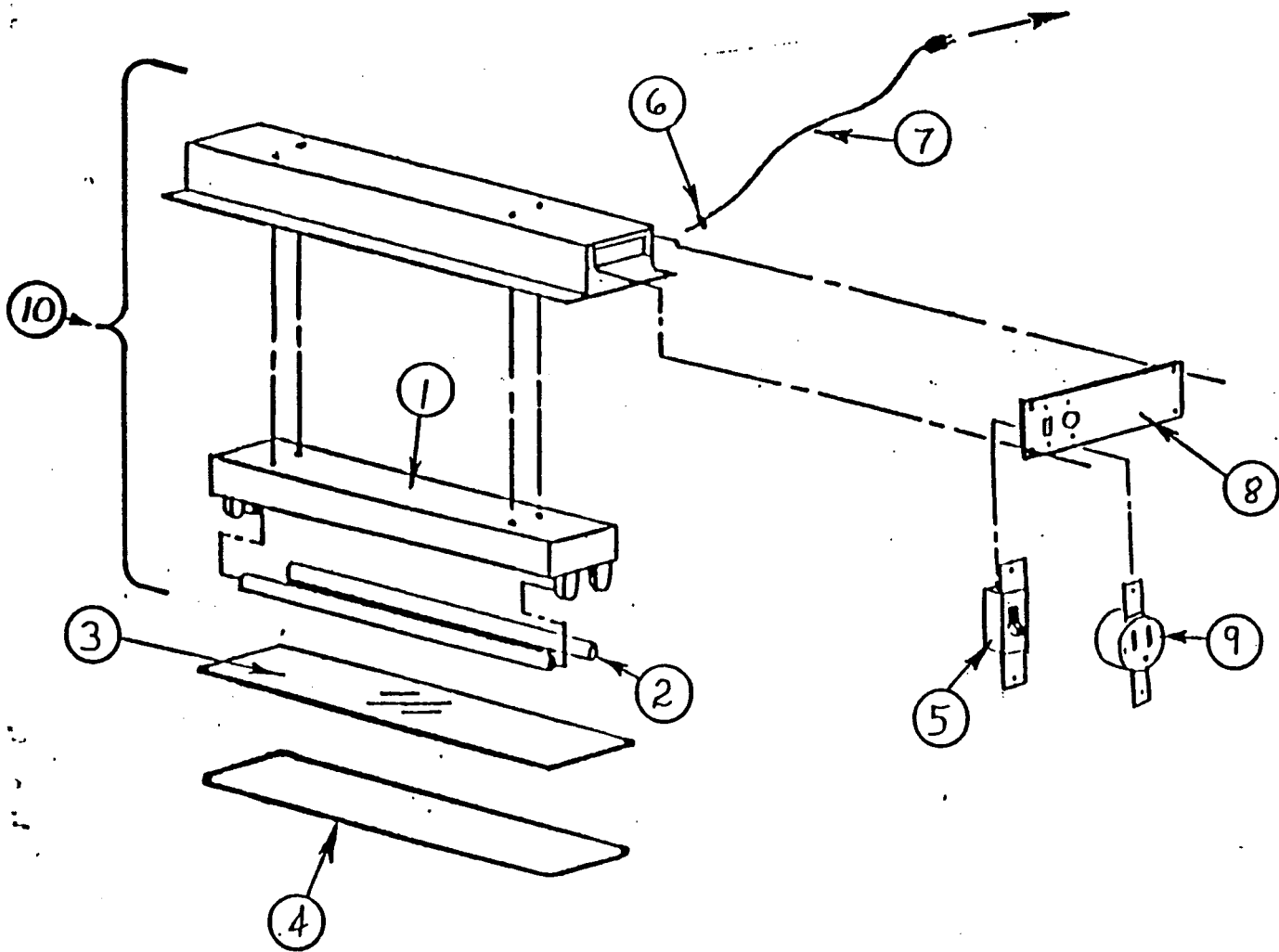
Item No.	Part No.	Description
1	000361	Hose, Air Specify Length
2	000815	Clamp
3	000363	Fitting
4	000823	Hose Grommet
5	000354	Hose, Media Specify Length
6	000801	Regulator
7	000543	Air Gauge
8	001234	Air Valve, Foot
9	000695	Street Ell
10	002790	Media Valve
11	002791	Plug
12	000353	Fitting
13	001527	Adaptor
14	---	Blast Gun Refer to Page 11
15	002924	Mounting Bracket, Regulator



Item #	Part #	Description
1	002748	Nozzle Nut
1	002861	Nozzle Nut (Wide Spray)
2	002862	Nozzle Ceramic, 1/4" I.D., Size 4
2	002863	Nozzle Ceramic, 5/16" I.D., Size 5
2	002864	Nozzle Ceramic, 3/8" I.D., Size 6
2	002865	Nozzle Ceramic, 7/16" I.D., Size 7
2	002866	Nozzle Ceramic, 1/2" I.D., Size 8
2	002856	Nozzle Carbide, 1/4" I.D., Size 4
2	002867	Nozzle Carbide, 5/16" I.D., Size 5
2	001026	Nozzle Carbide, 3/8" I.D., Size 6
2	002868	Nozzle Carbide, 7/16" I.D., Size 7
2	002869	Nozzle Carbide, 1/2" I.D., Size 8
2	002874	Nozzle Boron Carbide, 3/8" I.D., Size 6
2	002877	Nozzle Boron Carbide (Wide Spray), 3/8" I.D., Size 6
3	002749	"O" Ring - Nozzle Sealing
4	002750	Gun - Body Only
5	002751	Locknut Orifice
6	002752	Rubber Cover
7	001155	Orifice, Air 4/32" I.D., Size 4
7	002878	Orifice, Air 5/32" I.D., Size 5
7	002753	Orifice, Air 6/32" I.D., Size 6
7	002879	Orifice, Air 7/32" I.D., Size 7
7	002880	Orifice, Air 8/32" I.D., Size 8
8	002742	Clamp
9	000354	Hose, Media 1/2" I.D. (Specify Length)
10	000363	Fitting - Hose to Gun
---	002881	Gun, Standard Complete with Ceramic Nozzle
---	002882	Gun, Standard Complete with Carbide Nozzle
---	002883	Gun, Standard Complete less Nozzle (Specify Orifice Size)

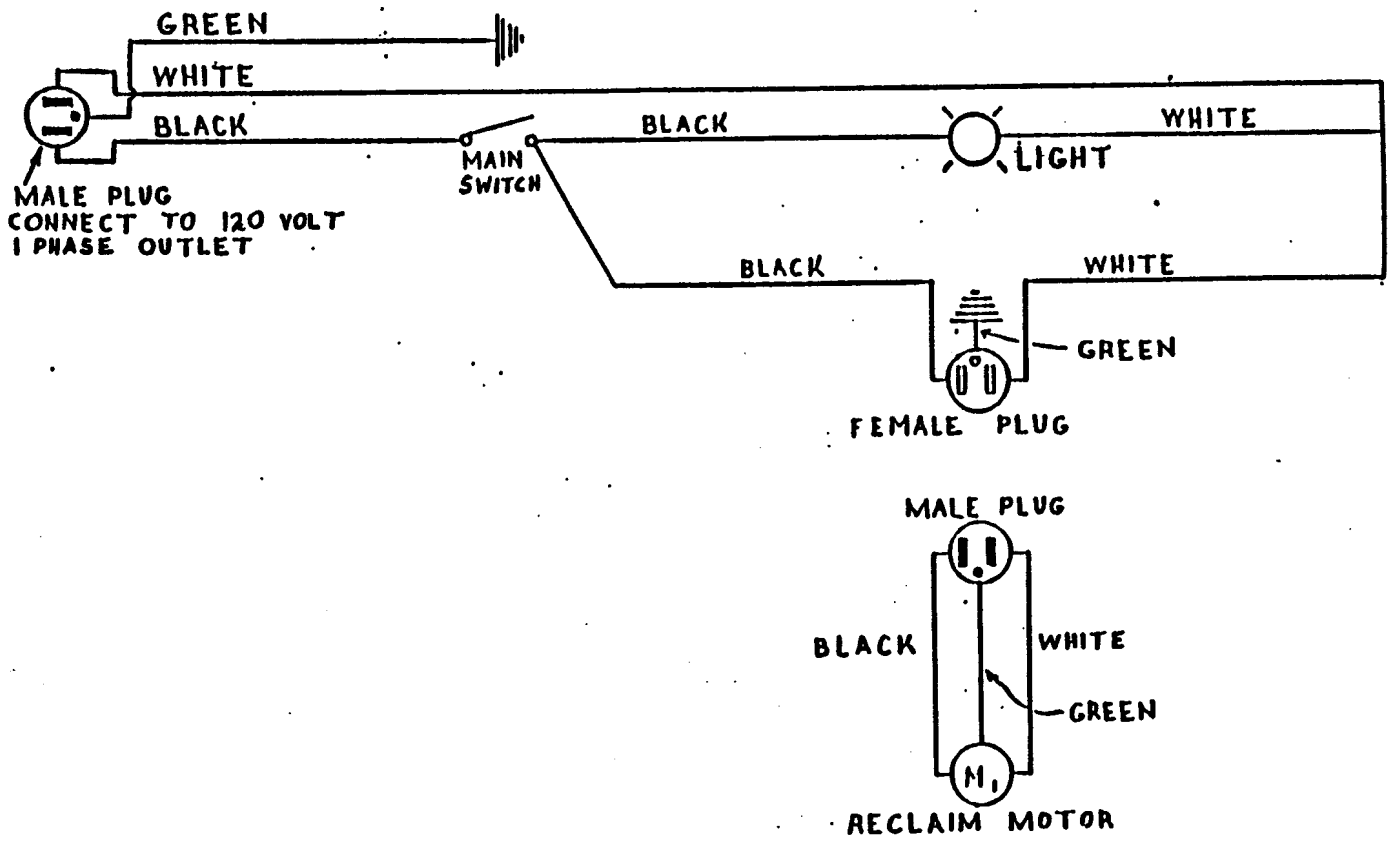
NOTE: When ordering a Gun Complete, indicate what size orifice is required.

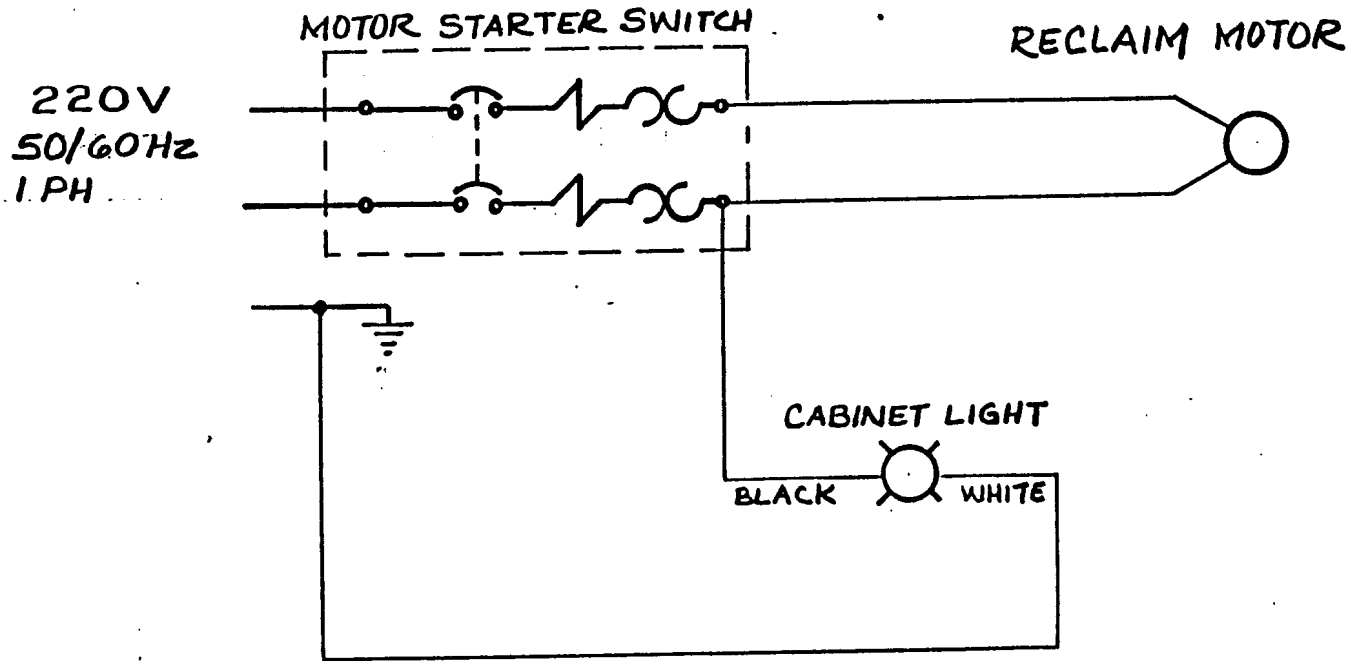
Connect to Power Source



Item No.	Part No.	Description
1	001672	Fluorescent Fixture
2	002739	24" Fluorescent Tube
3	002857	Window
4	001499	Window Seal
5	002858	Switch
6	000346	Heyco Connector
7	002859	Power Cord, 3 wire
8	001497	Switch Mounting Plate
9	001498	Receptacle
10	002922	Complete Light Box Except Items 3 & 4

120 VOLT POWER
50/60 Hz 1 PH





INFA PARTS LIST

Item No.	Part No.	Description
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BLAST GUN

1	002750	Blast Gun (Body only) Industrial Type
2	002881	Blast Gun complete with ceramic nozzle. State size.
3	002882	Blast Gun complete with carbide nozzle. State size.
4	001155	Blast Gun Orifice Air #4, 4/32 I.D.
5	002878	Blast Gun Orifice Air #5, 5/32 I.D.
6	002753	Blast Gun Orifice Air #6, 6/32 I.D.
7	002862	Blast Gun Nozzle ceramic #4, red 1/4" I.D.
8	002863	Blast Gun Nozzle ceramic #5, white 5/16" I.D.
9	002864	Blast Gun Nozzle ceramic #6, blue 3/8" I.D.
10	002867	Blast Gun Nozzle carbide #5, 5/16" I.D.
11	001026	Blast Gun Nozzle carbide #6, 3/8" I.D.
12	002749	"O" Ring - Nozzle sealing
13	002748	Nozzle Nut Holding

GLOVES

14	000309	Gloves - Standard Size, fits 8" arm hole
15	002863	Gloves - Large capacity, fits 10" arm hole
16	002865	Gloves - Left hand only, fits 8" arm hole
17	002866	Gloves - Right hand only, fits 8" arm hole
18		Gloves - 6" x 24", fits Trinco, Econoline, etc.

Item No.	Part No	Description
WINDOWS		
19	000302	Window Viewing, Safety Tempered Glass
20	002857	Window Light Protector - Safety Tempered Glass
21	002887	Window Frame Kit - To change round cornered and small windows to use InFa #23-050. Includes frame, window, window frame, seal and trim. Window Underlayment, 10 changes Window plastic, fits Trinco, Econoline, etc. 12" x 24"
22	000303	Window Frame Only
CABINET HARDWARE		
23	001946	Door Cam, right or left side
24	001947	Door Cam, rubber grip
25	001945	Door Striker, right or left side
26	001505	Door Latch, for top opening door
27	001505	Door Latch, for OS opening doors
28	001948	Door Latch, 300 and 600 CFM reclaimer
29	001948	Door Latch, for sump clean out door
30	000802	Filter Air, 3/8" inlet and outlet
31	000801	Regulator Air, 3/8" bracket outlet
32	002924	Regulator mounting bracket
33	002888	Gauge Air, 1/4" bottom outlet
34	001234	Valve Air, foot pedal valve
35	001502	Valve and safety foot pedal assembly
36	002889	Blow off gun
37	002922	Blow off gun - complete fluorescent light, switch, outlet, wire, etc.
38	002884	OS hand lift handle
ELECTRICAL		
39	001672	Fluorescent fixture 24", no tubes
40	002739	Fluorescent tube 24"
41	002858	Switch, light and D/C or reclaim
42	001498	Outlet, receptacle to D/C or reclaim
43	002859	Power cord, with 3 prong moulded plug

Item No.

Part No

Description

GASKET

44	001499	Gasket, window seal
45	001499	Gasket, light box
46	001499	Gasket, viewing window
46	001500	Gasket, door (specify size)
47	001504	Gasket, clean out door
48	000307	Gasket, arm hole 1" wide
49	000308	Gasket, arm hole tim bead
50	A1012-3	Gasket, IR-12-300 reclaim door
51	00837	Gasket, IR-12-300 reclaim motor plate
52	A1101-2	Gasket, IR-18-600 reclaim door
53	000837	Gasket, IR-18-600 reclaim motor plate
54	000823	Grommet rubber, for 1/2" air and media hose
55	000822	Grommet rubber, for 1/4" air hose
56	002928	Gasket, Motor

DUST COLLECTORS AND BAGS

57	002884	Dust collector, drum type complete
58	002885	Dust collector, top drum
59	002886	Dust collector, bottom collection drum
60	001233	Dust collector, drum type, motor
61	002929	Complete motor and cover assembly
62	001994	Dust collector motor, cover only (for drum type)
63	000663	Dust bag, for drum type collector
64	000564	Dust bag, for 300 CFM reclaimer
65	000566	Dust bag, for 600 CFM reclaimer

HOSES, AIR AND FLEX

66	000354	Hose, 1/2" I.D. media line (specify length)
67	000361	Hose, 1/2" I.D. air line (specify length)
68	000738	Hose, 1/4" I.D. air blow off (specify length)
69	002860	Flex hose, D/C to cabinet (specify length)
70	002792	Flex hose, 300 CFM reclaimer to sump (specify length)
71	002792	Flex hose, 600 CFM reclaimer to sump (specify length)

Item No.

Part No

Description

RECLAIMER PARTS

72	B1003	Reclaimer IR-12-30 CFM, complete. Includes motor, blades, bag, media valve
73	A1015	Reclaimer 300 CFM, Body only
74	12059.2	Reclaimer 300 CFM, Motor plate
75	A12062	Reclaimer 300 CFM, Fan blade
76	A1012.5	Reclaimer 300 CFM, Screen
77	A1012.6	Reclaimer 300 CFM, Door (no latch)
78	13-400	Reclaimer 300 CFM, 1/2 HP Motor
79	902005	Reclaimer, IR-18-600 CFM, complete. Includes motor, blade, bag, media valve
80	A1117.1	Reclaimer 600 CFM, body only
81	001056	Reclaimer 600 CFM, motor plate
82	01054	Reclaimer 600 CFM, fan blade
83	A1168	Reclaimer 600 CFM, screen
84	A1101	Reclaimer 600 CFM, door (no latch)
85	000080	Reclaimer 600 CFM, 1 HP motor
86	002926	Motor starter switch, 220 V, 1 PH, 50/60 HZ
87	002790	Media valve complete, 300 and 600 reclaim

ACCESSORIES

Turntable

88	0A-08	16" Diameter
89	0A-010	20" "
90	0A-012	24" "

Tumble Basket

100	0A-300	2 gallon tumble basket, complete
101	0A-302	Replacement basket

RETURN MERCHANDISE POLICY

BLAST-IT-ALL, INC. (BIA) will not accept returned merchandise for credit without proper authorization. A return authorization number will be issued and must be included on all purchases or correspondence. Any material returned without prior authorization will remain the property of the sender and BIA will not be responsible for returned merchandise.

WARRANTY

BLAST-IT-ALL, INC. (BIA) warrants its equipment against defective materials and workmanship for one year. This warranty does not apply to parts which are subject to wear such as blast guns, nozzles, hoses and gloves; nor does it apply to equipment that has been subjected to misuse, accident, improper installation, improper application or improper operation. BIA shall have no liability for labor, consequential damages or special charges. Warranty period is determined by the purchase date on the Warranty Form. If there is no Warranty Form on file at the manufacturer, warranty period will revert back to date of shipment from our factory.

Warranty void unless warranty is filled out completely and returned to InFa-Blast within 15 days after purchase.

Any freight damages must be reported to the freight carrier within 24 hours of delivery.

TERMS AND CONDITIONS

TERMS: 1/2 % 10 Days, Net 30 Days unless otherwise specified.

MINIMUM BILLING: \$50.00 Net.

RETURNED MERCHANDISE: Subject to 15% Restocking and/or Handling Charge. See above.

F.O.B.: Factory, unless otherwise specified.

SPECIAL ORDERS: Not returnable.

PRICES SUBJECT TO CHANGE WITHOUT NOTICE

Duplication of this Operation/Service Manual, either partial or in its entirety, must have written approval in advance from InFa Blast.

SHIPPING ADDRESS:

InFa Blast
Hwy. 29 South
Circle M Industrial Park
Salisbury, NC 28144