

# **BLAST-IT-ALL®**

## **DRY BLAST SYSTEMS**

### **SUCTION BLAST MACHINES**

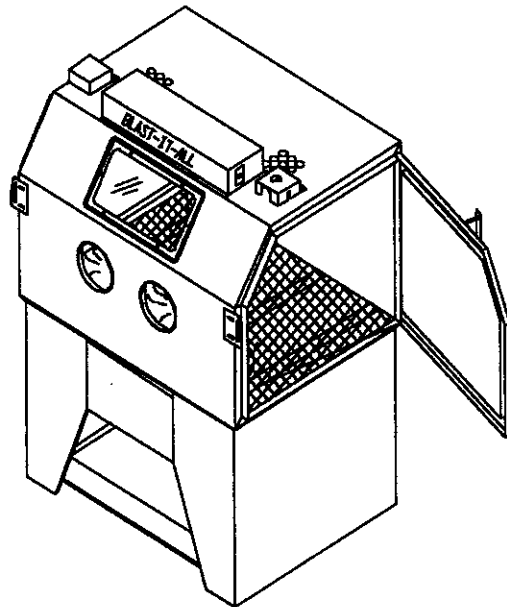
#### **WARNING**

**DO NOT USE *SAND*. SAND WILL CAUSE SILICA DUST, WHICH IS THE CAUSE OF SILICOSIS DISEASE, A CONDITION OF MASSIVE FIBROSIS OF THE LUNGS. *THIS STATEMENT INDICATES POTENTIAL PERSONNEL HAZARD. FAILURE TO COMPLY WITH THESE INSTRUCTIONS MAY RESULT IN PERSONAL INJURY.***

***WEBSITE FOR SILICOSIS:***

***[http://www.osha-slc.gov/SLTC/silica\\_advisor/mainpage.html](http://www.osha-slc.gov/SLTC/silica_advisor/mainpage.html)***

**THIS MACHINE IS DESIGNED FOR THE USE  
OF GLASS BEADS OR ALUMINUM OXIDE.**



**LARRY HESS & ASSOCIATES, INC**  
**P.O. BOX 1615**  
**SALISBURY, NC 28145-1615**  
**TOLL 1-800-535-2612 / FAX 704-636-9311**  
**[www.blast-it-all.com](http://www.blast-it-all.com) OR [sales@blast-it-all.com](mailto:sales@blast-it-all.com)**

SECTION I

INTRODUCTION AND GENERAL INFORMATION

1-1 INTRODUCTION

1-2 PURPOSE AND SCOPE

This publication contains operation and maintenance instructions, with illustrated part breakdown, for the BLAST-IT-ALL Dry Blast Cabinet, manufactured by BLAST-IT-ALL, INC., Salisbury, NC.

1-3 GENERAL INFORMATION

1-4 DESCRIPTION

This machine is designed primarily for the cleaning and peening process with glass beads; however, it will also handle abrasive media when cutting action is required. The gun pressure and media is determined by the application. Additionally, the blast cleaning and peening machine has the following applications:

- A. Increase tensile strength and relieve stress by microscopic bombardment.
- B. Remove burrs following machining or grinding operation, subminiature space age or large castings.
- C. Produces a metallurgically clean surface for plating, painting and other processes.
- D. Increase tool life by blending minute surface imperfections.
- E. Improve releasing characteristics of molds and dies which process glass, rubber and plastic parts.
- F. Enhance lubrication by imparting a microscopically controlled dimpled surface.
- G. Retain critical dimensions while producing above results.
- H. Reclaim and recondition parts by removing paint, rust, corrosion, etc. This process is also used on rubber, fiberglass and plastics.

The Blast Cleaning and Peening Machine is of the enclosed type. Parts for processing are loaded into the cabinet through doors on the right or left sides of the unit. The operators hands are inserted into a pair of gloves, connected to the unit. The gloves serve both to protect the operator, and to retain the media in the enclosure. Observation of the parts in process is through a glass window in the cabinet front. The unit also contains a sealed, two tube, fluorescent light which illuminates the work area when electrical power is on.

The media for abrasive blast cleaning or bead peening is propelled by externally supplied air pressure. The air pressure is routed through a moisture separator, pressure regulator, and control solenoid to the blast gun.

The Blast Cleaning and Peening Machine is equipped with a media reclaiming device. This device is a modified cyclone separator with a very delicate air balance. Media, dust, and debris being returned from the cabinet sump enters the air balance for separation. Reusable material drops thru the filter screen basket into the storage hopper for reuse. Air, dust, and debris are exhausted through the reclaiming device and into the dust bag to be discarded.

1-8 COMPRESSED AIR REQUIREMENTS  
Table # 1-1

Orifice	CFM Volume	P S I G
No. 4	21.0	80
No. 5	31.9	80
No. 6	47.0	80
No. 7	62.0	80
No. 8	85 7	80

## SECTION II

### INSTALLATION AND OPERATION

#### 2-1 INSTALLATION

- A. Select a location providing suitable air and electrical service. Position machine from surrounding obstruction so as to permit efficient handling of the largest parts to be processed.
- B. Before connecting electrical power, ensure machine is properly grounded per local regulations.
- C. Connect electrical power to unit. (Check motor voltage)
- D. Connect air pressure, regulate to 80 PSI. (See Table 1-1)
- E. Connect dust bag to blower, using proper clamp.
- F. Select and obtain proper blasting media for intended use.
- G. Fill hopper with media.

#### 2-2 ELECTRICAL REQUIREMENTS

- A. For machine equipped with a 1/2 H.P. or 1 H.P. blower motor, provide a 20 AMP, 115 volt, A.C. single phase, 60 cycle electric service.
- B. For machine equipped with a 2 H.P. 230 volt, A.C. single phase, 60 cycle blower motor, see wiring diagram.
- C. For safety, ground all machines as per local regulations.
- D. For 230/440 volt, 3 phase motors, before starting the blower, check the rotation of paddle located inside blower housing. To make the check, turn the electric switch on and off. This will cause the paddle wheel inside the housing to spin slowly, then by looking into the outlet of the blower, the rotation of the paddle can be easily observed. Rotation should be according to direction of arrow on the blower housing. See instruction sheet attached.

#### 2-3 OPERATION

The machine requires electricity, air and blast media to operate. Dry BLAST-IT-ALL glass beads, media, etc. as purchased from your distributor or dealer have been treated to insure free-flow operation even under moderately high humidity conditions. This does not imply that water may be introduced onto the cabinet. Beads accidentally subjected to excessive moisture may be reused after thorough drying and breaking up the lumps.

- A. Select the size bead best suited for your operation. Beads are dumped into the clean hopper of the reclaimer through the large pour-in door. The minimum amount of media to be placed in a hopper of the separator for satisfactory operation of the complete system should be as follows:

For a 400 CFM Separator - 10 lbs. media  
For a 700 CFM Separator - 20 lbs. media  
For a 900 CFM Separator - 40 lbs. media

#### CAUTION

Do not operate reclaim unit with fill door open.

- B. BE SURE ALL PREVIOUS MEDIA IS REMOVED.

To remove media or empty the reclaimer systems, secure a wrench and container, place container under metering valve, remove plug from valve and beads should flow into the container. If beads do not flow, this is an indication they have become caked. Open the fill door located on the side of the separator (reclaim), stir beads until they start to flow from the valve. Replace plug before operating.

SECTION II (cont.)

2-3 OPERATION (cont.)

- C. Adjust the air regulator to the desired operating pressure (turn knob of regulator clockwise to increase pressure). Observe the gauge and activate the gun; operating pressure will usually drop from closed line pressure.
- D. The toggle switch marked reclaimer turns the machine on and off. Some modified machines are equipped with individual gun switches. Other machines may have individual light switches.
- E. Insert hands into rubber gloves from the front of the cabinet.
- F. Hold gun in one hand and part to be processed with the other hand, then activate gun.

Note: Pressures of 80 PSIG or more normally require either a solid back rest for the part or the use of both hands, and mounting the gun stationary. Without this assist, especially on long peening operations, the operator will tire easily from fighting blast pressure.

- G. Blasting technique is similar to spray painting, that is, smooth continuous strokes are most effective. The distance from the part effects the size of the blast pattern. Normal usage places the gun approximately 3" from the surface of the material.
- H. Several media sizes and pressures may be required to process many varied types of materials. However, once the correct process is established, any person may be taught the application in a short time.

2-4 SHUT DOWN

For service economies, it may be desirable to shut down the unit after use.

- A. To turn the machine off, flip toggle switch; this will shut off all electrical services. Turn air off, press stop button on machines so equipped.
- B. Clean exhaust bag, see maintenance.
- C. The air filter is equipped with a manual drain and should be opened by screwing counter clockwise. Do not exceed half full. This is easily observed through the plastic bowl.

## SECTION III

### MAINTENANCE INSTRUCTIONS

#### 3-1 GENERAL

This section contains instructions for maintenance of the BLAST-IT-ALL blast cleaning and peening machine.

#### 3-2 PERIODIC MAINTENANCE.

To keep the BIA blast cleaning machine functioning properly, the following procedures should be performed at the recommended intervals:

##### A. After each use:

1. Check air intake ducts for obstructions (ducts should be open).
2. Empty filter bag. The exhaust bag is one of the most important items in the correct and proper functioning of the machine. The exhaust bag must be kept clean at all times. How to keep the bag clean depends on the type of peening operations. When cleaning extremely dirty parts, it may be necessary to clean bag in less than one hour. Other types of operations may require bag cleaning only once a day. Clean the exhaust bag by opening the zipper located in bottom of the bag. Empty by-products, turn bag inside out and shake thoroughly. Periodic washing is suggested to reopen the porosity of the cloth. The amount of washing depends on the type of operation.

##### B. Daily:

1. Open separator door, take out screen basket, clean, and reinstall.
2. Drain moisture separator.
3. Check gun parts for wear.

##### C. As required:

1. Wash filter bag.
2. Replace worn gloves.
3. Inspect and replace reclamer and cabinet door gasket.
4. Replace window.

FAULT ISOLATION

TABLE IV-1

<u>SYMPTOM</u>	<u>PROBABLE CAUSE</u>	<u>SOLUTION</u>
Fogging Cabinet	<ol style="list-style-type: none"><li>1. Reclaim not operating.</li><li>2. Dirty dust bag.</li><li>3. Fan rotation wrong.</li></ol>	<p>Activate reclaimer switch.</p> <p>Clean bag. (see 3-2-A)</p> <p>Check (see 2-2-D)</p>
Abnormal Media Consumption	<ol style="list-style-type: none"><li>1. Reclaimer fill door.<ol style="list-style-type: none"><li>A. Not in place.</li><li>B. Gasket worn.</li></ol></li><li>2. Improper exhaust hook-up.</li></ol>	<p>Install fill door. Replace as required.</p> <p>If the bag is not used and reclaim is exhausted outside without damper, never connect to any other system such as in-plant exhaust, roof vanes, or any system that will reduce the exhaust pressure, as this can effect the operation of the reclaim system and cause good beads to be lost.</p>
Reduction of Cleaning	<ol style="list-style-type: none"><li>1. Low bead level.</li><li>2. Reduced air pressure.</li><li>3. Media hose clogged.</li><li>4. Dirty exhaust bag.</li><li>5. Wet media.</li><li>6. Worn gun parts.</li></ol>	<p>Fill as required.</p> <p>Check air system set for blast at 80 psi.</p> <p>Inspect hose for worn places or soft spots.</p> <p>Clean bag.</p> <p>Purge system and refill.</p> <p>Inspect and replace or adjust as required.</p>

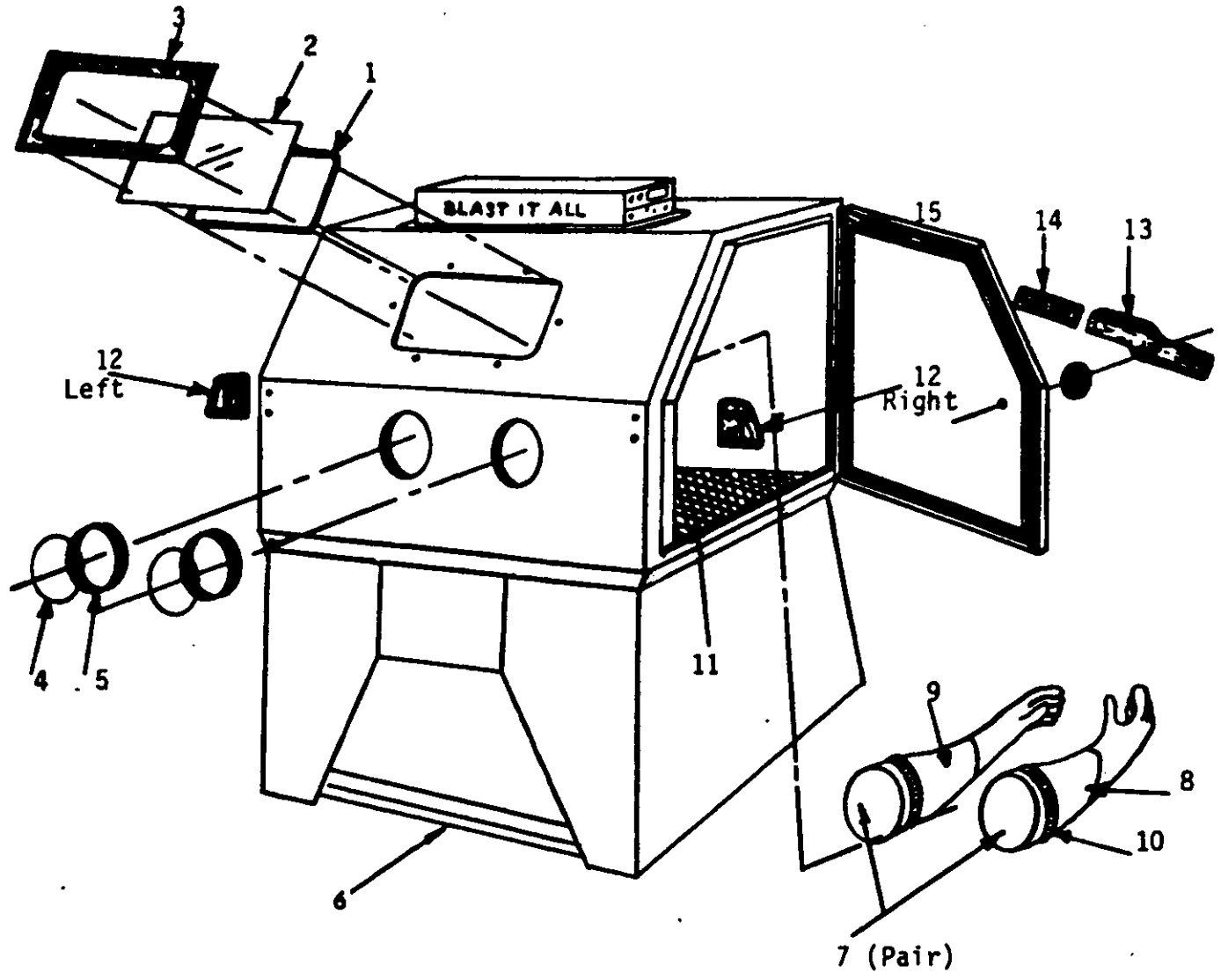
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DATE 7-9-87

M121

DESCRIPTION

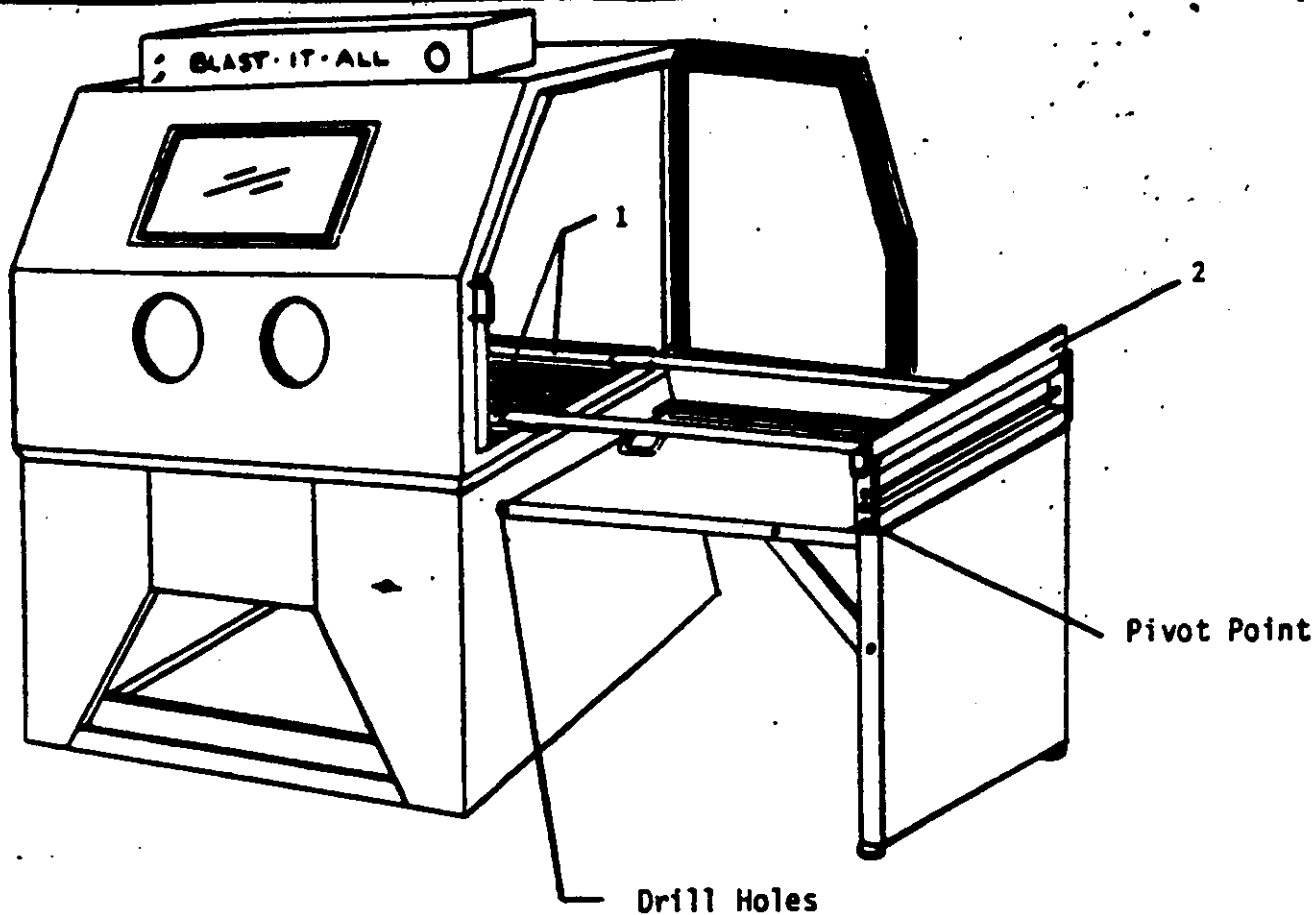
Standard Machine Replacement Parts

BLAST-IT-ALL, inc.



Item	Part No.	Description
1	23-059	Window Seal
2	23-050	Window
3	23-053	Window Frame
4	22-102	Arm Hole Trim (Pair)
5	22-101	Arm Hole Gasket
6	15-729	Foot Treadle
7	22-070	Gloves (One Pair)
8	22-078	Glove (Right)
9	22-077	Glove (Left)
10	21-038	Clamp
11	----	Grate (Specify Machine Model #)
12	15-730	Door Striker
13	15-719	Door Cam
14	15-720	Door Cam Rubber Grip
15	24-025	Door Gasket

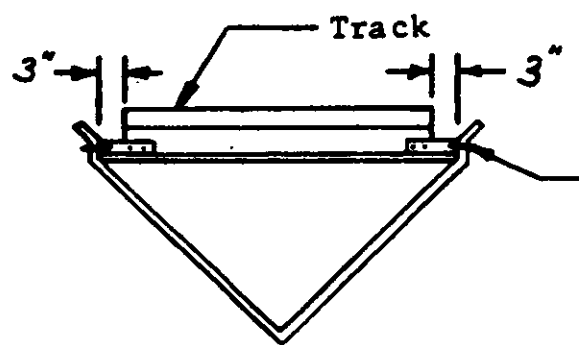
NOTE: When ordering, give Model #, Part #, and Description



Item No.	Machine Model Number				Description
	3636	4426	4836, 4848	5542	
1	17-111	17-112	17-113	17-114	Inside Track
2	17-110	17-110	17-110	17-110	Outside Track

**INSTALLATION INSTRUCTIONS**

1. Locate and install the inside tracks, per figure below. Center to center distance is 18 1/2".



Drill 1/4" Ø holes and assembly with 1/4" bolts furnished.

2. Locate and install outside table and track per drawing M11015.
  - A. Set table on either side of machine desired.
  - B. Drill two (2) 1/2" Ø holes in side of machine skirt to receive 1/2" Ø bolts furnished.
  - C. Flip track into machine.
  - D. Select (1) of (3) pivot holes in table assembly, that will allow the outside track to set level.
  - E. For minor height adjustments, use bolt levelers in bottom of table leg.
3. For turntable assembly see drawing M11016.



DESCRIPTION

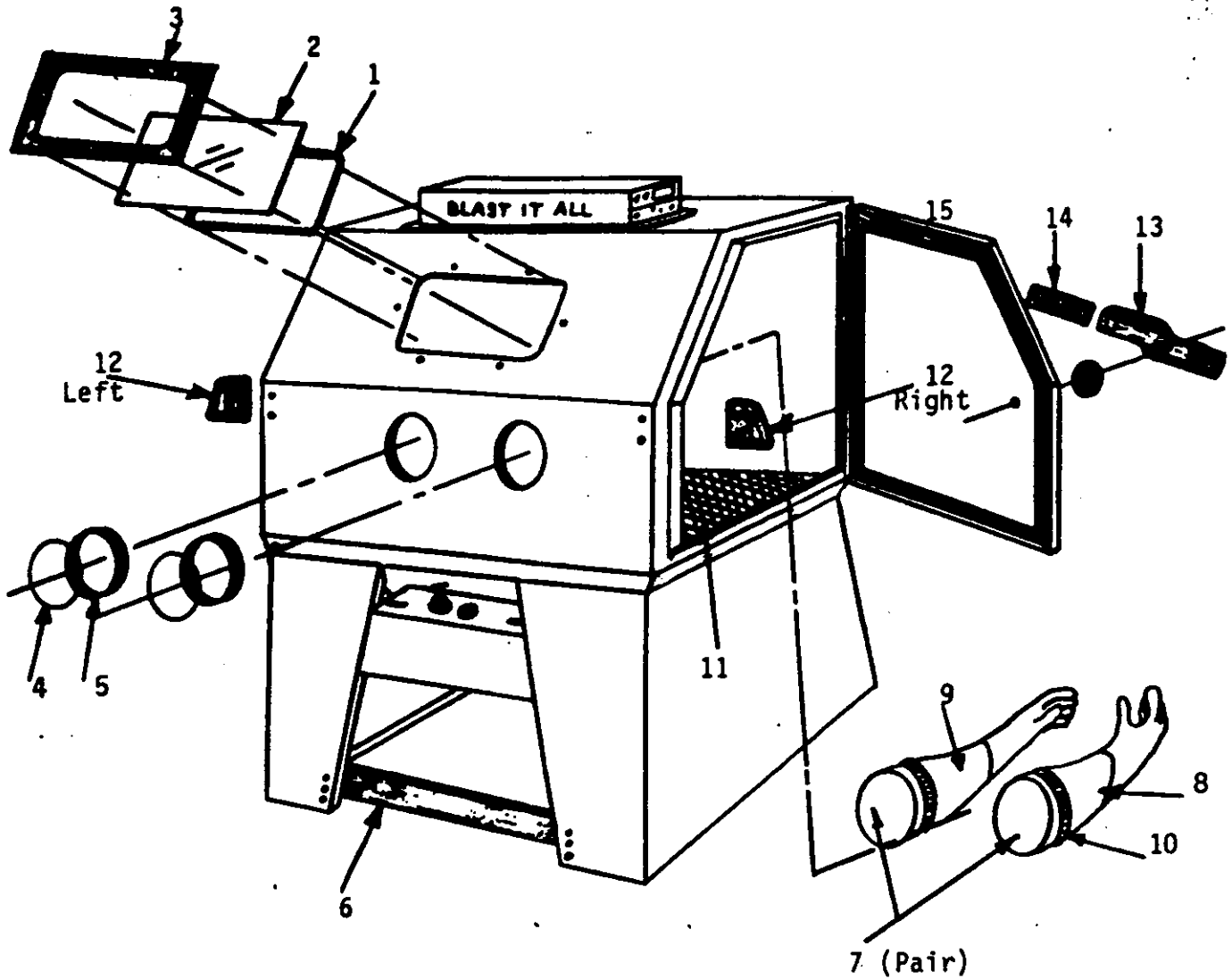
Standard Machine Replacement Parts

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DATE 3-13-85

DRAWING NO.

M117



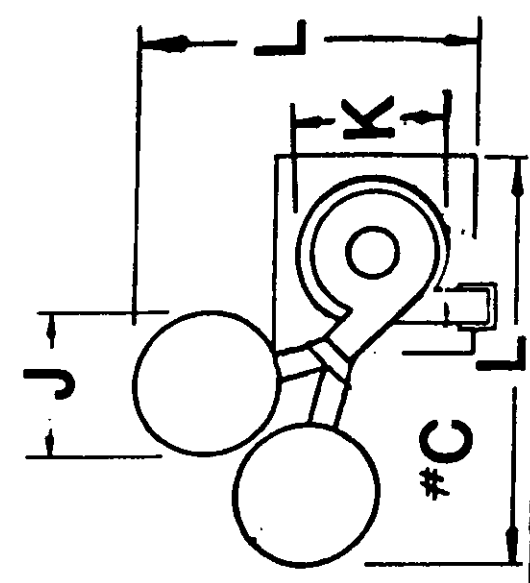
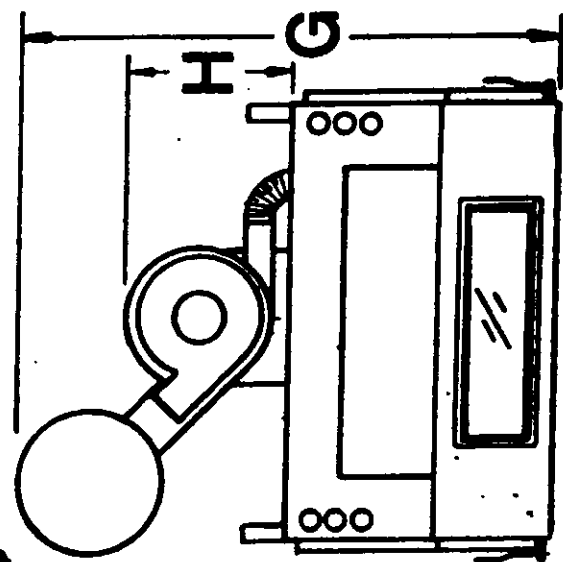
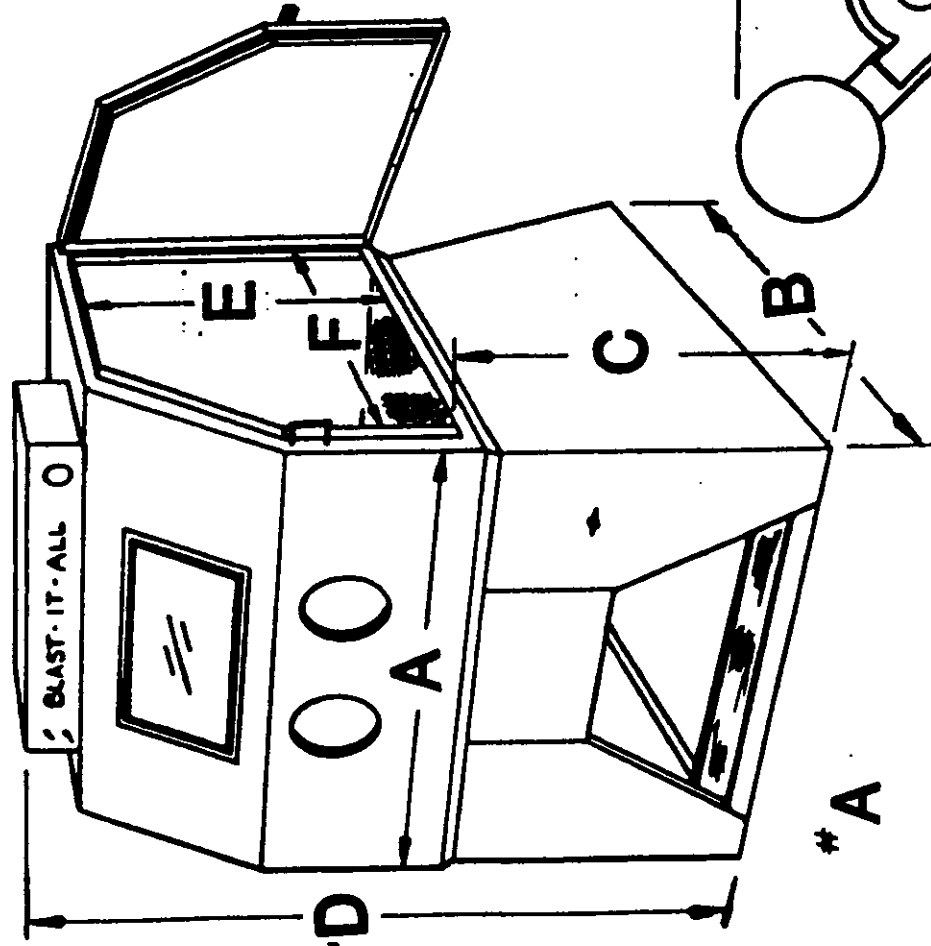
Item	Part No.	Description
1	23-059	Window Seal
2	23-050	Window
3	23-053	Window Frame
4	22-102	Arm Hole Trim (Pair)
5	22-101	Arm Hole Gasket
6	15-729	Foot Treadle
7	22-070	Gloves (One Pair)
8	22-078	Glove (Right)
9	22-077	Glove (Left)
10	21-038	Clamp
11	----	Grate (Specify Machine Model #)
12	15-730	Door Striker
13	15-719	Door Cam
14	15-720	Door Cam Rubber Grip
15	24-025	Door Gasket

NOTE: When ordering, give Model #, Part #, and Description

BLAST-IT-ALL, inc.

Machine	A	B	C	D	E	F	G	H	J	K	L
3620-4	36	31	34½	64½	28½	17	49	17	16	14	--
3620-7	36	31	34½	64½	28½	17	49	21	16	18	--
3636-4	36	40	28	64½	35	33	65	17	16	14	--
3636-7	36	40	28	64½	35	33	65	21	16	18	--
3636-9*	36	40	28	64½	35	33	--	--	16	24	48
4426-4	44	34	34½	64½	28½	23	55	17	16	14	--
4426-7	44	34	34½	64½	28½	23	55	21	16	18	--
4426-9*	44	34	34½	64½	28½	23	--	--	16	14	48
4833-4	48	33½	34½	64½	28½	30	62	17	16	14	--
4833-7	48	33½	34½	64½	28½	30	62	21	16	18	--
4833-9*	48	33½	34½	64½	28½	30	--	--	16	24	48
4836-4	48	35½	31	64½	32	33	65	17	16	14	--
4836-7	48	35½	31	64½	32	33	65	21	16	18	--
4836-9*	48	35½	31	64½	32	33	--	--	16	24	48
4848-7	48	47½	31	64½	32	45	77	21	16	18	--
4848-9*	48	47½	31	64½	32	45	--	--	16	24	48
5542-7	55	40½	34½	72	35½	39	71	21	16	18	--
5542-9*	55	40½	34½	72	35½	39	--	--	16	24	48

\*900 CFM Free Standing Rec.  
2 Dust Bags  
See Foot Print #C



#B

#A

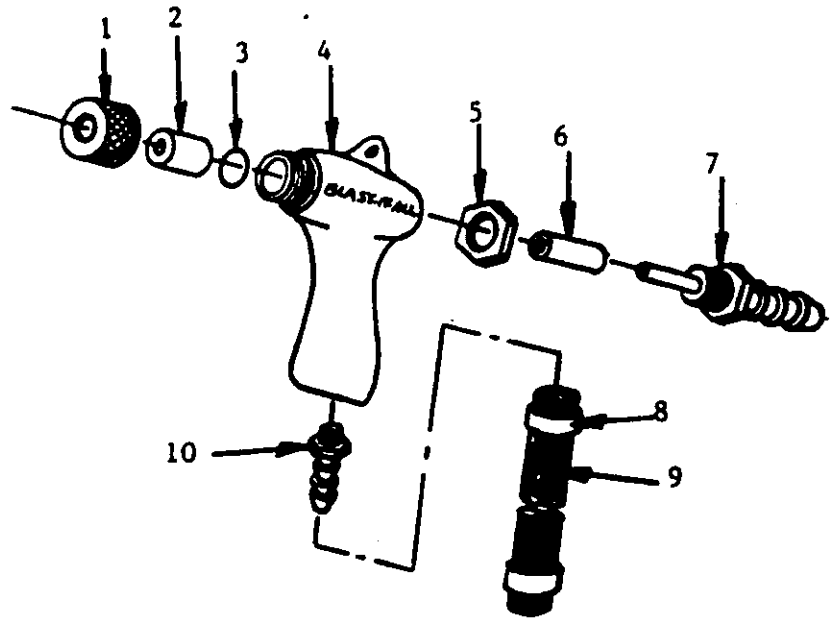
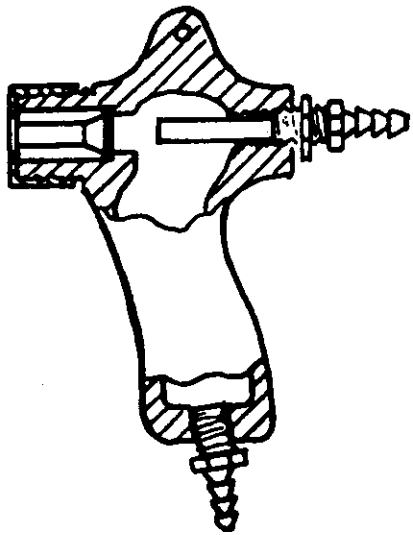
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DRAWING NO  
M9009

DRAWN BY TMS  
DATE 10/1/84

DESCRIPTION  
Standard Blast Gun Assembly

BLAST-IT-ALL, inc.



Item #	Part #	Description
1	20-054	Nozzle Nut
1	20-055	Nozzle Nut (Wide Spray)
2	20-074	Nozzle Ceramic, 1/4" I.D., Size 4
2	20-075	Nozzle Ceramic, 5/16" I.D., Size 5
2	20-076	Nozzle Ceramic, 3/8" I.D., Size 6
2	20-077	Nozzle Ceramic, 7/16" I.D., Size 7
2	20-078	Nozzle Ceramic, 1/2" I.D., Size 8
2	20-084	Nozzle Carbide, 1/4" I.D., Size 4
2	20-085	Nozzle Carbide, 5/16" I.D., Size 5
2	20-086	Nozzle Carbide, 3/8" I.D., Size 6
2	20-087	Nozzle Carbide, 7/16" I.D., Size 7
2	20-088	Nozzle Carbide, 1/2" I.D., Size 8
2	20-096	Nozzle Boron Carbide, 3/8" I.D., Size 6
2	20-099	Nozzle Boron Carbide (Wide Spray), 3/8" I.D., Size 6
3	20-053	"O" Ring - Nozzle Sealing
4	20-040	Gun - Body Only
5	20-052	Locknut Orifice
6	20-063	Rubber Cover
7	20-064	Orifice, Air 4/32" I.D., Size 4
7	20-065	Orifice, Air 5/32" I.D., Size 5
7	20-066	Orifice, Air 6/32" I.D., Size 6
7	20-067	Orifice, Air 7/32" I.D., Size 7
7	20-068	Orifice, Air 8/32" I.D., Size 8
8	21-031	Clamp
9	18-084	Hose, Media 1/2" I.D. (Specify Length)
10	14-304	Fitting - Hose to Gun
---	20-041	Gun, Standard Complete with Ceramic Nozzle
---	20-042	Gun, Standard Complete with Carbide Nozzle
---	20-044	Gun, Standard Complete less Nozzle (Specify Orifice Size)

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

# BLAST-IT-ALL, inc.

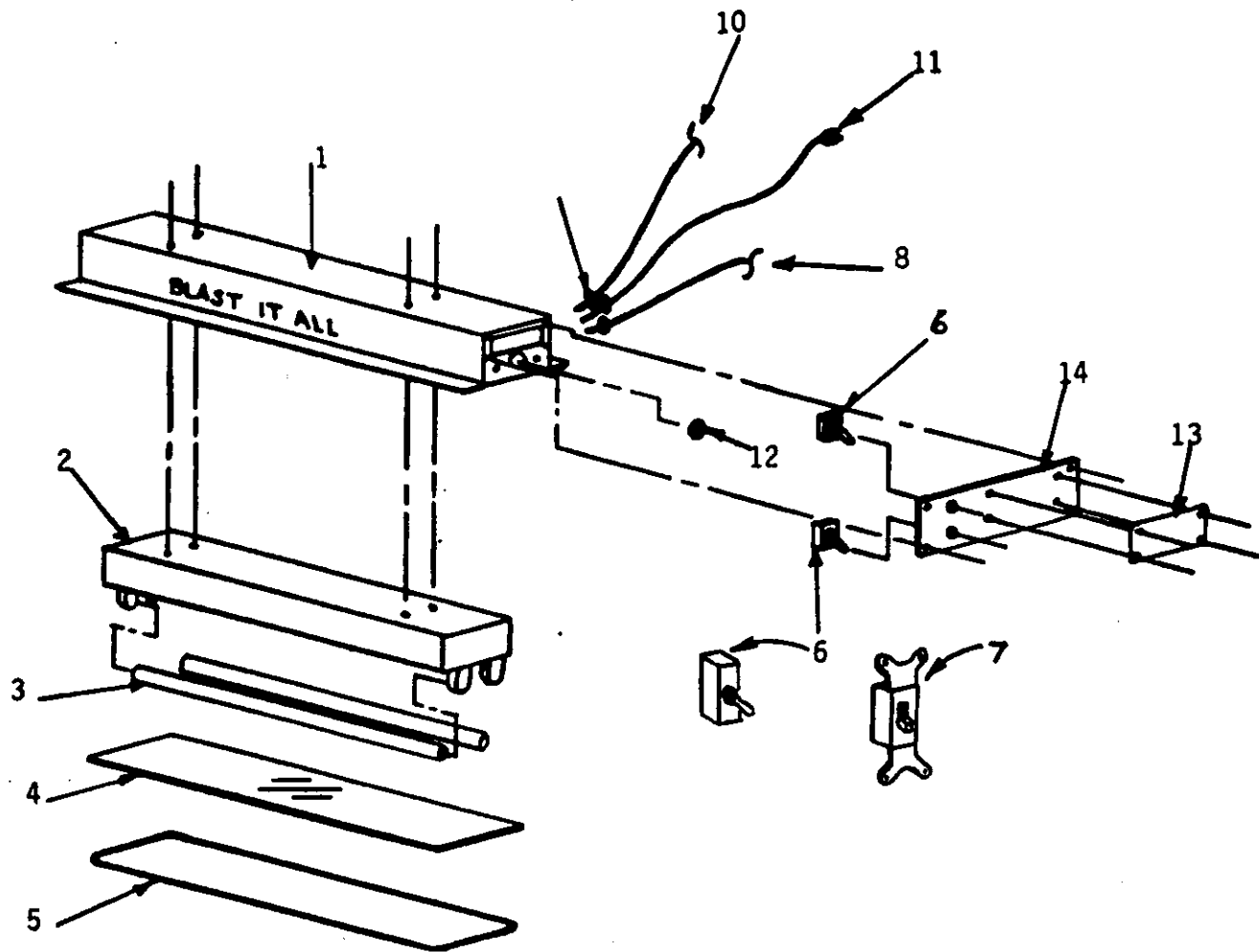
DESCRIPTION

Standard Machine Light Assembly

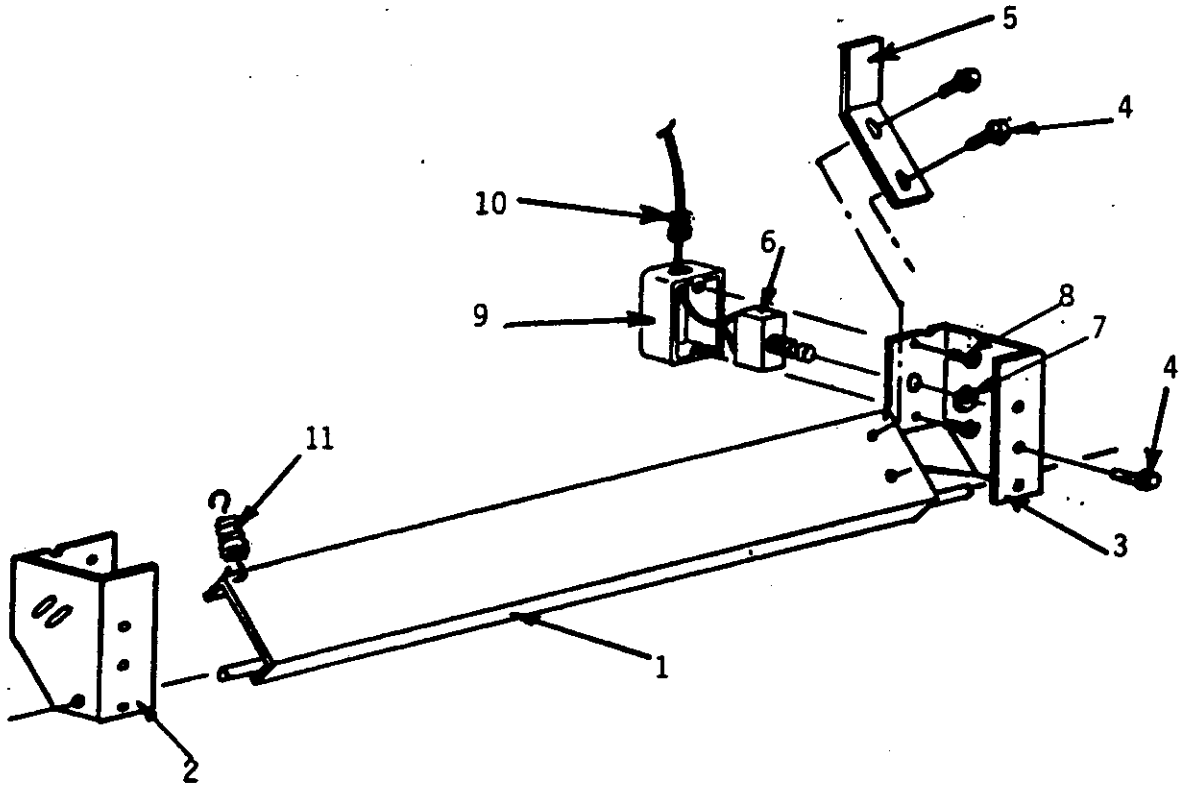
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## M8009



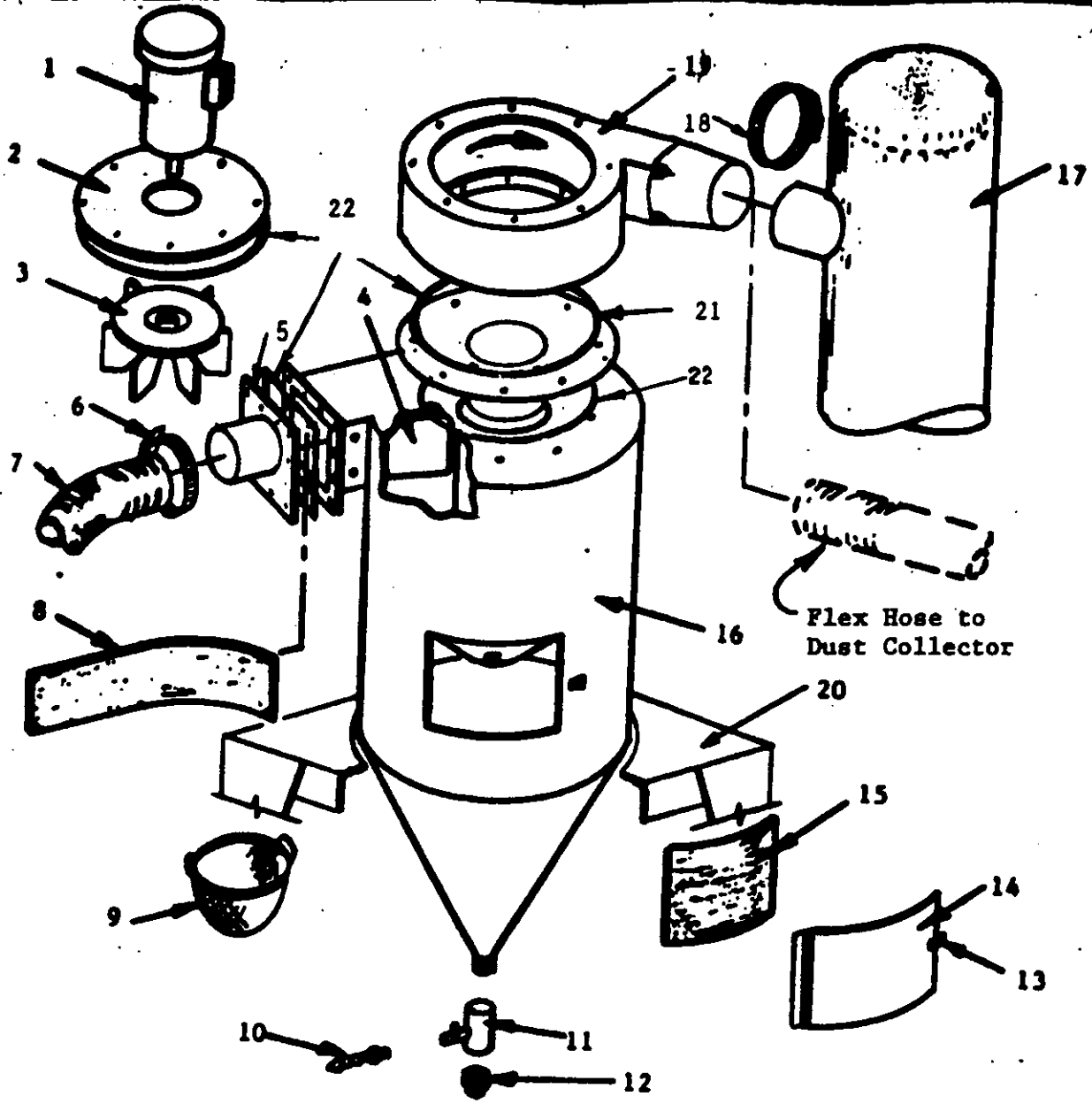
Item	Part No.	Description
1	13-648	Light Box
2	13-533	Fluorescent Fixture
3	13-534	24" Fluorescent Tube
4	23-058	Window
5	23-059	Window Seal
6	13-510	Switch (BEFORE 1986)
7	13-655	Switch (AFTER 1986)
8	13-555	S.J. Cord, 2 Wire (Specify Length)
9	13-605	Heyco Connector
10	13-552	S.J. Cord, 3 Wire (Specify Length)
11	13-550	Power Cord, 3 Wire, 6" Long
12	13-620	7/8" Knock Out Plug
13	---	Serial Number Plate
14	13-649	Switch Mounting Plate
14	13-649-1	" " " (AFTER 1986)



Item	Part No.	Description
1	A313(1)	Foot Treadle (Only)
2	A6277(1)	Left Bracket
3	A6277(2)	Right Bracket
4	30-111	1/4"-20 x 1/2" Self Tapper
5	A313(2)	Switch Bar
6	13-512	Switch
7	---	Nut (Furnished with switch)
8	30-617	#6-32 x 1/2" Sloted Head Screw
9	13-570	2 x 4 Handy Box
10	13-605	Haco Connector
11	15-721	Spring

DRAWING NO. **M1110**  
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 DATE **3-13-85**

DESCRIPTION  
 Reclaim Separator



**BLAST-IT-ALL, inc.**

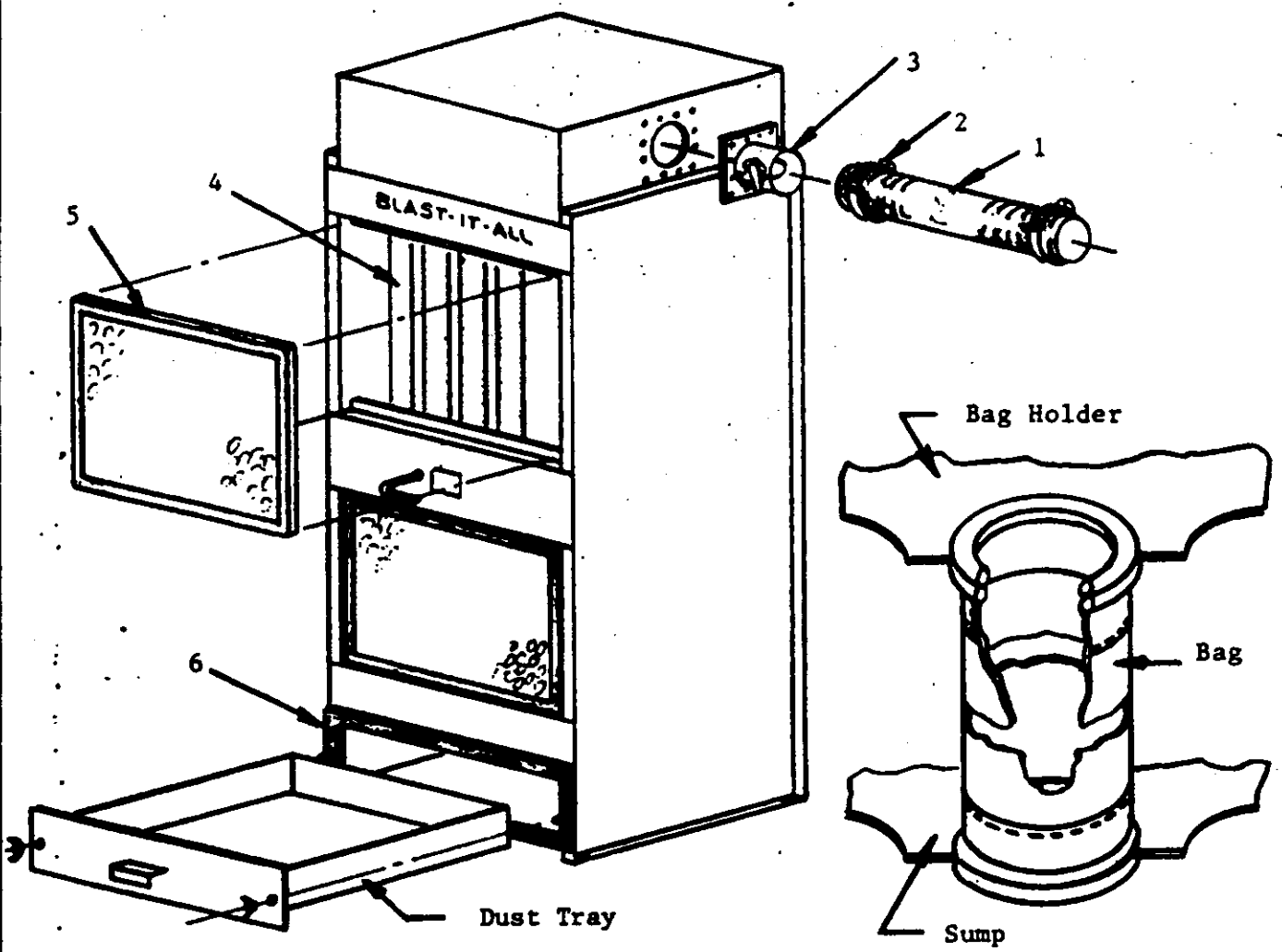
Item #	400 CFM	700 CFM	900 CFM	Description
1	13-400	13-700	13-900	Motor
2	11-420	11-720	11-920	Motor Plate
3	11-418	11-718	11-918	Blade
4	11-428	11-728	11-928	Baffel
5	11-405	11-705	11-905	Inlet Adaptor
6	21-034	21-035	21-035	Clamp
7	19-092	19-092	19-094	Flex Hose
8	11-417	11-717	11-917	Wear Plate
9	11-406	11-706	11-906	Screen Basket
10	14-301	14-301	14-301	Fitting
11	20-100	20-100	20-100	Media Valve (with Plug & Fitting)
12	20-101	20-101	20-101	Plug
13	15-728	15-728	15-728	Door Latch & Catch
14	11-402	11-702	11-902	Door and Gasket
15	11-403	11-703	11-903	Gasket (only)
16	11-401	11-701	11-901	Reclaimer Housing
17	11-415	11-715	11-915	Bag
18	21-035	21-036	21-037	Clamp
19	11-416	11-716	11-916	Blower Housing
20	11-407	11-707	11-907	Stand
21	11-431	11-731	11-931	Inner Vacuum Tube
22	24-030	24-030	24-030	Putty Tape

DRAWING NO  
M2056

DRAWN BY TMS  
DATE 10/1/84

DESCRIPTION  
Standard Push-In Dust Collector

BLAST-IT-ALL, inc.



**NOTE:**

BLAST-IT-ALL's specially designed tubular dust bag is installed by pushing end of bag into hole far enough to allow springs to snap into place. The bags fit extremely tight to form a perfect filtering media to control dust leakage.

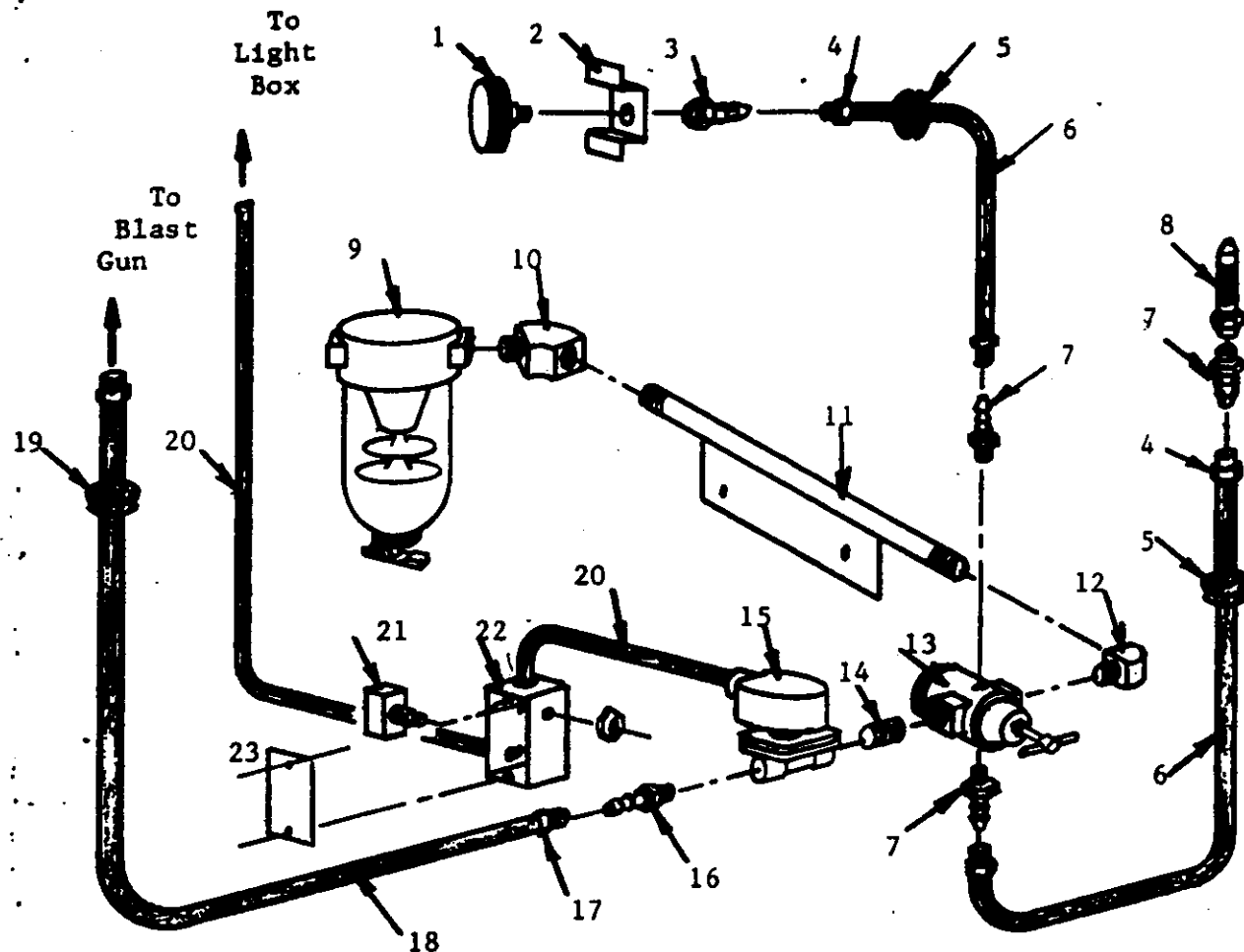
**\*CAUTION:**

Do not use a sharp instrument to force snapsprings into hole. Install one bag at a time starting with the rear halves and working forward.

Item #	400 CFM	700 CFM	900 CFM	Description
1	19-094	19-096	19-097	Flex Hose
2	21-035	21-036	21-037	Clamp
3	19-303	19-300	19-302	Inlet Damper
4	11-364 (18)	11-364 (30)	11-364 (42)	Bag
5	19-301	19-301	19-301	Filter
6	24-025	24-025	24-025	Gasket (Specify Length)

## Standard Machine Air Controls

BLAST-IT-ALL, inc.



Item #	Part #	Description
1	16-821	Air Gauge
2	16-820	Air Gauge Mounting Bracket
3	14-315	1/4" Hose x 1/4" FPT Fitting
4	21-030	1/2" Clamp
5	24-052	Rubber Grommet for 1/4" Hose
6	18-074	1/4" Air Hose (Specify Length)
7	14-313	1/4" Hose x 1/4" MPT Fitting
8	16-822	Blow-Off Nozzle
9	16-814	Air Filter
10	14-333	3/8" x 45° Street Ell
11	16-835	Air Pipe (Specify Model #)
12	14-331	3/8" x 90° Street Ell
13	16-813	Air Regulator
14	14-322	3/8" Close Nipple
15	13-513	Solenoid
16	14-304	1/2" Hose to 3/8" MPT Fitting
17	21-031	1" Clamp
18	18-076	1/2" Air Hose (Specify Length)
19	24-050	Rubber Grommet for 1/2" Hose
20	13-555	2 Wire, 14 Gauge S.J. Cord (Specify Length)
21	13-570	2" x 4" Electric Junction Box
22	13-512	Foot Control Switch
23	13-571	2" x 4" Electric Junction Box Cover

**NOTE:** When ordering, give Model #, Part #, & Description.



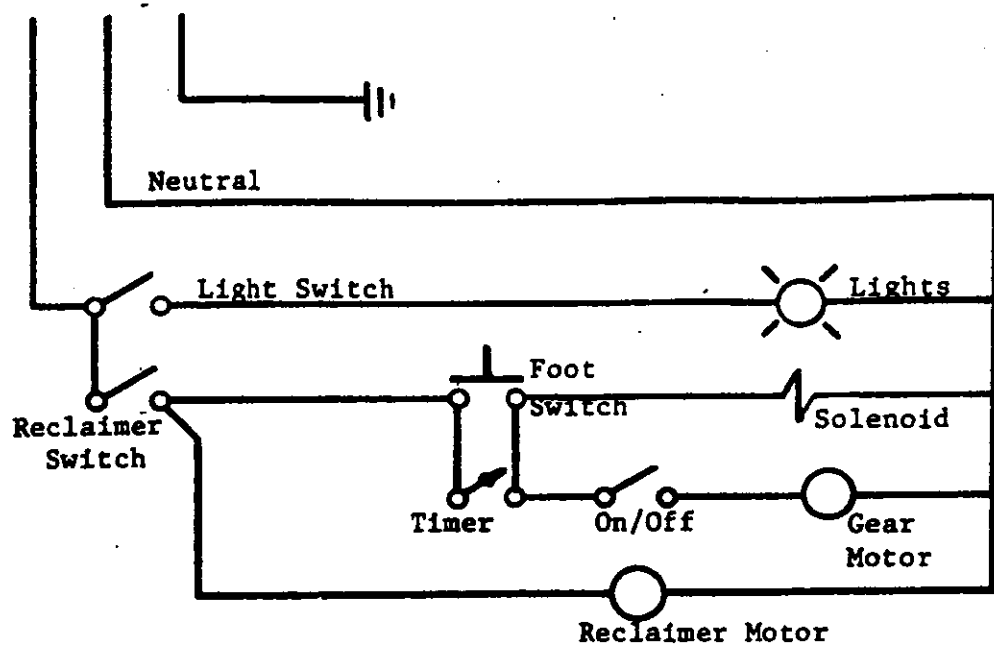
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M5008

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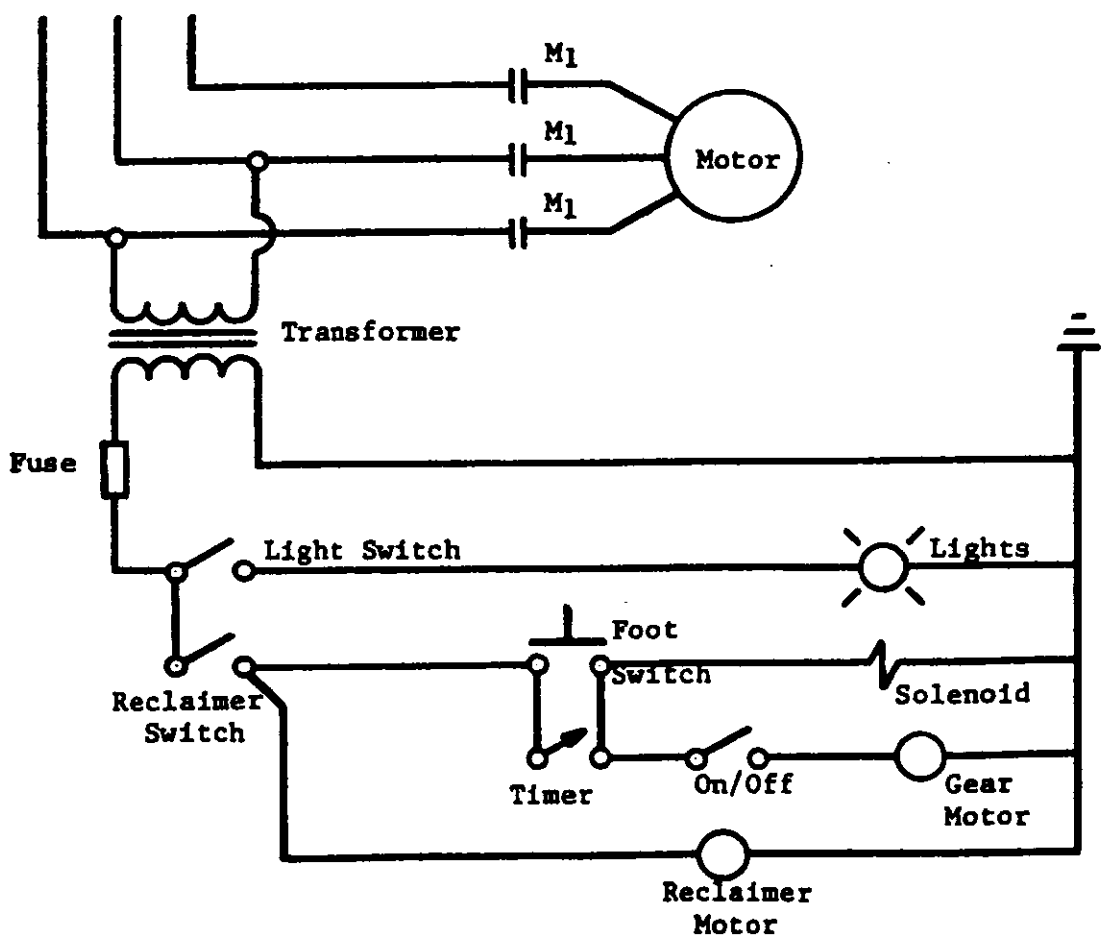
DESCRIPTION  
Standard Machine Wiring  
with 2 gallon Tumble Basket

BLAST-IT-ALL, inc.

120 Volts  
1 Phase Power



220 Volts  
3 Phase Power



DESCRIPTION

Standard Machine Wiring

DRAWN BY TMS

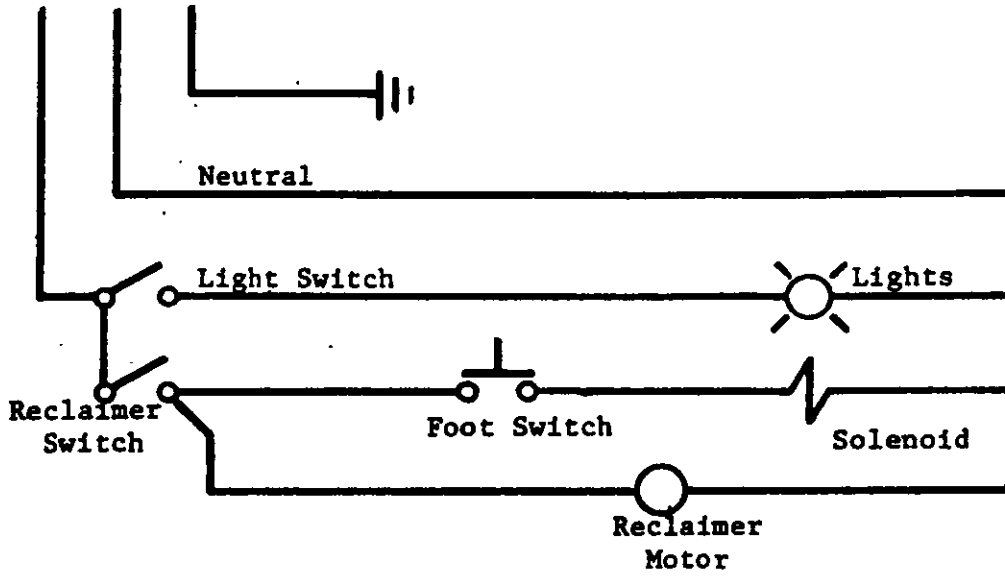
DATE 10/1/84

DRAWING NO.

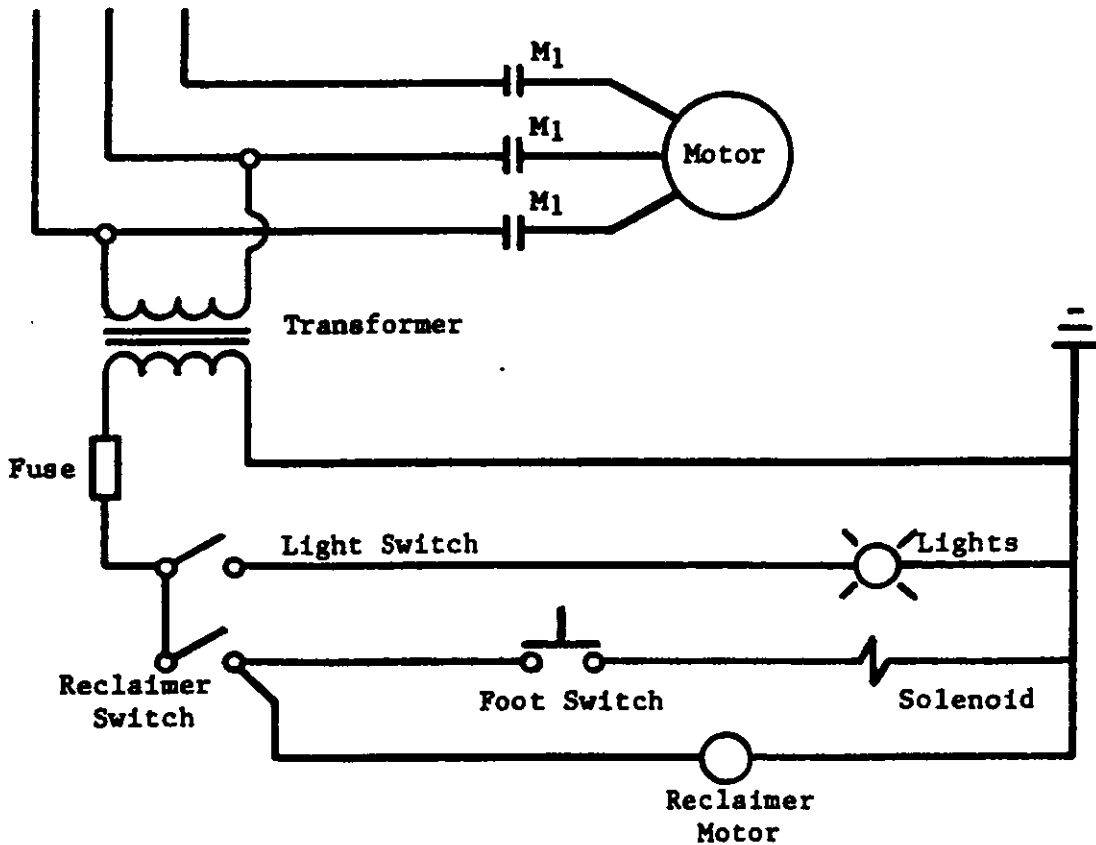
M5007

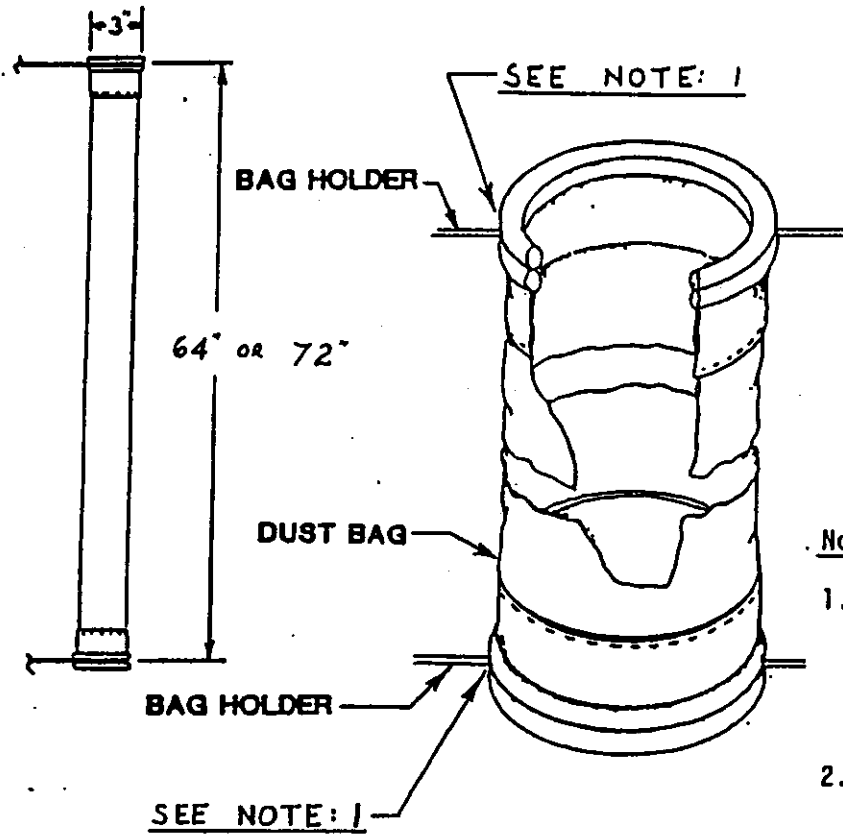
BLAST-IT-ALL, INC.

120 Volts  
1 Phase Power



220 Volts  
3 Phase Power

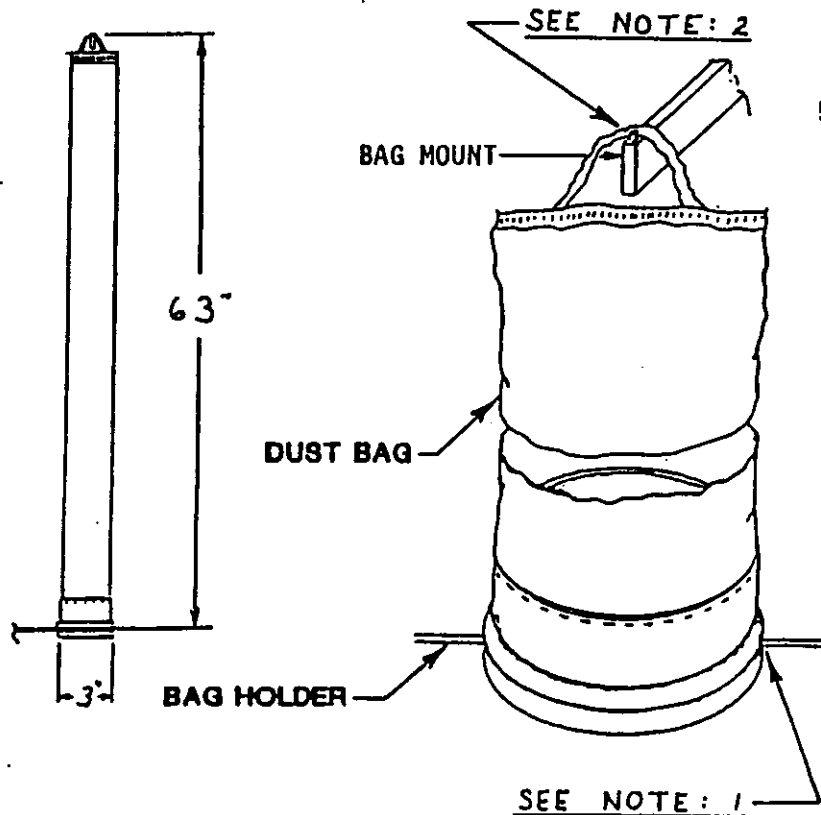




SIZE	PART #
64"	000561
72"	000562

Notes:

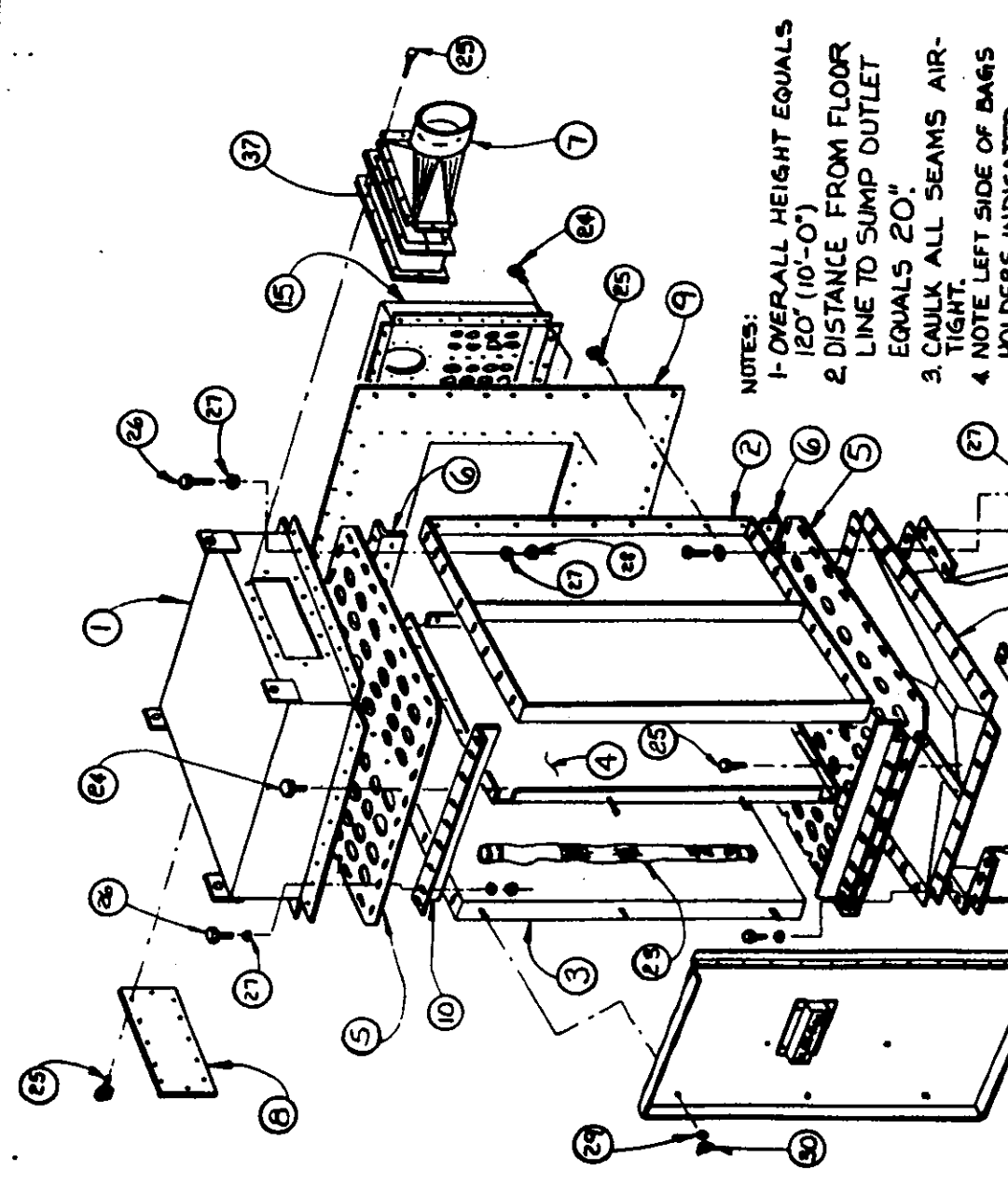
1. Blast-It-All's specially designed tubular dust bag is installed by pushing end of bag into hole far enough to allow springs to snap into place.
2. Hook loop ring on top of dust bag over bag mount.
3. **CAUTION:** Do not use a sharp instrument to force dust bag into position.
4. Install one bag at a time starting with the rear halves and working forward.
5. The bags fit extremely tight to form a perfect filtering media to control dust leakage.



SIZE	PART #
63"	000372

# B2045

ITEM	DESCRIPTION	PART NO.
1	TOP	A2267
2	RIGHT SIDE	A2270
3	LEFT SIDE	A2270
4	DIVIDER WALL	A2270
5	BAGS HOLDER	A2267
6	BAGS HOLDER	A2267
7	REAR ANGLE	A2267
8	INLET FLANGE	A2267
9	INSPECTION COVER	A2267
10	BACK PANEL	A2267
11	DOOR ANGLE	A2267
12	PLENUM DIVIDER	A2270
13	SUMP ASSY	A2271
14	STAND	A2271
15	DOOR ASSY	A2271
16	PLENUM	A2268
17	AUTO BAG SHAKER	A2260
18	MANUAL BAG SHAKER	A2052
19	WEATHER HOOD	A2267
20	SHAKER AIR CONTROLS	A2267
21	SHAKER INSTRUMENT	A2267
22	BLOWER ADAPTOR	A2267
23	BLOWER ASSY	A2065
24	BLOWER ASSY	A2002
25	MOTOR	A2367
26	MOTOR	15-1200
27	MOTOR	15-1200
28	DUST BAGS	11-372
29	DUST BAGS	11-372
30	SELF TAPPER, 1/4-18 x 1/2	30-615
31	SELF TAPPER, 1/4-20 x 3/4	30-112
32	BOLT, 3/4-16 x 1"	30-114
33	WASHER, 3/4"	30-603
34	WEL NUT, 3/4-18	30-504
35	WASHER, 3/4"	30-601
36	WASHER, 3/4"	30-510
37	HEX NUT, 1/2-20	30-502
38	BOLT, 1/2-20 x 1"	30-106



NOTES:

- 1-OVERALL HEIGHT EQUALS 120" (10'-0")
- 2-DISTANCE FROM FLOOR LINE TO SUMP OUTLET EQUALS 20"
- 3-CAULK ALL SEAMS AIR-TIGHT.
- 4-NOTE LEFT SIDE OF BAGS HOLDERS INDICATED BY "V" NOTCHES
- 5-CUSTOM FIT DOOR - DRILL, INSERT, & WELD (6) 1/4-20 x 1" HHCS.

SEE ASS'Y DWG. NO. B2046 FOR REAR VIEW

CONTINUED ON DWG. NO. B2046	
TOLERANCES UNLESS OTHERWISE SPECIFIED	FRACTIONS
DECIMALS	± .005
FRACTIONS	± .005
ANGLES	± .01
WELDS	AS SHOWN
FINISH	AS SHOWN
DRILLING	AS SHOWN
THREADS	AS SHOWN

**BLAST-IT-ALL, Inc.**  
 900, 1200, 1800 GPM 8.0.

**B2046**

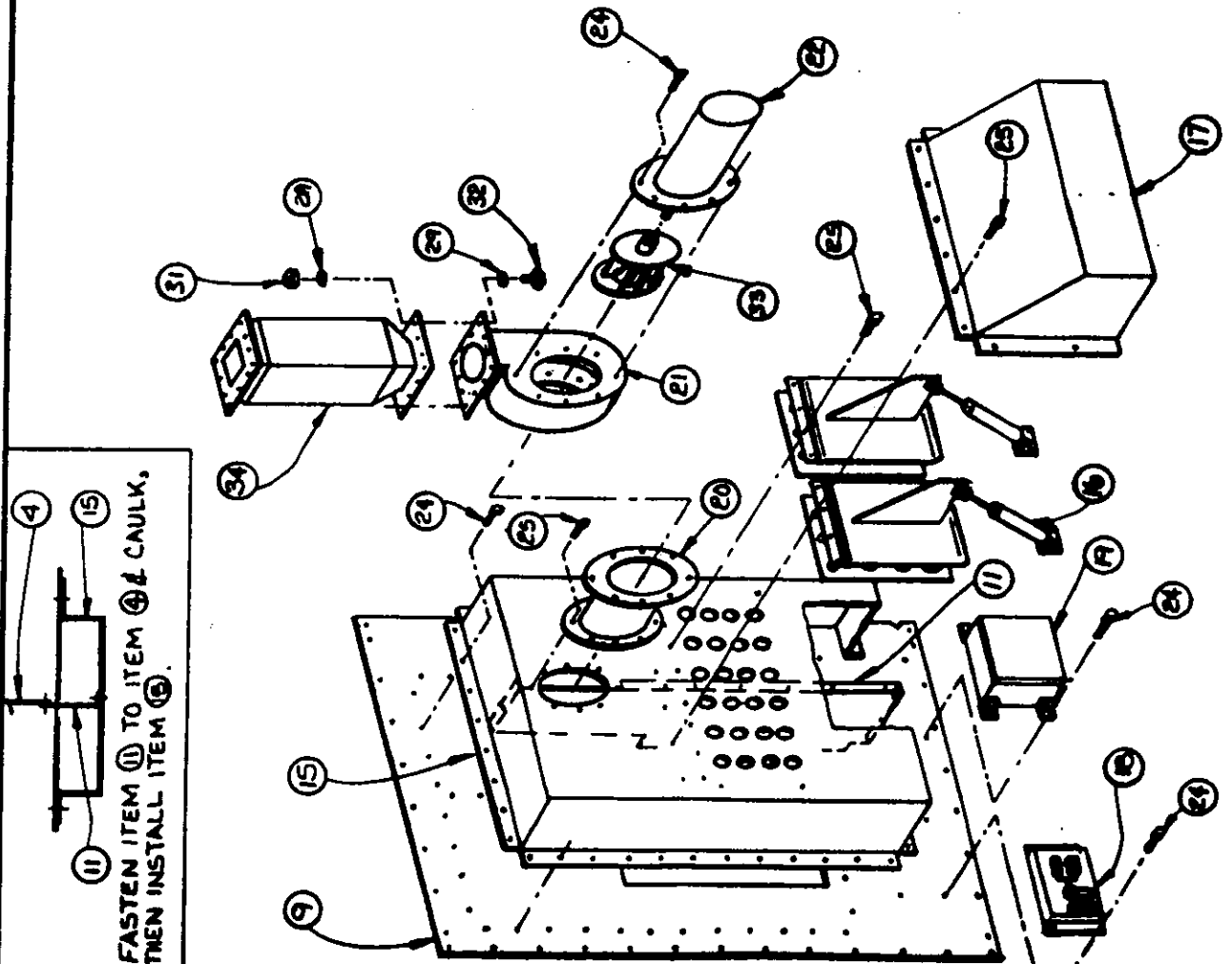
# B2046

ITEM	DESCRIPTION	PART N.O.
33	BLADE	11-918
33	BLADE	11-1218
33	BLADE	11-1818
34	SOUND SUPPRESSOR	A12312
34	SOUND SUPPRESSOR	A12250
34	SOUND SUPPRESSOR	A12250
35	APPROX. WEIGHT (IN LBS)	
36	CUT SHEET	A2284
36	CUT SHEET	A2285
36	CUT SHEET	A2286
37	SPACER	A3520

### NOTES:

- 1 - MAXIMUM D. C. HEIGHT INCLUDING SOUND SUPPRESSOR (MINIMUM IF ORDERED) EQUALS 14" (12"-0").
- 2 - SOUND SUPPRESSOR (ITEM 34) IS OPTIONAL.
- 3 - ITEMS ② & ③ SUPPLIED ONLY WITH AUTO BAG SHAKER.
- 4 - MANUAL SHAKER MUST BE SPECIFIED.
- 5 - CAULK ALL SEAMS.

SEE ASS'Y DWG. NB B2046 FOR FRONT VIEW.

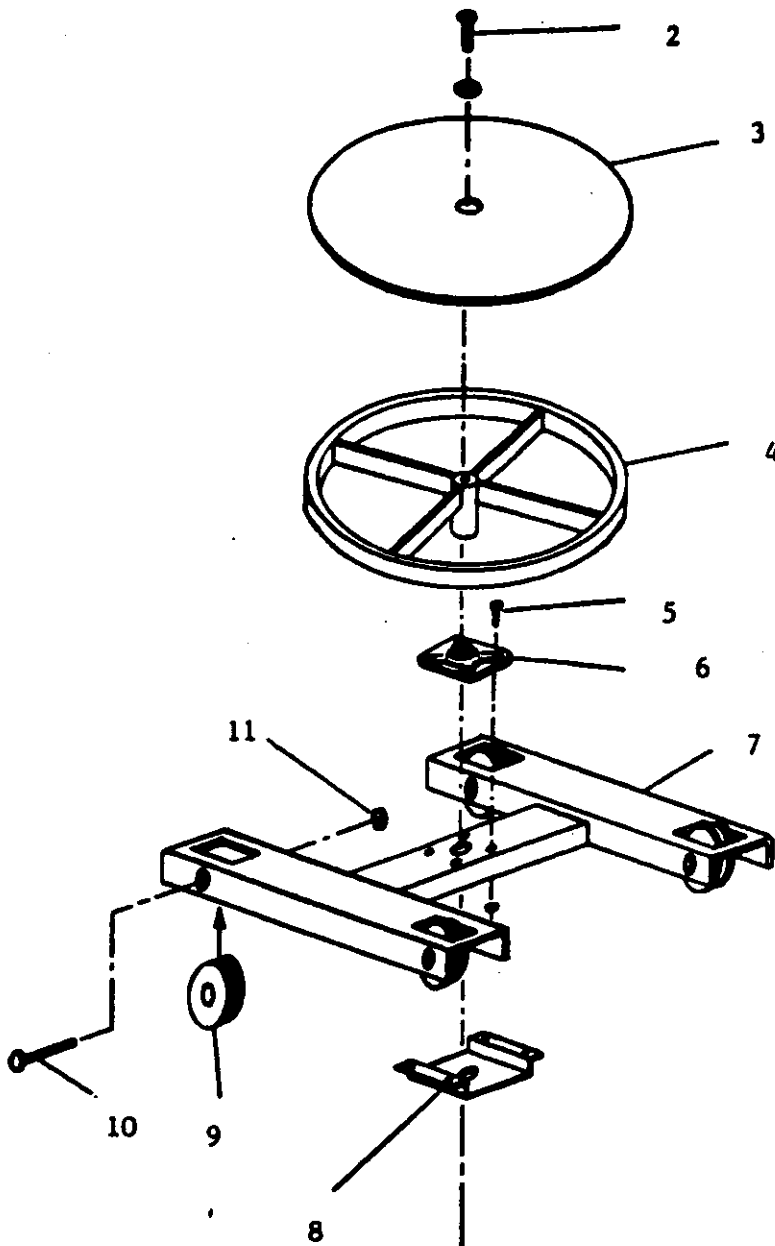


FASTEN ITEM ① TO ITEM ④ & CAULK, THEN INSTALL ITEM ⑤.

TOLERANCES UNLESS OTHERWISE SPECIFIED		RETURNS	
1	DATE	BY	
2			
3			
4			
5			
PROFESSIONAL APPROVAL		DATE	
2/16		10/1/53	
APPROVAL		DATE	

**BLAST-IT-ALL, INC.**  
 900, 1200, & 1000 RPM D.G.

NAME: NONE  
 DATE: 10/1/53  
 VALUE: \$2046



Item	20" dia.	24" dia.	30" dia.	Description
1	A-11026	A-11027	A-11028	Complete Assembly
2	30-114	30-114	30-114	5/16" x 1" Bolt & Washer
3	A11026-20	A11027-24	A11028-30	Turntable Top
4	A11026-20A	A11027-24A	A11028-30A	Turntable Base
5	30-123	30-123	30-123	3/8" x 1 1/2" Bolt & Nut
6	15-920	15-920	15-920	1" 4-Bolt Bearing
7	17-123	17-123	17-123	Cart
8	15-919	15-919	15-919	Bearing Support
9	15-913	15-913	15-913	3" Wheel
10	30-132	30-132	30-132	1/2" x 2 3/4" bolt
11	30-509	30-509	30-509	1/2" Lock Nut

**NOTE:**

Set-in turntable assemblies do not include 9, 10, or 11.

# BLAST-IT-ALL, inc.

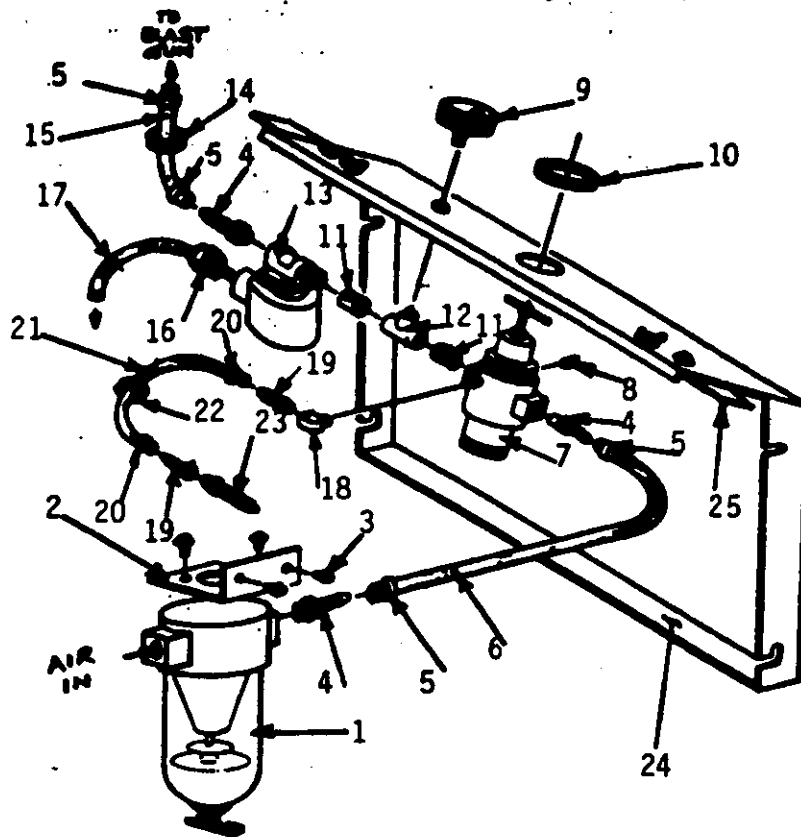
DESCRIPTION

Standard Machine Air Controls

DRAWN BY REH

DATE 3-12-85

DRAWING NO  
**M1119**



Item	Part No.	Description
1	16-814	3/8" Air Filter
2	A-7081	Air Filter Bracket
3	30-111	1/4"-20 x 1/2" Self Tapper
4	14-304	1/2" To 3/8" Barb.
5	21-031	1/2" Hose Clamp
6	18-076	1/2" Hose
7	16-813	3/8" Regulator
8	14-399	1/4" Pipe Plug
9	16-821	Air Gage (1/4" Back Outlet)
10	16-922	Lock Ring
11	14-322	3/8" Close Nipple
12	14-445	3/8" x 1/4" Tee
13	13-513	3/8" Solenoid Air Valve
14	24-050	1/2" Hose Grommet
15	18-076	1/2" Hose
16	13-621	1/2" NPT Liquid Tight Connector
17	13-555	SJ Cord
18	14-327	1/4" Street Ell
19	14-315	1/4" To 1/4" Barb.
20	21-030	1/4" Hose Clamp
21	18-074	1/4" Hose
22	24-052	1/4" Hose Grommet
23	16-822	1/4" Blow-Off Nozzle
24	A-7080	Mounting Panel
25	A-7104	Mounting Panel Latch

PROGRAM

MATERIAL

