

	<p style="text-align: center;">BLAST-IT-ALL® LEADING THE INDUSTRY IN SURFACE PREPARATION EQUIPMENT</p>	<p><b>HESS MANUFACTURING, INC.</b> <i>185 Piper Ln. Salisbury, NC 28147 (800) 535-2612</i></p> <p><small>LIVE CHAT- <a href="http://www.blast-it-all.com">www.blast-it-all.com</a></small></p>
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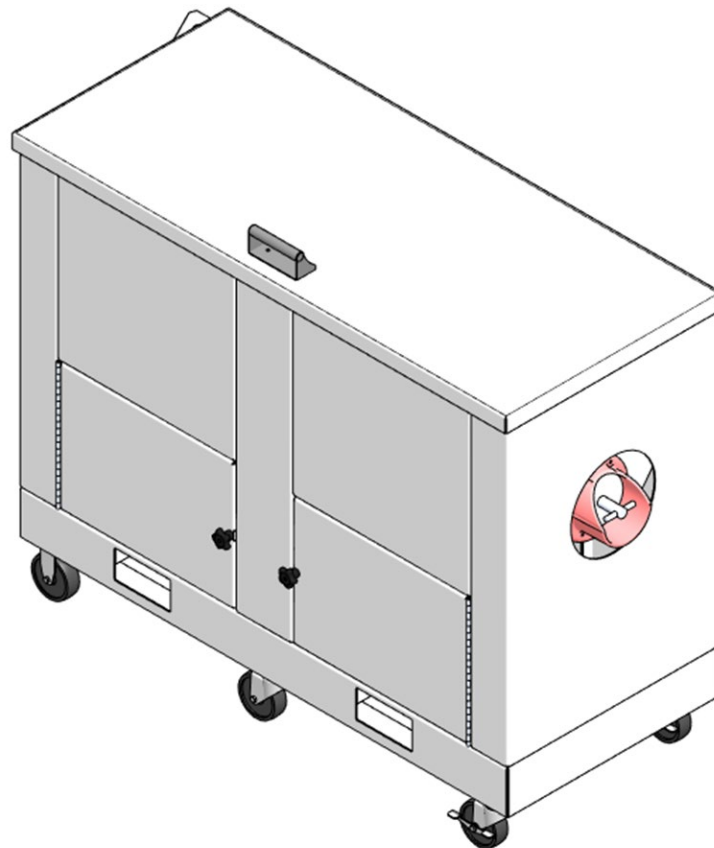


MANUAL DOWNLOAD

VIB-IT-ALL  
PORTABLE VIBRATORY  
DEBURR/FINISHING  
PV-50 (5.0 cu/ft)



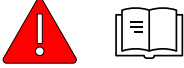





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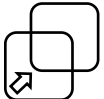

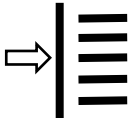


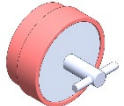

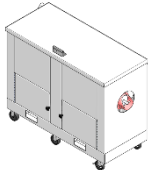
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## SAFETY

	<p style="text-align: center;"><b>*** READ ENTIRE MANUAL BEFORE INSTALATION/OPERATING EQUIPMENT ***</b></p>	
	<p>1. HEARING PROTECTION IS RECOMMENDED WHILE OPERATING MACHINE</p>	
	<p>2. EYE PROTECTION IS RECOMMENDED WHILE OPERATING MACHINE</p>	
	<p>3. PROTECTIVE FOOTWEAR IS RECOMMENDED WHILE OPERATING MACHINE</p>	
		<p>1. Use CAUTION when interacting with any Electrical Components. You MUST incorporate Lock Out / Tag Out Procedures Prior to Servicing Equipment.</p>





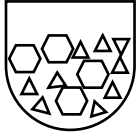
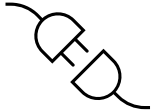
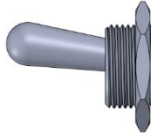
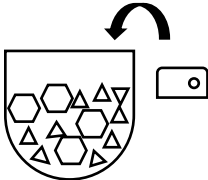
## INSTALLATION :

### VIB-IT-ALL INSTALLATION

	<p><b>*** READ BEFORE OPERATING EQUIPMENT ***</b></p>
	<p>1. Remove all shipping protection Check for any concealed shipping damage, if discovered, report the damage to your freight carrier AS Non-Disclosed Hidden Damage immediately.</p>
	<p>2. CAUTION : Some Items May have SHIFTED or became LOOSE during Shipment</p>
	<p>3. Check to see that Tub Support Springs are aligned on Spring Guides</p>
	<p>4. Make Sure Motor Pulleys and Shaft Pulleys are Aligned and Tight</p>
	<p>5. Make Sure Motor is Secure</p>
	<p>6. Install Belts (4)</p>
	<p>7. Make Sure Discharge Plug is Tight and Secure</p>
	<p>8. Check to Assure Drain Coupling and Hose are Attached to Tub with Loose End in the Solution Tank</p>
	<p>9. <b>NOTICE</b> : All Machines are TEST RUN at the Factory. ANY Residue Remaining is NORMAL</p>


# OPERATION

## VIB-IT-ALL OPERATION

 	<p><b>*** READ BEFORE OPERATING EQUIPMENT ***</b></p>
	<p><b>3. Fill Solution Tank :</b>            Open Access Door and Fill Solution Tank 2/3 Full with Water. Add Compound Solution to your Desired Concentration. It is <b>NOT</b> Recommended to use Rust &amp; Corrosion Stripper, Preventative or Metal Conditioner Solutions in the Solution Tank. Additives in these Solutions could be Non-Compatible with the Tank / Pump Materials.</p>
	<p><b>4. Drain Hose :</b>            Verify that the Drain Hose is in the Solution Tank</p>
	<p><b>3. Add Media :</b>            Fill Tub 2/3 Full with Media            NOTE :            When Using NEW Media, the Solution Tank will Need to be <b>Emptied and Refilled AFTER 2 HOURS</b> of Use as the Media Must be "Broken In" and Considerable Media <b>SLUGE</b> will Accumulate During this Time Period</p>
<p><b>20 AMP</b></p> 	<p><b>4. Plug in Machine :</b>            Plug Unit into 120V Outlet Rated with a <b>MINIMUM 20 AMP Load</b></p>
	<p><b>5. Turn on Motor and PUMP</b>            Expect a Slight Delay before Solution can be Seen Entering the Tub, Then Allow the Solution to Flow for 3 Minutes to Wet the Media</p>
	<p><b>6. Add Parts :</b>            Place Parts to be Processed into the Tub. Ratio may Vary Part to Part, up to 5 Parts Media to 1 Part of Work Pieces. Generally, Ratio should be in the Neighborhood of 3 Parts Media to 1 Part Work Piece.</p> <p style="text-align: center;"><b>**DO NOT OVERLOAD THE MACHINE**</b></p>

## OPERATION

### VIB-IT-ALL OPERATION – CONT'D

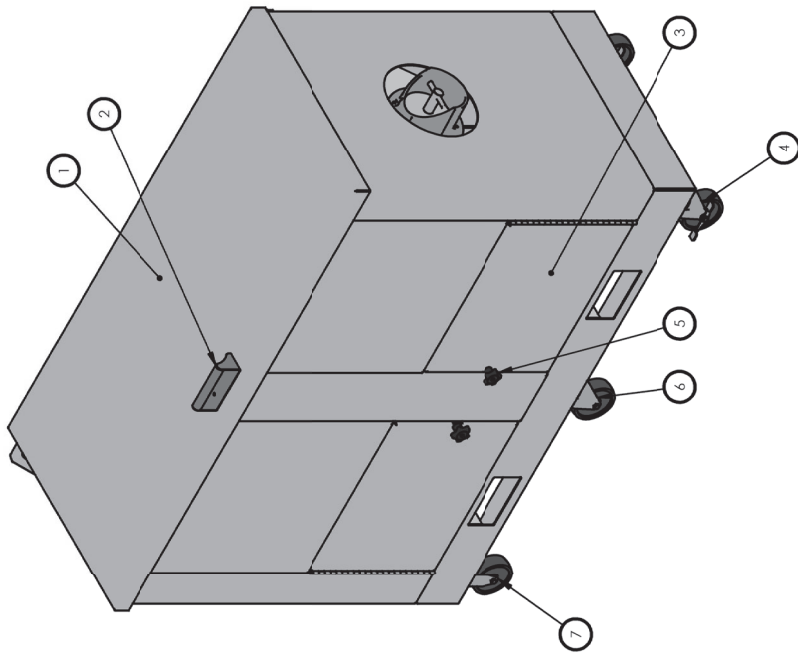
	<p><b>7. Inspection :</b> A Visual Inspection to see if Processing is Completed can be Accomplished by Removing a Part without Turning the Machine Off. You will Find it Easier to Remove Parts with the Machine in Operation as the Vibratory Motion Helps Separate the Parts and Media</p>
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## MAINTENANCE

### VIB-IT-ALL

<b>DAILY</b>	<ol style="list-style-type: none"> <li>1. Empty and Clean the Solution Tank Every 4 Hours to prevent the Sludge of Media and Parts Residue from Damaging the Solution Pump. Compound and Water <b>MUST</b> be Present at <b>ALL</b> Times to Lubricate the Pump. If the Pump does not Pump Solution, Check the Impeller Blades for Clogging.             <ol style="list-style-type: none"> <li>A. Remove 2 Screws on the Inlet Screen</li> <li>B. Remove Screen</li> <li>C. Clean Pump</li> <li>D. Back Flush Pump</li> <li>E. Reinstall Screen and Try Pump Again</li> </ol> </li> <li>2. Empty Solution Tank at the End of the Day. Do <b>Not</b> Let Full Tank Set Overnight</li> <li>3. Pump Clean Water Solution through Pump and Remove from Unit and Let Dry</li> </ol>
<b>WEEKLY</b>	<ol style="list-style-type: none"> <li>1. Lube Bearings Every 40 Hours. Grease Fittings are Provided on Each Flange Bearing Assembly. Relubricate with 1 of the Following Greases or Equivalent :             <ul style="list-style-type: none"> <li>➤ Shell Alvania #2</li> <li>➤ Texaco Multifak #2</li> <li>➤ Sinclair Litholene #2</li> <li>➤ Fiske's # 5433 Lubricant #2 Grade</li> <li>➤ Socony-Mobil Mobilux #2</li> <li>➤ Pure HT #@ E.P.</li> <li>➤ Sun Prestige #41</li> </ul> </li> </ol>
<b>MONTHLY</b>	<ol style="list-style-type: none"> <li>1. Inspect Condition of Belts. If Loose, Remove Belts , Loosen Bolts on Motor and Adjust Motor Position. Retighten Bolts and Reinstall Belts</li> <li>2. Inspect Pulleys on the Motor and Shaft to be Sure that they are Tight</li> <li>3. Inspect Hose Condition – Relace if Required</li> </ol>
<b>YEARLY</b>	<ol style="list-style-type: none"> <li>1. Inspect Urethane Lining for Excessive Wear</li> </ol>

09VPV50



C:\Users\Todd Shue\Documents\TODD\SW\_PARTS\PORT-A-VIBE\5.0 CU FT\SWPV50 - INTERIOR ASSY  
 LAST SAVED: Wednesday, February 16, 2022 8:02:54 AM

MODIFICATIONS:	
REV: A	DATE: 1/17/2022
DESCRIPTION: INITIAL RELEASE	
BY: MTS	

7	2	CASTER, STRAIGHT, 4.0"	01-1004
6	2	CASTER, SWIVEL, 4.0"	01-1003
5	2	HAND KNOB	3GEN1
4	2	CASTER, SWIVEL w/LOCK, 4.0"	010770
3	2	CABINET, DOOR ASSY	SWPV50-07 ASSY
2	1	LID HANDLE	SWPV50-23 ASSY
1	1	5.0 LID ASSY	SWPV50-10 ASSY
#:	QTY:	DESC/ MAT:	PRT#:

**BLAST-IT-ALL**  
**HESS MANUFACTURING, INC.**  
 185 PIPER LANE, SALISBURY, NC 28147-7949  
 P: 1.800.535.2612 F: 1.704.638.9311 WWW.BLAST-IT-ALL.COM

TITLE / VIB-IT-ALL 5.0 CU FT VIBRATORY	SIZE: B
DESC: SWPV50	DWG # A
	DREV: A
	XXXX: 01
	PART # SWPV50
DWG BY: T.SHUE	DATE: 1/17/2022
MAT: PER DRAWING	SHI#: 1 OF 3
	SCALE: 1:10
	DWG TYPE:

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**--SWPV50**

C:\Users\Todd Shue\Documents\TODD\SW\_PARTS\PORT-A-VIBE\5.0 CU FT\SWPV50 - INTERIOR ASSY  
LAST SAVED: Wednesday, February 16, 2022 8:02:54 AM

#:	QTY:	DESC / MAT:	PRT#:
25	2	1/8 BRASS ELBOW	001129
24	2	1/4 X 1/8 NPT BARBED TUBE	14-316
23	1	POWER CORD 20 AMP 115 VOLT	02-20115
22	2	20A TOGGLE SWITCH	02-20A2HP
21	1	TUB DRAIN HOSE	02-1015
20	1	SOLUTION PUMP	02-1032
19	1	SOLUTION TANK - 24" (NOT SHOWN)	02-1031-24
18	1	1/4 BRASS TEE	14-327
17	2	1/4 BRASS ELBOW	14-329
16	2	1/4 X 1/4 BARBED TUBE	14-313
14	4	SOLUTION PUMP HOSE	02-1034
13	18	TUB SPRING	02-1024
12	1	PLUG HANDLE	02-1030
11	1	PLUG BACK PLATE	02-1029
10	1	DISHARGE PLUG	02-1028
9	1	DISCHARGE SPOUT	02-1025
8	1	5.0 CU/FT TUB w/LINER	SWPV50-20 ASSY

**MODIFICATIONS:**

ZONE:	REV:	DESCRIPTION:	DATE:	BY:
	A	INITIAL RELEASE	1/17/2022	MTS

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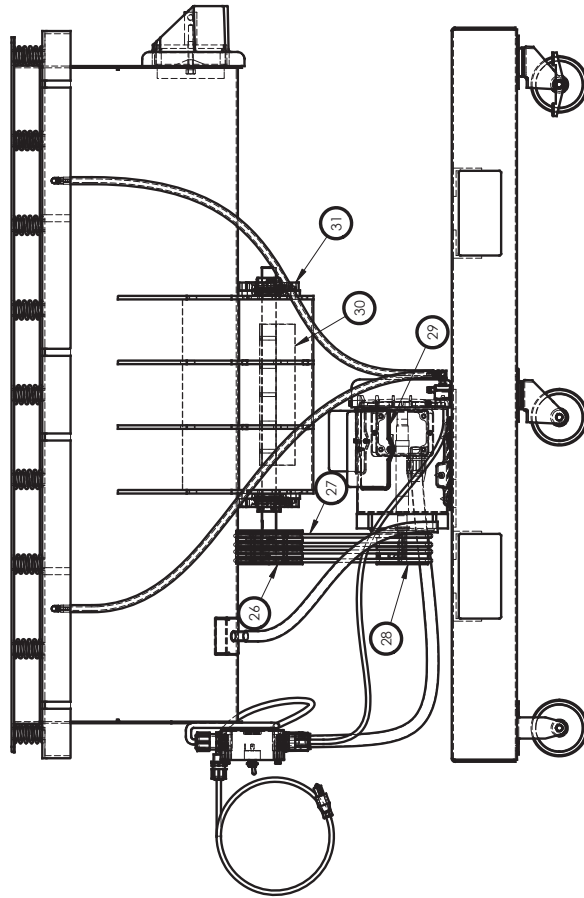
TITLE / VIB-IT-ALL 5.0 CU FT VIBRATORY	DWG #
DESC: SWPV50	--SWPV50
DWG BY: T.SHUE	DATE: 1/17/2022
MAT: PER DRAWING	SHI#: 2 OF 3
	SCALE: 1:10
	DWG TYPE:

09A JMS --SWPV50

C:\Users\todd.shue\Documents\TODD\SW\_PARTS\PORT-A-VIBE\5.0 CU FT\SWPV50 - INTERIOR ASSY  
 LAST SAVED: Wednesday, February 16, 2022 8:02:54 AM

8 7 6 5 4 3 2 1

ZONE:	REV:	DATE:	BY:
	A	1/11/2022	MTS
MODIFICATIONS:			
DESCRIPTION:			
INITIAL RELEASE			



31	2	SHAFT BEARING	02-1017
30	1	5.0 SHAFT/COUNTERWEIGHT ASSY	SWPV50-11 ASSY
29	1	MOTOR, 2HP, 220, 1 PH	13-900-220-60
28	2	3.50" MOTOR PULLEY	03-1039
27	4	DRIVE BELT	03-1042
26	2	4.50" SHAFT PULLEY	02-1021
#:	QTY:	DESC/ MAT:	PRT#:

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**HESS MANUFACTURING, INC.**  
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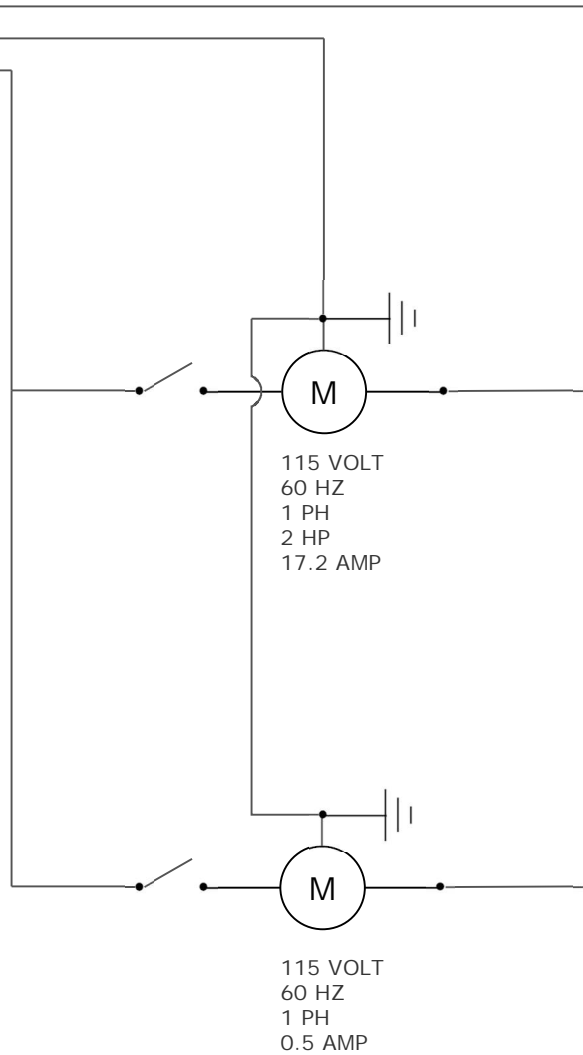
TITLE/	SIZE:
VIB-IT-ALL 5.0 CU FT VIBRATORY	B
DESC: SWPV50	
DWG #:	DREV:
--SWPV50	A
PART #:	XXXX:
SWPV50	01
DWG BY: T.SHUE	DATE: 1/17/2022
	SCALE: 1:8
MAT: PER DRAWING	SHT#: 3 OF 3
	DWG TYPE:

VIB-IT-ALL 5.0 cu/ft RECOMMENDED CONSUMABLE/SPARE PARTS

30	2	SHAFT BEARING	02-1017
28	1	MOTOR, 2HP,220,1 PH	13-900-220-60
26	4	DRIVE BELT	03-1042
17	1	SOLUTION PUMP	02-1032
<b>#:</b>	<b>QTY:</b>	<b>DESC/ MAT:</b>	<b>PRT#:</b>

115 VOLT  
60 HZ  
1 PH

L2  
GND  
L1



PART

PART NUMBER

20 AMP 115 VOLT POWER CORD  
20 AMP TOGGLE SWITCH  
2 HP MOTOR 115 VOLT  
SUBMERSIBLE PUMP

02-20115  
02-20A2HP  
19-900-220-60  
02-1032



Name: <b>IED INC/METAL TECH</b>	Drawing:	Project:	Drawn: JRL	Notes:115 VOLT 60 HZ 1 PH 20 AMP SERVICE REQUIRED	<b>HESS MANUFACTURING INC. 185 PIPER LANE, SALISBURY, NC 28147</b>
Cat: <b>ELECTRICAL SCHEMATIC/PARTS</b>	Scale: NTS	Date: JAN 2022	Rev: <b>A</b>		

WARRANTY

**BLAST-IT-ALL®**

A Division of Hess Manufacturing Inc.  
185 Piper Lane Salisbury, NC 28147  
P O Box 1615 Salisbury, NC 28145  
Toll Free 800-535-2612  
Fax 704-638-9311



Hess Manufacturing Inc. Warrants to the original purchaser of the merchandise sold, to be free from defects in material or workmanship under normal use and service for a period of (5) years. **This warranty does not cover typical wear items.** Upon prompt notification by the purchaser, to HM, components that are determined by HM to be defective will be repaired or replaced at no additional charge F.O.B. our factory.

This warranty requires the following:

- 1) **A completed and returned Warranty Registration card.**
- 2) **Use of Genuine Blast-it-all® OEM replacement parts purchased through Hess Manufacturing Inc. Blast-it-all® to include common wear items. For the entire period of the warranty.**
- 3) **Failures to provide proof of the purchase of Blast-it-all® OEM wear Items voids warranty.**

Manufacturer shall have the right to inspect prior replacing all merchandise in question.

Manufacturer shall not be required to pay any removal or installation charges whatsoever

Manufacturer shall not be held liable for prospective profits, special or consequential damages, nor shall any recovery of any kind against manufacturer be greater in amount the cost of the repairs of defects in workmanship

This warranty does not apply to damage caused by accidents, damage occurring during transit, alterations by unauthorized personnel, abuse or damage by flood, fire or acts of God, nor by artificially generated electric currents or any other cause whatsoever except defects in material or factory workmanship.

In ALL cases, defective parts must be returned to Hess Manufacturing Inc. before credit is issued.

This warranty is in lieu of all other warranties expressed, written or implied and releases Hess Manufacturing Inc. of all other obligations and liabilities whatsoever. This warranty neither assumes nor authorizes any person any obligation other than those specified by this warranty.



**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 PERSONEL HAZARD. FAILURE TO COMPLY WITH THESE INSTRUCTIONS MAY RESULT IN PERSONAL INJURY.**

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