

Hilka

84995000

SANDBLAST CABINET



Operation Manual and Part List

Model 84995000 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 operation injury as well as void the blasting system.

Your 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 pressure to avoid unnecessary peening or undesired, excessive abrasion.

Your 84995000 sandblasting system is equipped with a 3 - prong grounded plug which should be plugged directly into the mains supply. This powers the transformer for the fluorescent tube and provides safety against shock. Care should be taken when connecting the unit to the mains supply and no alterations should be made to the supplied equipment except by a qualified electrician.

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

Troubleshooting the 84995000

PROBLEM	CAUSE	REMEDY
Excessive dust in the Cabinet	Exhaust vent plugged or Air flow is blocked.	Clean rear vent and keep vent away from any wall.
	Abrasive media worn.	Replace abrasive media
	Too much abrasive media Inside cabinet	Remove excess media
	Loose air line or fitting Connections	Tighten fitting and make Sure air lines are secure.
Uneven blasting Actions	Too much abrasive media Inside cabinet.	Remove excess media Check air line to make
	Moisture present inside the Cabinet	Sure there is no moisture in it.
Inadequate speed or in inefficiency of blast.	Abrasive media worn.	Replace abrasive media
	Pressure too low.	Increase inlet pressure and make sure control valve is fully opened.
Static electricity	Dry weather conditions	Leave the item being Cleaned on the grating

MAINTENANCE

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 following 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 moist 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!

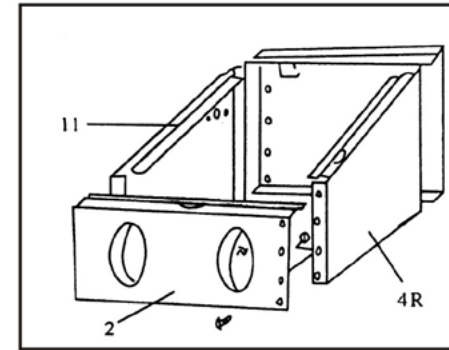
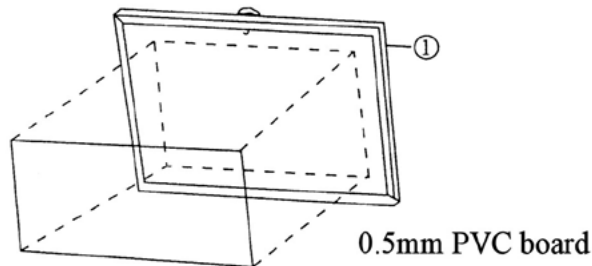
Wear conditions

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

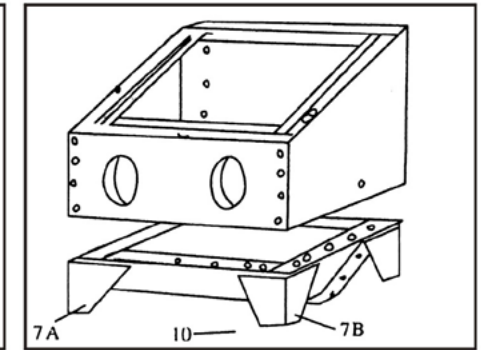
1. The abrasive blasting media is worn out .If it has lost its granular or spherical appearance or has a lot of debris from the parts being blasted and mixed in, replace it. This is usually noticed when the abrasive media that exits the nozzle looks like a smoke cloud coming instead of a stream
2. The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

To replace the transparent PVC board

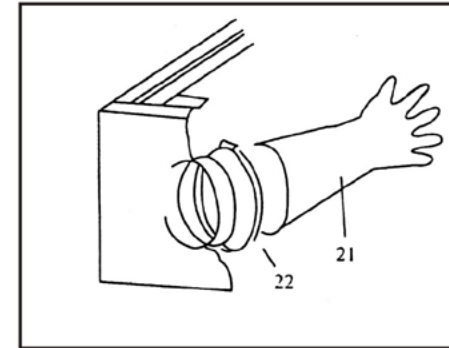
At the bottom of parts No.1 transparent top lid ,there is a 0.5mm replaceable transparent PVC board, when at work, if the transparent PVC board is getting unclear, it may be replaced with a new one to avoid affecting the sight during work.



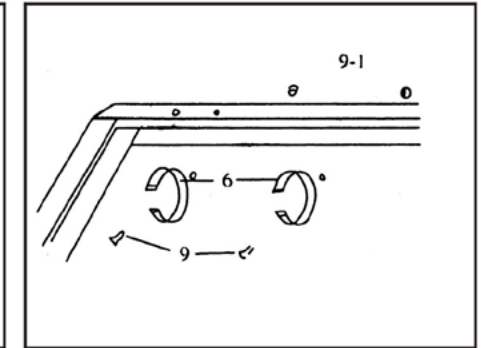
Step 1. Connect front panel(2),rear panel(3),right panel Left panel(4L)and screw up all of the screws.



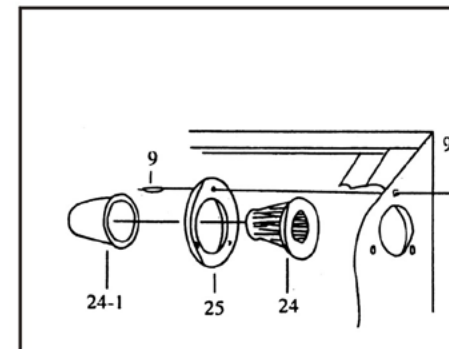
Step 2. Connect the Base to the four legs (7A and 7B) then put screen(23) in the cabinet.



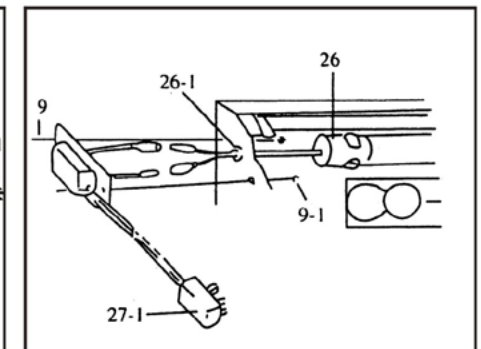
Step 3. Secure the glove(21) with glove clamp(22) onto the front panel as illustrated.



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

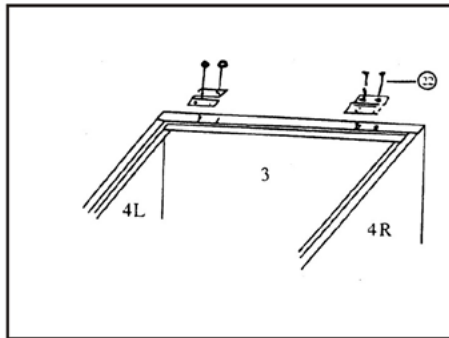
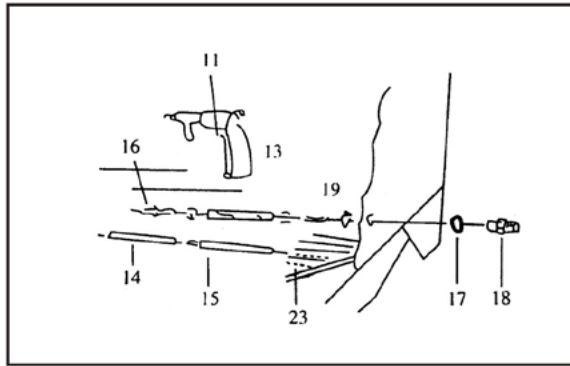


Step 5. Assemble the filter.

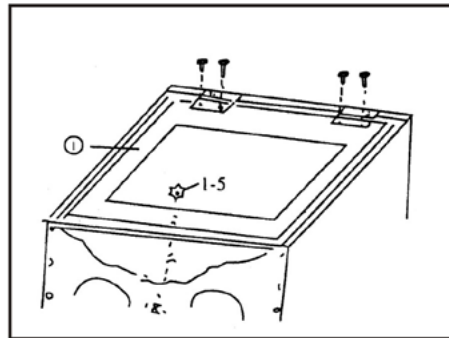


Step 6. Push the fluorescent lamp(26) forward into lamp clamp(6), the put the electric cord outside the hole through 4L, use screw nut(26-1) which is enclosed on the cord to secure, then combine with the circuit inside the wire connection box (27) and up tight at left panel(4L).

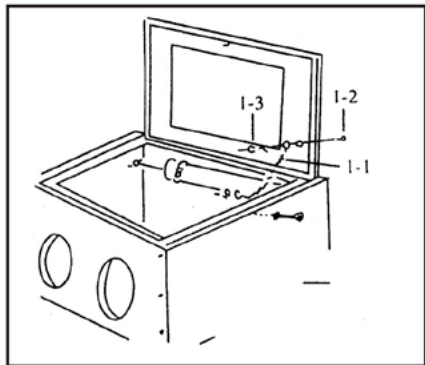
Step 7. Assemble the blast gun.



Step 8: After you complete the assembly of SBC, then you shall assemble the transparent to lid(01), please lock up 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 handle first then put item(22) through the holes on the movable leaf, press hard to lock onto the top 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 sucking forer when it is opened.(if the striking is too big may cause the damage of the top lid.)

2. Place the blast system near 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.

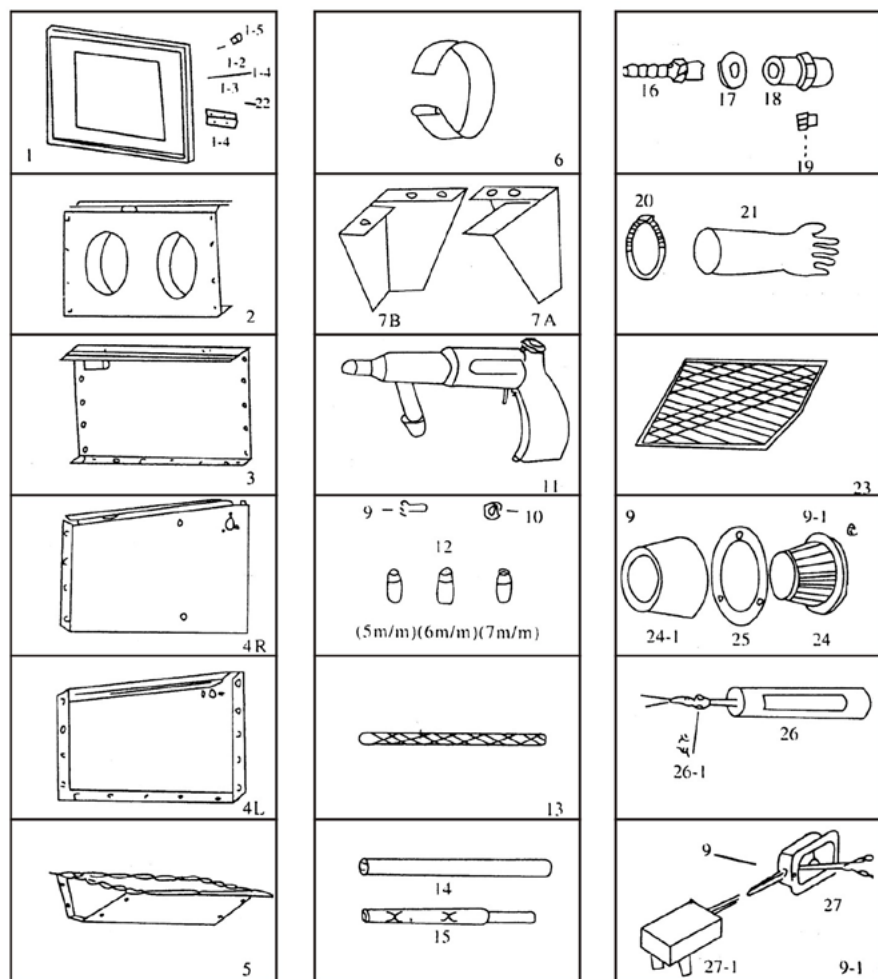
5. Place no more than 10 pounds of abrasive media into the center of the cabinet. Excessive amounts will create clouded cabinet conditions, blow by of media through the exhaust, or sluggish and ineffective blasting performance.

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 concentrated to avoid undesirable peening.



PARTS LIST

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