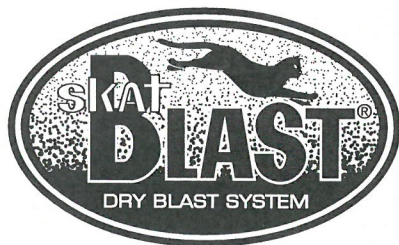


# INSTRUCTIONS AND SAFETY MANUAL



## Dry Blast Cabinets

MADE IN  
**USA**



**This Safety Alert Symbol Means ATTENTION IS MANDATORY!** The Safety Alert Symbol identifies important safety messages on equipment, safety signs, in manuals, or elsewhere. When you see this symbol, be alert to the possibility of personal injury or death. Follow the instructions in the safety message.



### **DANGER**

The use of the word "DANGER" indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury. Instructions, including recommended precautions, must be followed.



### **WARNING**

The use of the word "WARNING" indicates a potentially hazardous situation or unsafe practice which, if not avoided, could result in death or serious injury. Instructions, including recommended precautions, must be followed to avoid such a situation.

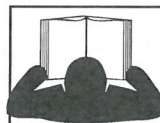


### **CAUTION**

The use of the word "CAUTION" indicates a potentially hazardous situation or unsafe practice which, if not avoided, could result in minor or moderate injury or product or property damage. Instructions, including recommended precautions, must be followed to avoid such a situation.

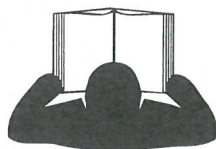


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This manual contains important warnings and information.  
**READ AND RETAIN FOR REFERENCE.**

## IMPORTANT



**Read this Safety Manual and Instructions BEFORE Operating Cabinet.**

An extra copy of this Instruction Booklet / Safety Manual is available on request. Made in USA by Skat Blast.  
Skat Blast, Inc., 7077 Route 446, Canfield, OH 44406



**Nationwide Distributor of Skat Blast Cabinets and Parts  
For Technical Help or Replacement Parts ...**

**Tip Plus Corp., dba TP Tools & Equipment - 7075 State Rt 446, Canfield, OH 44406  
Toll Free: 1-800-321-9260 • 330-533-3384 • Fax: 330-533-2876 • [www.tptools.com](http://www.tptools.com)**



# SAFETY EQUIPMENT REQUIRED - CABINETS

A closed cabinet provides a convenient, clean method of rust and paint removal. Like any air-operated tool, there are certain precautions that must be followed. Therefore, please spend a few minutes reading the information on this page prior to operating or servicing the cabinet. For additional protection, a NIOSH/OSHA-approved dust respirator and safety goggles (not included) **MUST** be worn during operation of the cabinet and when loading or unloading. **DO NOT USE SILICA SAND** for abrasive blasting.



## WARNING - IMPORTANT SAFETY INSTRUCTIONS



### RESPIRATOR REQUIRED

- A NIOSH/OSHA-approved dust respirator must be worn during operation of the cabinet and when loading, unloading, or servicing cabinet or vacuum. Even though cabinet door is closed, door is continually opened and closed while parts are loaded.
- **WARNING** DO NOT USE SILICA SAND OR ABRASIVES CONTAINING SILICA for abrasive blasting, even within a closed cabinet - **HEALTH HAZARD**. The use of abrasives containing silica or other abrasives can be dangerous to your health and can lead to silicosis, shortness of breath, coughing, and other respiratory problems.

PLEASE CONSULT OSHA or OTHER STANDARDS FOR SAFETY EQUIPMENT REQUIRED FOR YOUR APPLICATION.



- **SLIP/FALL HAZARD**. Clean up abrasive spills immediately. Glass Beads and other abrasives are as SLIPPERY AS ICE. Use caution.



- **CUT/SHARP EDGE HAZARD**. Always wear leather gloves and long sleeve jacket when assembling, unloading, moving, or servicing cabinet or components as metal has sharp edges, corners, and surfaces.



- **EYE PROTECTION REQUIRED**. When abrasive blasting, the use of approved safety goggles is **MANDATORY** to protect user from dust around the area or in case of lens breakage.



- **DAILY MAINTENANCE REQUIRED**. Disconnect air pressure before servicing unit. Check gloves, nozzles, gaskets, and lens for wear or leaks. Replace as needed. **Always use TEMPERED OR SAFETY GLASS** as a lens replacement.



- **ELECTRICAL SHOCK HAZARD**. Do not modify light, vacuum, or plug at end of power cord. NEVER operate cabinet or vacuum near water or in a damp location. Electrical receptacle in your shop must be 115V and grounded. If using an extension cord, it must be a 3-prong, grounded-type and be the proper wire size. **DO NOT USE VACUUM AS A WET VACUUM**, nor for vacuuming of hazardous materials.



- **HIGH-PRESSURE AIR CAN BE DANGEROUS**. Abrasive Blast Cabinets operate on air pressure in ranges of 40-120 PSI. NEVER exceed 125 PSI. High pressures will result in premature wear of components.
- **DISCONNECT** incoming air line when adding abrasive or when servicing valve, hoses, or power gun.



## DANGER - BLAST HAZARDS - IMPORTANT!



### To prevent serious injury or death:

- Do not point blast directly at fingers or hands, even though wearing gloves.
- Do not point abrasive stream at lens or door opening of cabinet.
- **NEVER OPEN DOOR WHILE BLASTING**.



### EXPLOSION HAZARD

#### To prevent serious injury or death:

- **NEVER** blast items containing oils, gas, or flammable liquids as abrasive hitting metal can spark and cause a dangerous explosion.

Shown below are the labels that are attached to the cabinet when new.

**DO NOT REMOVE THESE LABELS** as they provide information to users of the equipment.

If these labels are removed, damaged, or become illegible, please call for a replacement label: Skat Blast, Inc., 330-533-9477, Ext. 55.



### WARNING

**ELECTRICAL SHOCK HAZARD**  
To prevent serious injury or death:  
• Do not modify light, vacuum or plug at end of power cord.  
• Electrical receptacle in your shop must be 115V and grounded.  
• Do not operate cabinet near water or in a damp location.  
• If using extension cord, it must be a 3-prong, grounded-type and be the proper wire size.

**RESPIRATOR REQUIRED**  
• A NIOSH/OSHA-approved dust respirator **MUST** be worn during operation of the cabinet, and when loading or unloading. **DO NOT USE SILICA SAND** for blasting, even within a closed cabinet-Health Hazard.

**EYE PROTECTION REQUIRED**  
• When abrasive blasting, the use of approved safety goggles is **MANDATORY** to protect user from dust around the area, or in case of lens breakage.

**HIGH PRESSURE AIR HAZARD**  
To prevent serious injury:  
• Disconnect incoming air line prior to servicing power gun, hoses, or foot valve.

**CUT/SHARP EDGE HAZARD**  
To prevent serious injury:  
• Always wear leather gloves and long sleeve jacket when assembling, unloading, moving or servicing cabinet or components, as metal and components have sharp edges, corners and surfaces.

**SLIP/FALLING HAZARD**  
To prevent serious injury:  
• Clean up abrasive spills immediately. Glass Beads and other abrasives are as slippery as ice. Use caution.

Call factory for technical support or service (330) 533-9477, Ext. 22. Made in U.S.A. by Skat Blast, Inc. **SA** 7077 Rt. 446, Canfield, OH 44406

### MADE IN USA

#### OPERATING RULES

#### VACUUMS & DUST COLLECTORS

**FOR CLEANER OPERATION:**

1. Change abrasive regularly. All abrasive eventually "breaks down" into dust. Results are poor visibility and decrease in suction from vac or dust collector. Vac and DC filter cartridges will become coated with dust and small abrasive particles.
2. Replace vacuum and dust collector filter cartridges. If a worn filter cartridge is used, abrasive dust can escape into the room. Abrasive dust can be a health hazard to the operator and can cause damage to the vac or DC motor.  
Part #6011-HI Hepa Cartridge - Vac-50.  
Part #6011-HEPA Hepa Cartridge - 160-DC & 310-DC
3. Install Optional Final Filter or Exhaust Kit. Final Filter Kit prevents dust from escaping into the room by collecting the fine dust particles.  
Part #6011-10 Final Filter Kit for Vac-50  
Part #6020-10 Final Filter Kit for 160-DC & 310-DC  
Exhaust Kit vents dust particles outside for a cleaner shop and quieter atmosphere.  
Part #6011-08 Exhaust Kit for Vac-50  
Part #6017-08 Exhaust Kit for 160-DC & 310-DC

**VAC-50 MAINTENANCE PROCEDURES:**

**A) VAC-50 QUICK CLEAN-OUT**

1. Unplug vacuum from 115 volt outlet and remove vac hose.
2. Pick up entire vacuum and tap lightly on floor once or twice. Dust will fall off filter cartridge and into bottom vacuum container. Resume operation. If vac seems heavy, dust accumulation is excessive; follow B) below.

**B) MONTHLY VAC-50 CLEAN-OUT (after 30-40 hours of operation)**

1. Unplug vacuum from 115 volt outlet and remove vac hose.
2. Unhatch vac closing ring and lift off top vacuum assembly.
3. Remove filter cartridge and lightly dust filter surface with a cloth or soft paint brush. Inspect filter cartridge for any pinholes or holes and replace as needed. If filter is not replaced, dust will pass through these small openings, damaging bearings of vacuum motor and cause vacuum motor failure. Vac-50 only has a washable filter. Occasionally, run filter under water to remove dust, then air dry before reinstallation.

**160-DC & 310-DC MAINTENANCE PROCEDURES:**

**A) DUST COLLECTOR CARTRIDGE CLEANING - DAILY**

1. Shut off dust collector, shake down filters with shaker lever on rear of unit by twisting lever 5-10 times.
2. Remove bottom clean-out drawer and discard dust.
3. Occasionally remove filter cartridges and hand-wash using mild detergent & lukewarm water. Air-dry before reinstallation.

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### MADE IN USA

#### BLAST CABINET OPERATING RULES

**FOR CLEANER OPERATION:**

1. Check and adjust door latch assembly for proper sealing. Replace door gasket as needed.
2. Clean vacuum or dust collector filters and check for pinholes or holes, replace filter as needed.
3. Change abrasive regularly. All abrasive eventually "breaks down" into dust. Results are poor visibility and decrease in suction from vac or dust collector. Vac and DC filters will become coated with dust and small abrasive particles.
4. Close and latch door prior to operating cabinet.

**MAINTENANCE PROCEDURES:**

**REPLACE GLOVES** periodically - wear is normal, especially to left glove.

**REPLACE VACUUM & DUST COLLECTOR FILTERS**  
If a worn filter is used, abrasive dust can escape into the room. Abrasive dust can be a health hazard to the operator and can cause damage to the vacuum or dust collector motor.

**REPLACE NOZZLES AND AIR JETS** on a regular basis, as these parts wear rapidly.

**ACRYLIC OVERLAY (most models)** - The overlay is placed on TOP of Tempered Glass Lens for added protection. If overlay becomes scratched, it may be replaced.  
Part No. 6101-02, 12" x 24"  
Part No. 6101-12, 12" x 33"  
Part No. 6101-07, 12" x 45"

**TEMPERED GLASS LENS (most models)** - Tempered Glass Lens is extremely durable. If replacing lens, use tempered glass or laminated safety glass only. Ordinary window glass will break easily, resulting in possible serious injury. 3/16" thick with acrylic overlay and inner lens protector. Available in 3 sizes:  
Part No. 6101-02, 12" x 24"  
Part No. 6101-10, 12" x 33"  
Part No. 6101-08, 12" x 45"

**ACRYLIC LENS** - Fits top-load-series cabinets only. Includes inner lens protector. 220 thick.  
Part No. 6102-33, 12" x 24"

**INNER LENS PROTECTOR** - The inside of cabinet lens is covered with a thin mylar protective sheet to protect the cabinet lens. This sheet can be replaced after becoming scratched as needed. Package of three.  
Part No. 6101-02, 12" x 24"  
Part No. 6101-11, 12" x 33"  
Part No. 6101-06, 12" x 42 1/2"

For technical help or replacement parts -  
**Tip Plus Corporation, dba TP Tools & Equipment**  
7075 State Rt. 446, Canfield, OH 44406  
1-800-321-9268 • [www.tpools.com](http://www.tpools.com) 1025401 6/29/18

### CAUTION

**TRAP DOOR IS SPRING LOADED**  
Safety Equipment Required

**EYE PROTECTION REQUIRED**

- When draining abrasive from trap door, the use of approved safety goggles is **MANDATORY** to protect eyes from abrasive dust.

**RESPIRATOR REQUIRED**

- When draining abrasive from trap door, the use of a NIOSH/OSHA-approved dust respirator is **MANDATORY** to protect user from abrasive dust in and around the cabinet.

**DO NOT USE ABRASIVES CONTAINING SILICA.**

**SLIP/FALL HAZARD**  
To prevent serious injury:  
• Clean up abrasive spills immediately. Glass Beads and other abrasives are as slippery as ice. Use caution.

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### CAUTION

**LOADING DOOR MUST BE CLOSED AND LATCHED DURING OPERATION**

**Normal Maintenance**

- Replace inner lens protectors and lens as required
- Door gasket should be replaced as required
- Vacuum or Dust Collector required to remove dust

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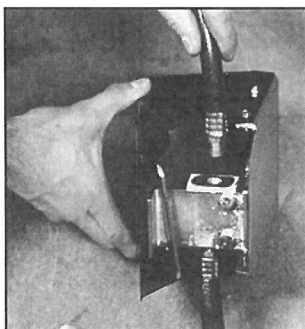
# CABINET INSTALLATION INSTRUCTIONS

## POWER GUN

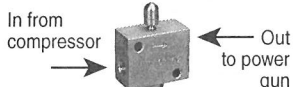


- 1) Install 7 ft Air Hose (6412-00) to threaded bottom connection of S-35 Trigger Gun or C-35 Foot Pedal Gun by screwing 1/4" male hose end into 1/4" female threaded handle of gun.
- 2) Slip Clear Siphon Hose, not shown, onto gun head assembly, all models.
- 3) Push other end of 7 ft air hose through hose grommet on front of cabinet.

## FOOT PEDAL



- 1) Larger cabinet models include a foot pedal control. Connect air hose from your air compressor to inlet side of foot pedal.
  - 2) Connect 7 ft Air Hose (6412-00) from power gun to outlet side of foot pedal.
- NOTE:** Arrow stamped on foot pedal valve shows air flow.

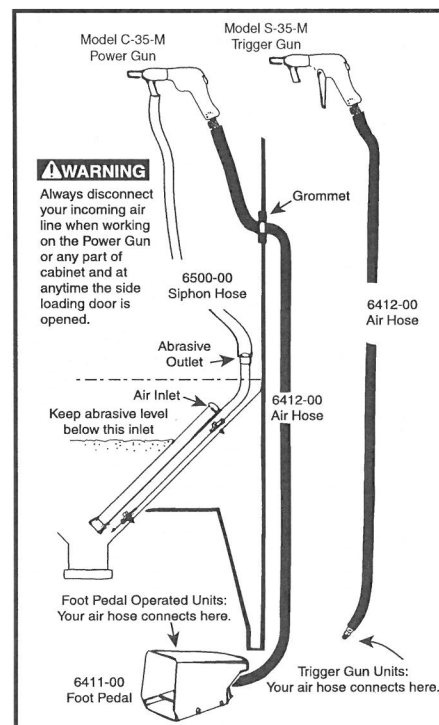


## LOADING ABRASIVE

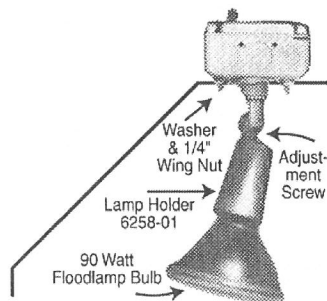


- 1) Open side or top-load door on cabinet.
- 2) Pour suitable abrasive through grid screen and into cabinet funnel. Most units include Skat Magic Abrasive for fast paint and rust removal.

**DO NOT OVERFILL CABINET**  
Fill only about 1/3 of the hopper (25-50 lbs). Too much abrasive will pack and not feed properly.



## LIGHT INSTALLATION



- 1) Remove 1/4" wing nuts and washers from light assembly.
- 2) Locate 2 5/8" hole on top of cabinet and drop light assembly through this hole. Gasket is installed on bottom of box for proper sealing. Some models may have two lights.
- 3) Reach up inside cabinet and fasten light assembly with 1/4" washers and wing nuts.
- 4) Adjust floodlight by unscrewing adjustment screw, and aim holder toward center of cabinet then tighten.
- 5) Install floodlight bulb.

## VACUUM FERRULE

- 1) Locate hole on left side of cabinet and remove four screws.
- 2) Install vacuum ferrule over hole with gasket placed between ferrule and cabinet body.
- 3) Reinstall four screws through vac ferrule and into cabinet. Tighten securely.

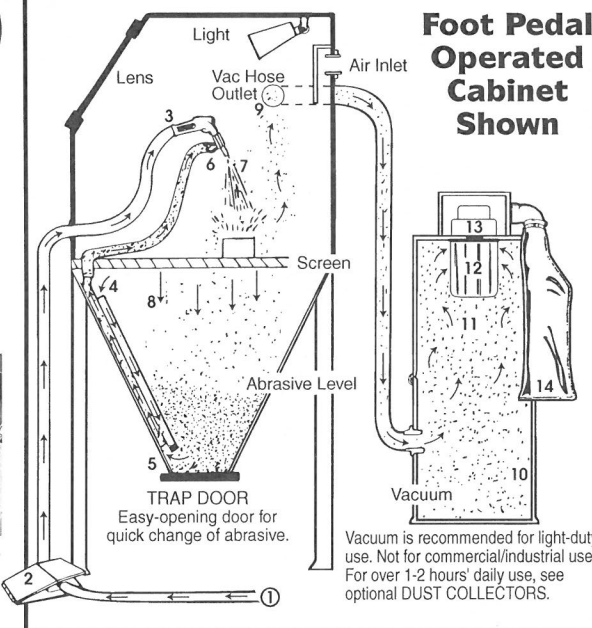
## WINDOW FILM REMOVAL

- 1) Located on the tempered glass lens is a protective plastic film that must be removed.
- 2) With a razor knife, score protective film inside black lens frame on all four sides.
- 3) Peel off protective plastic film and discard.



## HOW SKAT BLAST WORKS

### Principles of Operation



### Foot Pedal Operated Cabinet Shown

- 1) Air from compressor goes through
- 2) foot pedal control to
- 3) power gun. When pedal is pressed, air blows through power gun, pulling makeup air into
- 4) pickup tube through
- 5) power zone, picking up abrasive through
- 6) gun venturi and out
- 7) nozzle. Blast hits object. Most abrasive drops to
- 8) bottom for recycling. Dust is pulled out
- 9) vac hose outlet and into
- 10) vacuum container.
- 11) Lighter particles stick to
- 12) internal filter cartridge and clean air exhausts through
- 13) vac motor and into
- 14) optional Final Filter.

Vacuum is recommended for light-duty use. Not for commercial/industrial use. For over 1-2 hours' daily use, see optional DUST COLLECTORS.

**LIMITED WARRANTY** Congratulations on your Skat Blast Cabinet purchase! Cabinets are warranted to be free from defects in materials and workmanship for a period of five years from the date of purchase. During this period, we will replace or repair any defective parts free of charge (except wear items such as: nozzles, air jets, power head, gloves, hose, lens, and other wear items). This warranty applies only to the original purchaser as registered, provided unit or parts are delivered to us prepaid. Parts and complete units will be returned to the customer after repairs, plus shipping (if applicable). Advance notice is required on all returns. **We recommend that you use only genuine replacement parts. Improper or incorrectly performed maintenance or repair voids this warranty.** No warranty on units used for rental. **LIABILITY:** We will not be responsible for any loss or damage to person or property, or lost profits or other similar loss or damage which may result or be claimed to have resulted from a defect in workmanship or material of any product. (Some states not applicable.) We neither assume nor authorize any representative or other person to assume for us any obligation or liability other than expressly set forth herein.



**SKAT BLAST, Inc.,**  
PO Box 708, Canfield, OH 44406

Record  
for  
Future  
Reference

Model No \_\_\_\_\_  
Serial No \_\_\_\_\_  
Date Purchased \_\_\_\_\_

# VACUUM INSTALLATION INSTRUCTIONS

**1. UNPACKING:** On larger models, vacuum is included & shipped fully assembled (except for hose) with HEPA filter cartridge installed. Simply remove vac from box and set next to your cabinet.

**2. VAC HOSE INSTALLATION:** Install 6009-05 Vacuum Hose into side of vacuum container at Location "B" (see right). Install other end of hose into 6010-00 Ferrule on the side of cabinet.

**3. ELECTRICAL HOOKUP:** Plug 6257-00 Vacuum Cord into a 115 volt grounded receptacle.

**OPTIONAL FINAL FILTER (Vac-50):** Assemble Final Filter per instructions included with Final Filter. Insert 6011-10 Filter Bag Assembly into side outlet of Blower Guard at top of vacuum ("A").

## WARNING

VACUUM MUST ONLY BE USED FOR COLLECTING DUST FROM WITHIN A SKAT BLAST CABINET. DO NOT USE THIS FILTER FOR COLLECTING TOXIC, CARCINOGENIC, COMBUSTIBLE, OR OTHER HAZARDOUS MATERIALS SUCH AS ASBESTOS, ARSENIC, BARIUM, BERYLLIUM, LEAD, PESTICIDES, OR OTHER HEALTH-ENDANGERING MATERIALS. DO NOT USE PRODUCTS CONTAINING SILICA OR SILICA SAND FOR ABRASIVE BLASTING.

### VAC MOTOR

#### GUARANTEED FOR 90 DAYS

Improper maintenance can lead to abrasive leaking through filter and into motor bearings, causing premature motor failure. Always check filter on a regular basis. We suggest having an extra filter cartridge on hand.

### CLEANING PROCEDURES:

**A) QUICK VAC CLEAN-OUT PROCEDURE - Best Method,** with no chance of damaging filter cartridge. During normal operation most dust falls off the non-stick HEPA filter membrane before it can build up, and dust particles will drop into bottom vacuum container. However, in humid conditions some dust may stick to the filter surface. To remove dust, simply try the following "Quick Clean-out" procedure:

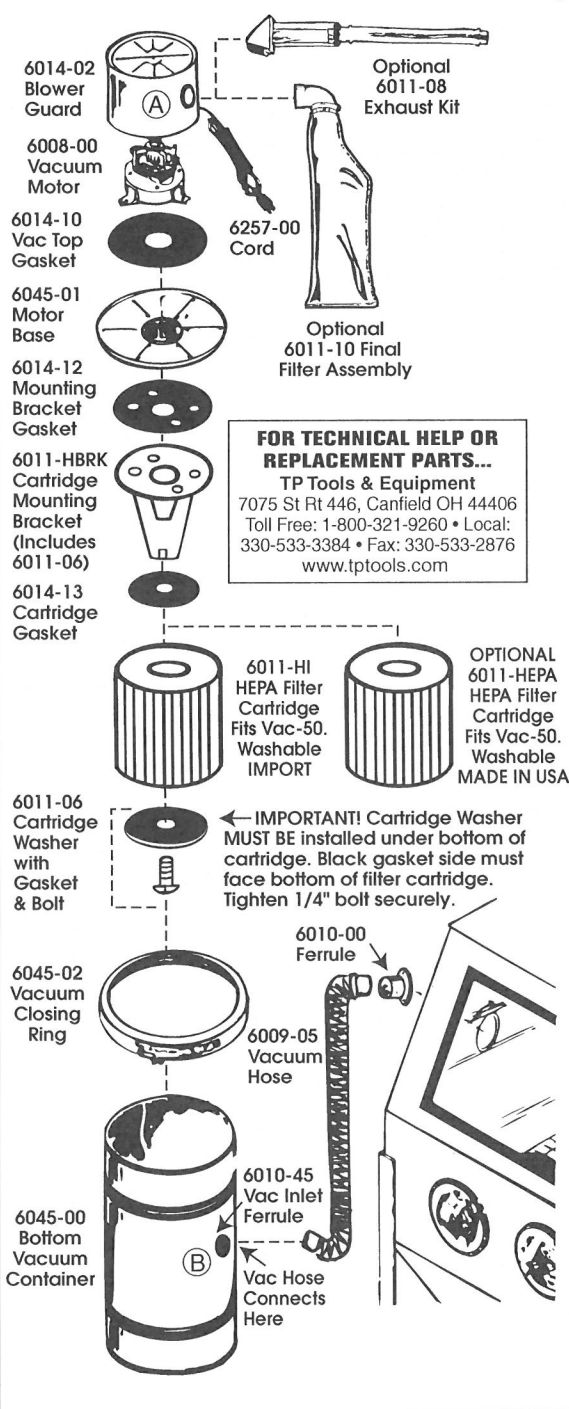
1. Unplug vacuum from 115 volt power supply. Disconnect vacuum hose.
2. Pick up entire vacuum and tap lightly on the floor once or twice. Dust will fall off filter and into the bottom vac container, and you may then resume operation. If vacuum seems heavier than usual, dust accumulation is excessive; and it will be necessary that you follow B) procedure below:

**B) MONTHLY VAC CLEAN-OUT PROCEDURE (after 30-40 hours of operation):** Non-stick surface of the internal HEPA Filter Cartridge can be damaged if handled roughly. For that reason, do not clean with a wire brush, putty knife, or other object that could scratch the HEPA filter membrane surface. Also, do not use compressed air to clean, as it will damage the filter. Remove HEPA filter cartridge and lightly dust filter surface with a cloth or soft paint brush. Inspect HEPA filter for any pinholes or holes and replace as needed. If HEPA filter is not replaced, dust will pass through these small openings, damaging bearings of vacuum motor and cause motor failure.

**C) VAC-50 HEPA FILTER CARTRIDGE CLEANING/REPLACEMENT:** Remove HEPA Filter Cartridge from underneath 6045-01 Motor Base by unscrewing mounting screw on bottom of filter. Normally, a light dusting with a soft paint brush is all that is needed to clean cartridge. Occasionally, filter must be washed by rinsing filter under a stream of water to remove accumulated dust, then air-dry before reinstallation. We recommend stocking an extra HEPA Filter Cartridge so you can swap filters while the other filter is drying.  
**HEPA Filter Cartridge - Part #6011-HI.**

**D) CLEANING OPTIONAL FINAL FILTER ASSEMBLY (accumulation of dust is normal, so it is absolutely necessary that this bag be cleaned and inspected after every 8 hours of use):**

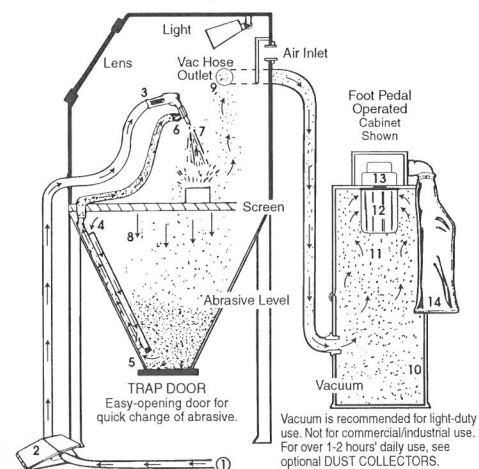
1. Remove bag by loosening clamp.
2. Shake dust into suitable receptacle.
3. Reinstall bag and clamp.



# HOW VAC WORKS

Vacuum filter cartridge has a non-stick filter membrane which resists clogging because the dust falls off the filter before it can build up. This dust then drops into the Bottom Vacuum Container (6045-00). Vacuum should be disassembled and cleaned out after 30-40 hours' use. At this time, lightly brush off filter cartridge to remove small particles of dust that can reduce vacuum flow.

If visibility is reduced in the cabinet, shut off vacuum and simply pick up and tap entire unit on floor. Then resume operation. Continual poor visibility is usually a sign the abrasive has "worn out" and turned to "dust". This dust can clog the filter cartridge in time. Abrasive change, disassembly, and clean-out or replacement of the vac filter will be required.



1) Air from compressor goes through 2) foot pedal control to 3) power gun. When pedal is pressed, air blows through power gun, pulling makeup air into 4) pickup tube through 5) power zone, picking up abrasive through 6) gun venturi and out 7) nozzle. Blast hits object. Most abrasive drops to 8) bottom for recycling. Dust is pulled out 9) vac hose outlet and into 10) vacuum container. 11) Lighter particles stick to 12) internal filter cartridge mounted just below the motor to trap ultra-fine dust particles down to 0.3 microns. When motor shuts off, heavier particles simply fall off filter cartridge and drop into vacuum container. Clean air then exhausts through 13) vacuum motor and into 14) Optional Final Filter. (Some cabinets use a trigger gun.)

### Optional Dust Collectors

Vac-50 Vacuum System is recommended for average small shop use (1-2 hours daily) and will accommodate abrasives up to 80 mesh or grit size. If finer abrasives are used or for all-day operation, Skat Blast can furnish Dust Collector Systems with 1/3 HP or 3/4 HP motors and larger capacity. Call for availability.

## WARNING

Some dust created by abrasive blasting, power sanding, sawing, grinding, drilling, and other construction activities may contain chemicals known to cause cancer, birth defects, or other reproductive harm.

Some examples of these chemicals are:

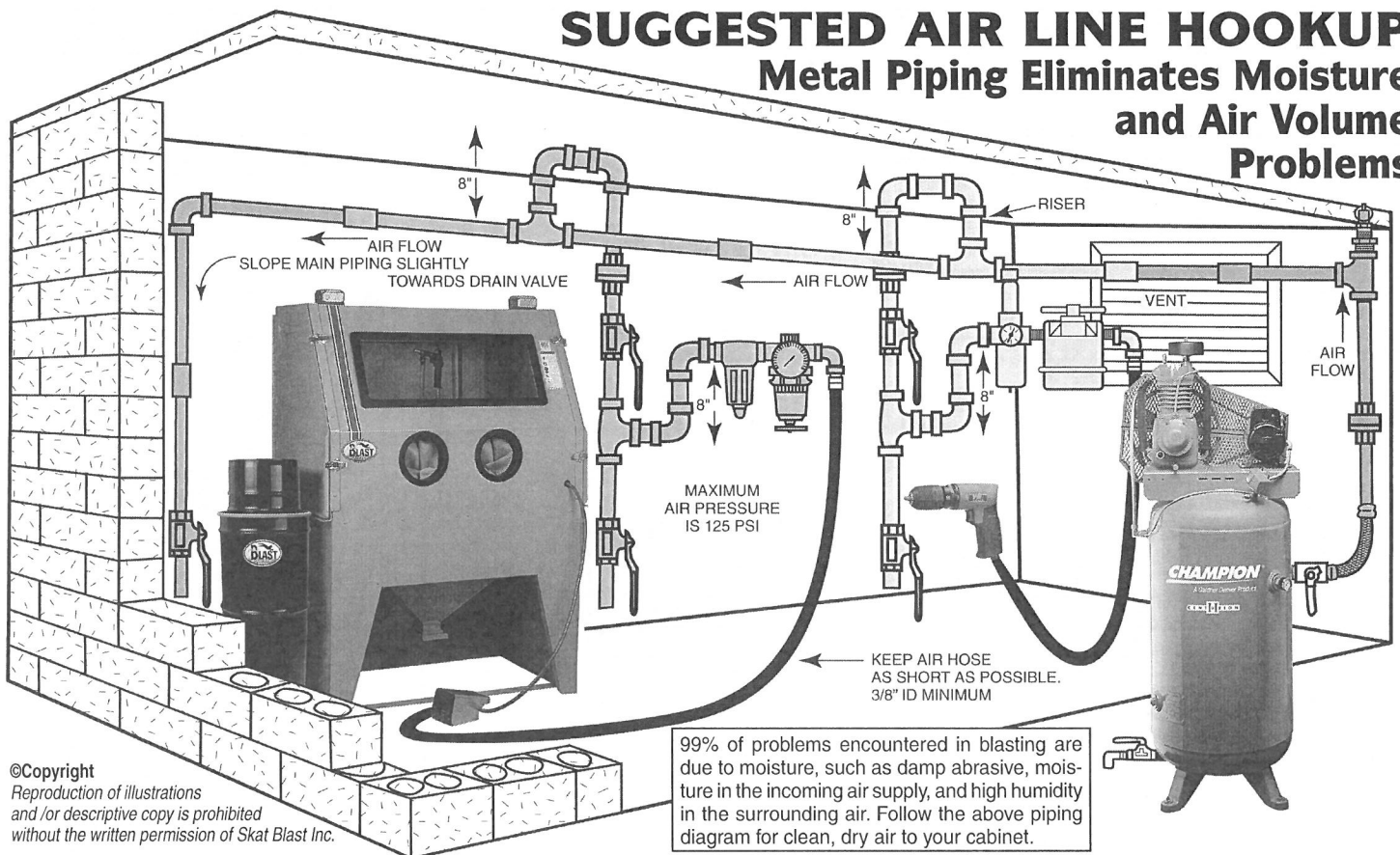
- lead from lead-based paints,
- crystalline silica from bricks, cement, and other masonry products, and
- arsenic & chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well-ventilated area and work with approved safety equipment, such as respirators that are specially designed to filter out microscopic particles or air-supplied respirators to provide clean, breathable air.



# SUGGESTED AIR LINE HOOKUP

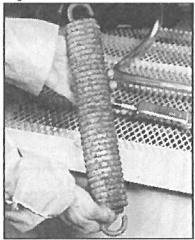
## Metal Piping Eliminates Moisture and Air Volume Problems



**Metal piping is the answer to moisture problems and will last for many years.** Choose 1/2" or 3/4" metal pipe sizes - 1/2" pipe for up to 75 ft of horizontal pipe runs from your compressor, and 3/4" pipe for horizontal runs over 75 ft. Mount piping along the walls of your shop. Not only does the metal piping act as an "air reservoir", it also enables the moisture-laden air to cool, so the water separators can do their job. The most important feature is the use of "risers", which allow the system to draw dry air from the piping, with the water separators removing most of the remaining moisture. (Moisture condenses in the cold metal pipes and can be easily removed by the water separators.) **The result is clean, dry air to all of your air tools and considerably longer life for any air-operated tool or equipment.**

**Use Black Iron Pipe only.** We do not recommend galvanized metal pipe, as galvanization can come off the inside of the pipe, clogging separators and regulators. Do not use PVC pipe, as PVC will not help cool the air; and glued joints often separate. Avoid copper tubing, as it is easily damaged; and soldered joints can come loose under pressure (Safety Hazard).

### 1) INSERT PARTS



### 2) TURN ON LIGHT/VAC



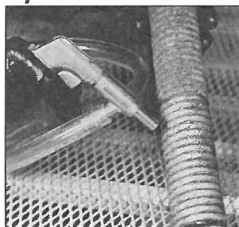
## GENERAL CABINET OPERATIONS

- 1) INSERT PARTS** - Place parts to be blasted through side or top-loading door and onto work screen. Reinforced screen holds up to 200 lbs. Close and latch door.
- 2) TURN ON LIGHT/VAC** - Adjustable floodlight directs an intense beam of light where you need it, and 90-100 cfm Vac-50 Vacuum keeps visibility within cabinet clear when blasting. (Light and vac are optional on some models.)
- 3) INSERT HANDS** - Place hands in gloves. Hold part to be blasted with one hand and power gun with other hand.
- 4) AIM POWER GUN** - Aim power gun at object and press foot pedal control or pull trigger handle (depending on model). Abrasive will come out of gun removing paint, rust, and scale instantly. Abrasive drops to bottom funnel where it is recycled automatically.
- 5) CHECK RESULTS** - After vacuum has cleared the work area, open side or top-load door to check results. Within minutes, all rust, paint, or scale is removed; and your part is ready for primer or paint.
- 6) QUICK UNLOADING** - Abrasive continually recycles from bottom funnel hopper each time the power gun is activated and eventually wears out. Abrasive should be changed when it gets "dusty" or a difference in cutting action is noticed. Place container under cabinet trap door and press down on spring-loaded trap door to empty.

### 3) INSERT HANDS

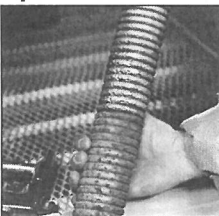


### 4) AIM POWER GUN



## START-UP HINTS & IDEAS FOR CLEANER OPERATION

### 5) CHECK RESULTS



### 6) QUICK UNLOADING



**AIR SUPPLY** - We recommend a 5 HP 2-stage compressor (10-15 cfm @ 80 psi). A small nozzle setup (6300-50) is available for use with 3-5 HP single-stage compressors. 125 PSI MAXIMUM.

**ABRASIVE** - Use only clean, dry abrasive of FINE GRADE, 35-80 grit. Change abrasive regularly, as any abrasive eventually "breaks down" into dust.

**LOCATION** - DO NOT locate cabinet near air compressor or other equipment that should be in a clean atmosphere. No matter how careful you are, some dust and abrasive will always be in the area of the cabinet.

**VACUUM** - See Cleaning Procedures (page 4).

# Item Description

# Order No.

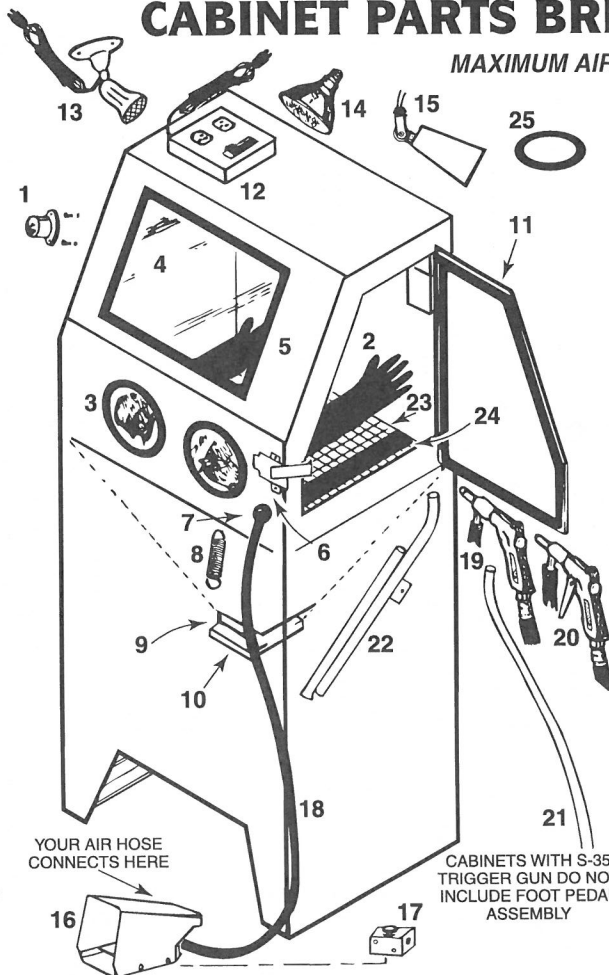
- 1 Vacuum Hose Ferrule, bolts to cabinet .....6010-00
- 2 24" Gauntlet Type Cab Gloves for 22-24"d cabinets .....6050-00
- 24" Left Hand Glove only .....6050-LH
- 24" Right Hand Glove only .....6050-RH
- 28" Gauntlet Type Cab Gloves for 28"d cabinets .....6051-00
- 28" Left Hand Glove only .....6051-LH
- 28" Right Hand Glove only .....6051-RH
- 32" Gauntlet Type Cab Gloves for 34"d cabinets .....6052-00
- 32" Left Hand Glove only .....6052-LH
- 32" Right Hand Glove only .....6052-RH
- 3 Glove Flange holds cabinet gloves in place, pair .....6057-04
- 4 Std Tempered Glass Cab Lens, 12" x 24" x 3/16" .....6101-00
- Standard Inner Lens Protector, 10" x 21 3/4", 3 pk,  
for 12" x 24" cabinet lens .....6101-03
- Med Tempered Glass Cab Lens, 12" x 33" x 3/16" .....6101-10
- Medium Inner Lens Protector, 10" x 30 3/4", 3 pk,  
for 12" x 33" cabinet lens .....6101-11
- XL Tempered Glass Cab Lens, 12" x 45" x 3/16" .....6101-05
- XL Inner Lens Protector, 10" x 42 3/4", 3 pk,  
for 12" x 45" cabinet lens .....6101-06
- Acrylic Cab Lens, 12"x24"x.220 thick w/inner lens protector.  
No mtg holes. Fits Model SC-33 & SC-33V only .....6102-33
- Acrylic Cab Lens, 12"x24"x.220 thick w/inner lens protector.  
Pre-drilled mtg holes. Fits Model 780-TL & 800-T only .....6102-24
- 5 Standard Lens Frame fits 12" x 24" cabinet lens .....6101-01
- Med Lens Frame fits 12" x 33" cab lens (2 pc) .....6101-09
- XL Lens Frame fits 12" x 45" cabinet lens (2 pc) .....6101-08
- 6 Door Latch Assembly .....6102-01
- 7 Hose Grommet, fits 1" hole .....6112-01
- 8 Trap Door Spring .....6114-00
- 9 Trap Door Gasket, adhesive back .....6203-42
- 10 Trap Door Assembly, with gasket, less spring .....6203-02
- 11 Door Gasket, 3/8" x 1" x 10'L (All except 780-TL,  
800-T, SC-33 & SC-33V) .....6217-00
- 12 Floodlight Assembly w/floodlight holder, switch & duplex  
assembly, gasket & cord, less bulb. Fits 28-32"d cabinets...6258-03
- HD Floodlight Assembly w/floodlight holder, switch & duplex  
assy, gasket & cord, less bulb. Models 1436-1836 .....6258-03HD
- 13 Floodlight Assy w/mtg. base, 6 ft cord & grommet  
(Plastic, no switch or bulb). Fits slant top cabinets..... H-130S
- 14 Floodlight, 90 watt, par 38 outdoor type.  
Fits 6258-03 and 6258-03HD .....6258-02
- 15 Floodlight Holder, 115v fits 6258-03 & 6258-03HD .....6258-01
- 16 Foot Pedal, complete with air valve .....6411-00
- 17 Air Valve, 1/4" female pipe threads .....6413-00
- 18 Air Hose, 7 ft long with 1/4" ends (whip hose) .....6412-00
- 19 Foot-Pedal-Operated Cabinet Gun. Fits foot-pedal-  
operated cabinets..... C-35-M
- 20 Trigger-Operated Cabinet Gun. Fits trigger-operated cabs... S-35-M
- 21 Siphon Hose, 24"L, to either power gun. Fits Model 731,  
731-TL, 780, 780-TL, 781, 800-T, SC-33 & SC-33V .....6500-24
- Siphon Hose, 36" long, to either power gun.  
Fits Model SC-35V, SC-45V, SC-28, SC-28V, SC-34, 850,  
850-T, 930, 935, 950, 951, 952, SC-40, 940-DLX, SC-46,  
960, 960-DLX, 960-T, 960-SE, 965, 966, 970, 976 & 985 .....6500-00
- Siphon Hose, 48" long, to either power gun. Fits  
Model 979, 992, 1436, 1500, 1536, 1636 & 1836 .....6500-04
- 22 18 1/4"L Pickup Tube Assembly - Model SC-33,  
SC-33V, 780, 780-TL, 800-T, 930, and 935 .....6442-04
- 27 1/2"L Pickup Tube Assembly - Fits SC-35V, SC-45V, SC-28,  
SC-28V, 850, 850-T, SC-34, 950, SC-40, 940-DLX, SC-46, 960,  
960-DLX, 960-T, 960-SE, 966, 970, 976, 992, 1400, 1800,  
1836, (1500 & 1600 before 7/2000). Curved end .....6442-274
- 31 1/2"L Pickup Tube Assy - Fits Model 979, 985, 1436, 1536,  
1636, (1500 & 1600 after 7/2000). Curved end .....6442-314
- 23 Bottom Screen, 18 1/8" x 30 1/4", Model 780,  
780-TL, 800-T, SC-33, SC-33V, 930, 935 .....6603-04
- Bottom Screen, 27 5/8" x 33 1/4", Model SC-35V, SC-34,  
850, 850-T, 950, 951, 952 .....6603-00
- Bottom Screen, 27 5/8" x 46 5/8", Model SC-45V, SC-46,  
960, 960-DLX, 960-T, 960-SE, 965, and 966 .....6603-01
- Bottom Screen, 27 5/8" x 57", Model 970, 975, 976 .....6603-02
- Bottom Screen, 27 5/8" x 71 1/2", Model 985 .....6603-03
- Bottom Screen, 33 1/2" x 45 1/2", Model 1400, 1436 .....6603-08
- Bottom Screen, 33 1/2" x 57 1/2", Model 979, 1500, 1536 .....6603-09
- Bottom Screen, 33 1/2" x 71 1/2", Model 1600, 1636 .....6603-10
- Bottom Screen, 33 1/2" x 95 1/2", Model 1800, 1836 .....6603-11

Note - Bottom screens are plus UPS and may be in 2 pieces to meet shipping size limits - call for shipping cost.

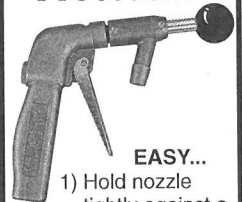
- 24 Screen Support, 28" deep cabinets .....6603-28
- 25 Trim Seal Ring, rear air inlet - Rubber, all models .....6200-09

## CABINET PARTS BREAKDOWN

MAXIMUM AIR PRESSURE IS 125 PSI



### Quick BACKFLUSH Procedure



EASY...

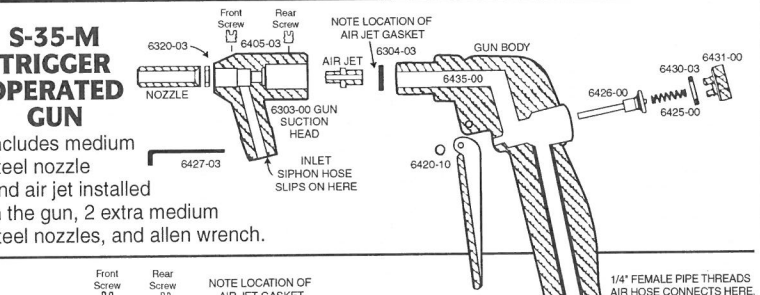
- 1) Hold nozzle tightly against a rubber ball.
  - 2) Push foot pedal or pull trigger 2-3 seconds to backflush.
  - 3) Resume blasting.
- Always backflush with gun inside cabinet.  
See "B" in 3rd section on page 7 for detailed information.

Parts are for replacement of "wear items" and for normal maintenance and are not intended to be resold in quantity for manufacturing purposes, nor to be used on equipment not manufactured by us. **Accordingly, we reserve the right to limit the sale of certain components.**

## S-35 & C-35 POWER GUN PARTS BREAKDOWN

### S-35-M TRIGGER OPERATED GUN

Includes medium steel nozzle and air jet installed in the gun, 2 extra medium steel nozzles, and allen wrench.



### VERY IMPORTANT!

Note exact position of 6304-03 Air Jet Gasket. Gasket fits over larger diameter of air jet, and larger end of air jet fits into barrel of gun. (Smaller end faces towards 6303-00 Gun Suction Head.) If position of Air Jet Gasket is reversed, gun positively will not work.

Part	Description
S-35-M	Trigger Gun (also S-35-S & S-35-L)
C-35-M	Cabinet Gun (also C-35-S & C-35-L)
6303-00	Die Cast Head Assembly (with steel nozzle and air jet installed)
6304-03	Air Jet Gasket (3 pk)
6420-10	Trigger & Pin Assembly
6425-00	Gun Spring (2 pk)

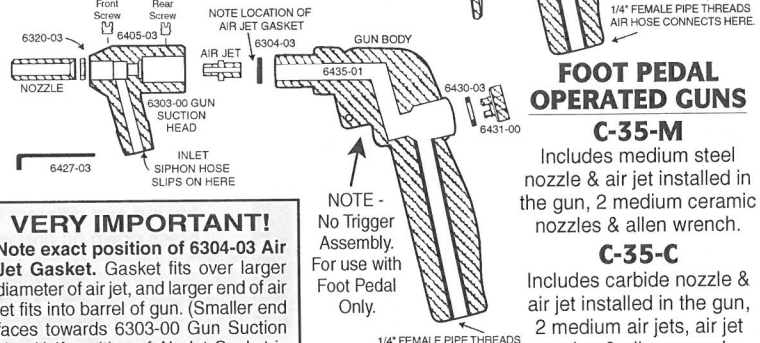
### FOOT PEDAL OPERATED GUNS

#### C-35-M

Includes medium steel nozzle & air jet installed in the gun, 2 medium ceramic nozzles & allen wrench.

#### C-35-C

Includes carbide nozzle & air jet installed in the gun, 2 medium air jets, air jet gasket & allen wrench.



Part	Description
6426-00	Valve Stem Assembly, complete
6427-03	Allen Wrench (3 pk)
6435-00	Gun Body with Trigger and Valve
6435-01	Gun Body (Foot Pedal use only)
6430-03	Gun Nut O-Ring (3 pk)
6431-00	Gun Nut with O-Ring
6420-03	Nozzle Gasket (3 pk)
6405-03	Set Screw (3 pk)



# TROUBLESHOOTING: Siphon Fed Cabinets

PROBLEM	CAUSE	CORRECTIVE ACTION
Little or no abrasive coming out of power gun	<p>A. <b>Incorrect nozzle/air jet setup</b></p> <p>B. Poor suction (Also see "D" in 2nd section)</p> <p>C. Low air supply (under 3 HP) or obstruction in your air line system</p> <p>D. Moist abrasive</p> <p>E. Moisture in the incoming air supply</p>	<p>A. <b>IMPORTANT</b> - Nozzle and air jets are color-coded and installed in MATCHING SETS. If nozzle and air jet do not match, unit will not work. If necessary, carefully measure hole size in both parts (SMALL: Nozzle 13/64" ID, Air Jet 5/64" ID; MEDIUM: Nozzle 1/4" ID, Air Jet 7/64" ID; LARGE: Nozzle 5/16" ID, Air Jet 5/32" ID).</p> <p>B. Remove hose from bottom inlet of gun suction head. Pull trigger or press foot pedal and blow air through gun. Put finger over bottom inlet of 6303-00 Gun Suction Head. A definite "suction" should be felt. If not, check that gun suction head is seated TIGHTLY against 6304-03 Air Jet Gasket and that the gasket surface is clean. When reassembling gun suction head to gun, push parts together VERY TIGHTLY or a loss of suction will result.</p> <p>C. Low air supply requires the use of the smaller gold nozzles and air jets. Also check your incoming air line system for clogged separators, faulty regulators and valves, or obstruction in air hose. Any minor problem in the incoming air supply can be CRITICAL. To check: connect air hose (of proper size) directly to your compressor, bypassing all regulators and separators. If air volume is increased, recheck your air line system and replace necessary parts.</p> <p>D. Abrasive can contain a considerable amount of moisture, even though it appears dry. Always purchase abrasive in sealed bags. (Strain before use.)</p> <p>E. Compressors (especially under heavy loads) put out moisture in a vapor form that can pass through moisture traps. We recommend a Coalescing Air Filter (3405-30) at the cabinet to eliminate moisture (extra cost option).</p>
Surging or sputtering of the abrasive flow at the nozzle	<p>A. <b>Incorrect nozzle/air jet setup</b></p> <p>B. Hose obstruction: clogged or blocked</p> <p>C. Worn-out nozzle/jet</p> <p>D. Worn-out pickup tube</p>	<p>A. Nozzles and air jets are color-coded and must be changed in sets (see "A" above). Also check exact position of 6304-03 Air Jet Gasket when installing parts. (See page 6 for correct position of gasket and air jet.)</p> <p>B. Sometimes a particle of rust or other obstruction can fall into the air inlet of the siphon hose and cause problems. Remove siphon hose and clean thoroughly. See "B" in 3rd section for details.</p> <p>C. Replace worn parts. Be sure parts seat firmly against gaskets to prevent loss of suction and premature wear.</p> <p>D. Inside the funnel of the cabinet is a metal pickup tube. Depending on the type of abrasive used and other factors, the pickup tube will eventually wear out and should be replaced. Signs of a worn-out pickup tube are surging, sputtering, and no or little abrasive in the blast itself.</p>
Air only coming out of the nozzle	<p>A. <b>Obstruction in gun suction head</b></p> <p>B. Obstruction in the siphon tube</p> <p>C. No abrasive or too little abrasive</p>	<p>A. Often an object will wedge in the inlet of the gun suction head. Remove obstruction with a nail or similar pointed object, and blow out with air. If this part is clogged, abrasive cannot enter the gun.</p> <p>B. Release trigger or foot pedal pressure to stop air flow. Place the nozzle end against a scrap of rubber or a rubber ball. Hold tightly against the rubber to seal off the air from coming out the end of the gun. Then pull trigger or push foot pedal and blow obstruction BACKWARDS for several seconds. Resume blasting. If necessary to repeat procedure frequently, abrasive may need strained and/or dried. (See page 6 "Quick Backflush".)</p> <p>C. Check abrasive level and replace as needed. Abrasive may need strained to remove foreign objects. *NOTE - When reusing abrasive, be sure to strain through two (2) layers of window screen or our Sifter Screen (1360-16).</p>
S-35 Gun Only: Sticking of valve in on or off position	<p>A. Worn Valve Disc (6426-00) or 6425-00 Spring</p> <p>B. Abrasive in valve/damaged valve stem</p>	<p>A. Disconnect incoming air. Disassemble valve assembly from power gun by removing 6431-00 Nut. Clean and replace valve and spring assembly as necessary. Rust, dirt, or moisture in your incoming air system will cause this problem. A Coalescing Air Filter (3405-30) is recommended to alleviate this problem (extra cost option).</p> <p>B. Same as above. Remove obstruction and disassemble. Lightly sand the valve stem before replacing.</p>
Wear items (These items are not guaranteed.)	<p>A. Nozzle wears out</p> <p>B. Air jet wears out</p> <p>C. Gun suction head wears out</p>	<p>A. After several hours' use, the nozzle will wear from the inside out, due to the abrasive and air mixture swirling around the inside of the nozzle. Wear always takes place on one side of the nozzle. Examine and replace nozzles as needed. (Use ceramic or carbide nozzles for longer life.) Rotate 1/4 turn after 3 hours of use for longer life.</p> <p>B. Air jet wears on one side. Change as needed (normally, one air jet for every three nozzles).</p> <p>C. Gun suction head wears from the inside out, the same as the nozzle, usually on one side. This is normal. Replace as needed (we suggest stocking a supply of nozzles, air jets, and gun suction heads).</p>

# TROUBLESHOOTING - Vacuum Systems

PROBLEM	CAUSE	CORRECTIVE ACTION
Final Filter is filling up with dust and dirt.	<p>A. HEPA Filter cartridge loose</p> <p>B. Hole in HEPA filter cartridge</p> <p>C. Use of fine or worn-out abrasive</p>	<p>A. HEPA filter cartridge inside vacuum is loose and not sealing. Tighten bolt on bottom of filter for proper sealing. See Installation Instructions (page 4).</p> <p>B. This can be due to the following:</p> <ol style="list-style-type: none"> <li>(1.) Normal wear - suggest replacing HEPA filter cartridge (#6011-HI).</li> <li>(2.) Improper maintenance (rough handling in cleaning, scraping surface with a wire brush or putty knife, beating against concrete or any hard surface). Always handle HEPA filter cartridge with extreme care, brushing off surface with a soft cloth or soft brush. Anything else will damage the HEPA filter's surface, causing holes and eventual leakage. Damage to the vacuum motor will result.</li> </ol> <p>C. Vacuum is designed for use with abrasives up to 80 grit size, which is about the consistency of ordinary table salt or sugar. If finer or worn-out abrasives are used, the dust will slowly restrict HEPA filter cartridge, causing premature failure of the vacuum motor. It is not practical to blast with abrasives finer than 100 mesh size* or worn-out abrasives. Use of such abrasives will void the vacuum motor warranty. * The higher the grit size or mesh size, the finer the abrasive. Vacuum is specifically designed for use with abrasives having a mesh size of 35-80.</p>
Screeching sound in motor	A. Inner bearing failure	<p>A. Any of the above conditions will allow abrasive to pass through the HEPA filter cartridge and into the vacuum motor. This abrasive will damage the motor bearings, causing a screeching sound, especially on start-up. Eventually, the vacuum motor will seize up and fail in operation.</p> <ol style="list-style-type: none"> <li>(1.) Replace vacuum motor and HEPA filter cartridge.</li> <li>(2.) Review all conditions in section above to help prevent motor failure.</li> </ol>
Poor visibility in cabinet due to lack of vacuum	<p>A. Clogged HEPA filter cartridge</p> <p>B. Worn-out abrasive</p> <p>C. Improper abrasive</p>	<p>A. HEPA filter cartridge requires some maintenance after every 30-40 hours of use. During use, if vacuum decreases, HEPA filter cartridge is gradually being coated with dusty abrasive (this is normal). <b>QUICK FIX:</b> To improve vacuum without disassembly, shut off and unplug vacuum 115 volt cord. Pick up vacuum and tap lightly against the floor. This will dislodge dust, which will fall off filter into bottom of lower vacuum container. Resume normal operation.</p> <p>B. Worn-out abrasive (or using abrasive of 100 grit or finer). As abrasive hits objects being blasted, it eventually turns to dust, resulting in decreased visibility inside cabinet and possible clogging of HEPA filter cartridge.</p> <ol style="list-style-type: none"> <li>(1.) Remove and gently clean HEPA filter cartridge by brushing surface with a soft cloth or soft brush. Do not beat against concrete or any hard surface. Do not scrape with wire brush or putty knife. Any of these "don'ts" will damage the filter. <b>IT IS NOT ECONOMICAL TO BLAST WITH WORN-OUT ABRASIVE.</b></li> <li>(2.) Discard worn-out (or fine abrasive) and replace with new abrasive in 35-80 grit size only.</li> </ol> <p>C. Abrasive with a grit size of 100 or finer should not be used.</p> <p><b>DO NOT USE SILICA SAND for abrasive blasting - Health Hazard.</b></p>



# Skat Blast Abrasive Blast Cabinets - Made in USA!

Skat Blast BUYER'S GUIDE																				
S = Standard Equipment   O = Optional (extra cost)   - = Not Available   (2) = Qty   All Skat Blast Cabinets are MADE IN USA																				
MODEL	SLANT TOP SERIES					SKAT CAT SERIES					PROFESSIONAL SKAT SERIES					COMMERCIAL SERIES				
	SC-33	SC-35V	SC-45V	SC-28	SC-34	SC-40	SC-46	940-DLX	960-DLX	970	985	992	966	976	979	1436	1536	1636	1836	
OVERALL SIZE:																				
Width	36"	36"	48"	30"	36"	42"	48"	42"	48"	60"	74"	96"	48"	62"	61 1/2"	48"	61 1/2"	74"	98"	
Depth	23"	30"	30"	30"	30"	30"	30"	30"	30"	30"	30"	30"	30"	30"	35"	35"	35"	35"	35"	
Height	54 1/4"	61 1/2"	61 1/2"	64 1/2"	64 1/2"	64 1/2"	64 1/2"	64 1/2"	64 1/2"	64 1/2"	64 1/2"	64 1/2"	71"	71"	64 1/2"	73 1/2"	73 1/2"	73 1/2"	73 1/2"	
WORK AREA:																				
Width	34"	34"	46"	28"	34"	40"	46"	40"	46"	58"	72"	92"	46"	58"	58"	46"	58"	72"	96"	
Depth	22"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"	28"	34"	34"	34"	34"	34"	
Height	20 1/2"	27"	27"	28"	28"	28"	28"	28"	28"	28"	28"	28"	34 1/2"	34 1/2"	28"	36"	36"	36"	36"	
POWER GUN, USA:																				
S-35 Trigger Operated	S	S	S	S	S	S	S	-	-	-	-	-	-	-	-	-	-	-	-	
C-35 Foot Pedal Operated	O	O	O	O	O	O	O	S	S	S	S	S(2)	S	S	S	S	S	S(2)	S(2)	
NOZZLES, Size Medium:																				
3 Steel, 1 Air Jet	S	S	S	S	S	S	S	-	-	-	-	-	-	-	-	-	-	-	-	
1 Steel, 2 Ceramic, 1 Air Jet	-	-	-	-	-	-	-	S	S	S	S	-	S	S	-	-	-	-	-	
Tungsten Carbide, 1 Air Jet	O	O	O	O	O	O	O	O	O	O	O	S(2)	O	O	S	S	S	S(2)	S(2)	
AIR REQUIREMENTS:																				
cfm @ 80 psi, med nozzle	10-15*	10-15*	10-15*	10-15*	10-15*	10-15*	10-15	10-15	10-15	10-15	10-15	10-30	10-15	10-15	10-15	10-15	10-15	10-30	10-30	
GAUNTLET GLOVES:																				
24"	S	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
28"	-	S	S	S	S	S	S	S	S	S	S(2)	S(2)	S	S	S	S	S(2)	S(2)	S(2)	
32"	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
ABRASIVE, 50lbs Skat Magic:																				
S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	
LENS SIZE:																				
12"x24" Acrylic w/peel-off	S	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
12"x24" Tempered w/peel-off	-	S	S	S	S	S	S	-	-	-	-	-	-	-	-	-	-	-	-	
12"x33" Tempered w/peel-off	-	-	-	-	-	-	-	S	S	-	S(2)	S(2)	S	-	-	S	-	S(2)	S(2)	
12"x45" Tempered w/peel-off	-	-	-	-	-	-	-	-	-	S	-	-	-	S	S	-	-	-	-	
LIGHTING, 115 Volt:																				
S	S	S	S	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
Floodlight Holder, no bulb	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
Floodlight Holder with 90w bulb & on-off switch	-	-	-	S	S	S	S	S	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	
CONSTRUCTION, Steel:																				
Cabinet Body, gauge	22	22	20	22	22	22	20	22	20	18	18	18	20	18	18	14	14	14	14	
Top-Load Door, 22 ga	S	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
Side Door, 11ga with welded angle-iron framework	-	S	S	S	S	S	S	S	S	S	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	S(2)	
Fully Assembled	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	
DUST COLLECTION:																				
Vac-50 HEPA Vacuum	O	S	S	O	S	S	S	S	S	S	S	S(2)	S	S	S	-	-	-	-	
180-DC Dust Collector	-	-	-	-	-	-	-	-	-	O	O	O	O	O	O	S	S	-	-	
310-DC Dust Collector	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	O	O	S	S	
SHIP WT, Lbs:																				
Motor Freight (Truck)	220	330	370	285	330	350	370	350	370	430	495	625	425	480	520	710	775	1025	1350	

\* If your air supply is 3-5 HP, you can purchase low air (4-8 cfm) supply nozzle setup #6300-50 - extra cost.







# ! WARNING - IMPORTANT SAFETY INSTRUCTIONS

## RESPIRATOR REQUIRED



- A NIOSH/OSHA-approved dust respirator must be worn during operation of the cabinet and when loading, unloading, or servicing cabinet or vacuum. Even though cabinet door is closed, door is continually opened and closed while parts are loaded.
- **! WARNING** DO NOT USE SILICA SAND OR ABRASIVES CONTAINING SILICA for abrasive blasting, even within a closed cabinet - HEALTH HAZARD. The use of abrasives containing silica or other abrasives can be dangerous to your health and can lead to silicosis, shortness of breath, coughing, and other respiratory problems.

PLEASE CONSULT OSHA or OTHER STANDARDS FOR SAFETY EQUIPMENT REQUIRED FOR YOUR APPLICATION.



- **SLIP/FALL HAZARD.** Clean up abrasive spills immediately. Glass Beads and other abrasives are as SLIPPERY AS ICE. Use caution.



- **CUT/SHARP EDGE HAZARD.** Always wear leather gloves and long sleeve jacket when assembling, unloading, moving, or servicing cabinet or components, as metal has sharp edges, corners, and surfaces.



- **EYE PROTECTION REQUIRED.** When abrasive blasting, the use of approved safety goggles is MANDATORY to protect user from dust around the area or in case of lens breakage.



- **DAILY MAINTENANCE REQUIRED.** Disconnect air pressure before servicing unit. Check gloves, nozzles, gaskets & lens for wear or leaks. Replace as needed. **Always use TEMPERED OR SAFETY GLASS as a lens replacement.**



- **ELECTRICAL SHOCK HAZARD.** Do not modify light, vacuum, or plug at end of power cord. NEVER operate cabinet or vacuum near water or in a damp location. Electrical receptacle in your shop must be 115 volt and grounded. If using an extension cord, it must be a 3-prong, grounded-type and be the proper wire size. DO NOT USE VACUUM AS A WET VACUUM, nor for vacuuming of hazardous materials.



- **HIGH PRESSURE AIR CAN BE DANGEROUS.** Abrasive Blast Cabinets operate on air pressure in ranges of 40-120 PSI. NEVER exceed 125 PSI. High pressures will result in premature wear of components.
- **DISCONNECT** incoming air line when adding abrasive or when servicing valve, hoses, or power gun.

## ! DANGER - BLAST HAZARDS - IMPORTANT!



To prevent serious injury or death:

- Do not point blast directly at fingers or hands, even though wearing gloves.
- Do not point abrasive stream at lens or door opening of cabinet.
- **NEVER OPEN DOOR WHILE BLASTING.**



EXPLOSION HAZARD

To prevent serious injury or death:

- **NEVER** blast items containing oils, gas, or flammable liquids, as abrasive hitting metal can spark and cause a dangerous explosion.

## TROUBLESHOOTING: Siphon Fed Cabinets

PROBLEM	CAUSE	CORRECTIVE ACTION
Little or no abrasive coming out of power gun	<p>A. <b>Incorrect nozzle/air jet setup</b></p> <p>B. Poor suction (Also see "D" in 2nd section)</p> <p>C. Low air supply (under 3 HP) or obstruction in your air line system</p> <p>D. Moist abrasive</p> <p>E. Moisture in the incoming air supply</p>	<p>A. <b>IMPORTANT</b> - Nozzle and air jets are color-coded and installed in MATCHING SETS. If nozzle and air jet do not match, unit will not work. If necessary, carefully measure hole size in both parts (SMALL: Nozzle 13/64" ID, Air Jet 5/64" ID; MEDIUM: Nozzle 1/4" ID; Air Jet 7/64" ID; LARGE: Nozzle 5/16" ID, Air Jet 5/32" ID).</p> <p>B. Remove hose from bottom inlet of gun suction head. Pull trigger or press foot pedal and blow air through gun. Put finger over bottom inlet of 6303-00 Gun Suction Head. A definite "suction" should be felt. If not, check that gun suction head is seated TIGHTLY against 6304-03 Air Jet Gasket and that the gasket surface is clean. When reassembling gun suction head to gun, push parts together VERY TIGHTLY or a loss of suction will result.</p> <p>C. Low air supply requires the use of the smaller gold nozzles and air jets. Also check your incoming air line system for clogged separators, faulty regulators and valves, or obstruction in air hose. Any minor problem in the incoming air supply can be CRITICAL. To check: connect air hose (of proper size) directly to your compressor, bypassing all regulators and separators. If air volume is increased, recheck your air line system and replace necessary parts.</p> <p>D. Abrasive can contain a considerable amount of moisture, even though it appears dry. Always purchase abrasive in sealed bags. (Strain before use.)</p> <p>E. Compressors (especially under heavy loads) put out moisture in a vapor form that can pass through moisture traps. We recommend a Coalescing Air Filter (3405-30) at the cabinet to eliminate moisture (extra cost option).</p>
Surging or sputtering of the abrasive flow at the nozzle	<p>A. <b>Incorrect nozzle/air jet setup</b></p> <p>B. Hose obstruction: clogged or blocked</p> <p>C. Worn-out nozzle/jet</p> <p>D. Worn-out pickup tube</p>	<p>A. Nozzles and air jets are color-coded and must be changed in sets (see "A" above). Also check exact position of 6304-03 Air Jet Gasket when installing parts. (See opposite side for correct position of gasket and air jet.)</p> <p>B. Sometimes a particle of rust or other obstruction can fall into the air inlet of the siphon hose and cause problems. Remove siphon hose and clean thoroughly. See "B" in 3rd section for details.</p> <p>C. Replace worn parts. Be sure parts seat firmly against gaskets to prevent loss of suction and premature wear.</p> <p>D. Inside the funnel of the cabinet is a metal pickup tube. Depending on the type of abrasive used and other factors, the pickup tube will eventually wear out and should be replaced. Signs of a worn-out pickup tube are surging, sputtering, and no or little abrasive in the blast itself.</p>
Air only coming out of the nozzle	<p>A. <b>Obstruction in gun suction head</b></p> <p>B. Obstruction in the siphon tube</p> <p>C. No abrasive or too little abrasive</p>	<p>A. Often an object will wedge in the inlet of the gun suction head. Remove obstruction with a nail or similar pointed object, and blow out with air. If this part is clogged, abrasive cannot enter the gun.</p> <p>B. Release trigger or foot pedal pressure to stop air flow. Place the nozzle end against a scrap of rubber or a rubber ball. Hold tightly against the rubber to seal off the air from coming out the end of the gun. Then pull trigger or push foot pedal and blow obstruction BACKWARDS for several seconds. Resume blasting. If necessary to repeat procedure frequently, abrasive may need strained and/or dried. (See opposite side "Quick Backflush".)</p> <p>C. Check abrasive level and replace as needed. Abrasive may need strained to remove foreign objects. *NOTE - When reusing abrasive, be sure to strain through two (2) layers of window screen or our Sifter Screen (1360-16).</p>
S-35 Gun Only: Sticking of valve in on or off position	<p>A. Worn Valve Disc (6426-00) or 6425-00 Spring</p> <p>B. Abrasive in valve/ damaged valve stem</p>	<p>A. Disconnect incoming air. Disassemble valve assembly from power gun by removing 6431-00 Nut. Clean and replace valve and spring assembly as necessary. Rust, dirt, or moisture in your incoming air system will cause this problem. A Coalescing Air Filter (3405-30) is recommended to alleviate this problem (extra cost option).</p> <p>B. Same as above. Remove obstruction and disassemble. Lightly sand the valve stem before replacing.</p>
Wear items (These items are not guaranteed.)	<p>A. Nozzle wears out</p> <p>B. Air jet wears out</p> <p>C. Gun suction head wears out</p>	<p>A. After several hours' use, the nozzle will wear from the inside out, due to the abrasive and air mixture swirling around the inside of the nozzle. Wear always takes place on one side of the nozzle. Examine and replace nozzles as needed. (Use ceramic or carbide nozzles for longer life.) Rotate 1/4 turn after 3 hours of use for longer life.</p> <p>B. Air jet wears on one side. Change as needed (normally, one air jet for every three nozzles).</p> <p>C. Gun suction head wears from the inside out, the same as the nozzle, usually on one side. This is normal. Replace as needed (we suggest stocking a supply of nozzles, air jets, and gun suction heads).</p>