

INSTRUCTION MANUAL

SB-420 Sandblasting Cabinet (240V)



S302

CONTENTS

1. IMPORTANT WARNING	pg.1
2. IMPORTANT NOTICE	pg.2
3. ASSEMBLY INSTRUCTIONS	pg.2&3
4. OPERATING INSTRUCTIONS	pg.3&4
5. MAINTENANCE INSTRUCTIONS	pg.4&5
6. MAINTAIN SUCTION EFFICIENCY WITH SIMPLE STEPS	pg.5&6
7. SUPPLY AIR PIPE SIZE	pg.6
8. CABINET PARTS DIAGRAM & PARTS LIST	pg.7&8

IMPORTANT WARNING

Read all instructions before using this equipment. For efficient and safe production, reference OSHA requirements.

Remember:

1. Start up preparations:

- Supply air line should be sized according to the table shown on page 6. All hoses should be rated at least 125 PSI and an isolation valve should be installed so that supply air can be turned off and then disconnected from blast machine for servicing.
- Supply air should be dry and clean from oil and other contaminants. (I.e.use air dryer, coalescent filter, or moisture separator as needed.)
- Blast machine must be grounded to avoid shock.
- Electric extension cords should be three wire grounded, and rated for the amperage of the blaster. Check nameplate for rated amps.

2. Operator's responsibilities before starting:

- Inspect fittings and hoses for damage and wear.
- Check the seal on all doors. Only operate the blast cabinet with all doors securely closed and dust collection system running.
- Clean dust from dust collector and clean filter as needed.

3. Caution:

- Watch for silicosis (from dust created when using silica sand as a blast media) or toxic dust hazard. **DO NOT USE MEDIA CONTAINING FREE SILICA.**
- Unless otherwise specified, working pressure of blast machine and related components must not exceed 125 PSI.
- Keep blast nozzle controlled and aimed at the work.

4. Maintenance

- Keep your machine in good repair. Use Nestor parts and do not substitute or modify Nestor supplied items.

IMPORTANT NOTICE

TO DISTRIBUTORS, PURCHASERS AND END USERS NESTOR PRODUCTS

The information provided described and illustrated in this material is intended for experienced, knowledgeable users of abrasive blasting equipment and supplies (products).

The products described in this material may be combined as determined solely by the user in a variety of ways and purposes. However no representations are made as to intended use, performance standards, engineering suitability, safe practices or compliance with government regulations and laws that apply to these products, products of others, or a combination of various products chosen by the user or others. It is the responsibility of the users of these products, products of third parties, and a combination of various products, to exercise caution and familiarize themselves with all applicable laws, government regulations and safety requirements.

Nor are representations made or intended as to the useful life, maintenance cycles, efficiency or performance of the referenced products of any combination of products.

This material must not be used for estimating purposes. Production rates, labor performance or surface finishes are the sole responsibility of the user based on the users expertise, experience and knowledge of industry variables.

It is the responsibility of the user to insure that proper and comprehensive training of operators has been preformed and all environmental and safety precautions observed.

Nestor provides a variety of excellent products to the surface preparation industry, and we are confident that all proficient users, operators and contractors in this industry will continue to use our products in a safe and knowledgeable manner.

Before using this product, read all instructions, literature, labels, specifications and warnings sent with and affixed to the unit. If operation of the unit is unclear after reading this manual, contact your supervisor for instructions. It is the responsibility of the employer to read the following instructions to users of this equipment, who are unable to read. Periodic inspection at the work site should be made by supervisory personnel to ensure the blast machine is being properly used and maintained. A copy of this owner's manual must be kept with the blast machine and readily accessible to the blast machine operators at all times.

ASSEMBLY INSTRUCTIONS

1. Remove all parts from inside cabinet including floor grate from bottom of crate, underneath cardboard.
2. Remove all parts from inside cabinet.
3. Place cabinet on its top(#22).
4. Attach legs using four 1/4 x 1/2" bolts.
 - a) Front left leg has name plate.
 - b) Rear legs will also take 2 self tapping screws each.
5. Stand cabinet upright on legs.
6. Attach bracket with pressure gauge (#8) to left front leg with two 1/4 x 3/4" bolts, lock washers and nuts.

7. Place foot pedal between front legs.
8. Attach metering valve (#13) using three self-tapping screws to back bottom on cabinet. Snap closed with door catch.
9. Attach left and right doors (#6) with four nuts.
10. Loosen bolts on door catches (#20) and move out to full extent and tighten bolts. Moving them in slightly will tighten door seal.
11. Place glass (#19) on top of cabinet.
12. Place light fixture (#1) on glass with light switch on right side. Fasten to cabinet with four 1/4 x 3/4" bolts and flat washers.
13. Dust Collector
 - a) Attach body of dust collector to rear panel (right side) aligning pipe with hole. Use 1/4" x 3/4" bolts and flat washers.
 - b) Place top of dust collector (with motor and filter) into top of unit. Do up the 2 catches.
 - c) Remove inlet box that covers the dust collector pipe inside the cabinet and place a bead of caulking around pipe to seal it. Replace inlet box.
14. Tighten all bolts, nuts and screws.
15. Place floor grate with cut out corner to front right of cabinet. Bring hoses through opening.
16. Plug dust collector into female plug coming from light. Then plug male cord from light into 240V 50HZ supply. Turn on switch on vacuum, the switch on cabinet will turn on light and vacuum or dust collector.
17. Put media into cabinet through floor grate. (approx. 1/4 bag.)

OPERATING INSTRUCTIONS

1. Preparing parts for blasting

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

2. Air pressure

Operating Pressure: from 50 to 80 PSI. (pounds per square inch)(higher pressures (up to 125) can be used but this breaks down some types of media's prematurely).(ex. glass bead)

- Set air pressure to 80 PSI. Most parts for blast cleaning can be blasted at 80 PSI. For light gauge steel, Aluminum, and other more delicate parts, start at lower pressure and gradually increase the pressure until the desired finish is achieved.

WARNING:

DO NOT CONNECT TO HIGH PRESSURE BOTTLE GAS, RUPTURE AND EXPLOSION CAN OCCUR.

3. Gun angle and distance

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

WARNING:

GUN MUST ALWAYS BE POINTED AWAY FROM THE OPERATOR AND TOWARDS ITEMS BEING PROCESSED. NEVER BLAST WITH ANY OF THE CABINET DOORS OPEN. WHILE LOADING AND UNLOADING, NO ONE SHOULD BE AT THE OPERATOR STATION, AT THE FRONT OF THE BLAST CABINET.

- Cabinets are available with safety doors so that the gun cannot be operated unless the doors are closed. Contact NESTOR for further information.
4. Media
- Media should be of good quality and dry. Moisture will cause the media not to flow and will clog metering valve and hopper.
- NEVER USE SAND**
- There are many types and sizes of media for different finishes. If you are having a problem selecting a media for a specific job, contact your distributor for recommendations.
5. Metering Valve
- The metering valve adjusts the amount of media being pulled into the venturi gun. This valve, located at the bottom of the hopper, has the media stored on top of it. When air is sent to the gun from the foot pedal a vacuum is created that sucks air and media up into the gun through the clear media hose. A 7/16" bolt on the top of the metering valve can be adjusted to vary the amount of air that is sucked in through the holes. If the holes are too far closed, the mixture will have too much media and the gun will pulsate. If the holes are too far opened, too little media will go to the gun and production will decrease.
6. Nozzle Size
- By changing to the next larger size of nozzle, production can increase significantly. Larger sized nozzles produce a larger cleaning pattern. This, however, requires more air (your compressor must be able to provide this)

MAINTENANCE INSTRUCTIONS

1. Blasting Gun
- After 10-12 hours of blasting time, the nozzle should be checked. If it shows uneven wear it should be turned 1/4 turn every 10 hours of use.
2. Caking of media
- Media caking is caused by moisture in the air supply or from oily and greasy parts. If this is not corrected media will not flow evenly and will plug up in the metering valve and the gun. Check air supply; if water is present install a good moisture trap. If oily or greasy parts are being blasted, you should degrease and dry the parts first.
3. Reverse pressure
- If media stops flowing occasionally, place thumb over nozzle (hold tight) and push foot pedal down for a couple of seconds. This will cause the system to back blast through the gun and up the media hose. This will help loosen any clogs.
4. Gun air pressure drop
- Set the air pressure to 80 PSI on the air gauge at regulator. Push the foot pedal while holding gun and see if the gauge pressure drops significantly. If the pressure drops, this indicates that there is a restriction in the supply line. This could be hose that is too small, a reducer or quick coupler, a plugged filter, or other piping that doesn't allow enough air through. Also if the cabinet is too far from the air compressor, a pressure drop will occur. Air supply line should be 1/2" or larger.

5. Poor visibility-Excessive dust:
 - Air inlet at front left above regulator, should be free to allow air into cabinet.
 - Dust container full and needs to be cleaned and emptied. (latch at bottom of dust collector or remove black cover on vacuum.
 - Dust cartridge contaminated. (clean or replace filter in dust collector, part #29)
 - Media breakdown; Eventually the media becomes so small that it is essentially dust. Replace media and clean dust collector.
6. Poor visibility-Viewing window
NESTOR windows come with a clear plastic protector on them. As these become pitted they can be easily replaced to extend the life of the window. The window can also be easily replaced.
7. Poor media flow
 - Check for moisture as indicated above. Install moisture trap as needed, Replace damp media and clean hoses and sump.
 - Holes in media hose will cause poor media delivery. Replace hose.
 - Debris in media. Replace or screen media.

MAINTAIN SUCTION EFFICIENCY WITH SIMPLE STEPS

The most common problem customers have with their suction (venturi) blast cabinets is a decrease in production rates. A properly maintained suction cabinet should provide years of constant service. When production rates fall the operator can usually locate the problem by checking

1. Air supply
 - If the pressure gauge on the regulator shows an adequate no-load supply (when the blaster is not running), press the foot pedal. If the pressure drops more than a few PSI your air supply is restricted or inadequate. Clean filters and moisture separators all the way back to the air compressor. Straighten any kinky lines. Use a master gauge to check the air pressure or replace existing gauge if you suspect it is giving you false readings.
2. Blast gun
 - The nozzle will wear out eventually. Replace it if it measures 1/16" over its original size or if it shows uneven wear. Adjust as needed for different media and conditions. A properly working gun will pull 15-17 inches of mercury on a manometer.
3. Dust collector
 - Inadequate cabinet ventilation results in reduced cleaning power at the nozzle as well as diminished view of the work in progress. Use the dust collectors shaker every 20-30 minutes when the cabinet is turned off, (more often in dusty conditions. Empty dust collector at least once a day. Remove filter and blow out occasionally to keep the dust collector or vacuum working efficiently. Replace as needed.
4. Media
 - Use quality blast media sized to the job. Damp or dirty media can bring blasting to an instant halt. Store media in a dry area and load the appropriate quantity. Add enough media through the flooring to have 6" deep of media on top of the metering valve. If you run out of media as you are blasting add enough so it keeps circulating to the gun. The media will eventually break down or get too contaminated to use. The less there is in the system, the less you will have to replace.

5. Media delivery

- Replace any media hose that has soft spots or visible wear. Adjust the metering valve to provide adequate flow. A mixture that is too rich will cause pulsating at the gun. An unusually loud noise while blasting means the mixture is too lean. A rich mixture can result in lower impact velocities, while a lean mixture reduces the number of impacts. Both reduce your cleaning rate.

If everything is adjusted right and you are still not getting the production levels needed, contact your distributor. The suction system may be operating properly, it may be time to get a cabinet with a media reclaimed or a pressure system. Many upgrades are available.

AIR REQUIREMENTS

SUPPLY AIR PIPE SIZE in inches

Line Length	Volume of air through pipe (cfm)									
	25	30	35	40	50	60	70	80	100	125
25'	.75	.75	.75	.75	1	1	1	1.25	1.25	1.25
50'	.75	.75	.75	1	1	1	1	1.25	1.25	1.25
75'	.75	.75	1	1	1	1	1	1.25	1.25	1.25
100'	.75	.75	1	1	1	1	1.25	1.25	1.25	1.25
150'	.75	1	1	1	1	1.25	1.25	1.5	1.5	1.5
200'	1	1	1	1	1	1.25	1.25	1.5	1.5	1.5
250'	1	1	1	1	1	1.25	1.25	1.5	1.5	1.5
300'	1	1	1	1	1	1.25	1.25	1.5	1.5	1.5

SANDBLAST GUN ADJUSTMENT



The sandblast gun comes ready to use but the factory adjustment may not be suitable for your setup. The picture above displays a red arrow pointing towards a bronze locknut on the back of the gun. To adjust the gun loosen this nut and adjust the black fitting either in or out. This will affect the performance of the gun.

To optimize the performance of your sandblast gun the following adjustment can be made.

1. Remove the garnet feed hose to the gun.
2. Loosen the fitting marked with the arrow above with a spanner. Spin the gun around, winding the black fitting out.
3. After the fitting has been wound out approximately 5mm, re-tighten the locknut and reconnect the garnet feed hose to the gun.

There is approximately 25mm of adjustment of the fitting. The picture above shows the fitting screwed all the way in. The pictures below show the fitting at the maximum adjustment as well as mid adjustment.



The adjustment is a “trial and error” process. The adjustment allows for the sandblaster to work as efficiently as possible based on particular needs and set up. Once the optimal position has been found for the gun make sure that the bronze locknut is re-tightened.

Parts Listing for Cabinet

ITEM #	DESCRIPTION	ITEM #	DESCRIPTION
1	Lamp Housing	21	Lid, cabinet
1A	Switch	22	Cabinet
2	Lamp Fixture, 2 Bulbs	23	Legs, Cabinet
3	Lamp	24	Top of D.C.
4	Lamp Window	25	Vacuum Motor
5	Trim-Lock Window Seal, PE	26	Screws
6	Side Door	27	Cover, Motor
7	Door Latch	28	Power Cord
8	Pressure Gauge, 1/4", 150psi	29	Dust Filter
9	Regulator, Air 3/8"	30	Round Dust Collector
10	Hose, Air Push on 1/2"	31	Sealing tape
11	3/8" Foot Pedal Complete	32	Board, Exhaust
12	Metering Valve Plug	33	Push rod
13	Metering Valve	34	Cap, round dust collector
14	Clamp, Gloves	35	Side door-post
15	Gloves, pair	36	Hole
16	Window Frame Cover	37	Cover
17	Glass	38	Bolt
18	Protection Film, PE	39	Web
19	Plastic board	40	Rubber strip
20	Mounting ring, Gloves		

Parts Listing for Gun

ITEM #	DESCRIPTION
1	Nozzle Holding Nut, Brass
2	Ceramic Nozzle set
	Ceramic Nozzle, 4mm
	Ceramic Nozzle, 5mm
	Ceramic Nozzle, 6mm
	Ceramic Nozzle, 7mm
3	O-ring, Nozzle
4	Gun Body, Mod-U-Blast (Only)
5	Air Jet Hex Nut, Brass
6	Sleeve, Air Jet
7	Air Jet
8	Swivel Air Inlet Fitting, 3/8"
9	Media Inlet Fitting, Barb 3/8"
10	Hose, Media 1/2"
11	Hose, Air 1/2"
12	Seal
13	Ring

PARTS DIAGRAM

