PRESSURE SAND BLASTER

10-GALLON

SA-3378

MADE IN TAIWAN

SAND BLASTER CAUTION

There is no hazard in use of this sandblasting equipment when it is used properly; Observe and insure that others observe the safety precautions listed.

Maximum working pressure is 125psi, before connecting air supply to your sandblaster check the air compressor to insure that pressure is peculated in range of 65-125psi. Observe pressure gauge (15) insuring it stabilizes below 125psi.

Wear protective clothing whenever a dust & abrasive hazard exists. Protective clothing at a minimum consists of hood, dust mask and gloves. Protect yourself while loading sand tank, while sandblasting and after completion of blasting until no dust is visible in the air.

Allow no person in work area who is not wearing protective clothing. Follow operation & safety instructions printed on side of tank.

Periodically inspect sand carrying components (22,24,18c,25,26,28) for wear. These are being sandblasted on the inside whenever you use the sandblaster. Replace before failure occurs.

Release air pressure on sand tank before opening tank. To do this turn off valve(18), press the gun (18c) panel to let off pressure. Insure tank pressure gauge reads zero, then open tank.

AIR SUPPLY

Sandblasting requires a large volume of air at high pressure, make sure you don't limit the efficiency of your unit by use of too small an air supply hose.

HOSE I.D.	LENGTH FT	NOZZLE I.D.	COMPRESSOR H.P	AIR 125PSI C.F.M.	SAND USAGE #/HR
3/8"	50	0.10"	2	6	60
"	25	0.125"	4	12	100
1/2"	50	0.150"	7	20	150
"	25	0.175"	10	25	200

Your sandblaster will operate properly with air pressure in the range of 65-125psi.

ABRASIVE SELECTION

The kind of sand you choose will have a large influence on time required to blast clean a given surface area. Sand is not any special material it means only small particles of rock or mixture of rocks. The size for sandblasting would be of a size like table salt.

SAND BLAST MATERIALS LIST

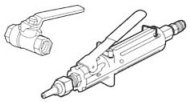
SILICON CARBIDE
ALUMINA
SILICA SAND
BANK SAND*
BEACH SAND*

Bank sand & beach sand even if washed have enough shell, coral & organic materials mixed in that they absorb moisture readily and accounts for these materials frequently plugging up the sand metering valve (18B).

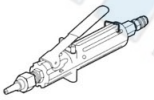
When reusing sand remember it does "WEAR OUT" The sharp edges "ROUND UP" That's when you replace the batch.

LOADING ABRASIVES

1. Check your abrasive, is it dry enough?
2. Put on protective clothing
3. Turn air supply valve (18) to off
4. Press the gun (18c) panel to on



5. Observe pressure gauge (15) to insures it indicates zero pressure.
6. Remove filler cap (12)
7. Insert funnel (29) and load abrasive in amount required to do job but onlt to maximum of 3/4 full.
   Tip: when operating in 90-100% relative humidity the water trap won't get all the moisture, in this condition it is better to load less abrasive, more frequently, to reduce chance of abrasive packing (blockage) at bottom of tank.
8. Close tank with filler cap (12)
9. Loose the gun (18c) panel to off



10. Open air supply valve (18)
11. Check for air leak at filler cap
12. Operate when pressure reaches minimum of 65 psi.

SANDBLAST STARTUP

1. Check valves to be properly ste.
   Air supply (18) "OFF" Throttling (18A) open
   Sand metering (18B) half open Sand blast gun (18c) closed
2. Put on protective clothing
3. Turn air supply valve (18) to "ON"
4. Point nozzle at work so that sand will strike surface at about 45 degree
5. Press the gun (18c) panel to full open.
   5.1 Keep the nozzle moving to change impact pattern on the workpiece to ensure uniform abrading over the whole work area.
   5.2 The flow rate of sand may be irregular when the unit is first started. But if sand is dry the flow will even up in a minute or two.
   5.3 To increase or decrease sand flow rate adjust sand metering valve (18B)
   5.4 To regulate total air flow & pressure at nozzle adjust throttle valve (18A)

SANDBLASTER SHUTDOWN

1. Loose the gun (18c) panel for stop operating.
2. Turn sand metering valve to closed position.
3. Press the gun (18c) panel for operating until all. Sand has cleared from sand hose (24)
4. Loose the gun (18c) panel quickly.
5. Turn air supply valve (18) to closed position.
6. Press the gun (18c) panel to DE-PRESSURIZE sandblaster.
7. Now you can get out of the protective clothing.

TROUBLE SHOOTING

Poor or irregular performance of your sandblaster is due to wet sand, low air volume, low air pressure or worn out nozzle.

Moisture in the sand in sufficient quantity will cause the sand to stop flowing thru the sand metering valve (18B)

A. Use dry sand. Check by laying newspaper on dry surface and dumping 6" cone of sand on the paper, after a few minutes remove sand. If paper is moist don't use the sand.
B. Drain compressor receiver tank of water regularly.
C. Drain water trap (17) regularly.

A low air pressure problem can be established by observing tank pressure gauge (15) reads above 65psi with sand blast gun (18c) closed. Read again with sand blast gun (18c) open if pressure drops below 65psi E air supply is too low in pressure. Nozzles increase in I.D. Thru sand blast action. Simple replacement of nozzle with one of smaller I.D. will increase sand blast efficiency.

YOUR AIR COMPRESSOR

Protect your air compressor and it's engine or motor from damage by sand or dust from sandblasting by

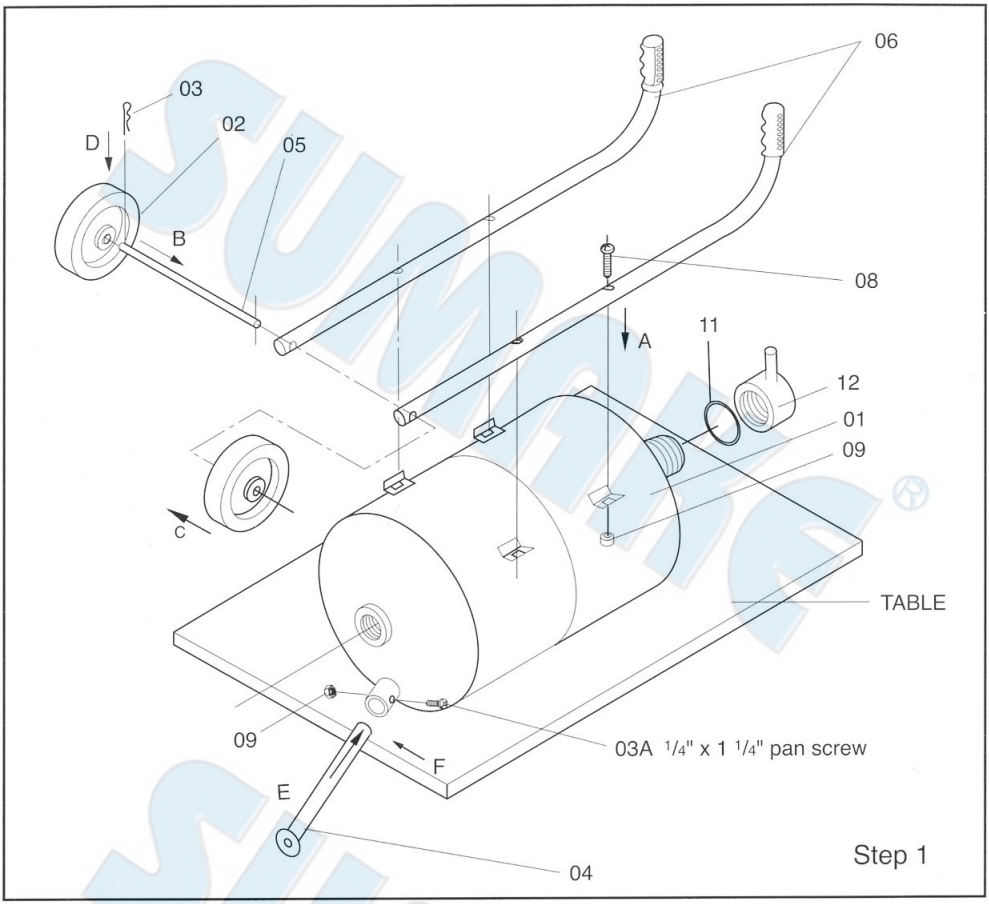
A. Keeping compressor UP-WIND of sandblaster

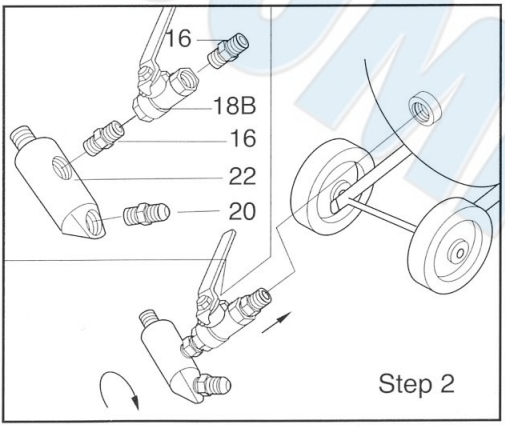
B. In room separate from sandblasting room.

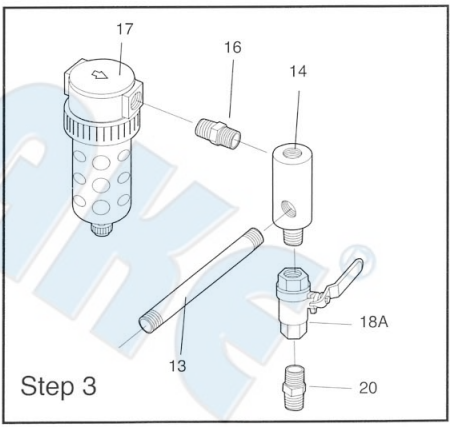
WEAR INSPECTION & PARES REPLACEMENT

The pares of your sandblaster that require frequent wear inspection & occasional replacement are those pares carrying the air sand mixture starting with the 8 foot sand blast hose (24) and onward thru the metal fittings, sand blast gun assembly (18c) and ceramic nozzle.

Air leaks in any of these parts indicate an obvious need for repair. The sand hose has 2 cord plies and wall thickness of 1/4" when new, as its I.D. is sandblasted away the wall becomes thinner. One way to inspect the hose, while wearing protective clothing, is with unit under pressure and sand blast gun (18c) closed run your hand the length of the hose, A spot of enlarged diameter indicates a weakened condition and hose should be replaced.


06
03
02
D
05
B
08
A
11
12
01
09
C
TABLE
09
03A 1/4" x 1 1/4" pan screw
F
E
04
Step 1


16
18B
16
22
20
Step 2


17
16
14
18A
13
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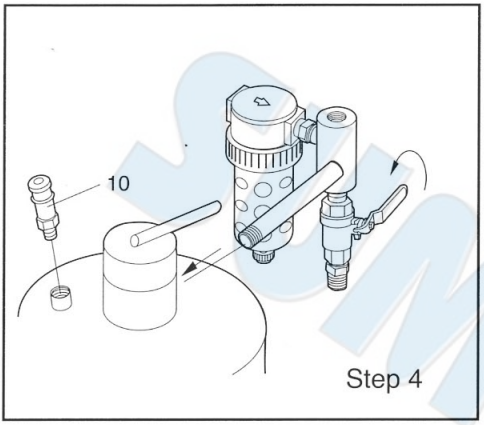
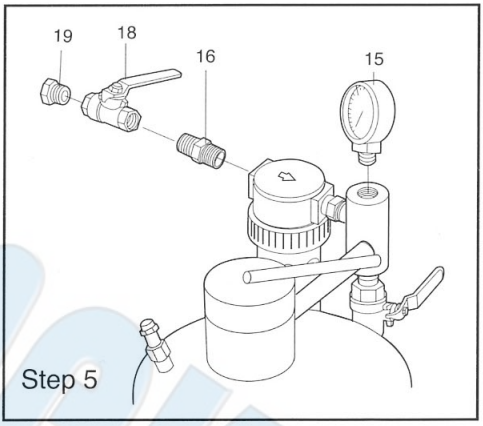
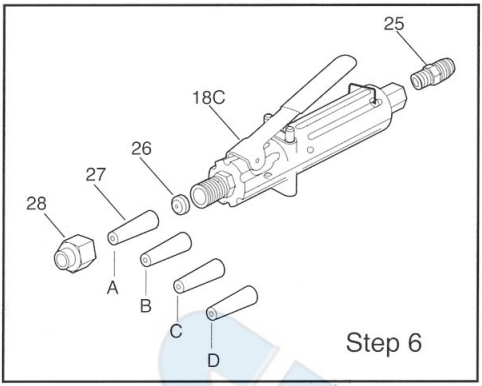
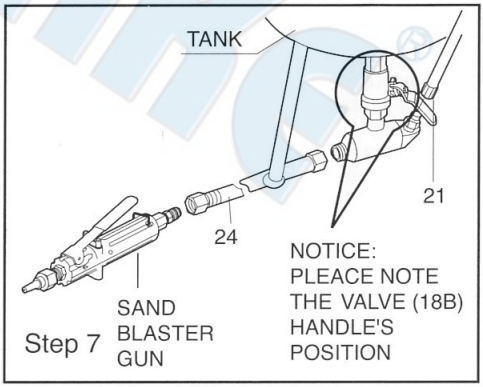
Step 3









PARTS ASSEMBLE

A. First open the box for you own safety read manual before sand blaster.
B. Take every thread parts on tape seal.
C. Step1: Take tank on the table put (06) on (01) and assemble (06)(01) and fix with(08)(09). Than put (05) into (06) , and put (02) into (05) and put (03) into (05).
D. Step2: Assemble sand outlet valve.
E. Step3: Assemble water trap filter & intake manifold.
F. Step4: Assemble (step3) and safety valve.
G. Step5: Assemble air supply valve & pressure gage.
H. Step6: Assemble sand blowing nozzle.
I. Step7: Assemble sand hose.

Parts List

NO	Description
1	Tank
2	Wheel
3	R pin
3A	1/4" x 1 1/4" pan screw
4	Foot
5	Wheel shaft
6	Handlebar
7	Handle grip
8	Pan screw
9	Hex nut
10	Safety valve
11	O. ring
12	Filler cap
13	Joint pipe
14	Intake manifold
15	Pressure gage
16	Nipple connector
17	Water trap filter
18	Valve brass 3/8" (Air supply)
18A	Valve brass 3/8" (Throttling)
18B	Valve brass 3/8" (Sand metering)
18C	Sand blast gun (Nozzle shut off)
19	Made / female connector
20	Nipple connector
21	Air hose
22	Sand outlet pipe
23	
24	Sand hose
25	Nipple connector
26	Gasket
27	Nozzles: A: ø3.6M/M B: ø3.2M/M C: ø2.7M/M D: ø2.4M/M
28	Nozzle cap nut
29	Funnel
30	Hood