IST International Surface Technologies

ISTblast

THE REFERENCE IN SURFACE TREATMENT

SANDBLASTING CABINET - M PRESSURE SERIES

240 V / 380 V

- Warranty
- Safety
- Operation
- Service Parts
- Accessory Information
- Registration Form

CE

INSTRUCTION MANUAL

2023-09-05

TABLE OF CONTENTS

NOTICE TO PURCHASERS AND USERS OF OUR PRODUCTS AND THIS INFORMATIONAL MATERIAL

The products described in this material, and the information relating to those products, is intended for knowledgeable, experienced users of abrasive blasting equipment.

No representation is intended or made as to the suitability of the products described herein for any particular purpose of application. No representations are intended or made as to the efficiency, production rate, or the useful life of the products described herein. Any estimate regarding production rates or production finishes are the responsibility of the user and must be derived solely from the user's experience and expertise, and must not be based on information in this material.

The products described in this material may be combined by the user in a variety of ways for purposes determined solely by the user. No representations are intended or made as to the suitability or engineering balance of the combination of products determined by the user in his selection, nor as to the compliance with regulations or standard practice of such combinations of components or products.

It is the responsibility of the knowledgeable, experienced users of the products mentioned in this material to familiarize themselves with the appropriate laws, regulations and safe practices that apply to these products, equipment that is connected to these products and materials that may be used with these products.

It is the responsibility of the user to insure that proper training of operators has been performed and a safe work environment is provided.

Our company is proud to provide a variety of products to the abrasive blasting industry, and we have confidence that the professionals in our industry will utilize their knowledge and expertise in the safe efficient use of these products.

SAFETY AND WARNING

GENERAL SAFETY

1. Carefully inspect the shipping carton for any signs of transport damage. The damage to the carton often indicates possibility of transport damage to the equipment inside.

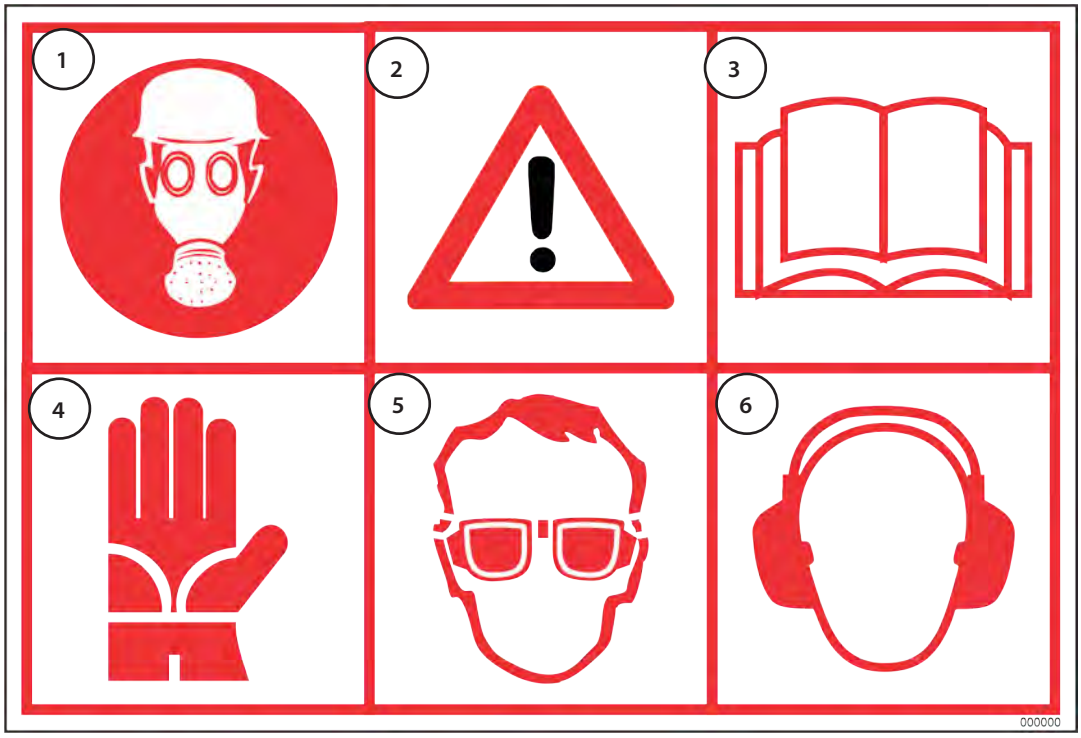
2. Carefully remove your IST SANDBLASTING CABINET from the shipping carton and skid.

3. Check your equipment immediately to ensure that it is free of transport damage. Report any transport damage to the carrier without delay for possible claim procedures. International Surface Technologies inc. is not responsible for damage to equipment after it leaves our warehouse.

4. Check the equipment and compare it with the parts you have received. If any parts are missing, contact the supplier you purchased the equipment from.

Before operating the IST SANDBLASTING CABINET, read this Instruction Manual completely. All IST products are engineered and manufactured to the highest performance standards and have been subjected to detail testing before shipment from the factory.

DANGER AND WARNING LABELS



1. Wear breathing mask
2. Observe warnings at all times.
3. Read the Instruction Manual carefully.
4. Wear rubber gloves.
5. Wear protective eyewear before use
6. Wear earing protection before use

WARNING

« READ ALL INSTRUCTIONS » Failure to follow the SAFETY RULES identified by a BULLET (●) symbol listed BELOW and other safety precautions may result in serious personal injury.

« SAVE THESE INSTRUCTIONS »

GENERAL SAFETY RULES

- **KEEP WORK AREA CLEAN.**
- **KEEP CHILDREN AWAY.** Do not let visitors come in contact with the equipment. All visitors should be kept away from the work area.

PERSONAL SAFETY

WARNING

SANDBLAST CABINET MAY EMIT POTENTIALLY HAZARD DUST AND AIRBORNE CONTAMINANTS DURING OPERATION. YOU MUST WEAR APPROPRIATE BREATHING PROTECTION AT ALL TIMES WHILE OPERATING OR STANDING AROUND THE UNIT.

- **GUARD AGAINST ELECTRIC SHOCK.** Non-skid footwear is recommended where damp or wet ground may be encountered. A ground fault circuit interrupter protected power line must be used for these conditions.
- **DRESS PROPERLY.** Do not wear loose clothing or jewelry. They can be caught in the moving parts. Wear protective hair covering to contain long hair.
- **USE SAFETY EQUIPMENT. WEAR SAFETY GOGGLES** or glasses with side shields.
- **WEAR A DUST PROOF MASK.**
- **STAY ALERT. USE YOUR COMMON SENSE.** Concentrate on what you are doing. Do not operate the unit when you are tired or under the influence of drugs.
- **DO NOT OVERREACH.** Keep proper footing and balance at all times.
- **BEFORE CONNECTING THE UNIT** be sure the power is the same as that specified on the nameplate of the Sand Blasting Cabinet. With power greater than that specified on the nameplate can seriously injure the user – as well as damage the Unit.
- **BEFORE STARTING TO WORK** you must wear earing protections, efficient for 80 dB or more.

UNIT USE AND CARE

- **DO NOT FORCE THE UNIT.** It will perform better and safer at the rate for which it was designed.
- **THE USE OF ANY OTHER ACCESSORIES** not specified in this manual may create a hazard.
- **CLOSE THE MAIN BREAKER SWITCH BEFORE SERVICING** or when not in use.
- **DO NOT ALTER OR MISUSE THE UNIT.** These units are precision built. Any alteration or modification not specified is misuse and may result in a dangerous situation.

  Only trained repairmen should attempt (●) ALL REPAIRS, electrical or mechanical. Contact the nearest IST a repair service facility. Use only IST replacement parts; any other parts may create a hazard.

ENVIRONMENTAL CONDITIONS FOR WHICH THE EQUIPMENT IS DESIGNED

- Indoor location
- Altitude: 2,000 m max.
- Ambient temperature: 40 °C) max.
- Relative humidity: 80 %
- Main supply voltage fluctuation: +/- 10 %
- To use with non combustible dust only

INTRODUCTION

Welcome to the IST ® family of sandblasting products. This booklet contains helpful information and acquaints you with the operation and maintenance of your equipment. Please read carefully and follow our recommendations to assure trouble free operation. If you have any questions, please do not hesitate to contact your distributor or our technical service.

INSTALLATION

1. Unbolt the blast cabinet from the pallet. Attach a strap or a hoist to the eyelets located on the top of the machine and move it to its final location using a lift truck or a crane.
2. Make sure the cabinet is leveled and well grounded. Do not place on a wooden floor or a rubber mat, unless a ground wire has been installed. Check with a qualified electrician.
3. Place the system to the installation location.
4. Unwrap and remove the cabinet from the pallet.
5. Insure there is adequate space on both sides of the cabinet for full opening of part loading/unloading and maintenance access doors.
6. Insure that there is adequate space at both sides of the system for easy access to components such as the reclaimer and dust collector.
7. The dust collector should be located on a leveled area near the back of the cabinet, on the right side (while facing cabinet). Attach one end of the corrugated discharge hose to the outlet of the reclaimer and the other end to the inlet located at the bottom of the dust collector. Secure both ends with the supplied clamps. See dust collector section for more details.

All IST M series cabinets are equipped with a motorized dust collector ranging from 400 to 1,800 cfm.

PNEUMATIC CONNECTION

Connect your shop's air supply line to the air inlet. The hose should have a minimum of ½" inside diameter. Never use male-female quick couplings. **Choose couplings that offer as little restriction to the airflow as possible.**

To properly operate, your IST system use clean, dry air. Moisture or oil from the compressed air supply can contaminate the abrasive, and prevent it from flowing freely and cause inefficient blasting.

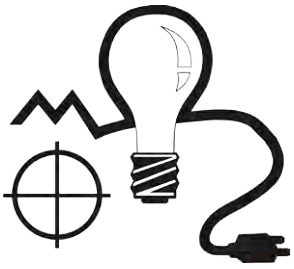
For detailed pneumatic connections, refer to pneumatic diagram page 43.

CAUTION **If you use interlocking connections, secure them with pins. A connection that disconnects under pressure, could cause serious injury.**

ELECTRICAL CONNECTIONS

Connect cabinet power supply cord to standard 240 V outlet.

Note: None-standard voltage is also available.



All electrical connections to the IST cabinet should be made by a qualified electrician and must complied to the codes, standards, and procedures specified by the local authority having jurisdiction.

The customer is responsible for providing appropriate disconnecting means adjacent to the equipment for each incoming power circuit.

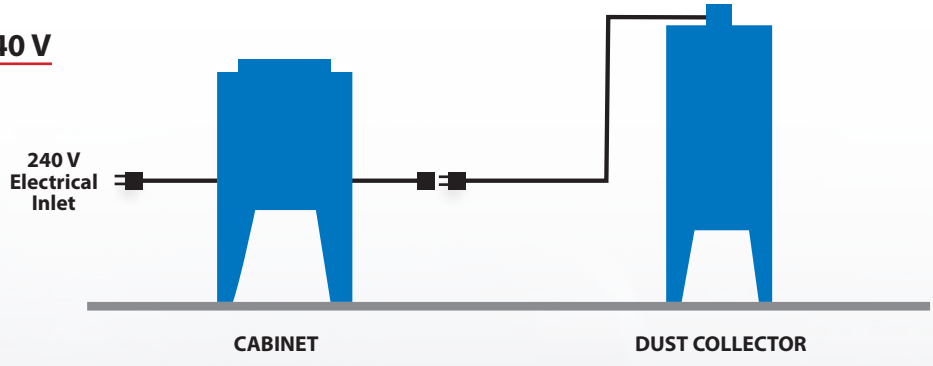
For detailed electrical connections wiring requirements, overload and starter, Refer to electrical drawings on pages 44 to 52.

It is important to connect the IST system to an Earth Ground to bleed off static electricity, which may be generated while blasting. The Earth Ground may also reduce the discomfort an operator may experience when static electricity is discharged.

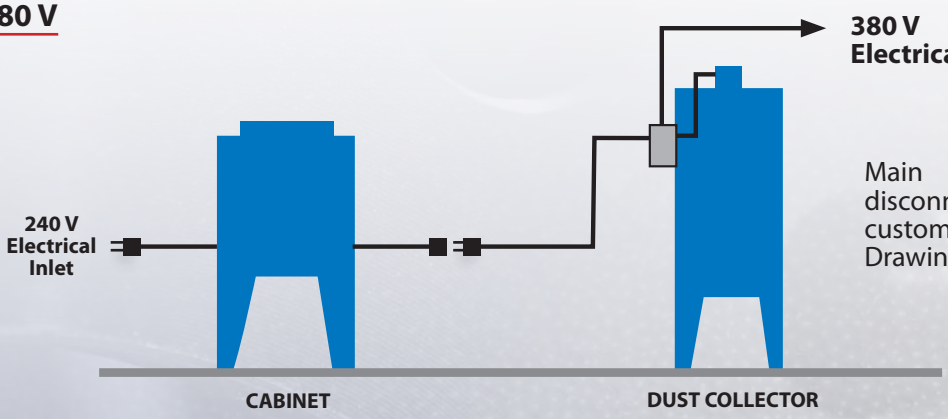
CONNECTIONS TO CABINET AND DUST COLLECTOR

	Dust Collector Model				
	DCM100	DCM600	DCM160/900	DCM230/1200	DCM330/1800
Fan Motor (kW)	0.373 or 0.746	0.746	1.5	Available from 2.25 to 7.46	
Fan Motor (m^3/h)	680 or 1,019	1,019	1,529	2,039	3,058
Power Requirement	240 V			380 V	

DCM Motor 240 V



DCM Motor 380 V



Main entry with fuse disconnect switch supplied by customer. Refer to Electrical Drawings on pages 44 to 52.

PROPER AIRJET/NOZZLE COMBINATIONS

Nozzle I.D.[4]	kPa -->	WORKING PRESSURES (kPa[1]) 138	172	207	35	241	310	345	414	483	551	620	690[0]	827
3.175	m^3/h[3]	12		14	15	17	20	22	24	25	29	32	34	42
	kg/h[2]	22		25	28	31	33	35	37	50	58	63	70	87
4.762	m^3/h	294	27	30	34	37	41	44	51	56	64	70	76	93
	kg/h	43	46	52	58	63	69	75	87	100	110	121	135	165
6.350	m^3/h	294	51	58	63	70	76	83	93	104	115	126	138	165
	kg/h	79	87	99	114	125	137	149	167	180	209	229	252	302
7.937	m^3/h	294	78	90	97	110	119	129	149	172	192	214	234	258
	kg/h	115	129	145	345	156	193	210	239	308	343	377	413	458
9.525	m^3/h	294	107	129	139	155	170	185	214	243	274	294	333	374
	kg/h	169	194	234	253	281	309	337	390	439	490	537	588	659
11.112	m^3/h	294	144	170	190	211	233	253	289	330	367	408	431	510
	kg/h	221	261	307	344	379	381	412	526	598	669	739	808	954
12.700	m^3/h	294	190	219	248	280	304	331	380	428	476	525	574	666
	kg/h	285	333	845	383	500	543	592	680	771	857	947	1006	1197
15.875	m^3/h	294	331	360	406	442	479	523	605	686	768	856	931	1038
	kg/h	490	553	601	667	726	778	850	971	1098	1220	1348	1474	1643

[0] Optimal pressure
[1] kPa: Pressure at nozzle in kilo Pascal
[3] m^3/h: Compressed air required in cubic meters per hour
[2] kg/h: abrasive consumption in kilograms per hour
[4] Nozzle I.D.: nozzle Interior Diameter in millimeters

VERIFY INSTALLATION

1. Check that all pipe and hose connections are tightly fastened and air tight.
2. Check that all electrical box covers are securely installed.
3. Check that the dust drum under the dust collector is sitting firmly and is center (if equipped).
4. Turn the cabinet power switch to the "ON" position. The cabinet lights will power on and the dust collector fan and the reclaimer will start.
5. Set the blast air pressure regulator to the desired pressure.
6. Insert both hands into the cabinet gloves, take the gun and press the foot pedal. Blasting will start, wait a few second and the blast flow will stabilize.
7. Turn the cabinet power switch to the "OFF" position. Light will turn off and the dust collector fan and reclaimer will stop.

CAUTION Disable and lock out power sources before performing service or maintenance work. Do not look into the fan outlet to determine the correct motor rotation. Check that the fan exhaust is clear of tools and free of debris before checking fan rotation. To avoid personal injury, stay clear of the fan exhaust.

LOADING ABRASIVE MEDIA

WARNING

Your suction cabinet is designed to operate efficiently with most **recyclable abrasive media** on the market. However, certain types such as sand, recycled glass or silica are not recommended and should not be used in our blast cabinet.

These abrasives generate very fine dust that may block the bag's pores, obstruct the ventilation system and cause dust accumulation inside the cabinet while in use. Instead, use reclaimable abrasives such as glass beads, aluminum oxide steel grit or plastic media.

For better results for the reclaiming process, **please call one of our technical representatives** if you have to use a different **type of abrasive** from the one your equipment has been set for at the factory.

Manufactured Abrasives

NAME	TYPE	SHAPE	HARDNESS SCALE	DENSITY kg/m³	CONTENT SILICA	DUST FACTOR	MESH SIZE	REUSE FACTOR	AVAILABILITY
Aluminium Oxide	Oxide	Irregular	8 Mohs	1922	None	Low	6-600	Good	Good
Silicon Carbide	Carbide	Angular	9 Mohs	1602-1762	None	Low	6-600	Good	Good
Glass Beads	Silica	Spherical	5-6 Mohs	1602	0 free Silica	Low	20-325	Good	Good
Plastic Grit	Polyurethane	Angular	3-4 Mohs	929-961	None	Low	12-80	Good	Good
Chilled Iron & Steel Grit	Metallic	Angular	40-68 Rc Rockwell C	4005	None	Very Low	18-200	High	Good
Chilled Iron & Steel Shot	Metallic	Spherical	40-68 Rc Rockwell C		None	Very Low	7-200	High	Good

LOADING ABRASIVE MEDIA

Follow these steps to avoid locking the drain at the bottom of the cabinet when adding a brasive media.

1. Turn on the cabinet to activate the vacuum system.
2. **SLOWLY add approximately** half a bag of abrasive media through the grating inside the cabinet.

NOTE: Some cabinets can hold more than half a bag when added gradually.

OPERATION

Turn on compressed air and turn on lightning and motor with the power switch. Compressed air must be clean, dry, and oil free.

1. When using the unit, air pressure (**should not exceed 758 kPa)** Place the part to be treated inside the cabinet. The parts must be free of oil, grease, and moisture. Close and latch the cabinet load doors.

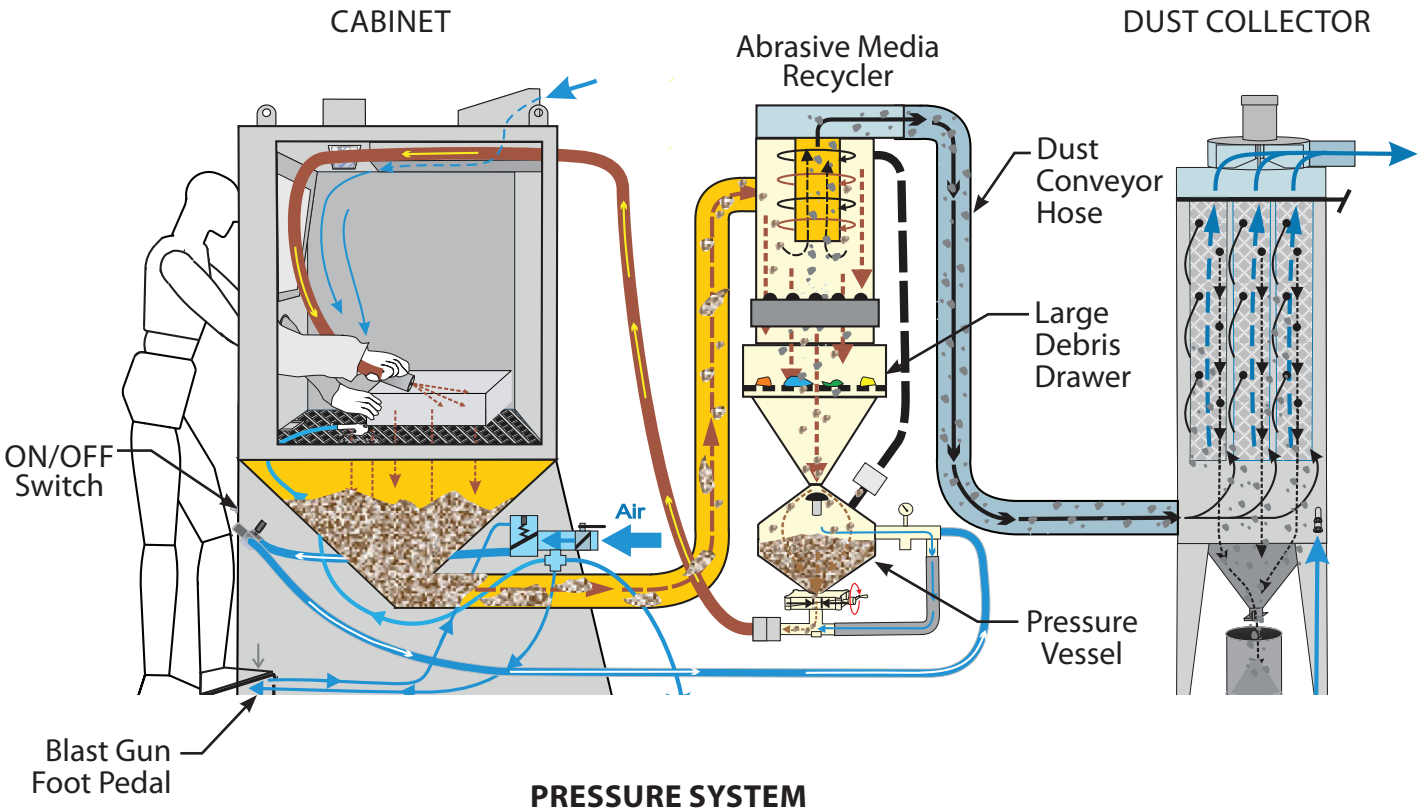
2. After closing the door, insert your hands into the two front glove openings. The blasting gun should be held firmly in one hand and the part to be treated in the other hand. The stream of abrasive should be oriented to the bottom of the working chamber.

3. Depressing blast control pedal will release compressed air flow to the blast gun. Hold the gun or nozzle at a 90° angle to the part at a distance that produces the fastest results. The reclaimer screen will require periodic cleaning. The frequency of cleaning will depend on the volume of debris produced. See maintenance section at page 15 for more information.

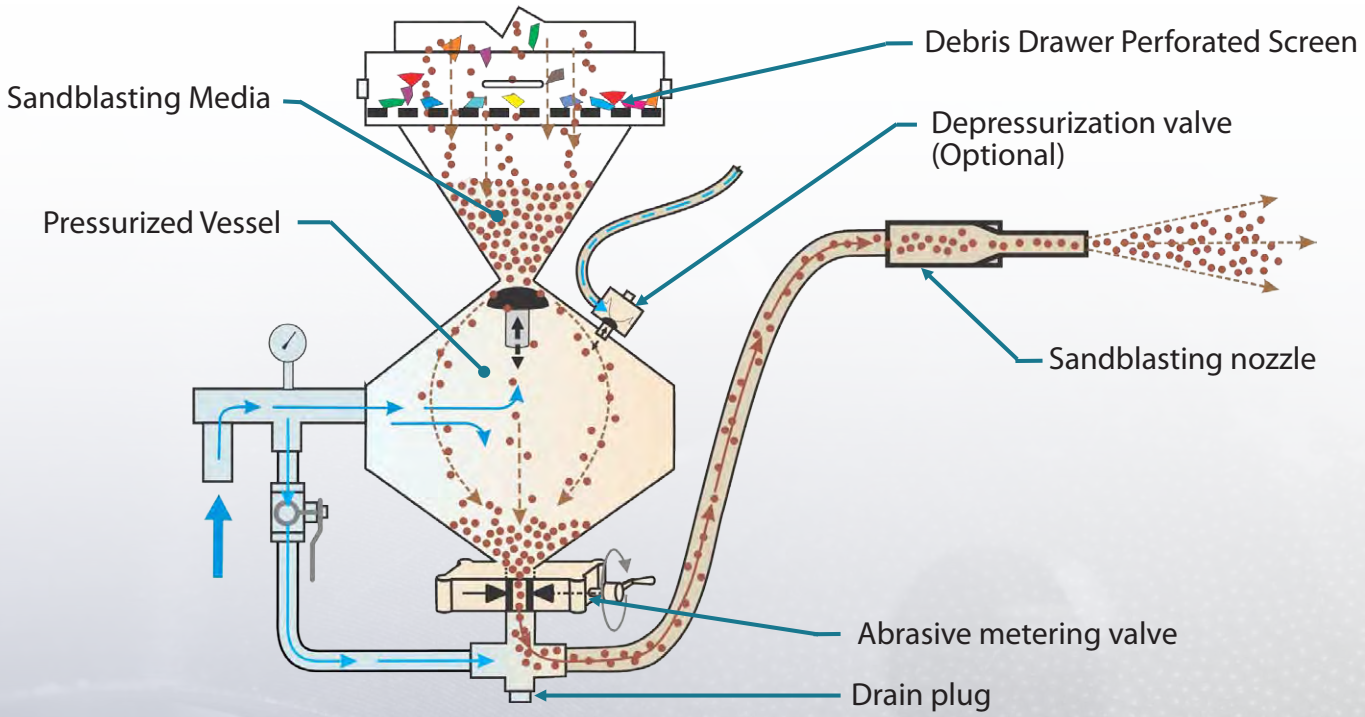
4. After the media has blasted the part, the reclaiming system vacuums up the abrasive, dust and foreign material through the conduit at the bottom of the cabinet to the reclaimer. The reusable abrasive is separated from the dust and foreign material and is returned to the storage hopper for reuse. The dust bag or the cartridges of the dust collector, filters the dust and fine particles. Larger pieces of contaminants are trapped in the hopper's screen drawer.

HOW IT WORKS

PRESSURE CABINET



PRESSURE SYSTEM



SHUT DOWN

1. Release the foot treadle. The blast will stop.
2. Once cleaning is finished, await 10 to 15 seconds before turning off the power switch and opening the door of the cabinet in order to allow the evacuation of dust in suspension.
3. Open the door and remove the treated parts from the blast cabinet.
4. Close air supply.
5. Turn power switch to the "OFF" position.
6. Empty the dust collector waste drum (Optional part). Replace the drum squarely on the dust drum platform and centered under the cover. The dust drum and cover must create an airtight seal.
7. Shake bags of your dust collector (disregard if you system is equipped with optional automatic bag shaker or a cartridge-type dust collector).

CHANGING THE MEDIA

When changing from one type or size of media to another, it can be extremely important to clean out the blast and recovery hoses, storage hopper, and the cabinet interior thoroughly to avoid contamination of the new media.

During normal sandblasting operation, the media should be replaced completely every 8 hours.

CLEANING THE SYSTEM

1. Turn the system off.
2. Adjust pressure at 138 kPa
3. Remove nozzle
4. Open sandblasting valve
5. Close ball valve on pressure vessel
6. You need a container large enough to collect used media. Place the container inside the cabinet and place the sandblasting hose inside the container.
7. Press on foot pedal

All media will be expelled from the system trough sandblast hose. **Make sure pressure does not exceed 138 kPa.** When cleaning is done put back everything in place.

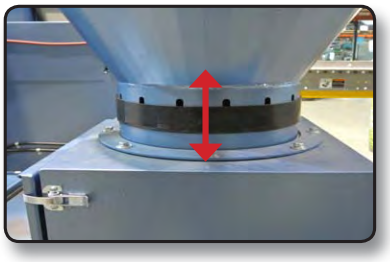
1. Release foot pedal
2. Screw nozzle in place
3. Open ball valve on pressure vessel
4. Close sandblasting valve
5. Adjust pressure at desired position
6. Turn system on

RELOADING WITH NEW ABRASIVE MEDIA

Refer to Abrasive Loading procedure on page 9

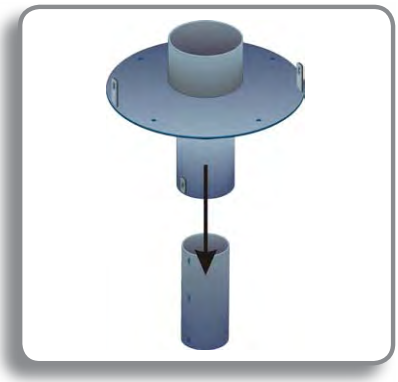
RECLAIMER

Although the reclaimer is factory set, it is possible to increase the amount of fine dust to be sucked up by the dust bag or dust collector. Just move the rubber band to adjust the obstruction of the holes located behind it. There ar**e two methods to change those settings.**



1. Adjustment of the SBR ³ mm x 50 mm rubber band

This adjustment will influence the quantity of dust that will be evacuated to the dust collector. Proceed step by step, moving the rubber band **6 mm** at the time, covering or uncovering the slots behind it. **A wider opening will draw up more dust to the dust collector; a smaller opening will reduce that quantity. The equipment has to run for approx. two (2) hours** before any changes can be noticed. Repeat as needed.



2. Adjustment of the telescopic tube, inside of reclaimer

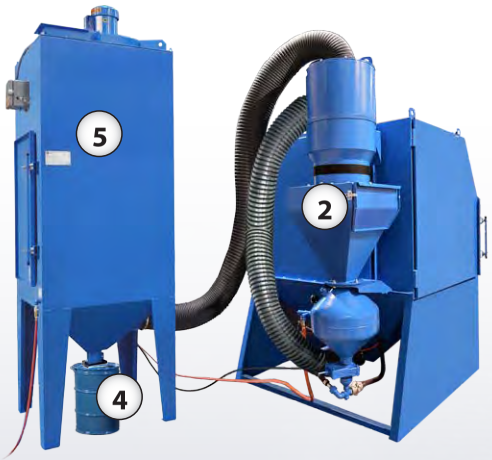
If, after a few tests, the rubber band adjustments should prove to be insufficient, you will have to proceed to the telescopic tube adjustment. This will be necessary if you have to change the abrasive type or granulometry. Proceed step by step, moving the tube up or down, 1 inch at the time. The equipment has to run for approx. two (2) hours before any changes can be noticed. Repeat as needed. Moving the tube downward will increase the quantity of dust drawn up by the dust collector, moving it up will decrease that quantity.

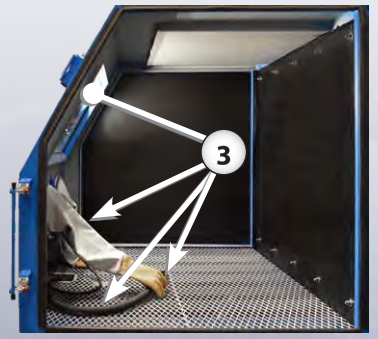
AR-7 ABRASIVE REGULATOR :

The AR-7 abrasive regulator is located at the bottom of the pressure vessel. It must be set according to the abrasive type in use. Turn the handle approx. 1/4 of a turn clockwise at the time to decrease the quantity of abrasive to the nozzle and counterclockwise to increase it. You must wait 15 seconds before any changes can be noticed. Adjustement to decrease the quantity has to be made while the pressure vessel is in operation.

Note : Too much abrasive in the sandblasting jet will cause it to be jerky and less efficient, not enough will cause an inconstant sandblasting.

MAINTENANCE CABINET AND DUST COLLECTOR





DAILY MAINTENANCE & OPERATION

1. Check both the quantity and quality of abrasive frequently. If required, clean out the system and reload with new media.
2. To avoid blockage, empty and clean the reclaimer's screen drawer regularely.
3. Check for wear on all parts in direct contact with the blasting action: nozzle, gloves, window, plastic shield, air-jet, gun etc. Special attention must be given to nozzle, nozzle ring and rubber protector to avoid premature wear of gun. Make sure ventilation inlet is always free of obstruction.
4. Empty dust barrel or dust collector's bottom hopper regularly.
5. **Baghouse Dust Collector:** after each use, turn off the impeller and shake bags inside the dust collector. Never shake bags while the cabinet is running. Never wash bags, instead use compressed use compressed air, ***blowing from the outside to the inside of the bag***, (the opposite would clog the bag's pores and make it unusable).
6. **Cartridge Dust Collector:** verify the values on the DCT1000 and replace cartridges when indicated. See next page for details.

WEEKLY

- **Sandblast Nozzle:** check the I.D. using a drill bit that is 3 mm wider than the original diameter of the nozzle. If the drill bit fits in, replace the nozzle. A worn nozzle will cause a drop of abrasive pull and velocity.
- **Abrasive Hose:** check abrasive hose for wear. It has to be changed before it gets any perforation. Give a special attention to parts of the hose that are curved.
- **Couplings and Gaskets:** check on a regular basis the hose couplings and gaskets for wear.
- **Media filters:** replace bags when the dust collector is unable to evacuate the dust cloud from the cabinet.

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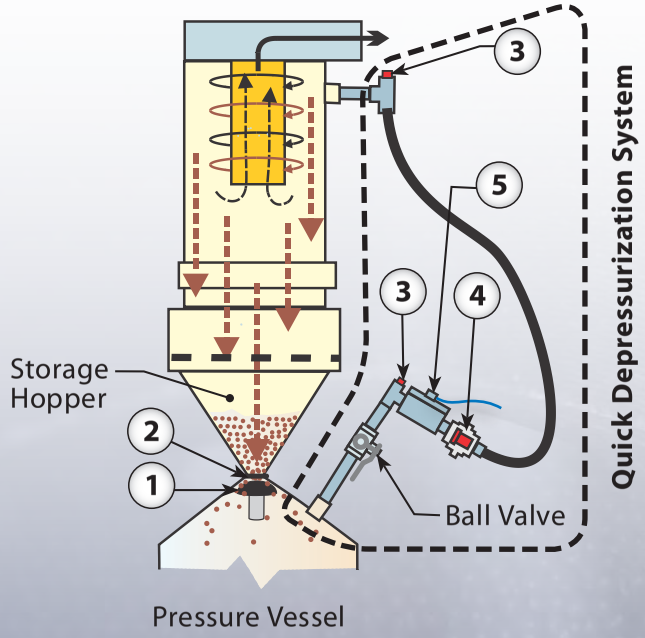
2023-09-05

MAINTENANCE CABINET & PRESSURIZED VESSEL



DAILY

1. Auditory inspection around the pressurized vessel to identify air leaks

MONTHLY

1. Proceed to Bubbling test (see below)
2. Disassembly and inspection of the pressurized vessel
3. Disassembly and inspection of the sandblast valve

BUBBLING TEST

a. The Bubbling Test identifies air leaks in the pressurized vessel (usually from the plunger or plunger's O-Ring)
b. Start the cabinet dust collector
c. Press the foot pedal to start blasting
d. Open the debris drawer door
e. Remove the debris drawer and observe the bottom of the hopper for bubbles:

If bubbles form, it means that the phenomenon of under pressure is observed and that air is infiltrating through the sand valve

MAINTENANCE OF PRESSURIZED VESSEL

WITH THE VESSEL DEPRESSURIZED

Dismantle the storage hopper above the pressurized vessel and check the wear condition of the sealing components inside the vessel:

ID	Parts #	Description	Qty
1	610040	PLUNGER	1
2	618205	PLUNGER O-RING	1
3	630671	1" PA MNPT SACRIFIED PLUGS	2
4	605011	5⁄16" BN2-5 BORON CARBIDE NOZZLE	1
5	608611	AUTO-DEPRESSURIZATION VALVE	1
	608612	DIAPHRAGM FOR DEPRESS. VALVE	1

Quick Depress System

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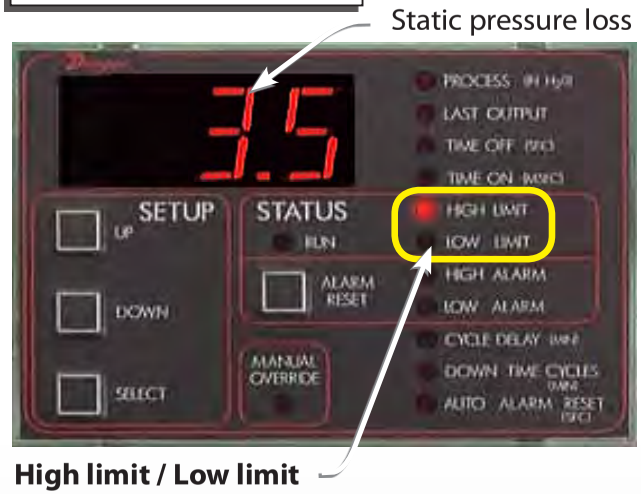
PERIODICAL ADJUSTMENTS OF THE DCT1000 TIMER CONTROLLER

DCT1000 TIMER CONTROLLER



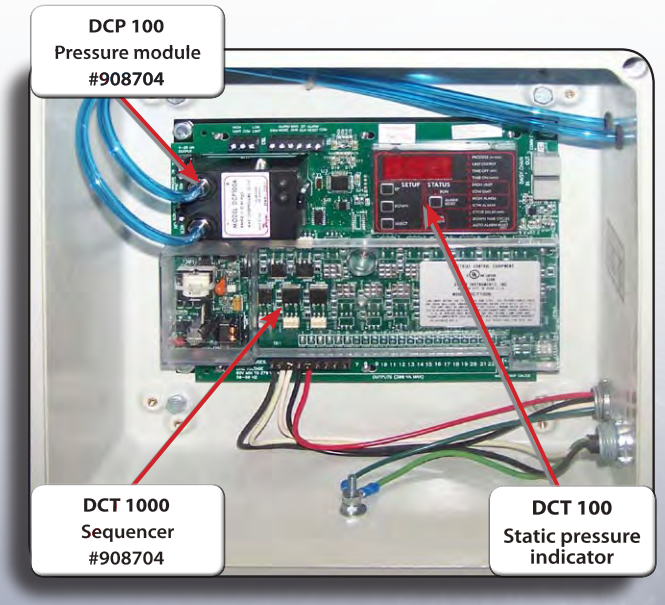
MONITORING OF PRESSURE DROPS

The DCT1000 monitors the static pressure differential between the clean and the dirty sides of cartridge filters – so-called pressure drop. As the filters load with dust, the resistance to air flow increases, and so does the pressure drop.

Brand new cartridge filter set will indicate a process value between **0.2 and 1.0**. During the first few hours of operation, dust will build up on the cartridges' pores in order to reach their optimal filtration capacities – this process is commonly referred to as the "dust cake".

High limit : 3.5
Low limit : 2.0

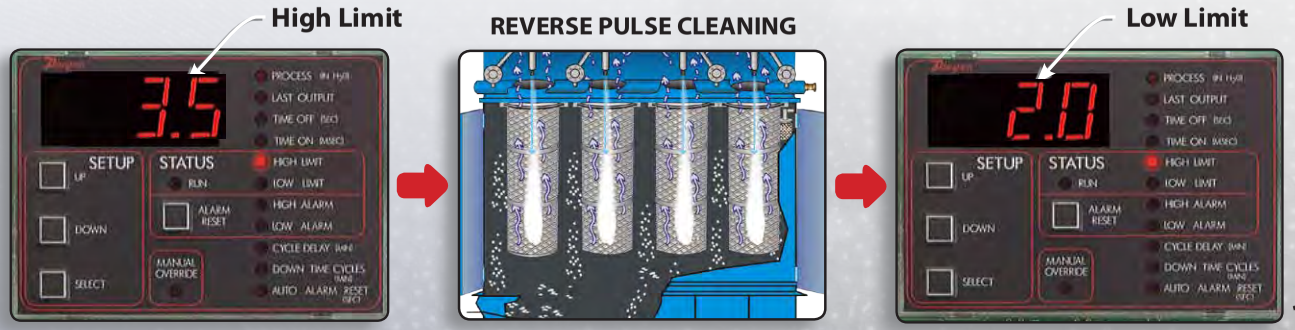
Once the new cartridges are saturated with a dust layer, the normal operating value should be between **2 and 3.5** – which are the initial **Low Limit** and **High Limit** defined in the DCT1000.



CARTRIDGE CLEANING

When the process value reaches the **High Limit**, the cleaning cycle starts emitting a series of pulses of air through each cartridge in order to dislodge exceeding amount of dust buildups. Pulses of air can be heard when the cycle is on.

During the cleaning cycle, the pressure drops should decrease on each pulse until it reaches the **Low Limit** which interrupts the cleaning cycle.



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IST International Surface Technologies

DCT1000 TIMER CONTROLLER

INITIAL VALUES

High limit : 3.5
Low limit : 2.0

Stagnant pressure drop

NEW VALUES

High limit : 3.9
Low limit : 2.4

PERIODICAL ADJUSTMENTS

Follow the procedure below in order to extend the life span of your cartridge filters while maximizing the filtration capacity of your dust collector.

When the cleaning process of the cartridges is no longer able to reach the **Low Limit** value, the cleaning cycle will run continuously.

At that moment, it is advised to increase the **Low Limit** and **High Limit** in order to extend the life span of the cartridge media to a certain limit.

Start increasing the **Low Limit** and **High Limit** of the cleaning process by 2 decimals above the stagnant value. For example, if the cleaning cycle runs continuously and the process value on the DCT1000 indicates **2.2,** set the new **Low Limit to 2.4** and the new **High Limit to 3.9**.

NEED TO REPLACE CARTRIDGES

FINAL VALUES

High limit : 8.5
Low limit : 7.0

Keep increasing moderately until your cartridges are incapable of reaching a **Low Limit of 7. 0**. At that moment, it is time to change your cartridge filters and reset your process values to initial **Low Limit 2.0** and **High Limit 3.5.**

REPLACEMENT OF CARTRIDGE FILTERS

Change all your cartridge filters at the same time, regardless of their individual condition.

If you notice a damaged cartridge, immediately replace all your cartridge filters at once – if a cartridge filter is damaged and/or perforated, it may cause severe damage to your impeller and mislead the DCT1000 timer controller in its ability to control the cartridges cleaning cycles properly.

Refer to the owner's manual for parts number and changing procedure.

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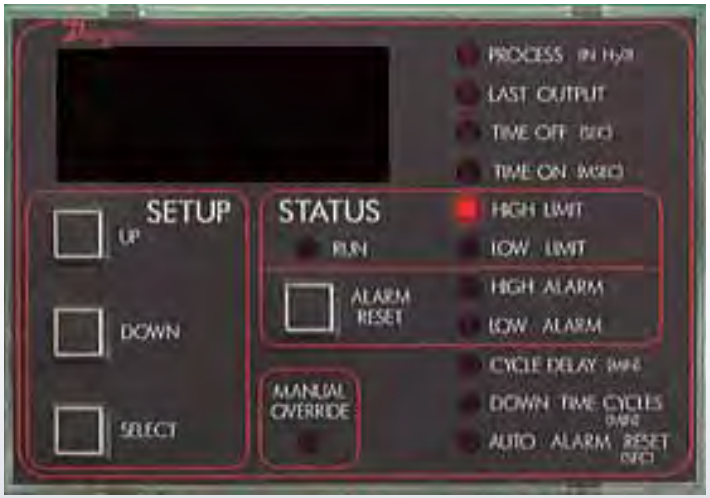
2023-09-05

DCT1000 TIMER CONTROLLER

SETTINGS

Use the (Select) and (Up) (Down) keys you will be able to change the parameters.

Note: Your unit has been programmed in the factory, if you change some settings during operation be sure to write down the initial values.



PARAMETERS

Process: Value displayed during operation of the fan (inches of water restriction cartridges).

Last Output: Number of active solenoid (this value can not be changed because the system auto-detects the number of active coil connected to the card).

Time Off: downtime between each pulse (value 10 seconds).

ON Time: Time pulse valves (value 250 milliseconds).

High Limit: The value to which the cleanup will begin (value between 2.5 and 3.5).

Low limit: The value to which the cleaning will stop automatically (value between 1.5 and 2.5).

High Alarm: Value must be reached to activate alarm (High limit value 2).

Low Alarm: Value must be reached to activate alarm (value = 0).

Cycle Delay: This value is to operate in manual mode (value = 0).

Down Time Cycles: This value is to operate in manual mode (value = 0).

Auto Alarm Reset: This value is to operate in manual mode (value = 0).

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BLAST NOZZLE INSPECTION - MAINTENANCE SCHEDULE

Nozzle: check the nozzle regularly for wear using a drill bit
3mm larger than the original nozzle diameter

IT GOES THROUGH

WORN NOZZLE TO BE REPLACED

DOES NOT GOES THROUGH

NOZZLE IN GOOD SHAPE

The inside diameter should never exceed 3mm of wear

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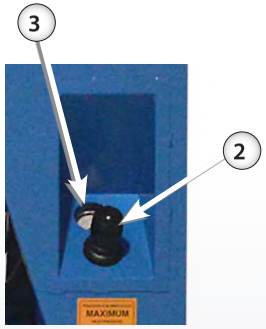
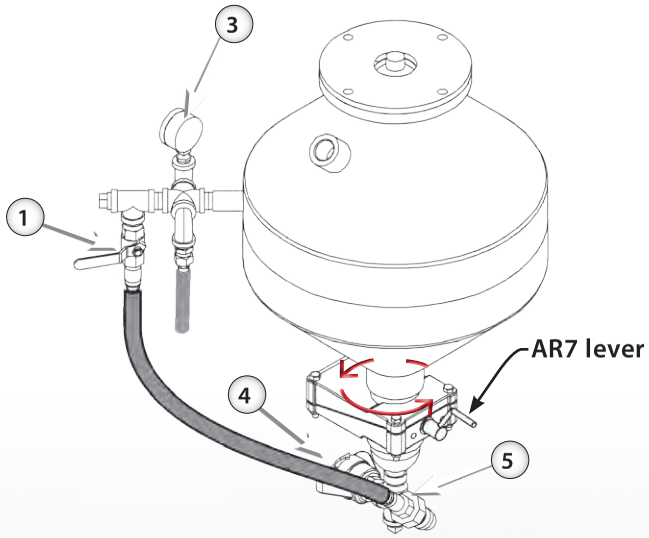
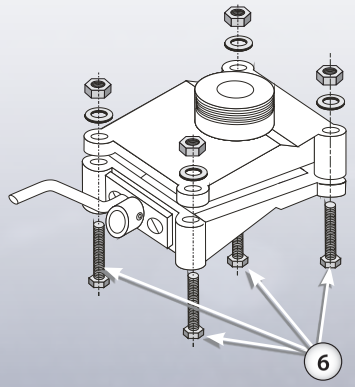
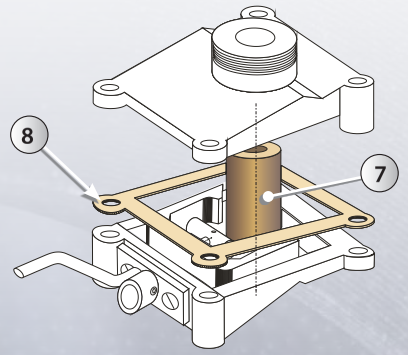
AR7 ASSEMBLY - DISASSEMBLY INSTRUCTIONS









1. Close Completely the Ball Valve (1)
2. Release pressure by turning the Pressure Regulator (2) until the pressure displayed on the Pressure Gauges (3) fall to zero.
3. Turn the AR-7 lever clockwise until end of course.
4. Unplug the Quick Connect (4) and unscrew the hose swivel insert (5)
5. Now you can remove the AR-7 by unscrewing it from the adaptor.
6. Loosen the 4 bolts (6) holding the 2 parts of the housings and separate them.
7. Remove the regulation tube (7) and replace it with a new.

   Before reassembling the AR-7 check the gasket (8) and replace it if necessary.
8. Replace the AR-7 kit and restore the pressure to initial value if required. **Must be at 70 psi max.**

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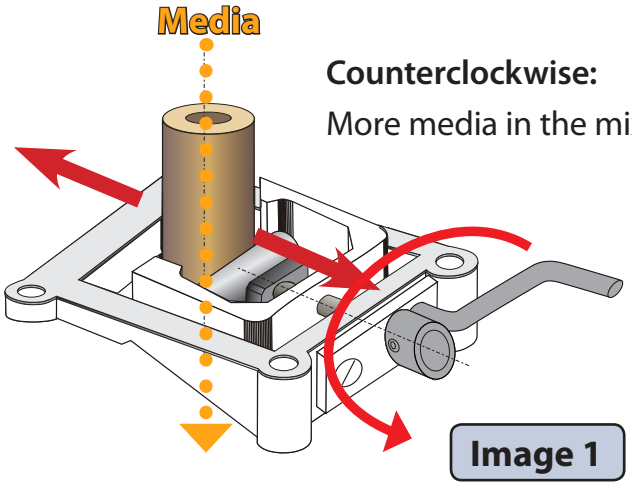
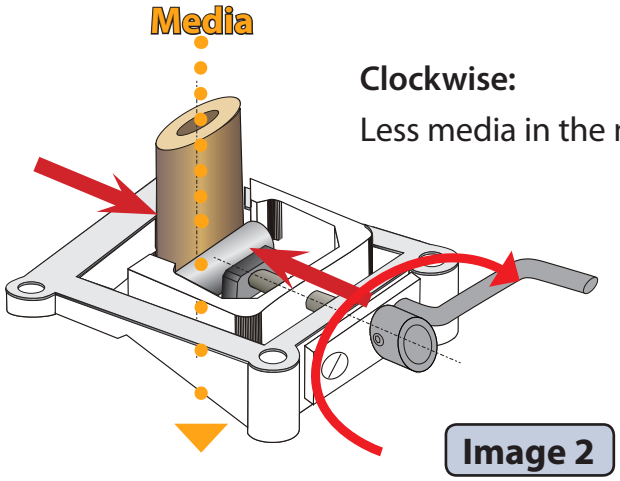
AR7 ABRASIVE METERING VALVE ADJUSTMENT



Counterclockwise:
More media in the mix

Image 1



Clockwise:
Less media in the mix

Image 2

Follow the procedure below to adjust your abrasive media valve for the first time or when you change blast nozzle or blast media.

1. Open completely the media valve by turning the crank counterclockwise **(see image 1)**
2. Make three (3) complete turns clockwise to close the valve **(see image 2).**
3. Press on the remote control handle for approximately 10 secondes and observe the blast jet.
4. Keep closing or opening the valve, half turn at the time, until desired blast jet is obtained.

How to determine the ideal abrasive media flow:

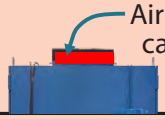
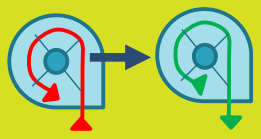
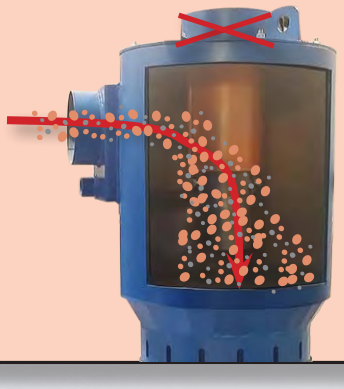
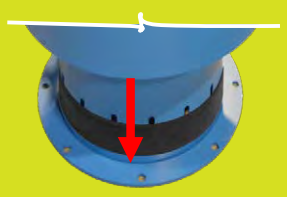
- ✓ Ideal flow: The flow is constant, even, stable, white color and you can see through.
- ✓ Too much media in the flow: The flow is unstable, pulsating or jerky. Close the valve **(Image 2)**, half turn at the time and check again.
- ✓ Not enough media in the flow: The flow is transparent and not powerful enough to produce desired result. Open the valve (Image 1), half turn at the time and check again.

AR-7 ABRASIVE METERING VALVE - TROUBLESHOOTING

TYPE OF FAILURE	POSSIBLE CAUSE	SOLUTION
THE ABRASIVE DOES NOT FLOW DURING SANDBLASTING (AIR ONLY)	1. The pressure vessel is empty.	Add media to the pressure vessel.
	2. The abrasive deactivation feature (if equipped) is activated and prevents the abrasive from leaking.	Flip the switch to allow the media valve to release the media into the push hose.
	3. The abrasive regulator is closed or not properly adjusted.	Turn the adjustment crank counter-clockwise to increase the amount of media in the mix.) If your machine has a booster that closes the valve when the machine is not running, make sure you only adjust it during sandblasting.
	4. There is a blockage in the abrasive regulator.	Operate the control handle / pedal and call in a second qualified person. close the non-return valve for 2 seconds and then reopen it immediately. Minor obstructions, such as paint chips, a bit of wet abrasive, or a piece of paper, will be forced through the abrasive regulator and nozzle. Return the abrasive regulator to the required sandblasting setting and check if the obstruction has been removed.
THE ABRASIVE FLOW IS TOO STRONG OR IRREGULAR DURING SANDBLASTING*	1. The non-return valve is partially closed	The sandblasting cup should ONLY be used with the non-return valve fully open.
	2. The abrasive regulator needs to be adjusted	(Turn the adjustment crank clockwise to restrict the mixture in the mixture.) If your unit is equipped with an air booster that closes the valve when the unit is not operating, make sure you only adjust it during cleaning.
	3. The rubber tube inside the valve is worn or punctured	(Disassemble the valve, clean any media buildup in the valve, and replace the rubber tube.) If the rubber tube is punctured, fluid can flow freely into the valve and settle on all other internal mechanical parts.

***Note:** The first time automatic depressurization systems are started, they may pulsate for a while if there is an accumulation of abrasive in the blast hose during a previous operation. This is normal and no corrective action is necessary.*

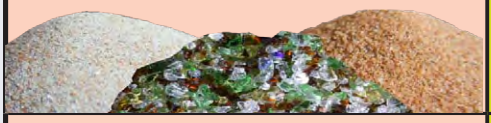
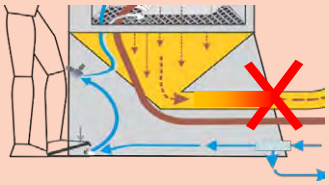
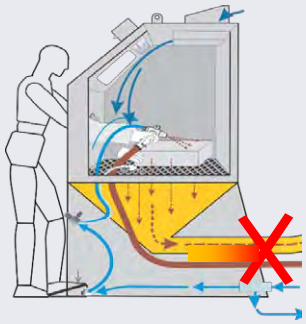
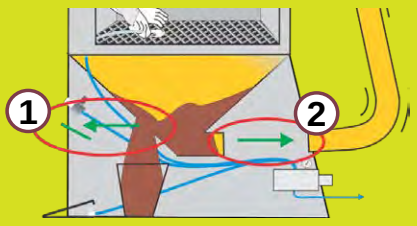
TROUBLESHOOTING

TYPE OF FAILURE	POSSIBLE CAUSE	SOLUTION
Excessive dust in the cabinet (poor visibility) and / or very dusty abrasive (inefficient)	Air intake behind the cabinet obstructed 	Check the trap above the cabinet to make sure it is open and clear
	Clogged filter media: 1. Dust barrel filled 2. Bags shaken during cabinet operating[1]	1. Empty the dust barrel as well as the connection hose connecting the barrel and the cyclone separator 2. Replace clogged bags[2]
	Dust collector fan motor connected upside down (blades turn upside down)	Reverse motor electric connection 
	Inccorect adjustment of the cyclonic separator (the dust recirculates in a loop instead of being evacuated to the dust collector and mixes with the abrasive) 	1. If the material has changed since the cabinet was manufactured, contact an IST representative 2. If the material has not changed since the cabinet was manufactured, slightly open the rubber band around the cyclonic separator to increase the velocity, observe the results on the abrasive level after a few hours of blasting 

[1] Never shake the bags while the dust collector fan is on. This forces dust to enter the pores of the media rather than lodge on the surface.

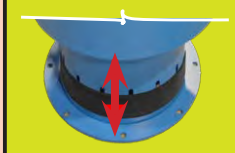
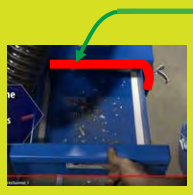
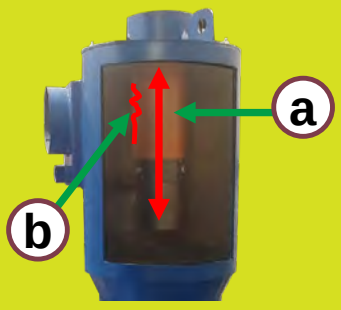
[2] Do not wash bags with water or by blowing compressed air through them. Both of these methods will damage the bags and make them obsolete.

TROUBLESHOOTING (CONT'D)

TYPE OF FAILURE	POSSIBLE CAUSE	SOLUTION
Excessive dust in the cabinet (poor visibility) and / or very dusty abrasive (inefficient)	Non-recyclable abrasive[3] 	Follow abrasive drain and cleaning procedures and replace with recyclable abrasive.
	Suction hose (behind the cabinet) is partially or completely blocked 	Follow the procedures for resolving a clogged suction hose.
Suction hose outlet (behind the cabinet) partially or completely blocked 	Incorrect filling procedure: too much abrasive or poured too quickly. 	Open the service door (1) and disconnect the abrasive suction hose (2) at the bottom of the hopper, remove the abrasive in excess and repeat the filling procedures properly. 
	Lack of cfm (problem with the dust collector) which causes the outlet to become progressively blocked.	Follow the procedures for resolving a dusty cabinet as described above.

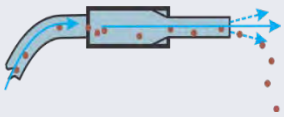
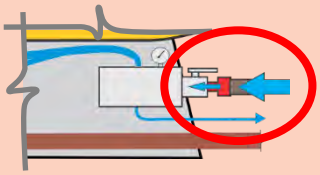
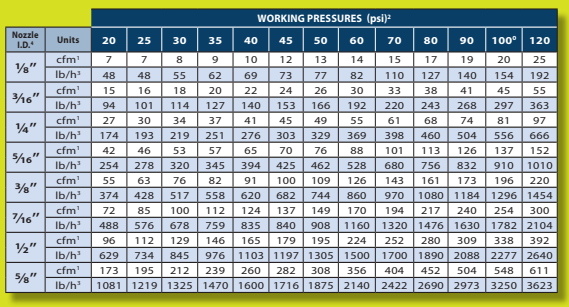
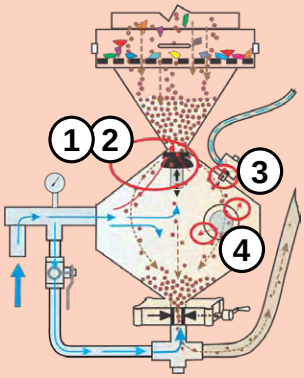
[3] Never use non-recyclable abrasive in IST cabinets, such as slag, silica sand, recycled glass, or other like them. IST cabinets are designed to be used exclusively with recyclable abrasive that generates a limited amount of dust. Ask your IST representative for more information.

TROUBLESHOOTING (CONT'D)

TYPE OF FAILURE	POSSIBLE CAUSE	SOLUTION
"Good" abrasive ends up in the dust container of the dust collector **Too much velocity (cfm) in the cyclone separator** 	Incorrect adjustment of the rubber band of the cyclonic separator	 Cover gradually the holes with the rubber band to reduce the velocity flowing through the cyclonic separator
	The seal around the debris drawer is damaged or not properly installed	 Check the gasket around the drawer to make sure it is tight and replace if necessary.
	a. The central tube of the cyclonic separator is not adjusted properly due to a change of abrasive	 Contact your IST representative
	b. The central tube of the cyclonic separator is perforated at the inlet of the separator	

[4]The center tube of the cyclonic separator is factory adjusted for the abrasive specified at the time of purchase. If the abrasive changes during operation, it may be necessary to readjust the inner tube to alter the movement and flow of air within the cyclonic separator.

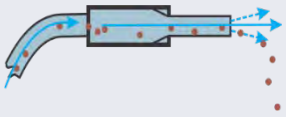
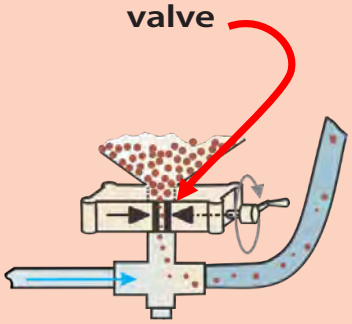
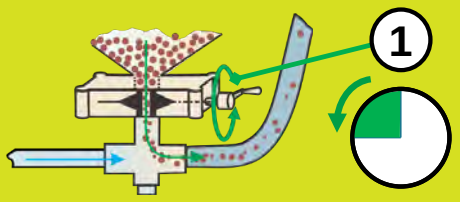
TROUBLESHOOTING (END)

<table>
<tr><th>TYPE OF FAILURE</th><th>POSSIBLE CAUSE</th><th>SOLUTION</th></tr>
<tr><td rowspan="2">Lack of abrasive in the mix (the nozzle blows mainly air)
  </td><td>Air supply problem (using a quick connect or a connection that creates a restriction to the cabinet air supply)
  </td><td>Follow cabinet air connection guidelines
(see chart page 8)
 
And use only straight couplings as indicated in the manual</td></tr>
<tr><td>Underpressure[2] phénomenon
(the vessel pressure is lower than the thrust line pressure)
  </td><td>Identify the air leak that is escaping from the vessel and preventing it from building its pressure properly
1. Plunger
2. Plunger O-Ring
3. Self-depressurization system (if equipped)
4. Access door (if equipped)
1st Step - Bubbling method
• Plunger and/or Plunger O-Ring
• Access door
2nd Step – Push line cut-off
• Self-depressurization system</td></tr>
</table>

Nozzle I.D.[4]	Units	WORKING PRESSURES (psi)[2]												
		20	25	30	35	40	45	50	60	70	80	90	100°	120
1/8"	cfm[1]	7	7	8	9	10	12	13	14	15	17	19	20	25
	lb/h[3]	48	48	55	62	69	73	77	82	110	127	140	154	192
3/16"	cfm[1]	15	16	18	20	22	24	26	30	33	38	41	45	55
	lb/h[3]	94	101	114	127	140	153	166	192	220	243	268	297	363
1/4"	cfm[1]	27	30	34	37	41	45	49	55	61	68	74	81	97
	lb/h[3]	174	193	219	251	276	303	329	369	398	460	504	556	666
5/16"	cfm[1]	42	46	53	57	65	70	76	88	101	113	126	137	152
	lb/h[3]	254	278	320	345	394	425	462	528	680	756	832	910	1010
3/8"	cfm[1]	55	63	76	82	91	100	109	126	143	161	173	196	220
	lb/h[3]	374	428	517	558	620	682	744	860	970	1080	1184	1296	1454
7/16"	cfm[1]	72	85	100	112	124	137	149	170	194	217	240	254	300
	lb/h[3]	488	576	678	759	835	840	908	1160	1320	1476	1630	1782	2104
1/2"	cfm[1]	96	112	129	146	165	179	195	224	252	280	309	338	392
	lb/h[3]	629	734	845	976	1103	1197	1305	1500	1700	1890	2088	2277	2640
5/8"	cfm[1]	173	195	212	239	260	282	308	356	404	452	504	548	611
	lb/h[3]	1081	1219	1325	1470	1600	1716	1875	2140	2422	2690	2973	3250	3623

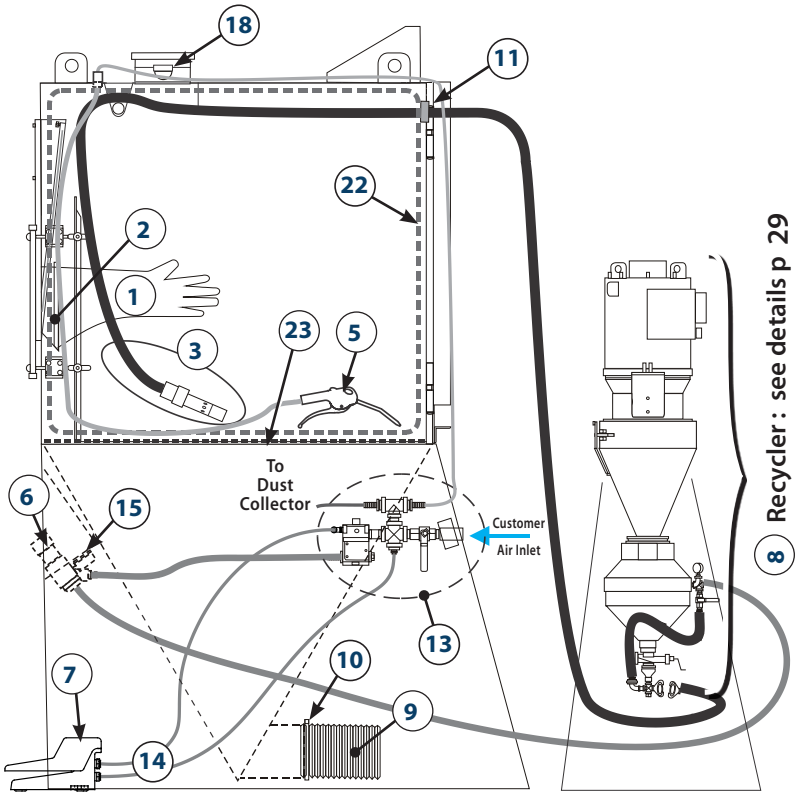
[2]The underpressure phenomenon exerts a negative pressure upstream of the abrasive flow at the outlet of the pressure vessel. This prevents the abrasive from flowing freely by gravity into the push line.

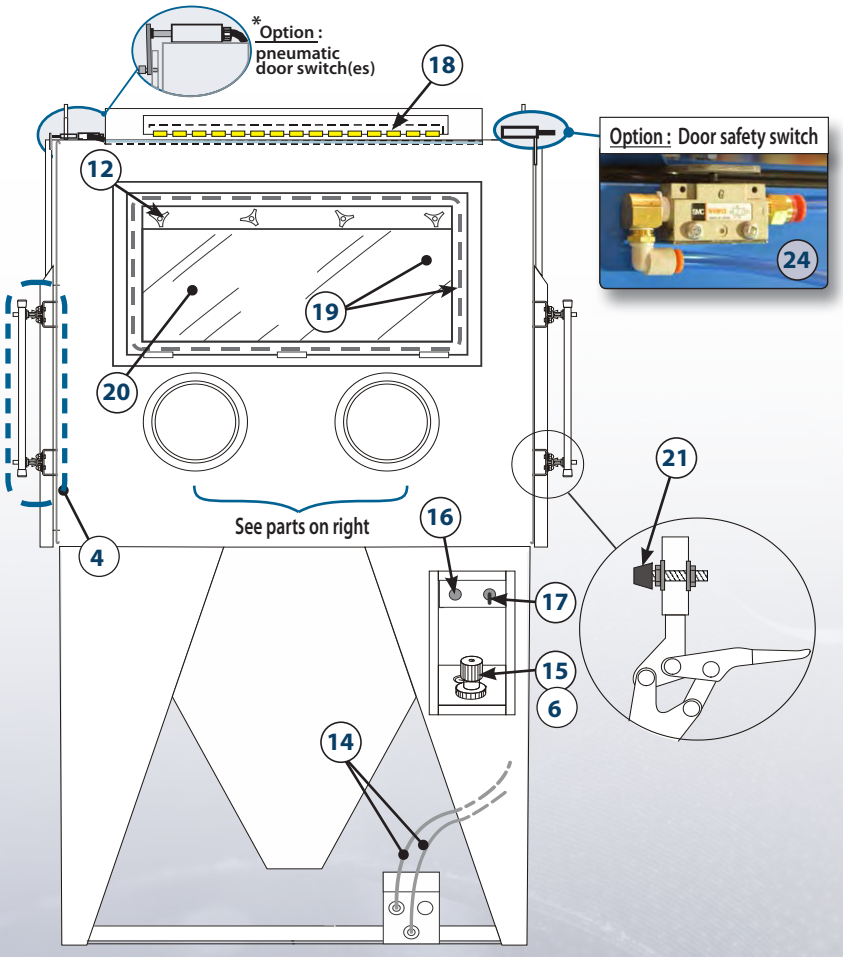
TROUBLESHOOTING (END)

TYPE OF FAILURE	POSSIBLE CAUSE	SOLUTION
Lack of abrasive in the mix (the nozzle blows mainly air) 	**Wrong adjustment of the AR7 abrasive valve** 	1. Open the rubber tube opening slightly by turning the crank handle counterclockwise 6 mm turn at a time 2. Advance the sanding for approximately 20 seconds and note the difference. 3. Repeat steps 1 and 2 as needed 

[1] Perform 6 mm of a turn at a time and observe the difference. It takes about 30 seconds for the system to renew the air/media mix in the line.

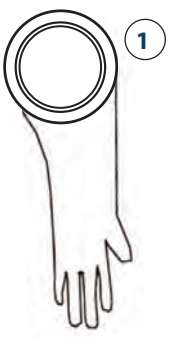
SCHEMATIC OF UNIT - EXPLODED VIEW & PARTS





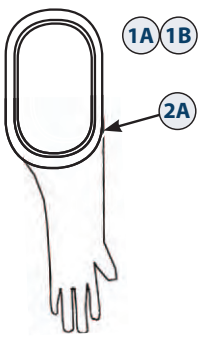
Option : Door safety switch

1	603212	Gloves with nylon sleeves E3 8" I.D. x 30" length
	603205	Gloves with leather sleeves E3 8" I.D. x 30" length
1A	603217	Wide opening gloves nylon sleeves W1 10" I.D. x 30" length
1B	603218	Wide opening gloves leather sleeves W1 10" I.D. x 30" length
2	624128	8" ø glove "T" clamp (standard)
2A	624137	10" ø glove "T" clamp (optional)
3		Hose, couplings and nozzles (see page 30, 31)
4	610288	Standard door handle
5	610275	Dust blow-off gun
6	608022	½" pressure regulator
7		Complete foot pedal-pressure (see page 41)
8		Complete recycler (see page 29)
9	606120	Reclaimer hose 5" – 600 cfm
	606123	Reclaimer hose 6⅛" – 900 to 1800 cfm
10	624121	5" clamp
	624124	6" clamp
11	618131	Rubber grommet for abrasive hose ½" SBH
12	940025	Star knob
13	666214	Pressure manifold (see page 32-33)
14	324571	¼" Poly. blue tubing Air hose (sold by foot)
15	611022	¼" Pressure Gauge
16	616933	AGC fuse 1A - 250 v
	616907	Fuse holder
17	617014	ON/OFF switch
18*	617161	24" light fixture c/w LED
	617160	48" light fixture c/w LED
19*	610212	23¾" x 18¾" laminated safety glass (cabinet less than 48")
	610211	17" x 48" laminated safety glass (cabinet 48" and more)
	618318	Window seal type "G15" (sold by foot)
20	613038	RPW 50 – 23 ¾" x 18 ¾" acetate glass protector
	613035	RPW 1748 acetate glass protector (cabinet 48" and more)
21	910223	Door Toggle Stem
22	618322	Door rubber gasket type "P"
23	610453	28" x 44" — Expanded Steel Floor
	610458	36" x 36"
	610459	36" x 48"
	610462	42" x 48"
	610463	48" x 48"
	610469	48" x 60"
	610465	60" x 60"
24	600116	Complete Door Safety Switch

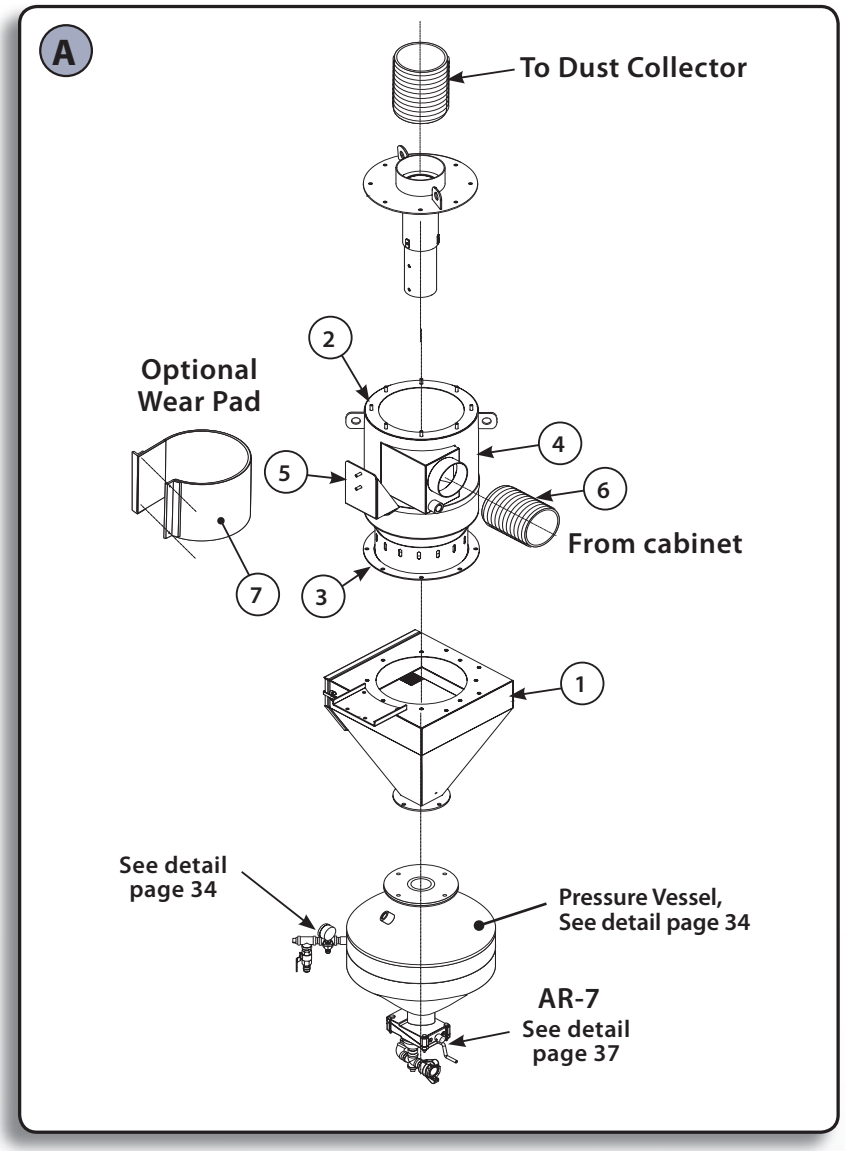


Standard :
Round opening gloves

Optionnal :
Wide opening gloves



RECYCLING SYSTEM - EXPLODED VIEW & PARTS LIST

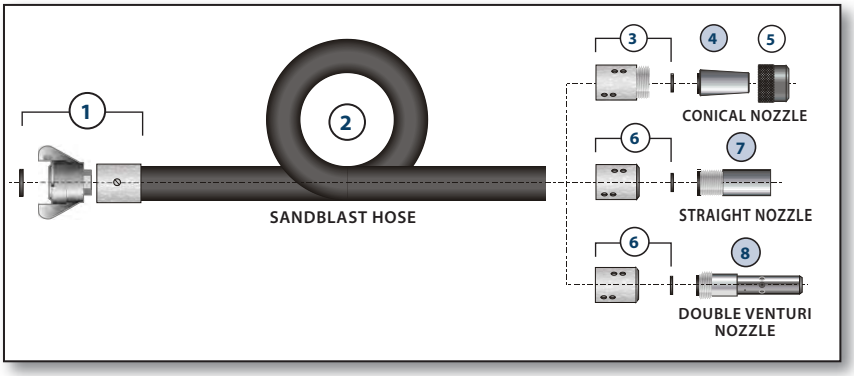


GENERAL PARTS		
#	STOCK	DESCRIPTION
1	609286	Hopper
2	618318	Auto-adhesive Rubber
3	618334	Rubber Band

	A	4	5	6	7
RECYCLER BODY ID	COMPLETE RECYCLER	BODY ONLY	BODY SUPPORT	"ABRASIVE CARRY HOSE"	"EXTERIOR WEAR PAD"
254 mm (10")	609241	609225	N/A	606161	609282
330 mm (13")	609243	609230	609180	606120	609283
406 mm (16")	609245	609231	609181	606123	609284
610 mm (24")	609247	609232	N/A	606124	609285
762 mm (30")	609249	609234	N/A	606124	609288

HOSE, COUPLING & NOZZLES - EXPLODED VIEW (CONT'D)

HOSE, COUPLINGS & NOZZLES

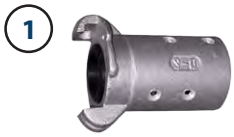


1	607025	½" CQ Coupling
2	606020	½" SBH SANDBLAST HOSE
3	607059	NC3-N3 ½" x 1" NPT
4	CONICAL NOZZLE	
5	607040	NA-1 Adaptor 1" NPT
6	NH ½" Nozzle Holder ½" & ¾" NPS	
7	STRAIGHT THREADED NOZZLE ¾" NPS	
8	DOUBLE VENTURI NOZZLE 1¼" NPS or 50mm	

BULK SANDBLAST HOSES
(LENGTH OF 12.5', 25' & 50' ONLY)

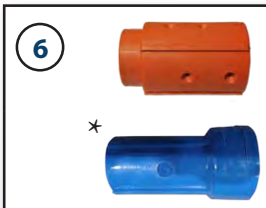
PART NB.	MODEL	INSIDE DIAMETER	OUTSIDE DIAMETER
606020	SBH-½	½	1 3⁄16"
606003	SBH-¾	¾	1 ½"

HOSES FITTINGS



PART NB.	MODEL	SBH I.D.	SBH O.D.
607002	QC-½	½"	1 3⁄16"
607003	QC-¾	¾"	1 ½"

THREADED NOZZLE FITTINGS



		THREAD		
MODEL	HOSE I.D.	¾" NPS	1¼" NPS	50 mm
NH-½	½"	607057	607056 **	* 407022
NH-¾	¾"	607020	N/A	

HOSE AND FITTINGS PRE-ASSEMBLED KITS

SANDBLAST HOSES			FITTINGS		
MODEL	INSIDE DIAM. (ID)	HOSE LENGTH (FT)	QC-QC	QC-NH	QC-NC
SBH ½"	½"	10'	606016	N/A	606011
		25'	606018		606013
		50'	606019		606014
SBH ¾"	¾"	12 ½'	606021	606022	N/A
		25'	606024	606023	
		50'	606025	606026	

HOSE, COUPLING & NOZZLES - EXPLODED VIEW (CONT'D)

CONICAL NOZZLE

#	TYPE	PART No	MODEL	ORIFICE	LENGTH	THREAD
④	 DC2-F - TUNGSTEN CARBIDE	605302	DC2-F2	1/8" Ø	1-5/8"	N/A
		605303	DC2-F3	3/16" Ø		
		605304	DC2-F4	1/4" Ø		
	 BN2-F - BORON CARBIDE	605308	BN2-F2	1/8" Ø		
		605309	BN2-F3	3/16" Ø		
		605310	BN2-F4	1/4" Ø		

STRAIGHT THREADED NOZZLE

⑧	 DC1 - TUNGSTEN CARBIDE	605358	DC1-2	1/8" Ø	1-3/4"	3/4" - 1/4" N.P.S.
		605359	DC1-3	3/16" Ø		
		605360	DC1-4	1/4" Ø		
		605361	DC1-5	5/16" Ø		
	 BC1 - BORON CARBIDE	605414	BC1-2	1/8" Ø		1 1/4" N.P.S.
		605415	BC1-3	3/16" Ø		
		605416	BC1-4	1/4" Ø		
		605417	BC1-5	5/16" Ø		

DOUBLE VENTURI NOZZLE

⑨	 DOUBLE VENTURI NOZZLE	405463	# 3	3/16" Ø	4 11/16"	50 mm
		405464	# 4	1/4" Ø	5 5/16"	
		405465	# 5	5/16" Ø	6 11/16"	
		405466	# 6	3/8" Ø	6 1/8"	
		405467	# 7	7/16" Ø	8 15/32"	
		405468	# 8	1/2" Ø	9 1/16"	

TUNGSTEN CARBIDE

DCV-

Part Nb	Model	Orifice	Lenght
605203	DCV-3	3/16" Ø	4 1/4"
605204	DCV-4	1/4" Ø	5 1/4"
605205	DCV-5	5/16" Ø	6"
605206	DCV-6	3/8" Ø	6 3/4"
605207	DCV-7	7/16" Ø	8"
605208	DCV-8	1/2" Ø	9 1/4"

Threaded nozzle 1¼" N.P.S., 1" Ø entry venturi orifice, use with NCV, all NH- except NH - ½"

BORON CARBIDE

BCV-

605454	BCV-4	1/4" Ø	4 1/8"
605455	BCV-5	5/16" Ø	4 1/8"
605456	BCV-6	3/8" Ø	4 1/8"

Threaded nozzle 1¼" N.P.S., 1" Ø entry venturi orifice, use with NCV, all NH- except NH- ½ "

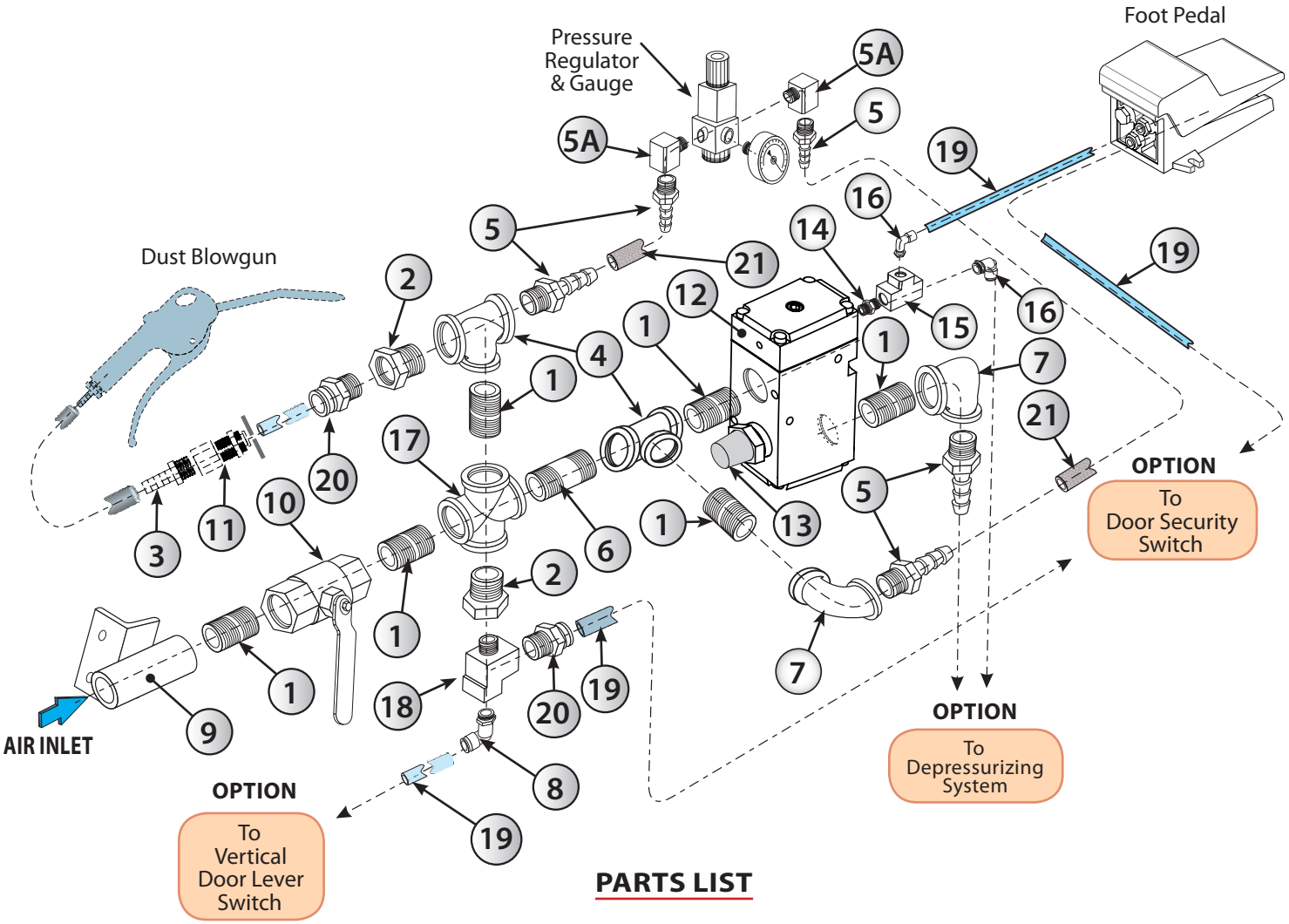
TUNGSTEN CARBIDE

DC3-

Part Nb	Model	Orifice	Lenght
605313	DC3-3	3/16" Ø	3"
605314	DC3-4	1/4" Ø	3"
605315	DC3-5	5/16" Ø	3"
605316	DC3-6	3/8" Ø	3"

Threaded nozzle 1¼" – 14 N.P.S., straight orifice, use with NCV, all NH- except NH - ½"

AIR PRESSURE MANIFOLD - STANDARD ½" PIPING

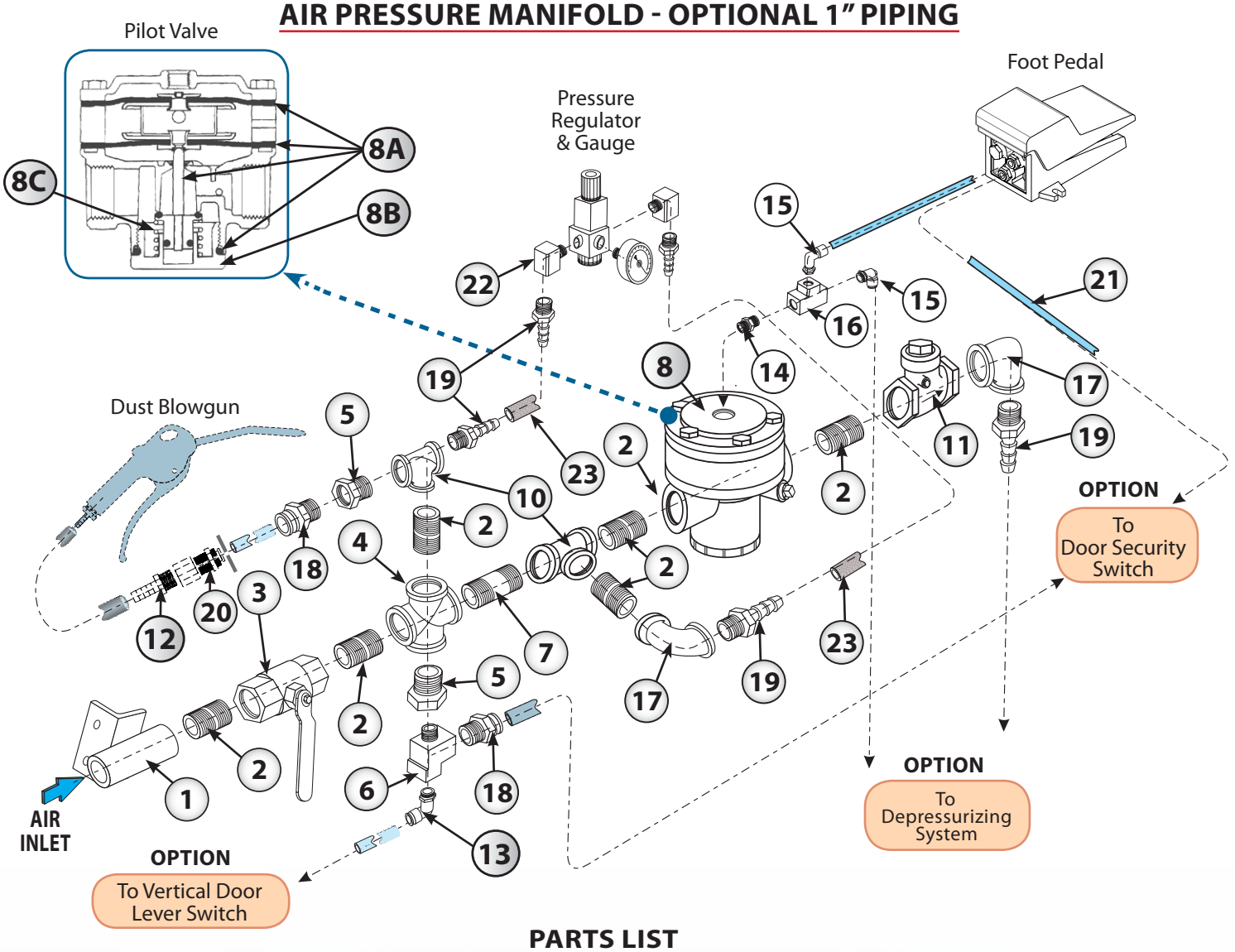


PARTS LIST

1	630301	½" NPT Nipple
2	632745	½" NPT x ¼" NPT Reducer
3	632270	¼" NPT x ¼" Pipe Hose Barb
4	630328	M-F ¼" NPT Tee
5	632760	½" NPT x ½" Hose Barb Fitting
5A	632730	½" PL MF Elbow Fitting
6	630317	½" MPT x 3" Lg. Nipple
7	630340	½" FF PA Elbow
8	324560	¼" NPT ¼" TU @ 90° Push-In
9	610390	½" Inlet Ring
10	608102	½" NPT Ball Valve

11	324503	¼" MTP x ¼" TU Bulkhead Push-in
12	608519	½" FPT Pilot Valve
13	608287	½" MPT Muffler
14	632002	⅛" Hex. Nipple
15	632018	⅛" PL Street Tee
16	324561	⅛" NPT ¼" TU @ 90° Push-in
17	630327	½" Cross Fitting
18	632226	¼" Tee Street
19	324571	¼"Poly. blue tubing
20	324558	¼" MTP ¼" TU Push-in
21	606104	½" Clear Nylon Tube

AIR PRESSURE MANIFOLD - OPTIONAL 1" PIPING

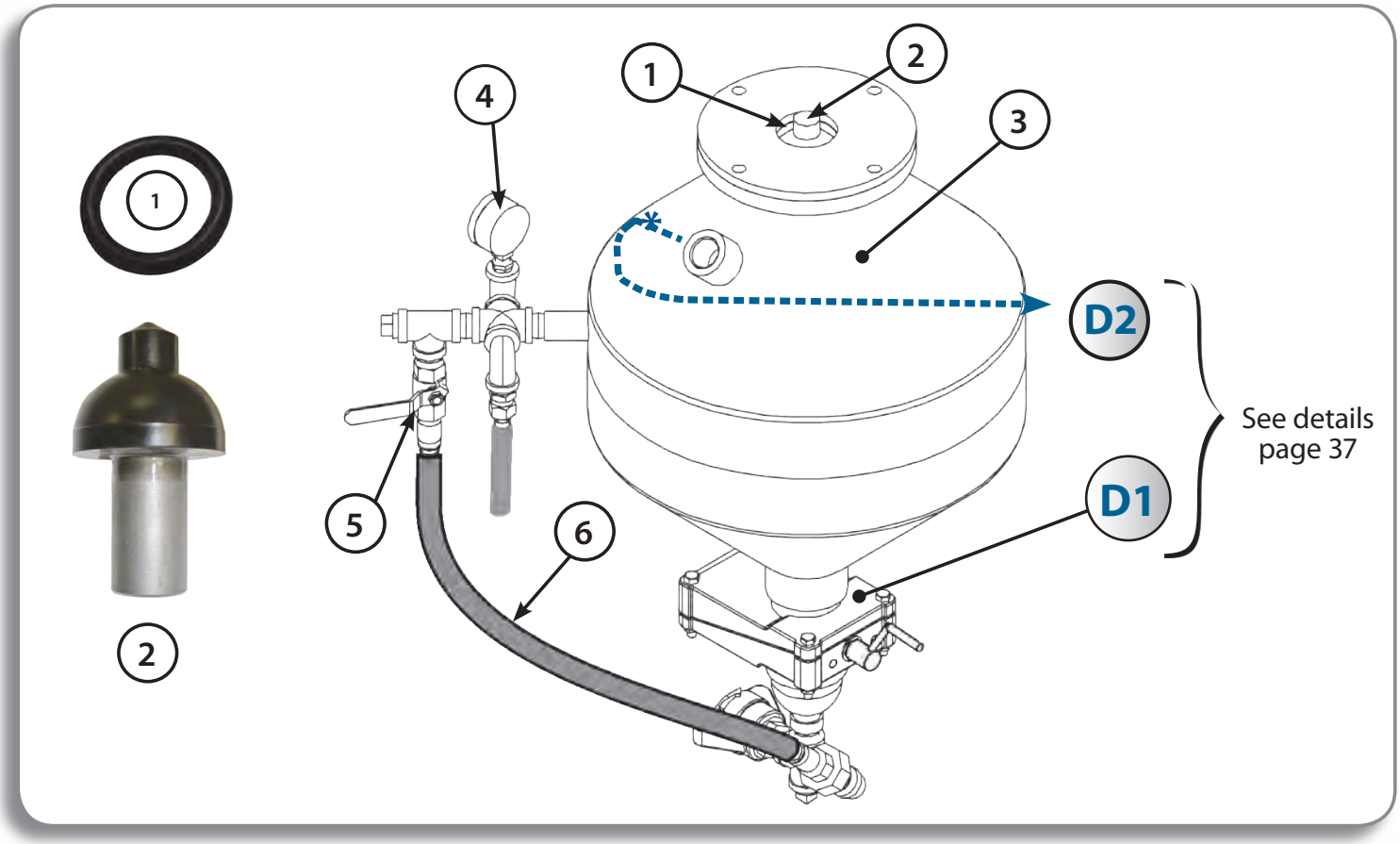


PARTS LIST

#	STOCK	DESCRIPTION
1	610387	1" Inlet Ring
2	630601	1" Nipple
3	608104	1" Ball Valve
4	630629	1" Cross Fitting
5	630653	1" x ¼" Reducer
6	632232	¼" F x ¼" M Street Elbow
7	630605	1" x 3" Lg. Nipple
8	608069	1" WATTS Valve (complete ass'y)
8A	608064	Kit : Diaphragm Assembly T. & B. - Disc ass'y (Pop Pet) Bottom Plug O-Ring
8B	608066	1" - 1¼" WATTS Valve Plug
8C	608071	Spring (Return)
10	630630	1" PA Tee

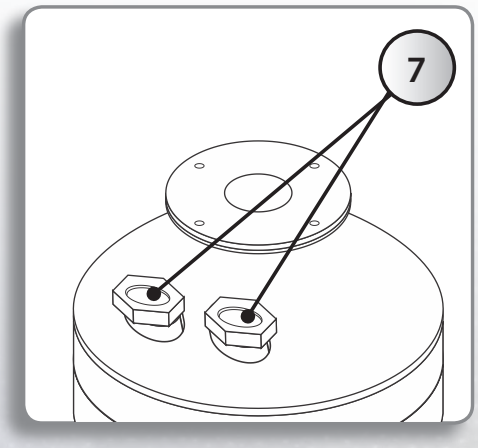
#	STOCK	DESCRIPTION
11	608204	1" Check Valve
12	632270	¼" NPT x ¼" Pipe Hose Barb
13	324560	¼" NPT ¼" TU @ 90° Push-In Fitting
14	632002	⅛" Hex Nipple
15	324561	⅛" NPT ¼" TU @ 90° Push-In Fitting
16	632018	⅛" PL Street Tee
17	632730	½" PL MF Elbow fitting
18	324558	¼" MTP ¼" TU Push-in Fitting
19	630690	1" Hose Barb Fitting
20	324503	¼" MTP x ¼" TU Bulkhead Fitting
21	324571	¼"Poly. blue tubing
22	632730	½" PL MF Elbow Fitting
23	606104	½" Clear Nylon Tube

PRESSURE VESSEL - EXPLODED VIEW & PARTS

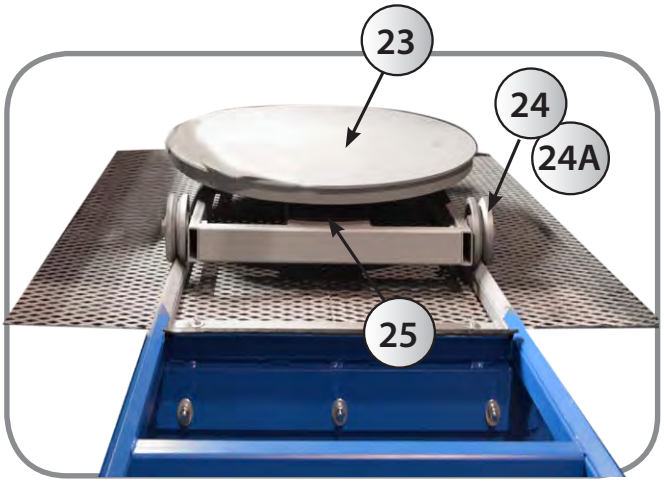


#	STOCK	DESCRIPTION
1	618205	M101P "O" RING
2	610040	M101P PLUNGER
3	610313	M101P PRESSURE VESSEL
4	611022	¼" PRESSURE GAUGE
5	608102	½" BALL VALVE
	608104	1" BALL VALVE (OPTIONAL)
6	606001	½" SBH HOSE (SOLD PER FOOT)
	606005	1" SBH HOSE OPTIONAL (SOLD PER FOOT)
7	610311	2" SIGHT GLASS (OPTIONAL)

SIGHT GLASSES OPTION

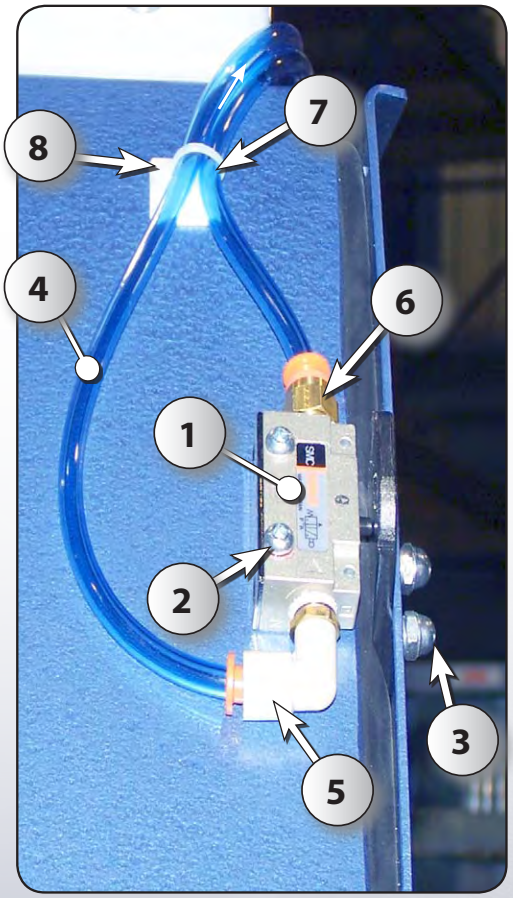


OPTION : ROTARY TABLE ON RAILS



#	STOCK	DESCRIPTION	
23	619121	457mm (18")	ROTATING TABLE TOP ONLY
	619122	533mm (21")	
	619123	711mm (28")	
	619124	813mm (32")	
	619125	914mm (36")	
	619126	1 016mm (40")	
	619127	1 210mm (48")	
24	619022	4" WHEEL WITH «V» GROOVE C/W BUSHING	
24A	619025	BUSHING ONLY (FOR WHEEL)	
25	619211	1" AXLE BEARING	

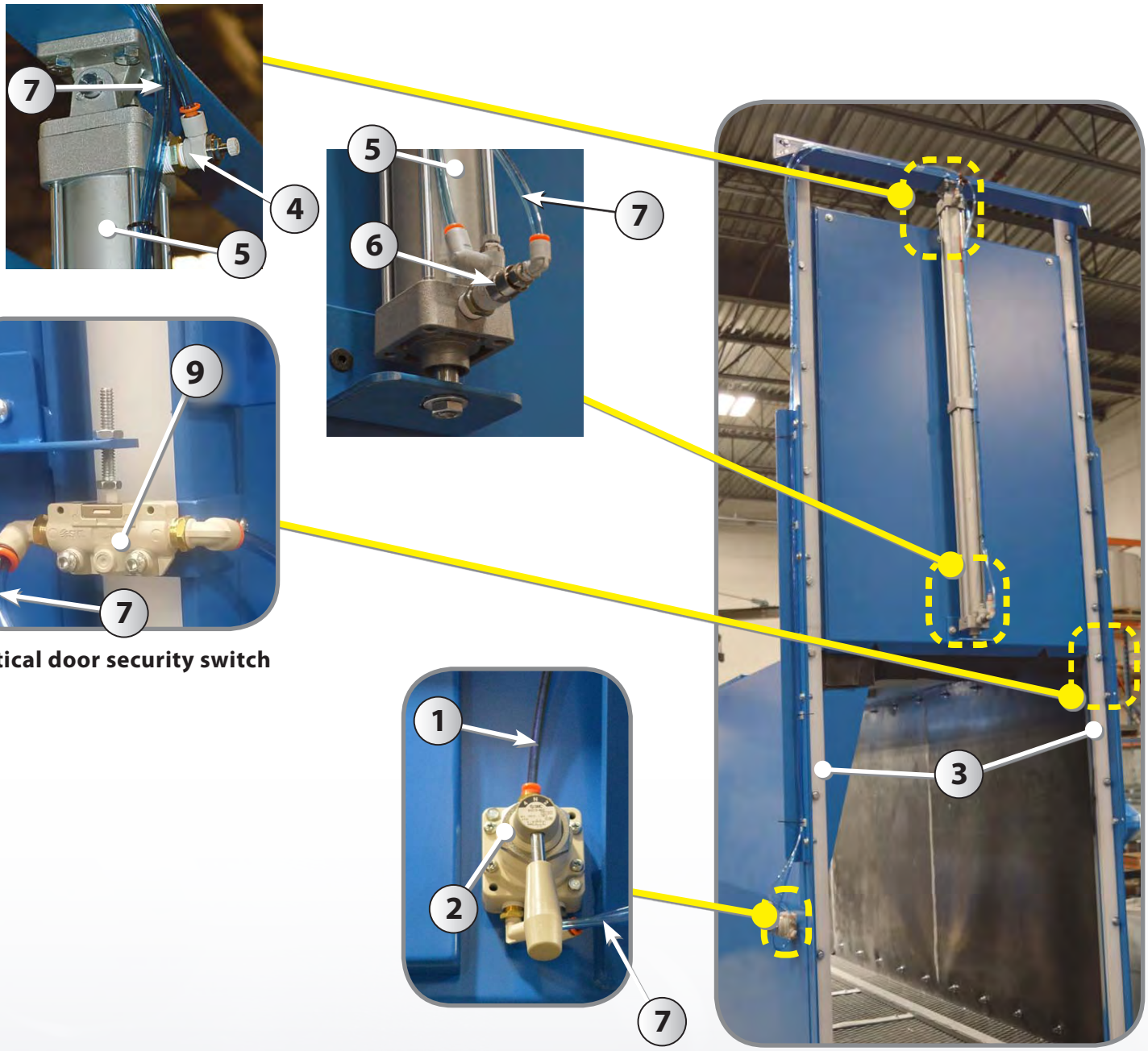
OPTION : DOOR SAFETY SWITCH - INSTALLATION KIT (600116)



1. Place the door safety switch (1) as shown (fig 1) mark and drill 2 holes 5/32 " and secure with 2 screws + nuts and washers (2) (supplied)
2. Place the screw plate screw in front of the switch button, mark and drill 2 holes 7/32 " in the door, and screw the 2 screws + cap nuts (3) (supplied)
3. Push the poly. blue tubes (4) in push-in (5) and (6) (supplied), attach them with a Ty-Rap (7) and it self-adhesive support (8) (supplied).

ID	PART NB	DESCRIPTION
1	908501	THREE WAYS AIR VALVE ⅛" PORT
2	NPN	2 SETS OF SCREW AND NUT & WASHER (SUPPLIED)
3	NPN	2 SETS OF SCREW + WASHER & DOME NUT (SUPPLIED)
4	324571	15' OF BLUE POLY. TUBE ¼"
5	324561	90° PUSH IN FITTING ⅛"' NPT ¼" TUBE
6	324570	STRAIGHT PUSH IN ¼ X ⅛" "
7	616706	NYLON TY-RAP 3 ½"
8	616717	TY-RAP MOUNTING (1x2)

OPTION : VERTICAL DOOR



Vertical door security switch

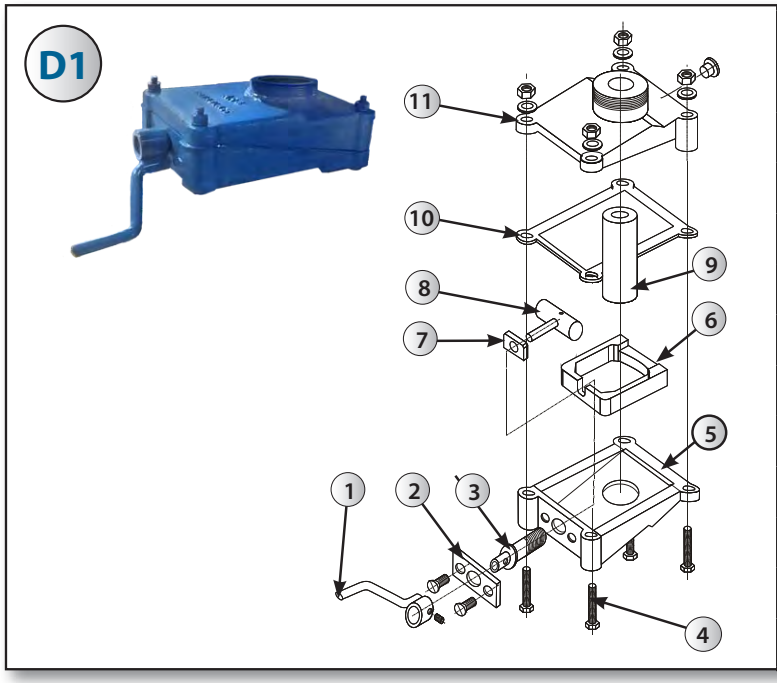
#	STOCK	DESCRIPTION
1	324571	¼" BLUE POLY. TUBING
2	908589	PNEUMATIC DOOR SWITCH
3	NPN	UHMW DOOR GUIDE
4	908699	FLOW CONTROL
5	908436	CYLINDER 28" STROKE
	908880	CYLINDER 39" STROKE

#	STOCK	DESCRIPTION
6	908659	FLOW CONTROL WITH CHECK VALVE
7	324571	¼" BLUE POLY. TUBING
9	908501	VERTICAL DOOR SWITCH (OPTION.)

D1 AR-7 REGULATOR & DEPRESSURIZING SYSTEM - VIEWS & PARTS

AR-7 REGULATOR

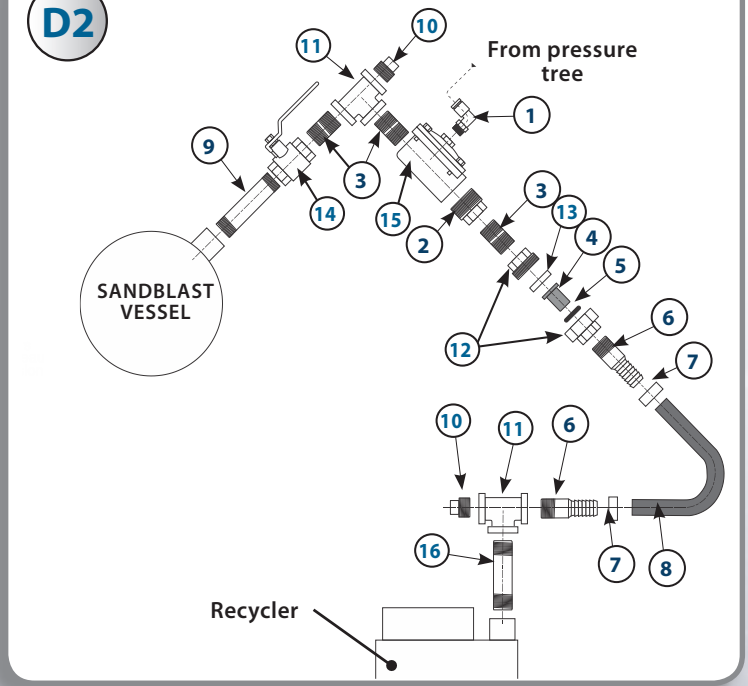
D1



A	608043	Complete AR7 Abrasive Regulator
1	608093	Handle
2	608091	Retaining plate
3	608039	Regulating Screw
4	608096	Clamping Bolts (sold by kit)
5	608047	Lower Housing
6	608037	Crushing bracket
7	608040	½" Regulating Plate
8	608036	Crushing Tube
9	618228	Rubber Tube
10	618231	Gasket Seal
11	608046	Upper Housing

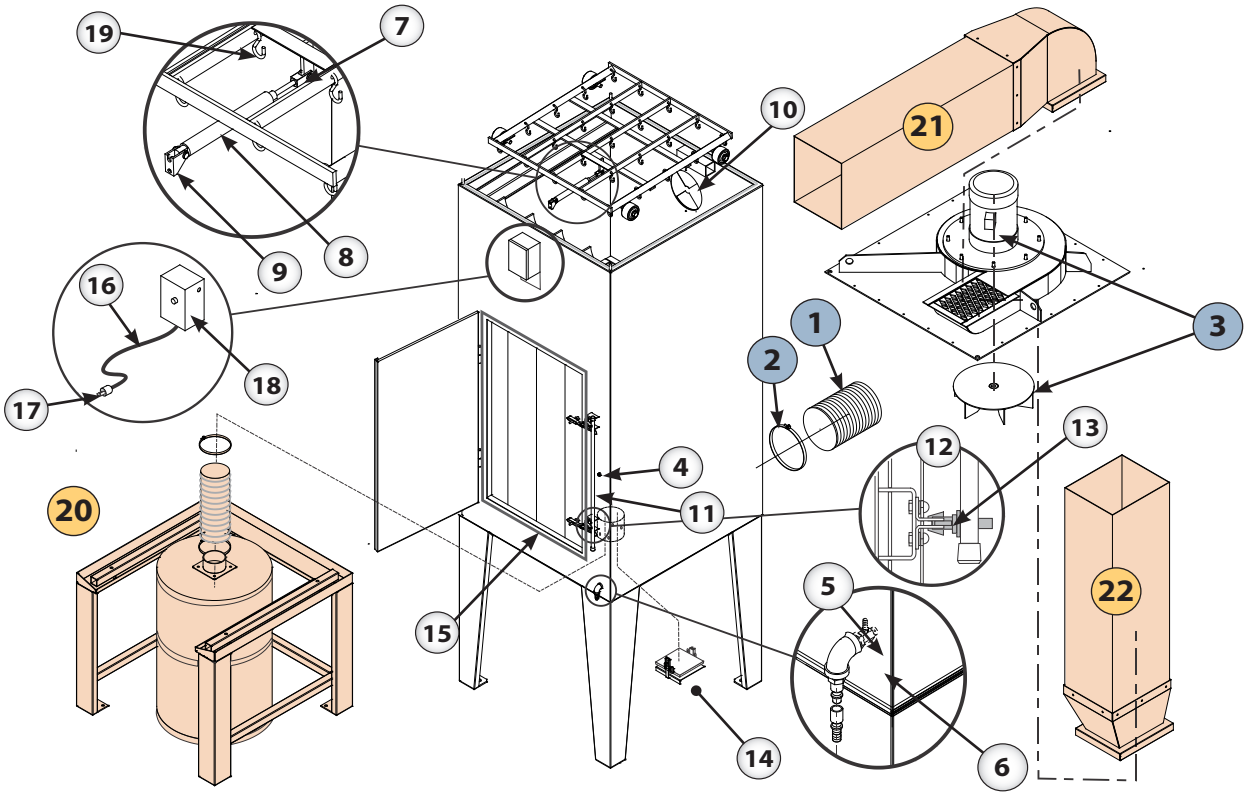
DEPRESSURIZING SYSTEM

D2



#	STOCK	DESCRIPTION
1	324560	¼" @ 90° Push-in Coupling
2	630860	1¼" x 1" Bushing (incl. W. #15)
3	630624	1" ced. 80 PA Nipple
4	605011	BN2-5 5/16 Nozzle
5	618110	G5 O-Ring
6	630690	1" Adaptor
7	607087	1¼" Hose Clamp double bolt
8	606005	SBH 1" Sandblast Hose (sold per ft.)
9	630605	1" x 7" lg. PA Nipple
10	630671	1" M Plug
11	630630	1" PA Tee
12	630680	1" PA Union
13	610070	Depress Spacer
14	608104	1" Ball Valve
15	608611	1" NPT depress. valve
	608612	Diaphragm only (for 608611)
16	630605	1" x 3" lg. PA Nipple

BAGHOUSE DUST COLLECTOR - GENERAL PARTS LIST



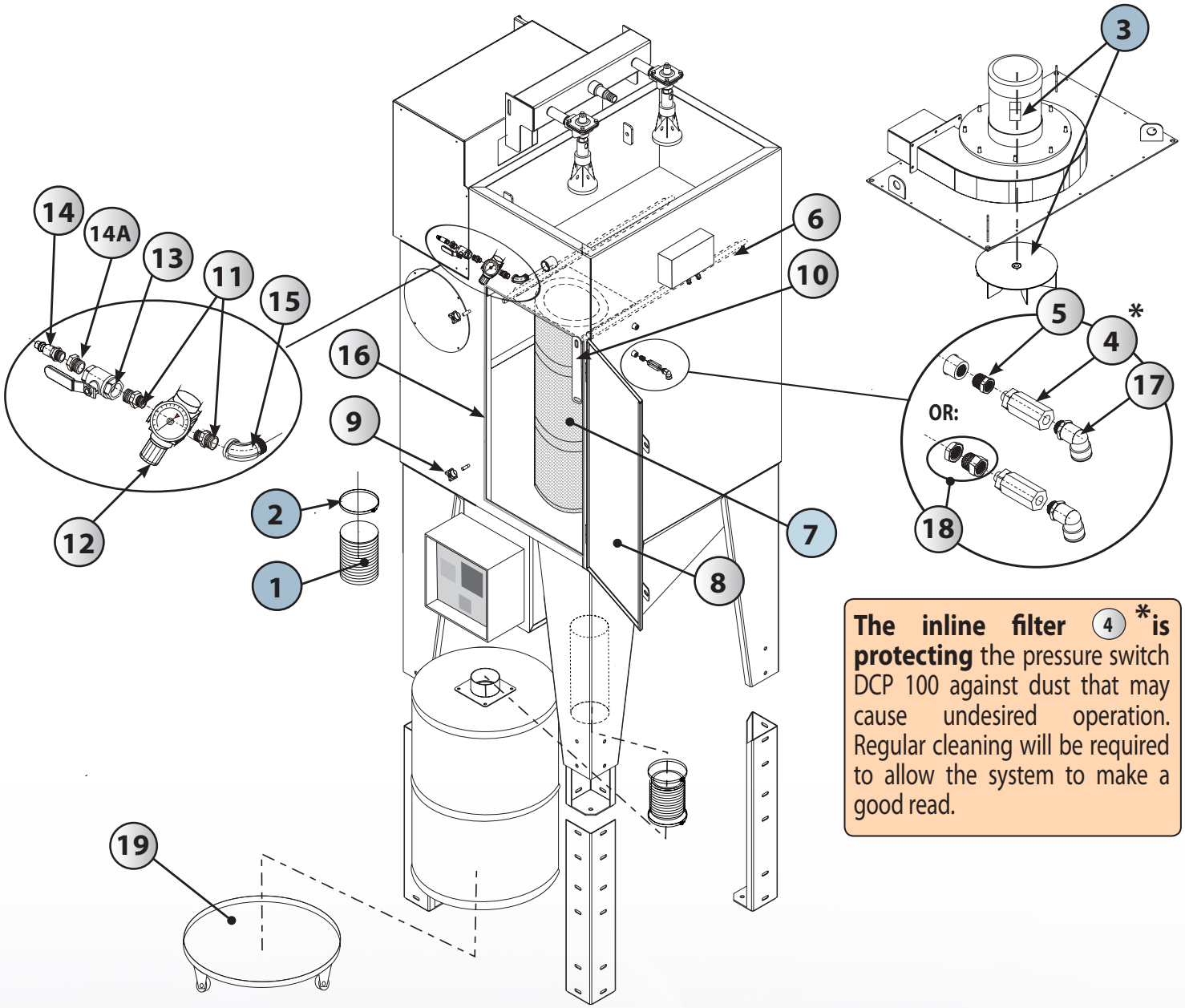
#	STOCK	DESCRIPTION
1	**Hoses:** see chart page 40	
2	**Clamps:** see chart page 40	
3	**Fan Motor:** See chart page 40	
4	608508	Shaking button
5	608408	Flow regulator
6	608409	Adaptor
7	608406	Hinge axle
8	608405	Cylinder
9	608407	Hinge plate
10	610280	Adjustable air trap

#	STOCK	DESCRIPTION
11	**610287**	Door handle
12	**610223**	Toggle lock
13	**910223**	Toggle stem
14	**601378**	Trap door for dust
15	**618321**	"D" type rubber (sold per foot)
16	**616575**	Electric cable (sold per foot)
17	**616406**	Electrical plug
18	**617063**	Electrical box
19	**601309**	"S" Hook

BAGHOUSE DUST COLLECTOR OPTIONS

	20 DUST BARREL OPTION			HORIZONTAL MUFFLER 21	VERTICAL MUFFLER 22
DCM MODEL	OPTION NUMBER	BARREL CAPACITY (L)	BARREL TROLLEY		
DCM-100-4	601486	57	**501182**	601434	601423
DCM-100	601486			601434	601423
DCM-160	601487	113.5	**919633**	601435	601424
DCM-230	601490			601436	601425
DCM-330	601490			601437	601426

CARTRIDGE DUST COLLECTOR - GENERAL PARTS LIST

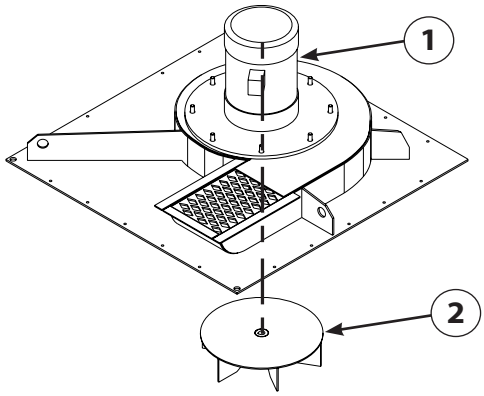


The inline filter (4) * is protecting the pressure switch DCP 100 against dust that may cause undesired operation. Regular cleaning will be required to allow the system to make a good read.

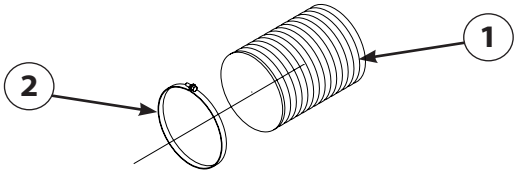
#	STOCK	DESCRIPTION
1	Hoses: see chart page 40	
2	Clamps: see chart page 40	
3	Fan Motor: See chart page 40	
4	611058	INLINE FILTER
5	632248	¼" REDUCER
6	NPN	CARTRIDGE GUIDE
7	Filtering Cartridge: see Dust Collector Instr. Manual	
8	NPN	ACCESS DOOR
9	940109	KNOB
10	NPN	HANDLE FOR FIXING THE CARTRIDGES

#	STOCK	DESCRIPTION
11	630651	1"TO 1/2" REDUCER
12	608022	COMPLETE REGULATOR
13	608102	1/2" BALL VALVE
14	607222	¼"-¼" NPT « QUICK-CONNECT » FITTING
14A	630351	½" @ ¼" MF REDUCER
15	630641	90° MF 1" ELBOW
16	618321	"D" TYPE RUBBER (SOLD PER FOOT)
17	314048	¼"@ 90° PUSH-IN FITTING
18	932004	FF ¼" BULKHEAD
19	919325	TROLLEY FOR BARREL

FAN MOTOR & SUCTION HOSE

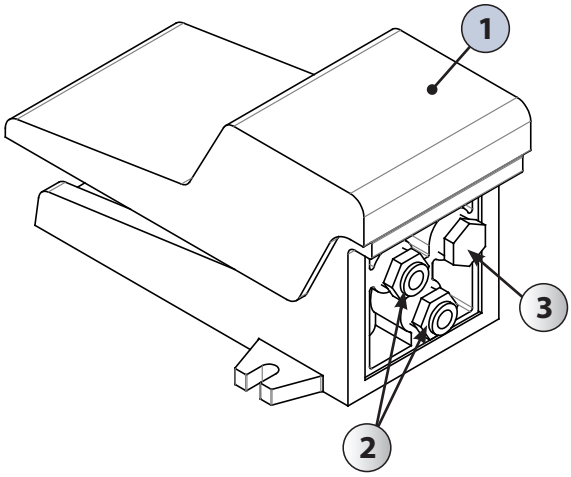


FAN MOTOR			
Fan Motor (kW) (1)	Voltage		Impeller (2)
	220 V	380 V	
0.37	IST	N/A	610525
0.75	IST	N/A	610526
1.49	IST	N/A	610527
2.24	N/A	IST	610528
3.73	N/A	IST	610529
5.59	N/A	IST	IST
7.46	N/A	IST	IST



CORRUGATED SUCTION HOSES AND CLAMPS			
Fan Motor (kW)	Hose ID	Hose (1)	Clamp (2)
0.373	127mm (5")	606168	624121
0.746	152mm (6")	606169	624124
1.492	178mm (7")	606171	624127
2.238	203mm (8")	606173	624128
3.730	254mm(10")	606177	624137

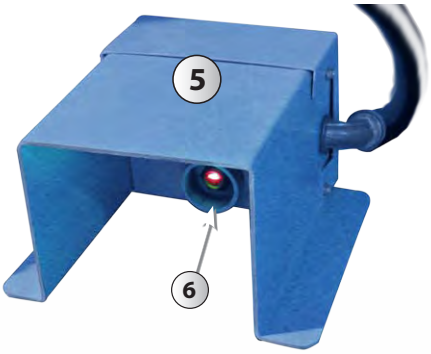
STANDARD FOOT PEDAL - PARTS DETAIL

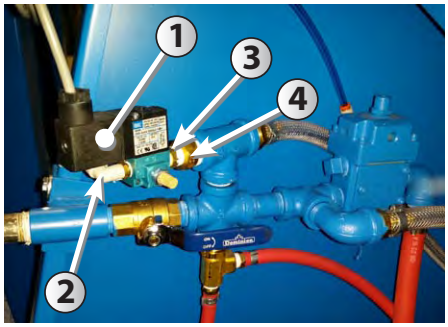


#	STOCK	DESCRIPTION
1	908065	Pneumatic Foot Pedal (complete)
2	950264	¼" Push-in Fittings
3	632551	¼" Brass Plug

NO-CONTACT FOOT PEDAL (OPTIONAL)

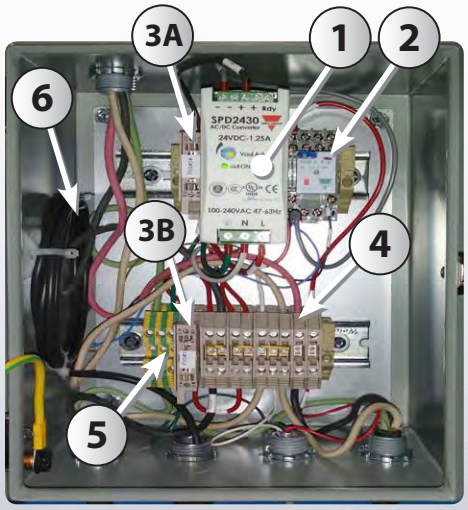
PEDAL & PARTS





#	STOCK	DESCRIPTION
1	608568	SOLENOID VALVE
2	324561	⅛" PUSH-IN FITTING
3	632214	ADAPTER ⅛" TO ¼"
4	632745	ADAPTER ½" TO ¼"
5	910525	COMPLETE NO-CONTACT FOOT PEDAL
6	917879	INFRARED SENSOR CELL

CONTROL PANEL WITH PARTS



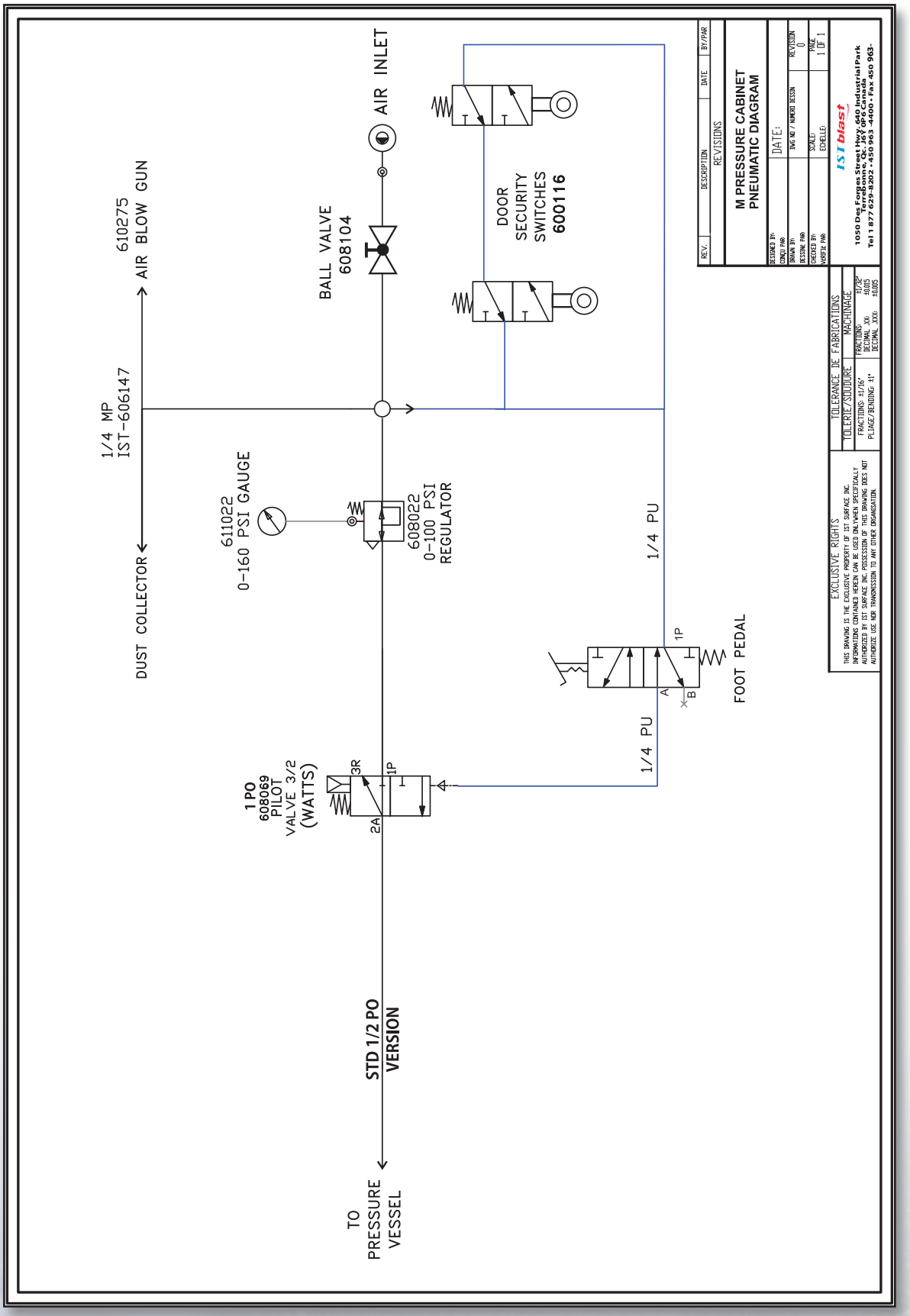
#	STOCK	DESCRIPTION
1	917618	24V DC - POWER SUPPLY
2	917877	24V DC RELAY
3A	917893	MDL.2A FUSE
3B	616933	AGC-1A FUSE
4	-/-	TERMINAL BLOCKS
5	616865	GROUND BLOCKS
6	917880	SENSOR CABLE

RECOMMENDED SPARE PARTS

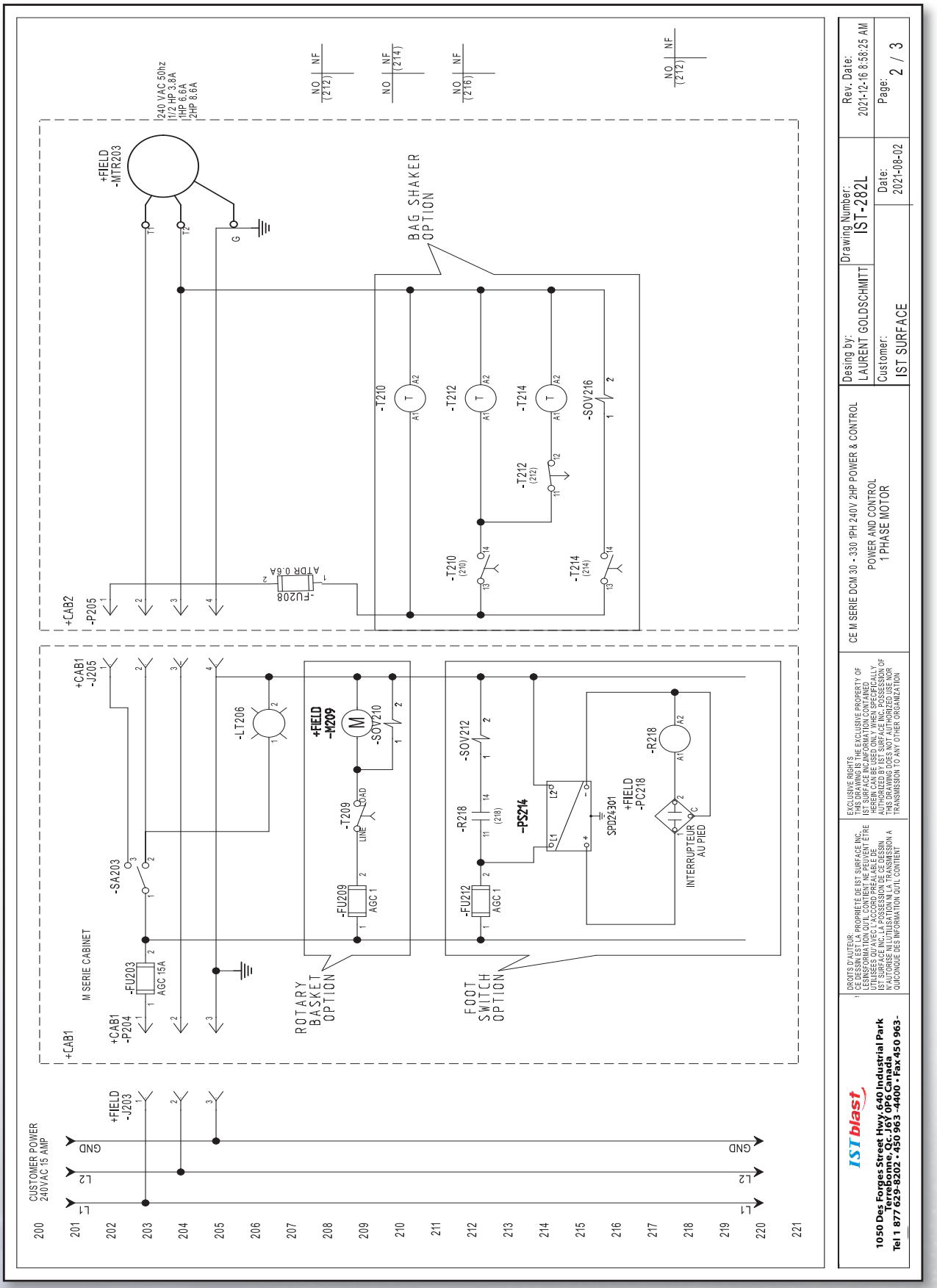
Description	Configuration	Part No	Qty
Cabinet			
Leather Gloves	All Models	**603205**	1
Nozzle 5/16" ID*		**405465**	
"Blast Hose (sold by foot)"	2636-2844-3636-3648-4248-4848	**606020**	7
	3660-3672-4860-4872-6060-6072		12
Safety Glass	2636-2844-3636-3648-4248-4848	**610212**	1
	3660-3672-4860-4872-6060-6072	**610211**	5
Window Shield	2636-2844-3636-3648-4248-4848	**613038**	1
	3660-3672-4860-4872-6060-6072	**613035**	5
Reclaiming Hose	DCM100-DCM600	**606120**	8
	DCM100-DCM600	**606123**	
	DCM230-DCM1200	**606124**	
Dust Collector			
Filtering Bag	DCM100	**601316**	16
	DCM160		25
	DCM230		36
Filtering Cartridge	DCM600	**901321**	2
	DCM900		
	DCM1200		4
Dust Carrying Hose	DCM100-DCM600	**606169**	12
	DCM160-DCM900	**606171**	
	DCM230-DCM1200	**606173**	
Pressure Vessel			
AR7 Rubber Tube	All Models	**618228**	1
O-RING		**618205**	
Plunger		**610040**	
Nozzle 5/16" ID		**605011**	
Cap		**630671**	2
Depressurization Valve		**608611**	1
Diaphragm		**608612**	

*Corresponds to the standard items and may not reflect your actual cabinet configuration

PNEUMATIC DIAGRAM



ELECTRICAL SCHEMATIC WITH DCM 50 TO 330 BAG-TYPE - 240 V/1 PH - DRAWING



Fonction	Localisation	Tag	Material (Cat. No.)	Series	Cat. No. Description	Spplier
	+CAB1	-FU203	AGC15		GLASS FUSE 15 AMP	FERRAZ
	+CAB1	-FU203	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB2	-FU208	ATDR1		FUSE 1A 600V TYPE CC TIME DELAY	FERRAZ
	+CAB2	-FU208	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB1	-FU209	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB1	-FU209	AGC1		GLASS FUSE 1 AMP	FERRAZ
	+CAB1	-FU212	10140		FUSE BLOCK VUSI4-4	WEIDMULLER
	+FIELD	-J203	CUSTOMER		CUSTOMER FUSE DISCONECT	CUSTOMER
	+CAB1	-J205	27W75		PLUG 4P FEMELLE 15A	LEVITON
	+FIELD	-LT206	2SLSTP2040DD120V/4SLSTP4040DD120		STRIP LED 24" / STRIP LED 48"	METALUX
	+FIELD	-M209	0449 (34R4BF-Z4)		REDUCTOR MOTOR 1/15HP 115V 180/1 RATIO	BODINE
	+FIELD	-MTR203	113912		MOTOR 1/2HP 120/220V 1PH 50HZ 3000RPM	LEESON
	+FIELD	-MTR203	113914		MOTOR 1HP 120/220V 1PH 50HZ 3000RPM	LEESON
	+FIELD	-MTR203	120990		MOTOR 2HP 220V 1PH 3000RPM 50HZ	LEESON
	+CAB1	-P204	BRY5466NP		Straight Blade Devices 20A 250V, 2-Pole 3-Wire MALE	HUBBELL
	+CAB2	-P205	26W75		PLUG 4P MALLE 15A	LEVITON
	+FIELD	-PC218	GX3-AP-1E		PHOTOELECTRIC SENSOR PNP UP TO 100MM	AUTOMATION DIRECT
	+CAB1	-PS214	SPD24301		POWER SUPLY 24VDC 300W	CARLO GAVAZZI
	+CAB1	-R218	RMIA4524DC		RELAY 4PDT 24VDC	CARLO GAVAZZI
	+CAB1	-R218	SY4S05C		RELAY HOLDER 4 POLE	CARLO GAVAZZI
	+CAB1	-SA203	R13-437I			
	+FIELD	-SOV210	12QW2-EUBN-7281		VALVE DIAPH 1/2	GOYEN
	+FIELD	-SOV212	35A-AAA-DAAJ-1JB		SOL.VALVE 35A-AAA-DAAJ-1JB 120V NC	MAC
	+FIELD	-SOV216	35A-AAA-DAAJ-1JB		SOL.VALVE 35A-AAA-DAAJ-1JB 120V NC	MAC
	+CAB1	-T209	FF15MC		15 MINUTE TIMER	INTERMATIC
	+CAB2	-T210	TMM1		TIMER RELAY 1NO 1NC	LOVATO
	+CAB1	-T212	TMM1		TIMER RELAY 1NO 1NC	LOVATO
	+CAB2	-T214	TMM1		TIMER RELAY 1NO 1NC	LOVATO

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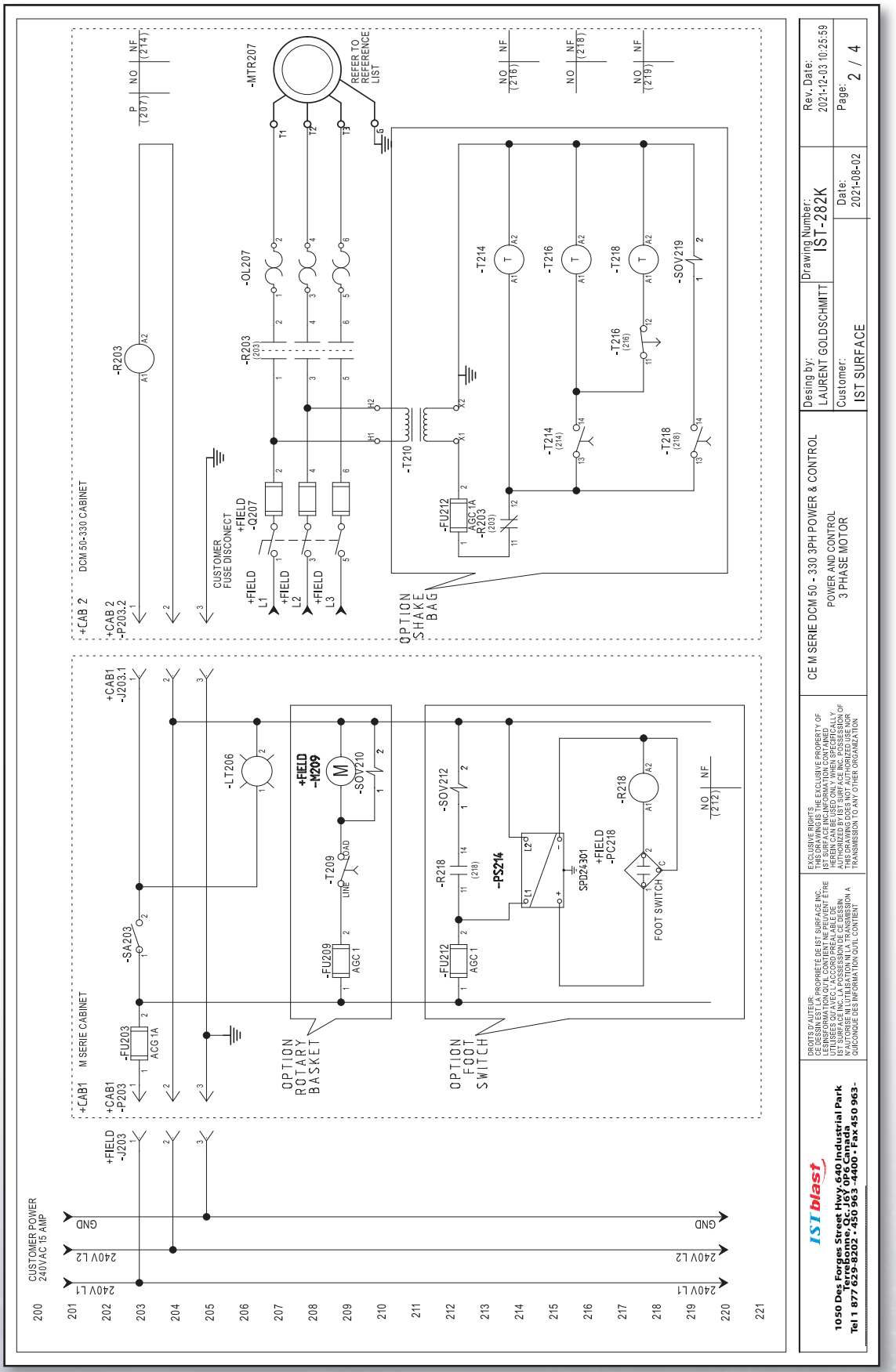
CE M SERIE DCM 30 - 330 1PH 240V 2HP POWER & CONTROL

Customer:	Drawing number:	Rév.:	Page Rev. Date:
IST SURFACE	IST-282L		2021-12-16 8:59:45 AM
Drawing by:	Date:		Page:
LAURENT GOLDSCHMITT	2021-12-16		3 / 3

ELECTRICAL SCHEMATIC WITH DCM 50 TO 330 BAG-TYPE - 3 PH - DRAWING



Fonction	Localisation	Tag	Material (Cat. No.)	Series	Cat. No. Description	Spplier
	+CAB1	-FU203	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB1	-FU209	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB1	-FU212	10140		FUSE BLOCK VUSI4-4	WEIDMULLER
	+CAB 2	-FU212	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+FIELD	-J203	CUSTOMER		CUSTOMER FUSE DISCONECT	CUSTOMER
	+CAB1	-J203.1	BRY5669NC		Straight Blade Devices 20A 250V, 2-Pole 3-Wire FEMALE	HUBBELL
	+FIELD	-LT206	2SLSTP2040DDUNV/4SLSTP4040DDUNV		STRIP LED 24" / STRIP LED 48" 240V	METALUX
	+FIELD	-M209	M38P17NZ26		MOTOR 230V 1/15 HP	LEASON
	+FIELD	-MTR207	REFERT TO		REFERT TO REFERENCE LIST	SCHNEIDER ELECTRIC
	+CAB 2	-OL207	REFERT TO		REFERT TO REFERENCE LIST	SCHNEIDER ELECTRIC
	+CAB1	-P203	BRY5466NP		Straight Blade Devices 20A 250V, 2-Pole 3-Wire	HUBBELL
	+CAB 2	-P203.2	BRY5466NP		Straight Blade Devices 20A 250V, 2-Pole 3-Wire	HUBBELL
	+FIELD	-PC218	GX3-AP-1E		PHOTOELECTRIC SENSOR PNP UP TO 100MM	AUTOMATION DIRECT
	+CAB1	-PS214	SPD24301		POWER SUPLY 24VDC 300W	CARLO GAVAZZI
	+FIELD	-Q207	COSTOMER		COSTOMER FUSE DISCONECT	COSTOMER
	+CAB 2	-R203	REFERT TO		REFERT TO REFERENCE LIST	SCHNEIDER ELECTRIC
	+CAB1	-R218	RMIA4524DC		RELAY 4PDT 24VDC	CARLO GAVAZZI
	+CAB1	-R218	SY4S05C		RELAY HOLDER 4 POLE	CARLO GAVAZZI
	+CAB1	-SA203	R13-437A		SEALED TOGLE SWITCH	SHIN CHIN INDUSTRIAL
	+FIELD	-SOV210	12QW2-EUBN-7251		VALVE DIAPH 1/2 240VAC	GOYEN
	+FIELD	-SOV212	35A-ABA-DAAJ-1JB		SOL.VALVE 35A-AAA-DAAJ-1JB 240V NC	MAC
	+FIELD	-SOV219	35A-ABA-DAAJ-1JB		SOL.VALVE 35A-AAA-DAAJ-1JB 240V NC	MAC
	+CAB1	-T209	FF15MC		15 MINUTE TIMER	INTERMATIC
	+CAB 2	-T210	MTC100-31		CONTROL TRANSFORMER 380/240VAC 100VA	MARCUS
	+CAB 2	-T214	TMM1		TIMER RELAY 1NO 1NC	LOVATO
	+CAB 2	-T216	TMM1		TIMER RELAY 1NO 1NC	LOVATO
	+CAB 2	-T218	TMM1		TIMER RELAY 1NO 1NC	LOVATO

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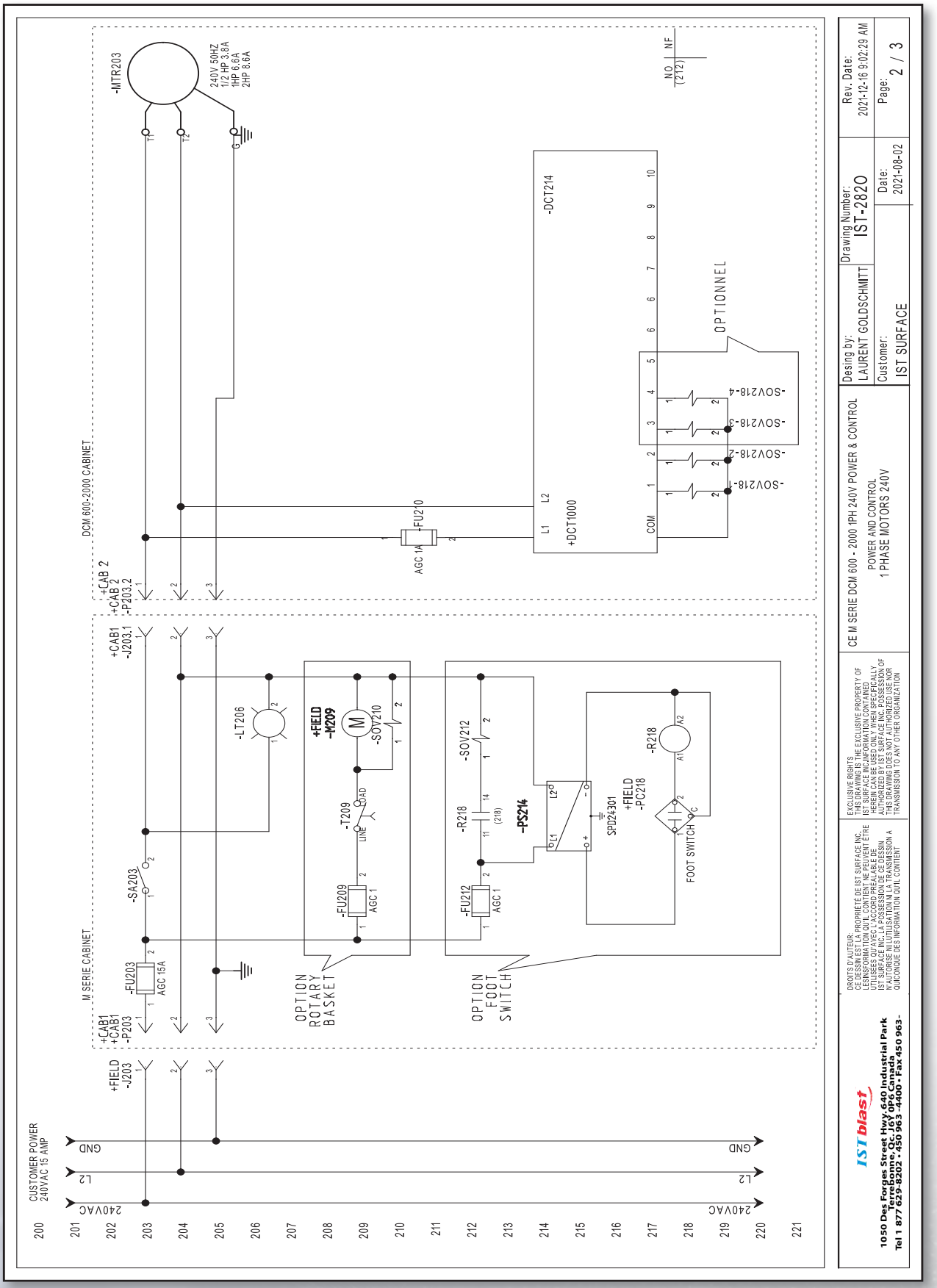
CE M SERIE DCM 50 - 330 3PH POWER & CONTROL

Customer: IST SURFACE	Drawing number: IST-282K	Rév.:	Page Rev. Date: 2021-12-07 15:04:35
Drawing by: LAURENT GOLDSCHMITT	Date: 2021-12-07		Page: 4 / 4

ELECTRICAL SCHEMATIC WITH DCM 600 TO 1800 CARTRIDGE TYPE - 1 PH



Fonction	Localisation	Tag	Material (Cat. No.)	Series	Cat. No. Description	Spplier
	+DCT1000	-DCT214	DTC1000		DUST COLLECTOR TIMER CONTROLLER	DWYER
	+CAB1	-FU203	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB1	-FU203	AGC15		GLASS FUSE 15 AMP	FERRAZ
		-FU209	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
		-FU210	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
		-FU212	10140		FUSE BLOCK VUSI4-4	WEIDMULLER
	+FIELD	-J203	CUSTOMER		CUSTOMER FUSE DISCONECT	CUSTOMER
	+CAB1	-J203.1	BRY5669NC		Straight Blade Devices 20A 250V, 2-Pole 3-Wire FEMALE	HUBBELL
	+FIELD	-LT206	2SLSTP2040DDUNV/4SLSTP4040DDUNV		STRIP LED 24" / STRIP LED 48" 240V	METALUX
	+FIELD	-M209	M38P17NZ26		MOTOR 230V 1/15 HP	LEASON
	+CAB 2	-MTR203	113914		MOTOR 1HP 120/220V 1PH 50HZ 3000RPM	LEESON
	+CAB 2	-MTR203	113912		MOTOR 1/2HP 120/220V 1PH 50HZ 3000RPM	LEESON
	+CAB 2	-MTR203	120990		MOTOR 2HP 220V 1PH 3000RPM 50HZ	LEESON
	+CAB1	-P203	BRY5466NP		Straight Blade Devices 20A 250V, 2-Pole 3-Wire	HUBBELL
	+CAB 2	-P203.2	BRY5466NP		Straight Blade Devices 20A 250V, 2-Pole 3-Wire	HUBBELL
	+FIELD	-PC218	GX3-AP-1E		PHOTOELECTRIC SENSOR PNP UP TO 100MM	AUTOMATION DIRECT
		-PS214	SPD24301		POWER SUPLY 24VDC 300W	CARLO GAVAZZI
		-R218	SY4S05C		RELAY HOLDER 4 POLE	CARLO GAVAZZI
		-R218	RMIA4524DC		RELAY 4PDT 24VDC	CARLO GAVAZZI
		-SA203	R13-437A		SEALED TOGLE SWITCH	SHIN CHIN INDUSTRIAL
	+FIELD	-SOV210	12QW2-EUBN-7251		VALVE DIAPH 1/2 240VAC	GOYEN
	+FIELD	-SOV212	35A-ABA-DAAJ-1JB		SOL.VALVE 35A-AAA-DAAJ-1JB 240V NC	MAC
	+FIELD	-SOV218-1	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
	+FIELD	-SOV218-2	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
	+FIELD	-SOV218-3	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
	+FIELD	-SOV218-4	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
		-T209	FF15MC		15 MINUTE TIMER	INTERMATIC

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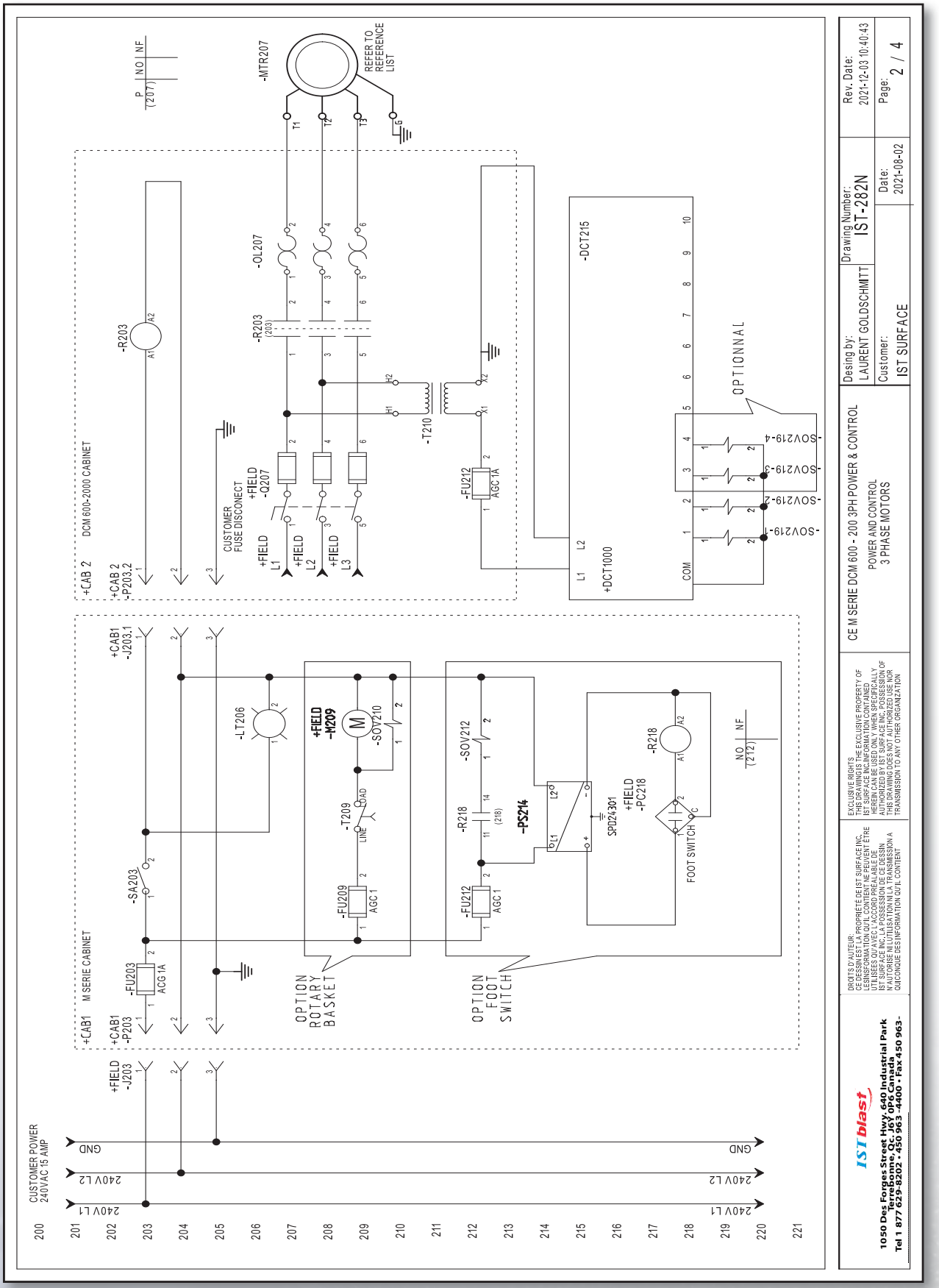
CE M SERIE DCM 600 - 2000 1PH 240V POWER & CONTROL

Customer: IST SURFACE	Drawing number: IST-2820	Rév.:	Page Rev. Date: 2021-12-16 9:02:29 AM	
Drawing by: LAURENT GOLDSCHMITT	Date: 2021-12-16		Page: 3 / 3	

ELECTRICAL SCHEMATIC WITH DCM 600 TO1800 CARTRIDGE TYPE - 3 PH - DRAWING



Fonction	Localisation	Tag	Material (Cat. No.)	Series	Cat. No. Description	Spplier
	+DCT1000	-DCT215	DTC1000		DUST COLLECTOR TIMER CONTROLLER	DWYER
	+CAB1	-FU203	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB1	-FU209	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+CAB1	-FU212	10140		FUSE BLOCK VUSI4-4	WEIDMULLER
	+CAB 2	-FU212	HKP-HHR		FUSE HOLDER E-3/RB-14-6-FL	BUSSMAN
	+FIELD	-J203	CUSTOMER		CUSTOMER FUSE DISCONECT	CUSTOMER
	+CAB1	-J203.1	BRY5669NC		Straight Blade Devices 20A 250V, 2-Pole 3-Wire FEMALE	HUBBELL
	+FIELD	-LT206	2SLSTP2040DDUNV/4SLSTP4040DDUNV		STRIP LED 24" / STRIP LED 48" 240V	METALUX
	+FIELD	-M209	M38P17NZ26		MOTOR 230V 1/15 HP	LEASON
	+FIELD	-MTR207	REFERT TO		REFERT TO REFERENCE LIST	SCHNEIDER ELECTRIC
	+CAB 2	-OL207	REFERT TO		REFERT TO REFERENCE LIST	SCHNEIDER ELECTRIC
	+CAB1	-P203	BRY5466NP		Straight Blade Devices 20A 250V, 2-Pole 3-Wire	HUBBELL
	+CAB 2	-P203.2	BRY5466NP		Straight Blade Devices 20A 250V, 2-Pole 3-Wire	HUBBELL
	+FIELD	-PC218	GX3-AP-1E		PHOTOELECTRIC SENSOR PNP UP TO 100MM	AUTOMATION DIRECT
	+CAB1	-PS214	SPD24301		POWER SUPLY 24VDC 300W	CARLO GAVAZZI
	+FIELD	-Q207	COSTOMER		COSTOMER FUSE DISCONECT	COSTOMER
	+CAB 2	-R203	REFERT TO		REFERT TO REFERENCE LIST	SCHNEIDER ELECTRIC
	+CAB1	-R218	RMIA4524DC		RELAY 4PDT 24VDC	CARLO GAVAZZI
	+CAB1	-R218	SY4S05C		RELAY HOLDER 4 POLE	CARLO GAVAZZI
	+CAB1	-SA203	R13-437A		SEALED TOGLE SWITCH	SHIN CHIN INDUSTRIAL
	+FIELD	-SOV210	12QW2-EUBN-7251		VALVE DIAPH 1/2 240VAC	GOYEN
	+FIELD	-SOV212	35A-ABA-DAAJ-1JB		SOL.VALVE 35A-AAA-DAAJ-1JB 240V NC	MAC
	+FIELD	-SOV219-1	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
	+FIELD	-SOV219-2	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
	+FIELD	-SOV219-3	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
	+FIELD	-SOV219-4	RCAC25T4200		1" NPT Diaphragm Valve - 1/8 NPT	GOYEN
	+CAB1	-T209	FF15MC		15 MINUTE TIMER	INTERMATIC
	+CAB 2	-T210	MTC100-31		CONTROL TRANSFORMER 380/240VAC 100VA	MARCUS

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GE M SERIE DCM 600 - 200 3PH POWER & CONTROL

Customer: IST SURFACE	Drawing number: IST-282N	Rév.:	Page Rev. Date: 2021-12-07 15:10:04
Drawing by: LAURENT GOLDSCHMITT	Date: 2021-12-07		Page: 4 / 4

MOTOR RATINGS VOLTS INPUT, STARTER AND OVERLOAD SELECTION								
POWER	VOLTS	AMPS	PHASES	HERTZ	RPM	STARTER	OVERLOAD	CUSTOMER FUSE TYPE AND CAPACITY
3HP	380V	4.6A	3	50	3000	LE1D093A62OM70	LRD12	AJT6
5HP	380V	7.4A	3	50	3000	LE1D093A62OM70	LRD16	AJT10
7.5HP	380V	10.6A	3	50	3000	LC1D12M7	LRD21	AJT15
10HP	380V	14.5A	3	50	3000	LC1D18M7	LRD22	AJT20

MOTOR RATINGS VOLTS INPUT AND SELECTION							
POWER	VOLTS	AMPS	PHASES	HERTZ	RPM	PARTS NO	MAKER
3HP	380V	4.6A	3	50	3000	NEPT82TC2-2X4	NORDIC
5HP	380V	7.4A	3	50	3000	NEP184TC2-2X4	NORDIC
7.5HP	380V	10.6A	3	50	3000	NEP213TC2-2X4	NORDIC
10HP	380V	14.5A	3	50	3000	NEP215TC2-2X4	NORDIC

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CE M SERIE DCM 50 - 330 3PH POWER & CONTROL
REFERENCE LIST

Desing by: LAURENT GOLDSCHMITT	Drawing Number: IST-282K		Rev. Date: 2021-12-03 10:25:59
Customer: IST SURFACE		Date: 2019-11-06	Page: 3 / 4

IST LIMITED WARRANTY

IST warrants all equipment led in this manual which is manufactured by IST and bearing its name, to be free from defects in material and workmanship on the date of sale by an authorized IST distributor to the original purchaser for use. Notwithstanding any special, extended or limited warranty published by IST will, for a period of TWENTY FOUR (24) months from the date of sale, repair or replace any part of the equipment determined by IST to be defective. This warranty applies only when the equipment is installed, operated and maintained in accordance with IST's written recommendations.

This warranty does not cover, and IST shall not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non- IST component parts. Nor shall IST be liable for malfunction, damage or wear caused by the incompatibility with IST equipment with structures, accessories, equipment or materials not supplied by IST, or the improper design, manufacture, installation, operation or maintenance of structures, accessories, equipment or materials not supplied by IST.

This warranty is conditioned upon the prepaid return of the equipment claimed to be defective to an authorized IST distributor for verification of the claimed defect. If the claimed defect is verified, IST will repair or replace free of charge any defective parts. The equipment will be returned to the original purchaser, transportation prepaid. If the inspection of the equipment does not disclose any defect in material or workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

THIS WARRANTY IS EXCLUSIVE, AND IS IN LIEU OF ANY OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO WARRANTY OF MERCHANTABILITY OR WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.

IST's sole obligation and the buyer's sole remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach of warranty must be brought forward within one (2) years of the date of sale.

IST MAKES NO WARRANTY, AND DISCLAIMS ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, IN CONNECTION WITH ACCESSORIES, EQUIPMENT, MATERIALS OR COMPONENTS SOLD BUT NOT MANUFACTURED BY IST. These items sold, but not manufactured by IST (such as electric motors, switches, hose, etc.), are subject to the warranty, if any, of their manufacturer. IST will provide the purchaser with reasonable assistance in making any claim for breach of these warranties.

LIMITATION OF LIABILITY

In no event will IST be liable for indirect, incidental, special or consequential damages resulting from IST supplying equipment hereunder, or the furnishing, performance, or use of any products or other goods sold hereto, whether due to a breach of contract, breach of warranty, the negligence of IST, or otherwise.

Report all accidents or "near misses" which involve IST products to:

- **Technical Assistance**

The following items are not covered under the IST warranty policy:

- Parts or chassis replacement due to normal wears.

Defective material or workmanship is not considered normal wear

IST WARRANTY REGISTRATION

IST would like to thank you for your recent purchase of our product line. Please complete the card below and either mail or fax it to our office so that we may start the warranty of your product and keep you up to date on the EPA regulations by fax. Again, thank you for your purchase and if you have any suggestions or comments, please feel free to contact our office.

COMPANY NAME : |__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|

ADDRESS : |__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__

CITY : |__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__| **STATE/PROV. :**|__|__|__|__|__|__|__|__|__|

COUNTRY : |__|__|__|__|__|__|__|__|__|__|__|__|__| **ZIP CODE :**|__|__|__|__|__|__|__|__|__|__|__

CONTACT : |__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|

TEL. NUMBER: |__|__|__| |__|__|__| - |__|__|__|__| **EMAIL:** |__|__|__|__|__|__|__|__|__|__|__|__|__|

FAX NUMBER: |__|__|__| |__|__|__| - |__|__|__|__|

PURCHASE FROM:|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|_

DATE OF PURCHASE: |__|__| |__|__| |__|__|__|__|
Month Day Year

SERIAL NUMBER: |__|__| - |__|__|__| - |__|__|__|__| **MODEL NUMBER:** |__|__|__|__|__|__|

TYPE OF MEDIA USED: |__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|__|_

Which factors most influenced your decision to purchase this unit?

SUGGESTIONS ABOUT THE EQUIPMENT: ____

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Please fill out the form above and send it to us by mail, email or fax so we can register your product and keep you updated on the latest regulations released by the EPA. We thank you for your purchase and remain at your entire disposal for any further query regarding the operation of your equipment.

International Surface Technologies

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INFORMATION / TECHNICAL ASSISTANCE

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For more information, pricing or technical support, contact your local IST distributor or call / fax to our Consumer Information numbers:

TEL.: 1 877 629-8202 & 450 963-4400

Or visit us at:
istsurface.com

ABOUT THE COMPANY

WHO WE ARE

IST is a leading manufacturer of equipment for the surface treatment industry and the solvent recycling industry. Our extensive line of equipment includes batch units and automated machines designed to achieve the highest manufacturing standards.

MISSION

IST works tightly with their customers to transform industrial processes to improve their quality, productivity, and environmental footprint.

OUR SERVICES

- Custom Design & Fabrication
- Installation & Startup
- Preventative Maintenance Program
- Private Labels
- Testing Lab
- 24/7 Technical Support5656

INDUSTRIES WE SERVE

- Aerospace & Aviation
- Aluminium Smelters
- Automotive
- Construction & Civil Engineering
- Flexography (labelling) & Lithography
- Foundry & Forge
- General Manufacturing
- Military
- Power & Energy
- Rail & Mass Transit
- Shipyards
- Wood finishing