

SANDBLASTING CABINET - M PRESSURE SERIES

120 V / 208-230 V / 240 V / 460 V / 575 V



- Warranty
- Safety
- Operation

- Service Parts
- Accessory Information
- Registration Form



INSTRUCTION MANUAL

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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.

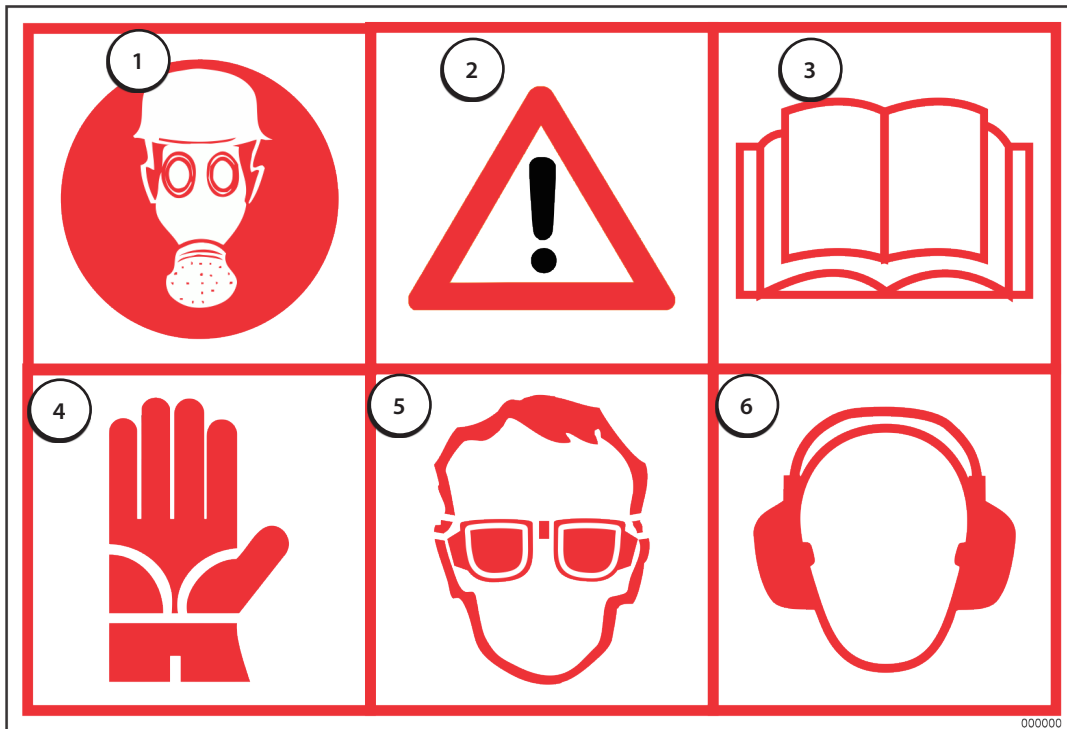
SAFETY AND WARNING

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 6,562 ft max
- Ambient temperature: 104 °F (40 °C) max
- Relative humidity: 80 %
- Main supply voltage fluctuation +/- 10 %
- To use with noncombustible 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 44.

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



Air dryer



½" min. diameter

ELECTRICAL CONNECTIONS

Connect cabinet power supply cord to standard 120 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 comply 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 45 to 53.

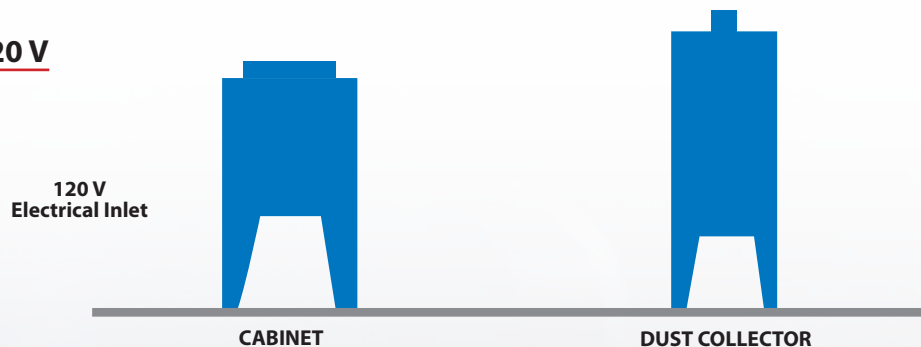


It is important to connect the IST system to an Earth Ground to bleed off static electricity, which may be generated while blasting. The Earth Ground may also reduce the discomfort an operator may experience when static electricity is discharged.

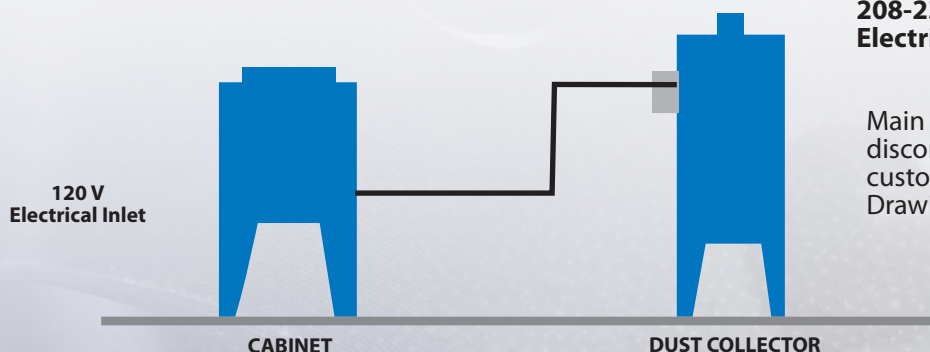
CONNECTIONS TO CABINET AND DUST COLLECTOR

| | Dust Collector Model | | | | |
|-------------------|----------------------|-------------|--|-------------|-------------|
| | DCM100 | DCM600 | DCM160/900 | DCM230/1200 | DCM330/1800 |
| Fan Motor (hp) | 1/2 | 1 | Available from 2 to 10 hp | | |
| Fan Motor (cfm) | 400 | 600 | 900 | 1200 | 1800 |
| Power Requirement | 120 V /15 A | 120 V /20 A | Available in 208-230V, 240 V, 460 V, and 575 V | | |

DCM Motor 120 V



DCM Motor 208-230 V, 240 V, 460 V, and 575 V



208-230 V, 240 V, 460 V and 575V Electrical Inlet

Main entry with fuse disconnect switch supplied by customer. Refer to Electrical Drawings on pages 45 to 53.

PROPER AIRJET/NOZZLE COMBINATIONS

AIR CONSUMPTION PRESSURE BLASTING SYSTEM

| Nozzle I.D. ⁴ | Units | WORKING PRESSURES (psi) ² | | | | | | | | | | | | |
|--------------------------|-------------------|--------------------------------------|------|------|------|------|------|------|------|------|------|------|------------------|------|
| | | 20 | 25 | 30 | 35 | 40 | 45 | 50 | 60 | 70 | 80 | 90 | 100 ⁰ | 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 |

⁰ Optimal pressure

¹ psi: Pressure at nozzle in pounds per square inch

² cfm: Compressed air required in cubic feet per minute

³ lb/h: Abrasive consumption in pounds per hour

⁴ Nozzle I.D.: nozzle interior diameter

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 PDS/CUFT | CONTENT SILICA | DUST FACTOR | MESH SIZE | REUSE FACTOR | AVAILABILITY |
|---------------------------|--------------|-----------|---------------------|------------------|----------------|-------------|-----------|--------------|--------------|
| Aluminium Oxide | Oxide | Irregular | 8 Mohs | 120 | None | Low | 6-600 | Good | Good |
| Silicon Carbide | Carbide | Angular | 9 Mohs | 100-110 | None | Low | 6-600 | Good | Good |
| Glass Beads | Silica | Spherical | 5-6 Mohs | 100 | 0 free Silica | Low | 20-325 | Good | Good |
| Plastic Grit | Polyurethane | Angular | 3-4 Mohs | 58-60 | None | Low | 12-80 | Good | Good |
| Chilled Iron & Steel Grit | Metallic | Angular | 40-68 Rc Rockwell C | 250 | None | Very Low | 18-200 | High | Good |
| Chilled Iron & Steel Shot | Metallic | Spherical | 40-68 Rc Rockwell C | 250 | 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

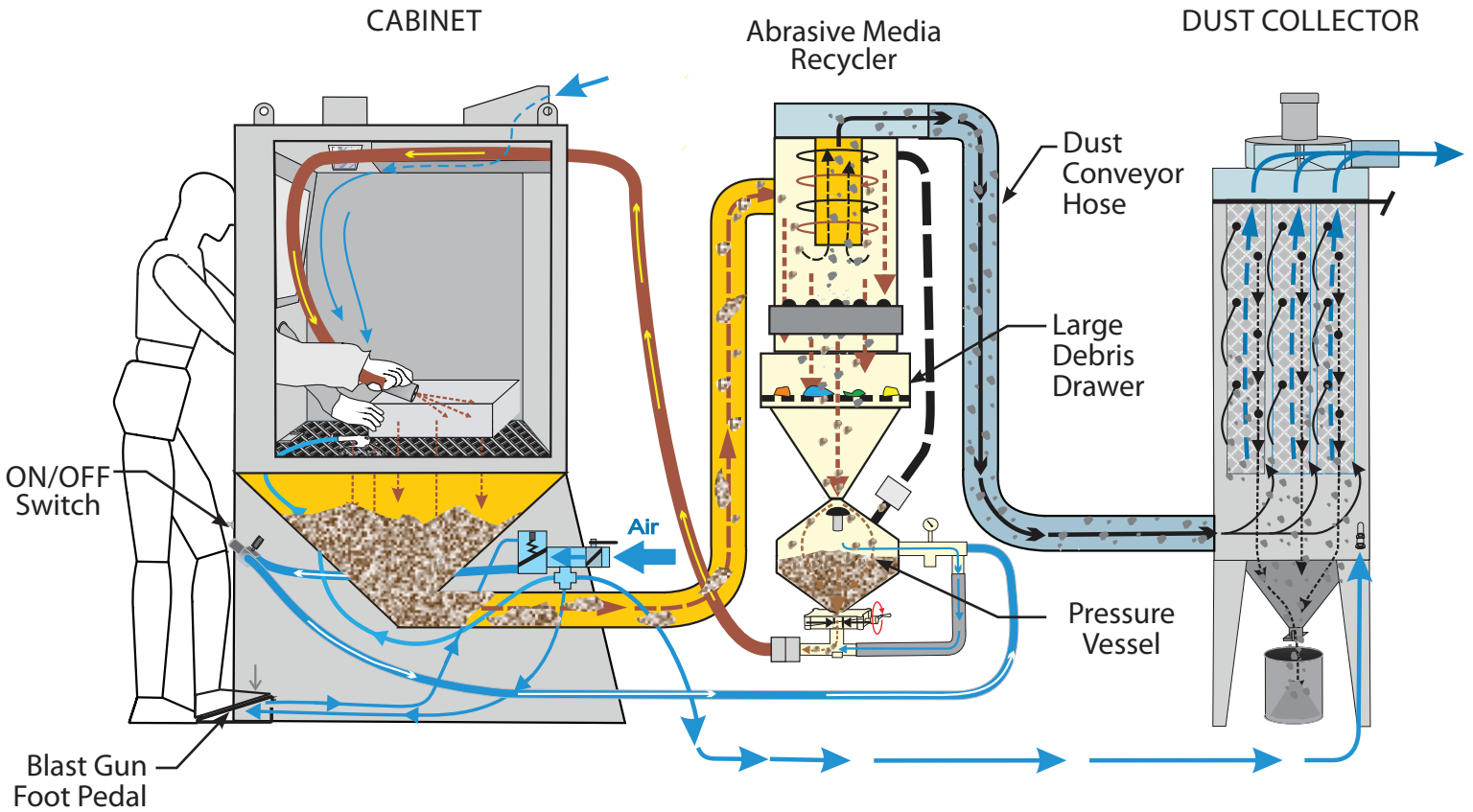
Turn on compressed air and turn on lightning and motor with the power switch. Compressed air must be clean, dry, and oil free.

1. When using the unit, air pressure (**should not exceed 110 psi**) 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.

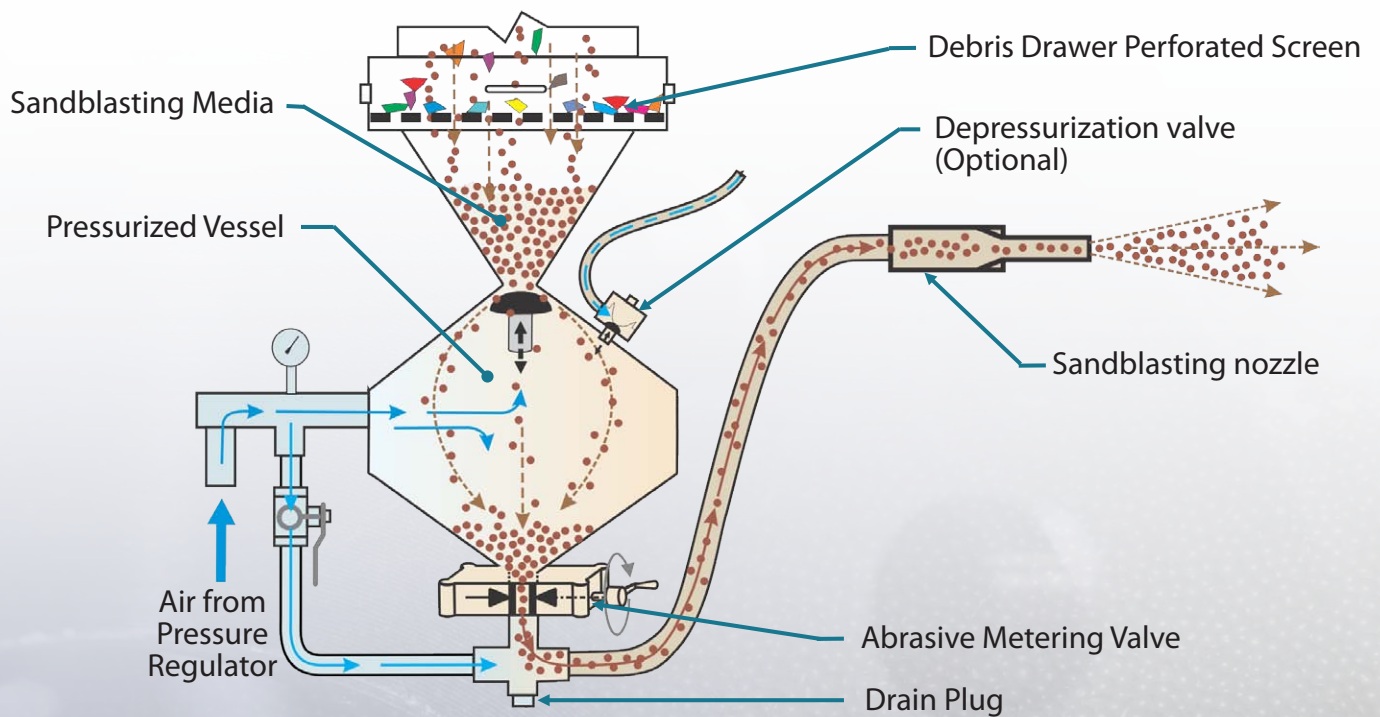


HOW IT WORKS

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 20 psi
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 20 psi.** 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

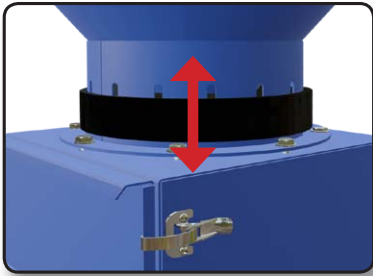
RELOADING WITH NEW ABRASIVE MEDIA

Refer to Abrasive Loading procedure on page 9.

RECLAIMER

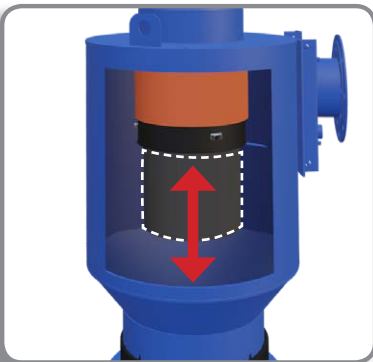
RECYCLER INFORMATION

Although the recycler is factory set, it is possible to increase the amount of fine dust to be sucked up by the dust collector. There are two methods to change those settings:



1. Adjustment of the SBR 1/8 " X 2 " rubber band

This adjustment will influence the quantity of dust that will be evacuated to the dust collector. Proceed step by step, moving down the rubber band 1/4" 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 recycler

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.**

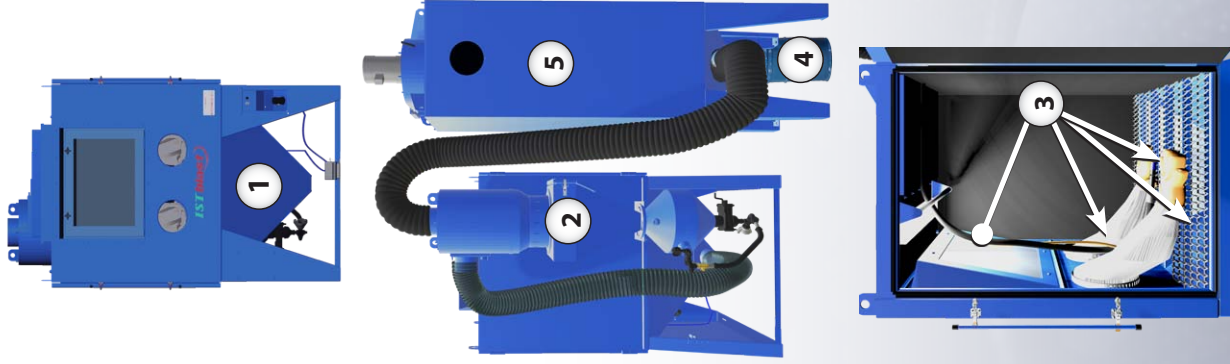
AR7 ABRASIVE REGULATOR



The AR7 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. Adjustment 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



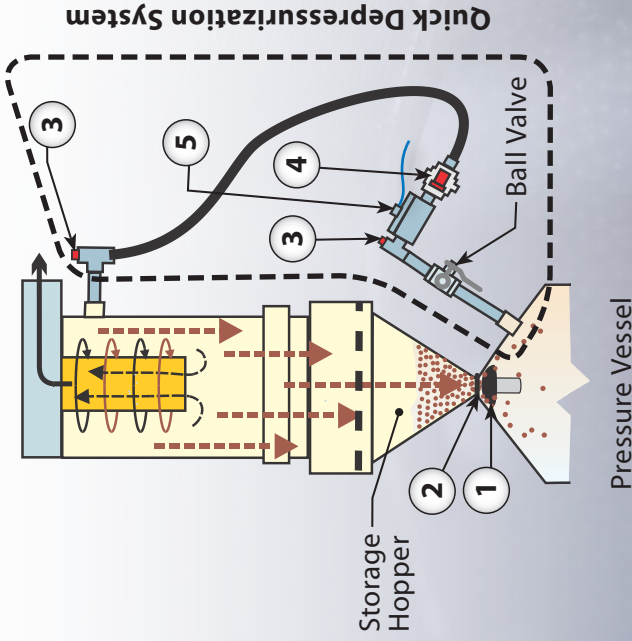
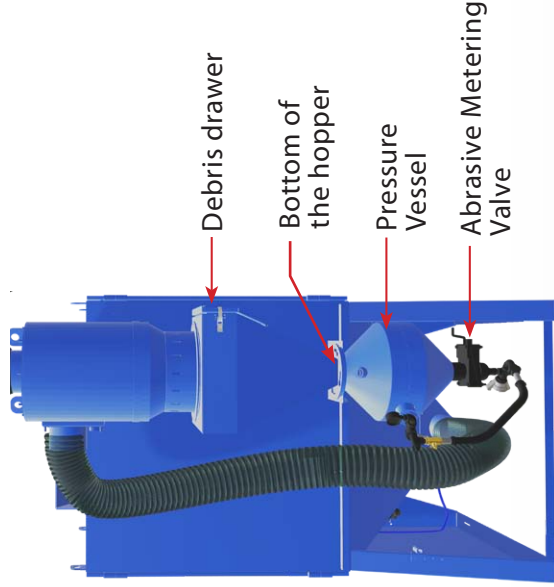
DAILY MAINTENANCE & OPERATION

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 reclaimers's screen drawer regularly.
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 1/8" 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.

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

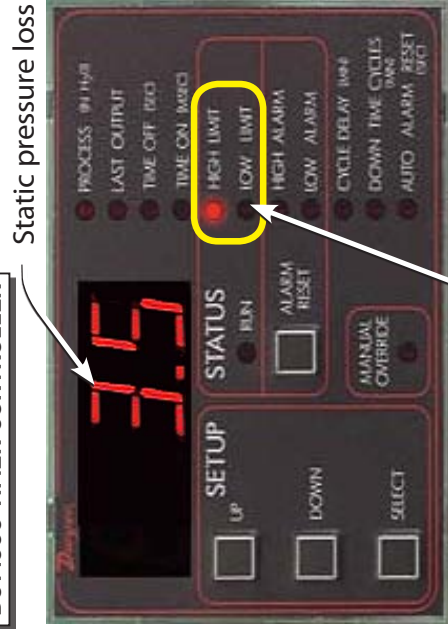
Dismantle the storage hopper above the pressurized vessel and check the wear condition of the sealing components inside the vessel:

| ID | Parts # | Description | Qty |
|----|---------|----------------------------------|-----|
| 1 | 610040 | PLUNGER | 1 |
| 2 | 618205 | PLUNGER O-RING | 1 |
| 3 | 630671 | 1" PA MNPT SACRIFICED 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

PERIODICAL ADJUSTMENTS OF THE DCT1000 TIMER CONTROLLER

DCT1000 TIMER CONTROLLER



Static pressure loss

High limit / Low limit

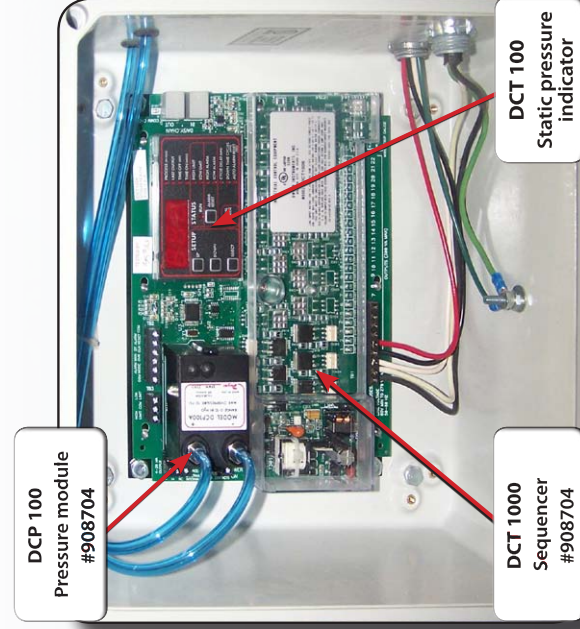
MONITORING OF PRESSURE DROPS

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.



DCP 100 Pressure module #908704

DCT 100 Static pressure indicator

DCT 1000 Sequencer #908704

CARTRIDGE CLEANING

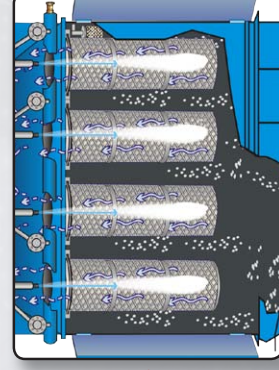
When the process value reaches the **High Limit**, the cleaning cycle starts emitting a series of pulses of air through each cartridge in order to dislodge exceeding amount of dust buildups. Pulses of air can be heard when the cycle is on.

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

High Limit

REVERSE PULSE CLEANING

Low Limit



DCT1000 TIMER CONTROLLER (CONT'D)

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.

DCT1000 TIMER CONTROLLER (END)

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).

BLAST NOZZLE INSPECTION - MAINTENANCE SCHEDULE

Nozzle: check the nozzle regularly for wear using a drill bit **1/8" larger than the original nozzle diameter**

IT GOES THROUGH



WORN NOZZLE TO BE REPLACED

DOES NOT GOES THROUGH



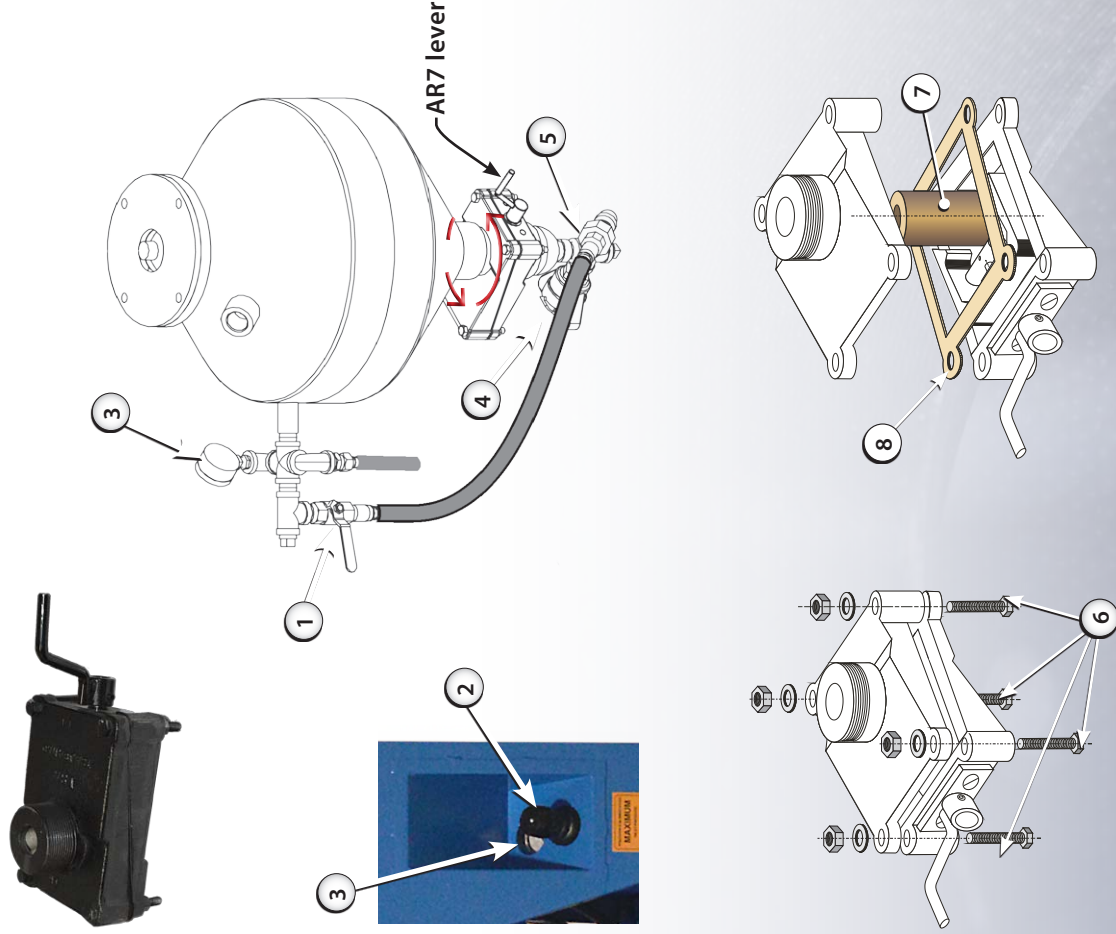
NOZZLE IN GOOD SHAPE

The inside diameter should never exceed 1/8" of wear

RUBBER WASHER

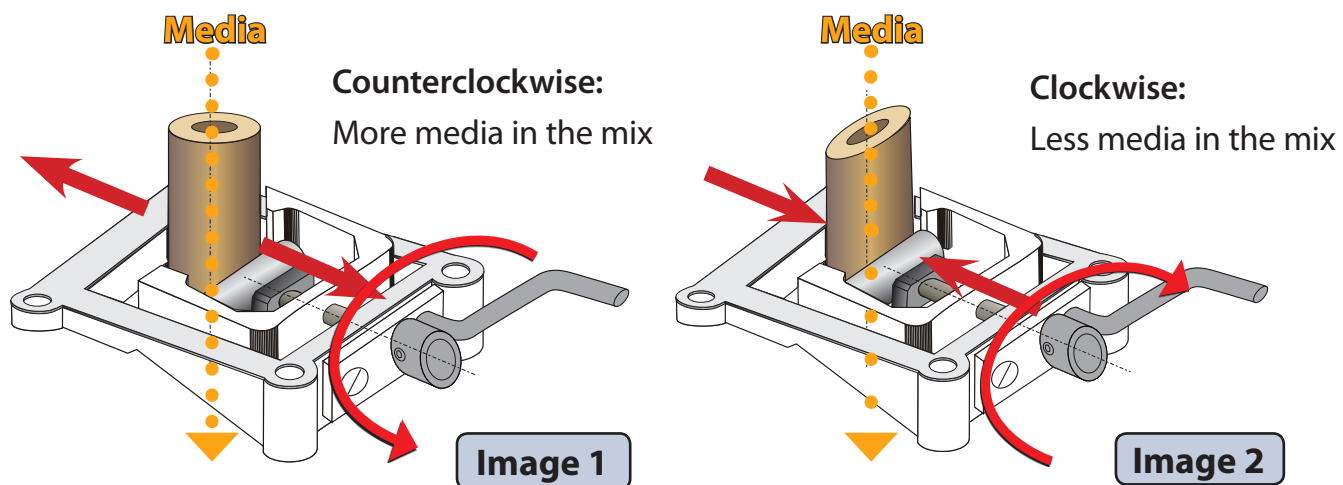


AR7 ASSEMBLY - DISASSEMBLY INSTRUCTIONS



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 AR7 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 AR7 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 AR7 check the gasket (8) and replace it if necessary.
8. Replace the AR7 kit and restore the pressure to initial value if required.
Must be at 70 psi max.

AR7 ABRASIVE METERING VALVE ADJUSTMENT



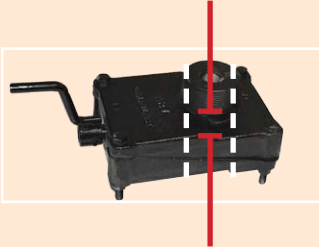
Follow the procedure below to adjust your abrasive media valve for the first time or when you change blast nozzle or blast media.

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 seconds 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.

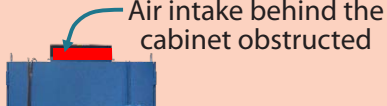
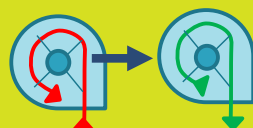
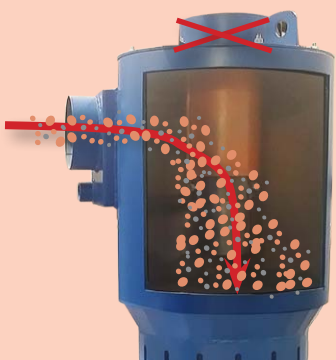
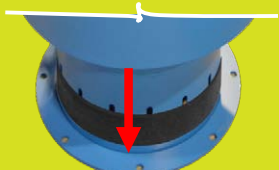
- ✓ Ideal flow: The flow is constant, even, stable, white color and you can see through.
- ✓ Too much media in the flow: The flow is unstable, pulsating or jerky. Close the valve (Image 2), half turn at the time and check again.
- ✓ Not enough media in the flow: The flow is transparent and not powerful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

AR7 ABRASIVE METERING VALVE - TROUBLESHOOTING

| TYPE OF FAILURE | POSSIBLE CAUSE | SOLUTION |
|---|---|---|
| ABRASIVE NOT FLOWING DURING BLASTING (AIR ONLY) | The Pressure vessel is empty. | Depressurize the pressure vessel, add media and check again. |
| | The «Blast On / Air Only Switch» (if equipped) is set to «Air Only» mode and is preventing the abrasive from flowing. | Turn the switch to «Blast On» allowing the media regulator to release media in the push line. |
| | The Abrasive Regulator is closed or not properly adjusted. | Turn the adjustment crank counterclockwise, half turn at the time, to allow more media in the mix. |
| |  <p>There is a blockage in the Abrasive Regulator.</p> | <p>Have a second qualified person to assist. Activate the control handle and ask a qualified person to alternate open/close the «choke valve» for 3-5 times until the obstruction is released. Minor obstructions, such as paint chips, a bit of wet abrasive or a piece of paper, will be forced through the Regulator and out the nozzle. Turn the Regulator back to the required blast setting and check if the obstruction has been removed.</p> <p>If the blockage persists, release the remote-control handle, depressurize the vessel and proceed to disassembling the Regulator and removing the blockage manually.</p> |
| | The pressurized vessel has an air leak and the pressure inside the vessel is less than the one on the push line. | Check for air leaks (plunger seal, maintenance door, and/or quick-depress valve) and service your blast pot. |
| | The abrasive media is contaminated with humidity, which prevent it from flowing through the Regulator. | Empty your pressurized vessel from media, clean the reservoir through the maintenance door, and replace with new media. Consider servicing and/or adding air dryer and/or dessicant filter on your airline. |
| ABRASIVE STREAM TOO HEAVY OR THROBBING DURING BLASTING | Note : When Auto-depress systems first start up, they may throb for a while if there is an accumulation of abrasive in the blast hose from a previous operation. This is normal, and no corrective action is needed. | |
| | The Choke Valve is partially closed. The Abrasive Blaster should be operated ONLY with the Choke Valve fully open. | Open the Choke Valve and check again. |
| | The Abrasive Regulator needs adjusting. | Turn the adjustment crank clockwise to restrict media in the mix. If your unit is equipped with a Actuator that closes the Regulator when the unit is not blasting, be sure to adjust the Regulator only while blasting. |
| | The rubber tube inside the regulator is worn or ultimately pierced. | Disassemble the Regulator, clean any accumulation of media in it and change the rubber tube. If the rubber tube as a perforation, the media can flow freely in the Regulator and therefore can create wear on all the other inner mechanical parts. Proceed to a complete inspection of the push line before using the unit again. |

***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.**

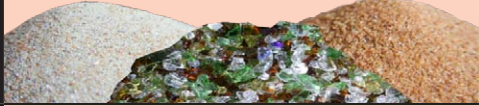
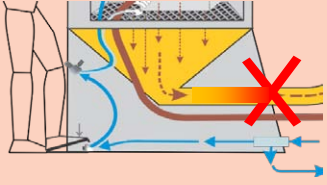
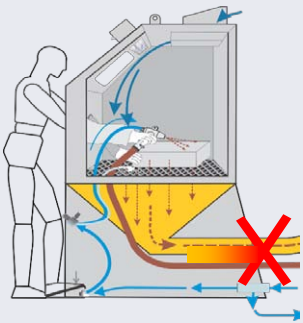

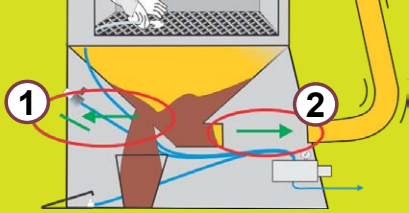
TROUBLESHOOTING

| TYPE OF FAILURE | POSSIBLE CAUSE | SOLUTION |
|--|--|--|
| <p>Excessive dust in the cabinet (poor visibility) and/or very dusty abrasive (inefficient)</p> |  <p>Air intake behind the cabinet obstructed</p> | <p>Check the trap above the cabinet to make sure it is open and clear</p> |
| | <p><u>Clogged filter media:</u></p> <ol style="list-style-type: none"> Dust barrel filled Bags shaken during cabinet operating¹ | <ol style="list-style-type: none"> Empty the dust barrel as well as the connection hose connecting the barrel and the cyclone separator Replace clogged bags² |
| | <p>Dust collector fan motor connected upside down (blades turn upside down)</p> | <p>Reverse motor electric connection</p>  |
| | <p>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)</p>  | <ol style="list-style-type: none"> If the material has changed since the cabinet was manufactured, contact an IST representative 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  |

¹Never 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.


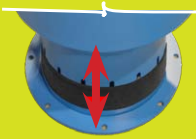

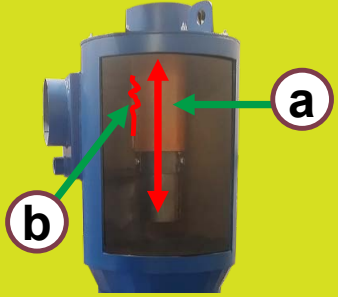
²Do not wash bags with water or by blowing compressed air through them. Both of these methods will damage the bags and make them obsolete.

TROUBLESHOOTING (CONT'D)

| TYPE OF FAILURE | POSSIBLE CAUSE | SOLUTION |
|--|---|--|
| <p>Excessive dust in the cabinet (poor visibility) and / or very dusty abrasive (inefficient)</p> | <p>Non-recyclable abrasive³</p>  | <p>Follow abrasive drain and cleaning procedures and replace with recyclable abrasive.</p> |
| | <p>Suction hose (behind the cabinet) is partially or completely blocked</p>  | <p>Follow the procedures for resolving a clogged suction hose.</p> |
| <p>Suction hose outlet (behind the cabinet) partially or completely blocked</p>  | <p><u>Incorrect filling procedure:</u> too much abrasive or poured too quickly.</p>  | <p>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.</p>  |
| | <p>Lack of cfm (problem with the dust collector) which causes the outlet to become progressively blocked.</p> | <p>Follow the procedures for resolving a dusty cabinet as described above.</p> |


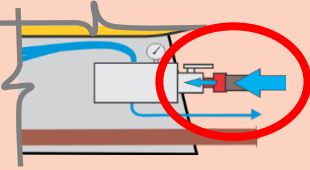
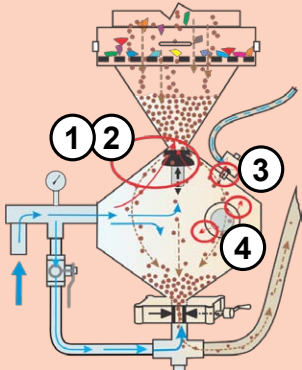
³ Never use non-recyclable abrasive in IST cabinets, such as slag, silica sand, recycled glass, or other like them. IST cabinets are designed to be used exclusively with recyclable abrasive that generates a limited amount of dust. Ask your IST representative for more information.

TROUBLESHOOTING (CONT'D)

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

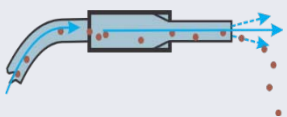
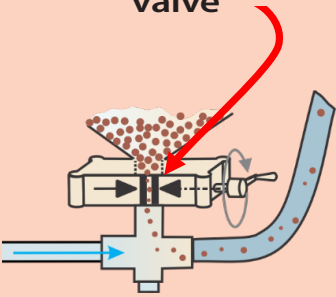
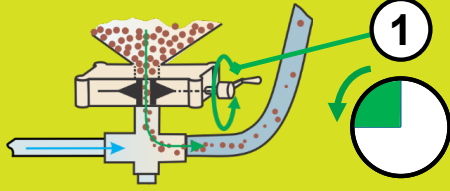
⁴The center tube of the cyclonic separator is factory adjusted for the abrasive specified at the time of purchase. If the abrasive changes during operation, it may be necessary to readjust the inner tube to alter the movement and flow of air within the cyclonic separator.

TROUBLESHOOTING (END)

| TYPE OF FAILURE | POSSIBLE CAUSE | SOLUTION | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|---|------|------|--------------------------------------|------|------|------|------|------|------|------|------------------|------|--|--|--|--|--------------------------|-------|----|----|----|----|----|----|----|----|----|----|----|------------------|-----|------|------------------|---|---|---|---|----|----|----|----|----|----|----|----|----|-------------------|----|----|----|----|----|----|----|----|-----|-----|-----|-----|-----|-------|------------------|----|----|----|----|----|----|----|----|----|----|----|----|----|-------------------|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|------|------------------|----|----|----|----|----|----|----|----|----|----|----|----|----|-------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-------|------------------|----|----|----|----|----|----|----|----|-----|-----|-----|-----|-----|-------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|------|------|------------------|----|----|----|----|----|-----|-----|-----|-----|-----|-----|-----|-----|-------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|------|------|------|------|-------|------------------|----|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-------------------|-----|-----|-----|-----|-----|-----|-----|------|------|------|------|------|------|------|------------------|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-------------------|-----|-----|-----|-----|------|------|------|------|------|------|------|------|------|------|------------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| <p>Lack of abrasive in the mix (the nozzle blows mainly air)</p>  | <p>Air supply problem (using a quick connect or a connection that creates a restriction to the cabinet air supply)</p>  | <p>Follow cabinet air connection guidelines (see chart page 8)</p> <table border="1" data-bbox="906 525 1458 808"> <thead> <tr> <th colspan="2"></th> <th colspan="14">WORKING PRESSURES (psi)²</th> </tr> <tr> <th>Nozzle I.D.²</th> <th>Units</th> <th>20</th><th>25</th><th>30</th><th>35</th><th>40</th><th>45</th><th>50</th><th>60</th><th>70</th><th>80</th><th>90</th><th>100²</th><th>120</th> </tr> </thead> <tbody> <tr> <td rowspan="2">1/8"</td> <td>cfm¹</td> <td>7</td><td>7</td><td>8</td><td>9</td><td>10</td><td>12</td><td>13</td><td>14</td><td>15</td><td>17</td><td>19</td><td>20</td><td>25</td> </tr> <tr> <td>lb/h²</td> <td>48</td><td>48</td><td>55</td><td>62</td><td>69</td><td>73</td><td>77</td><td>82</td><td>110</td><td>127</td><td>140</td><td>154</td><td>192</td> </tr> <tr> <td 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<td>254</td><td>278</td><td>320</td><td>345</td><td>394</td><td>425</td><td>462</td><td>528</td><td>680</td><td>756</td><td>832</td><td>910</td><td>1010</td> </tr> <tr> <td rowspan="2">3/8"</td> <td>cfm¹</td> <td>55</td><td>63</td><td>76</td><td>82</td><td>91</td><td>100</td><td>109</td><td>126</td><td>143</td><td>161</td><td>173</td><td>196</td><td>220</td> </tr> <tr> <td>lb/h²</td> <td>374</td><td>428</td><td>517</td><td>558</td><td>620</td><td>682</td><td>744</td><td>860</td><td>970</td><td>1080</td><td>1184</td><td>1296</td><td>1454</td> </tr> <tr> <td rowspan="2">7/16"</td> <td>cfm¹</td> <td>72</td><td>85</td><td>100</td><td>112</td><td>124</td><td>137</td><td>149</td><td>170</td><td>194</td><td>217</td><td>240</td><td>254</td><td>300</td> </tr> <tr> <td>lb/h²</td> <td>488</td><td>576</td><td>678</td><td>759</td><td>835</td><td>840</td><td>908</td><td>1160</td><td>1320</td><td>1476</td><td>1630</td><td>1782</td><td>2104</td> </tr> <tr> <td rowspan="2">1/2"</td> <td>cfm¹</td> <td>96</td><td>112</td><td>129</td><td>146</td><td>165</td><td>179</td><td>195</td><td>224</td><td>252</td><td>280</td><td>309</td><td>338</td><td>392</td> </tr> <tr> <td>lb/h²</td> <td>629</td><td>734</td><td>845</td><td>976</td><td>1103</td><td>1197</td><td>1305</td><td>1500</td><td>1700</td><td>1890</td><td>2088</td><td>2277</td><td>2640</td> </tr> <tr> <td rowspan="2">5/8"</td> <td>cfm¹</td> <td>173</td><td>195</td><td>212</td><td>239</td><td>260</td><td>282</td><td>308</td><td>356</td><td>404</td><td>452</td><td>504</td><td>548</td><td>611</td> </tr> <tr> <td>lb/h²</td> <td>1081</td><td>1219</td><td>1325</td><td>1470</td><td>1600</td><td>1716</td><td>1875</td><td>2140</td><td>2422</td><td>2690</td><td>2973</td><td>3250</td><td>3623</td> </tr> </tbody> </table> <p>And use only straight couplings as indicated in the manual</p> | | | WORKING PRESSURES (psi) ² | | | | | | | | | | | | | | Nozzle I.D. ² | Units | 20 | 25 | 30 | 35 | 40 | 45 | 50 | 60 | 70 | 80 | 90 | 100 ² | 120 | 1/8" | cfm ¹ | 7 | 7 | 8 | 9 | 10 | 12 | 13 | 14 | 15 | 17 | 19 | 20 | 25 | lb/h ² | 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 ² | 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 ² | 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 ² | 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 ² | 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 ² | 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 ² | 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 ² | 1081 | 1219 | 1325 | 1470 | 1600 | 1716 | 1875 | 2140 | 2422 | 2690 | 2973 | 3250 | 3623 |
| | | WORKING PRESSURES (psi) ² | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Nozzle I.D. ² | Units | 20 | 25 | 30 | 35 | 40 | 45 | 50 | 60 | 70 | 80 | 90 | 100 ² | 120 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1/8" | cfm ¹ | 7 | 7 | 8 | 9 | 10 | 12 | 13 | 14 | 15 | 17 | 19 | 20 | 25 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | lb/h ² | 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 ² | 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 ² | 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 ² | 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 ² | 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 ² | 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 ² | 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 ² | 1081 | 1219 | 1325 | 1470 | 1600 | 1716 | 1875 | 2140 | 2422 | 2690 | 2973 | 3250 | 3623 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | <p>Underpressure² phenomenon (the vessel pressure is lower than the thrust line pressure)</p>  | <p>Identify the air leak that is escaping from the vessel and preventing it from building its pressure properly</p> <ol style="list-style-type: none"> 1. Plunger 2. Plunger O-Ring 3. Self-depressurization system (if equipped) 4. Access door (if equipped) <p>1st Step - Bubbling method</p> <ul style="list-style-type: none"> • Plunger and/or Plunger O-Ring • Access door <p>2nd Step - Push line cut-off</p> <ul style="list-style-type: none"> • Self-depressurization system | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

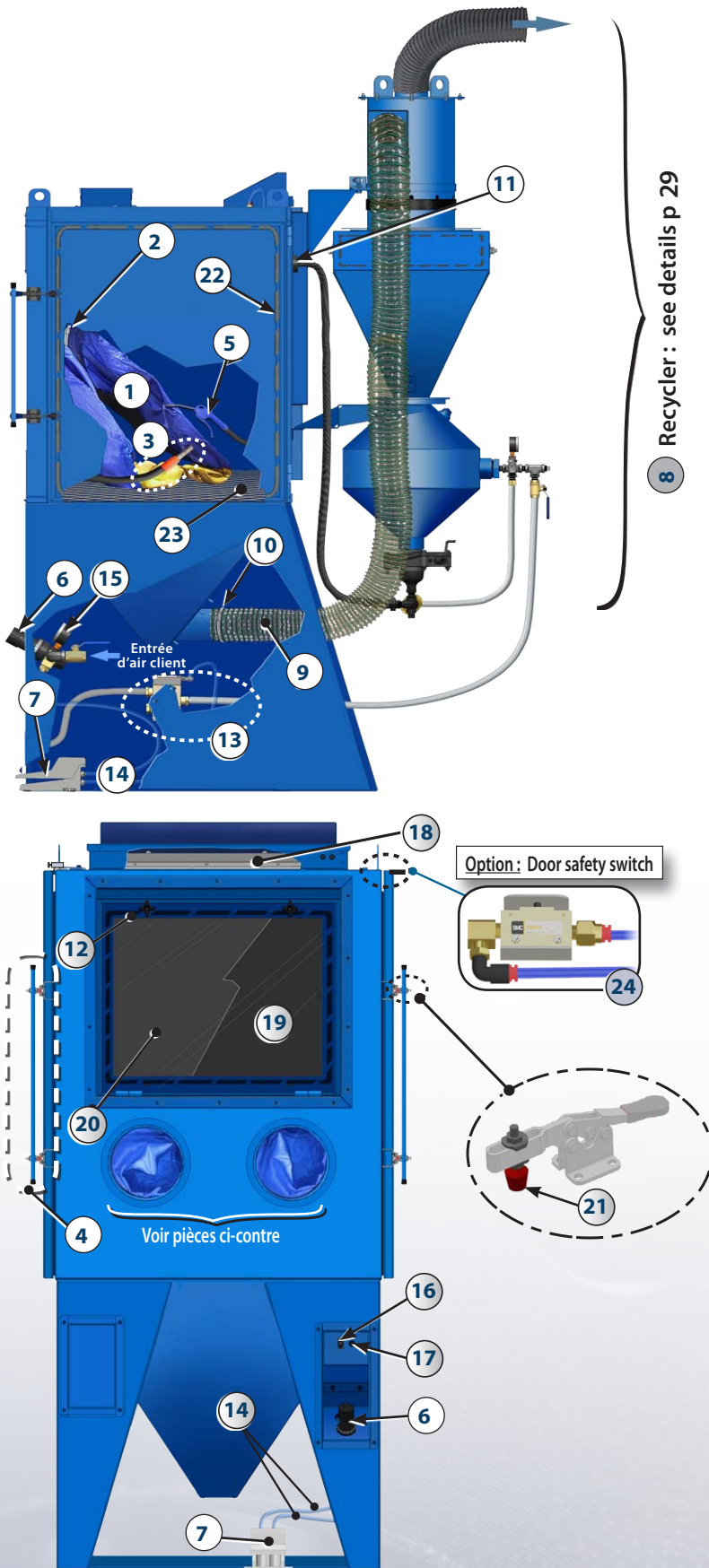
²The underpressure phenomenon exerts a negative pressure upstream of the abrasive flow at the outlet of the pressure vessel. This prevents the abrasive from flowing freely by gravity into the push line.

TROUBLESHOOTING (END)

| TYPE OF FAILURE | POSSIBLE CAUSE | SOLUTION |
|--|---|---|
| <p>Lack of abrasive in the mix (the nozzle blows mainly air)</p>  | <p>Wrong adjustment of the AR7 abrasive valve</p>  | <ol style="list-style-type: none"> 1. Open the rubber tube opening slightly by turning the crank handle counterclockwise ¼" turn at a time 2. Advance the sanding for approximately 20 seconds and note the difference. 3. Repeat steps 1 and 2 as needed  |

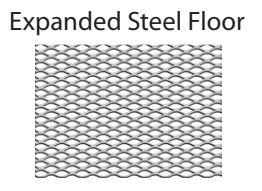
¹ Perform ¼" of a turn at a time and observe the difference. It takes about 30 seconds for the system to renew the air/media mix in the line.

SCHEMATIC OF UNIT - EXPLODED VIEW & PARTS



8 Recycler : see details p 29

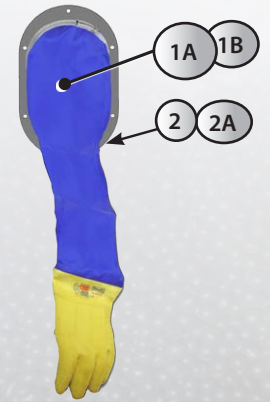
| | | |
|-----|--------|--|
| 1 | 603212 | Gloves with nylon sleeves e3 8" i.d. x 30" length |
| | 603205 | gloves with leather sleeves e3 8" i.d. x 30" length |
| 1A | 603217 | wide opening gloves nylon sleeves w1 10" i.d. x 30" length |
| 1B | 603218 | wide opening gloves leather sleeves w1 10" i.d. x 30" length |
| 2 | 624128 | 8" ø glove "t" clamp (standard) |
| 2A | 624137 | 10" ø glove "t" clamp (optional) 30, 31 |
| 3 | | hose, couplings and nozzles (see page 13) |
| 4 | 610288 | standard door handle |
| 5 | 610275 | dust blow-off gun |
| 6 | 608022 | 1/2" pressure regulator 41) |
| 7 | | complete foot pedal-press. (see page) |
| 8 | | complete recycler (see page 16) |
| 9 | 606120 | reclaimer hose 5" - 600 cfm |
| | 606123 | reclaimer hose 6 1/8" - 900 to 1800 cfm |
| 10 | 624121 | 5" clamp |
| | 624124 | 6" clamp |
| 11 | 618131 | rubber grommet for abrasive hose 1/2" |
| 12 | 940025 | Star knob |
| 13 | 666214 | pressure manifold (see page 32) |
| 14 | 324571 | 1/4" Poly. blue tubing air hose (sold by foot) |
| 15 | 611022 | 1/4" 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 | 23 3/4" x 18 3/4" 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 3/4" x 18 3/4" 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" |
| | 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 |



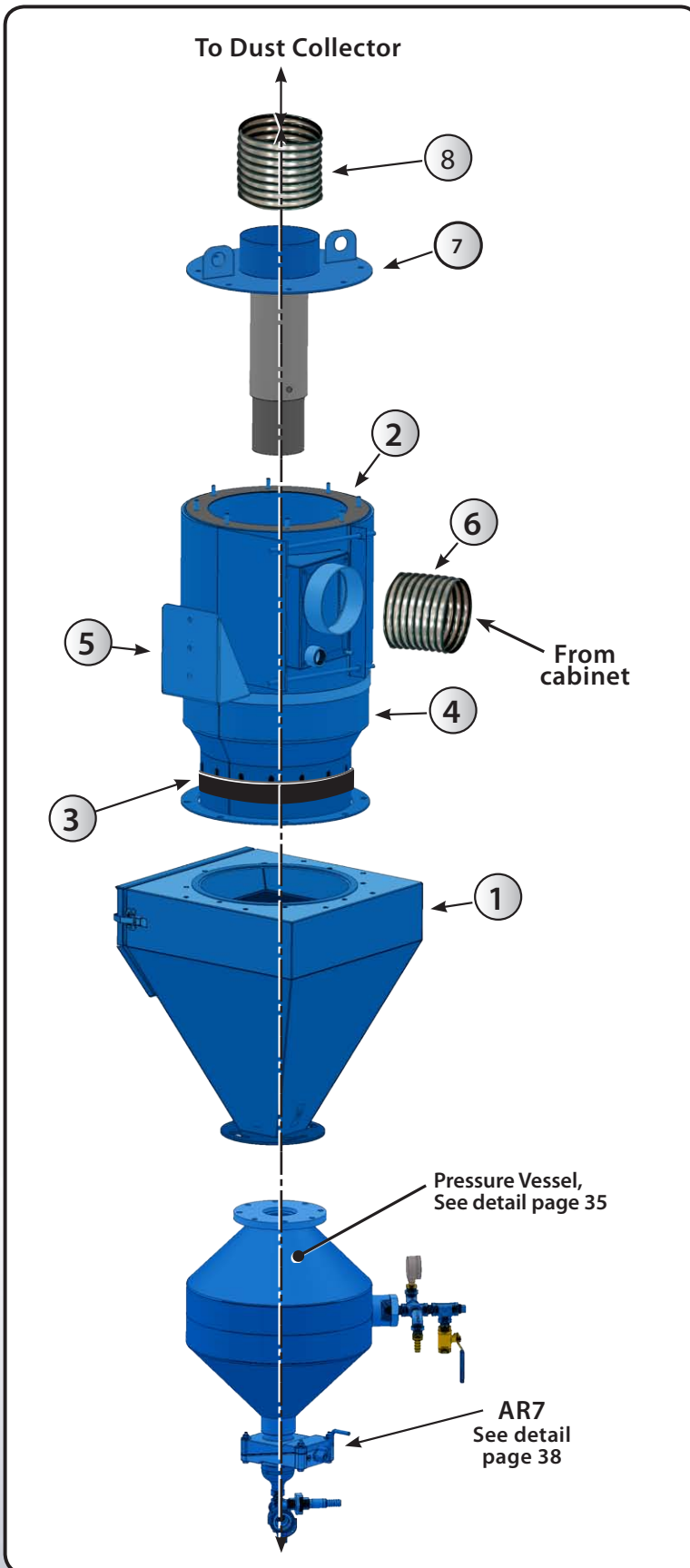
Standard :
Round opening gloves



Optionnal :
Wide opening gloves



RECYCLING SYSTEM - EXPLODED VIEW & PARTS LIST



| 10" RECYCLING SYSTEM | | |
|----------------------|----------|-------------------------|
| NB | PART NB | DESCRIPTION |
| 1 | 609256 | 10" HOPPER |
| 2 | 618318 | SELF-ADHESIVE RUBBER |
| 3 | 618334 | RUBBER BAND |
| 4 | 609225 | RECYCLER BODY |
| 5 | 609313 | RECYCLER BODY BRACKET |
| 6 | 606161 | ABRASIVE HOSE CONVEYOR |
| 7 | 609216 | 10" VERTICAL OUTLET BOX |
| 8 | See p.34 | ABRASIVE DUST CONVEYOR |

SANDBLASTING CABINETS - HOSES, COUPLINGS & NOZZLES

HOSE, COUPLINGS & NOZZLES

| | | | |
|---|---|---|----------------------------|
| <p>SANDBLAST HOSE</p> <p>CONICAL NOZZLE</p> <p>STRAIGHT NOZZLE</p> <p>DOUBLE VENTURI NOZZLE</p> | 1 | 607012 | 1/2" CQ Coupling |
| | 2 | 607020 | 1/2" SBH SANDBLAST HOSE |
| | 3 | 607059 | NC3-N3 1/2" x 1" NPT |
| | 4 | CONICAL NOZZLE | |
| | 5 | 607040 | NA-1" Adaptor 1" NPT |
| | 6 | 607057 | NH-1/2" Adaptor 3/4" NPS |
| | 7 | 607056 | NH-1/2" Adaptor 1 1/4" NPS |
| | 8 | STRAIGHT THREADED NOZZLE 3/4" NPS | |
| | 9 | DOUBLE VENTURI NOZZLE 1 1/4" NPS or 50mm | |

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

| | PART NB. | MODEL | INSIDE DIAMETER | OUTSIDE DIAMETER |
|----------|----------|---------|-----------------|------------------|
| <p>2</p> | 606020 | SBH-1/2 | 1/2" | 1 3/16" |

HOSES FITTINGS



| | PART NB. | MODEL | INSIDE DIAMETER | OUTSIDE DIAMETER |
|---------------------------|----------|--------|-----------------|------------------|
| <p>1</p> <p>(CHICAGO)</p> | 607002 | QC-1/2 | 1/2" | 1 3/16" |

THREADED NOZZLE FITTINGS



| | MODEL | HOSE I.D. | THREAD | | |
|-------------------|--------|-----------|----------|------------|----------|
| | | | 3/4" NPS | 1 1/4" NPS | 50 mm |
| <p>6</p> <p>*</p> | NH-1/2 | 1/2" | 607057 | 607056 | * 407022 |

SANDBLASTING CABINETS - HOSES, COUPLINGS & NOZZLES (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 1/16" | 50 mm |
| | | 405464 | # 4 | 1/4" Ø | 5 5/16" | |
| | | 405465 | # 5 | 5/16" Ø | 6 1/16" | |
| | | 405466 | # 6 | 3/8" Ø | 6 1/8" | |
| | | 405467 | # 7 | 7/16" Ø | 8 15/32" | |
| | | 405468 | # 8 | 1/2" Ø | 9 1/16" | |

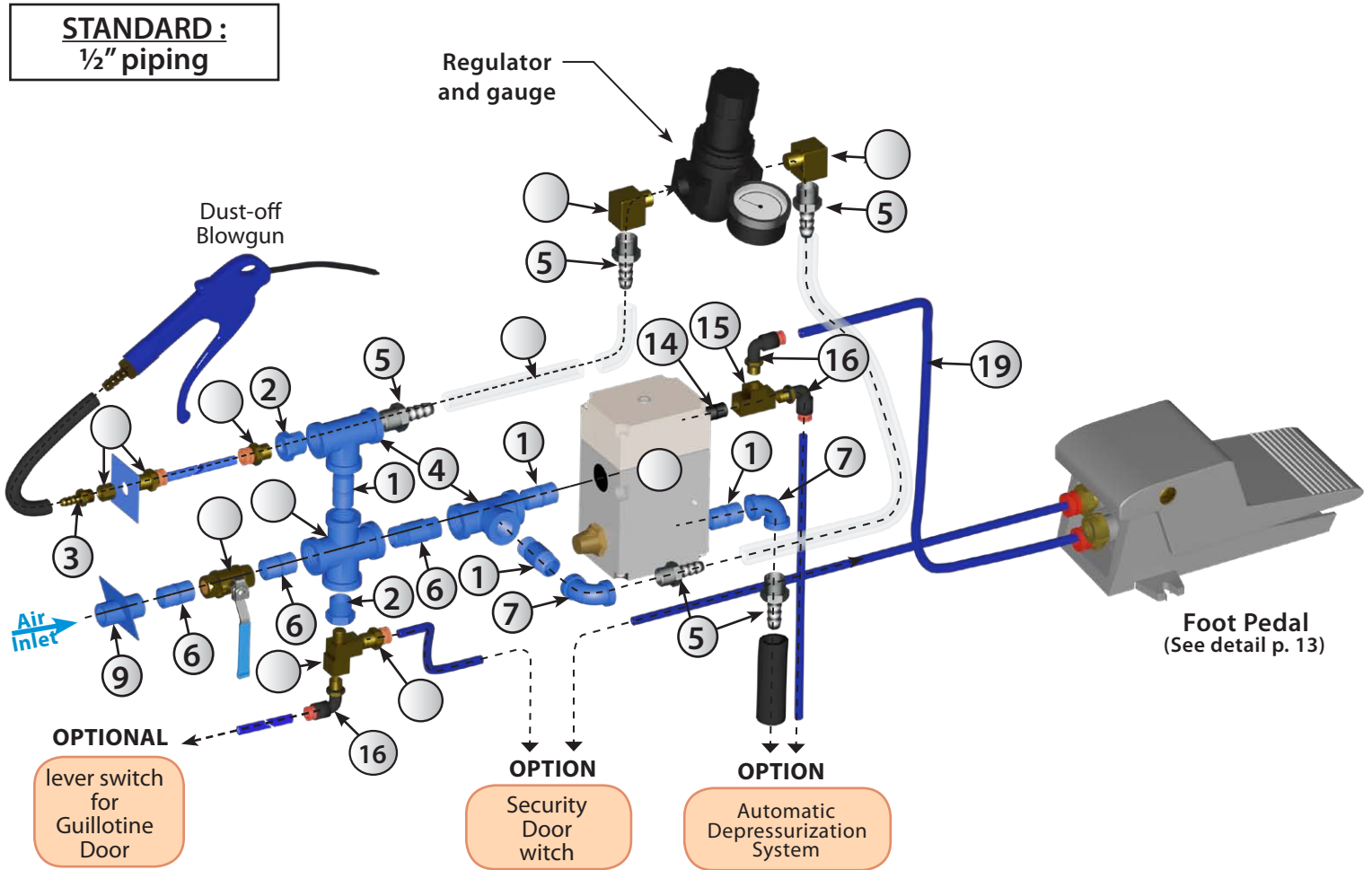
TUNGSTEN CARBIDE

| | | | | | | |
|------|---|----------------------|-------|---------|--------|---|
| DCV- |  | Part Nb | Model | Orifice | Lenght | Threaded nozzle 1 1/4" N.P.S., 1" Ø entry venturi orifice, use with NCV, all NH- except NH - 1/2" |
| | | 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" | |
| BCV- |  | BORON CARBIDE | | | | Threaded nozzle 1 1/4" N.P.S., 1" Ø entry venturi orifice, use with NCV, all NH- except NH - 1/2" |
| | | 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" | |

TUNGSTEN CARBIDE

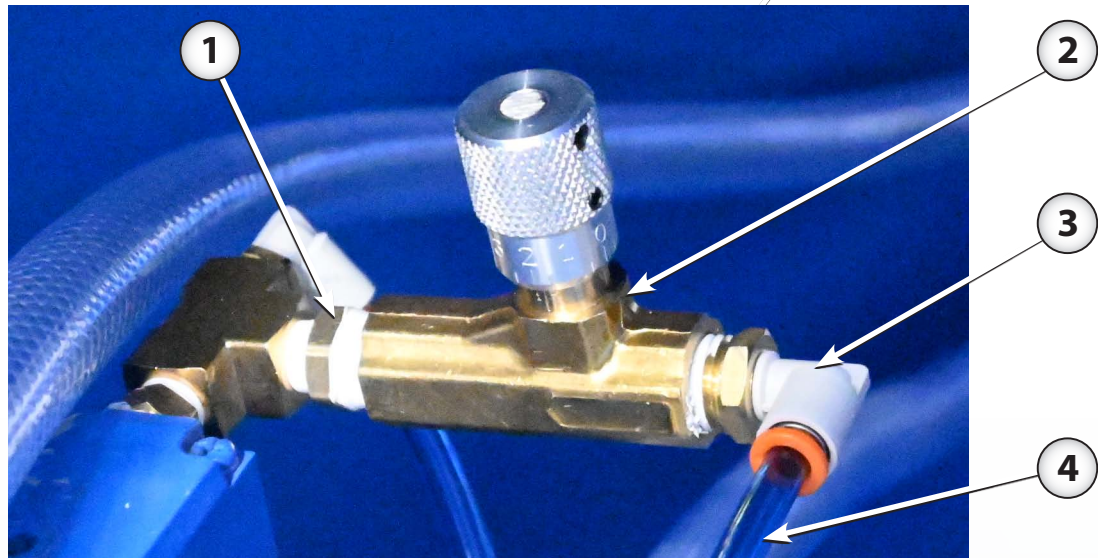
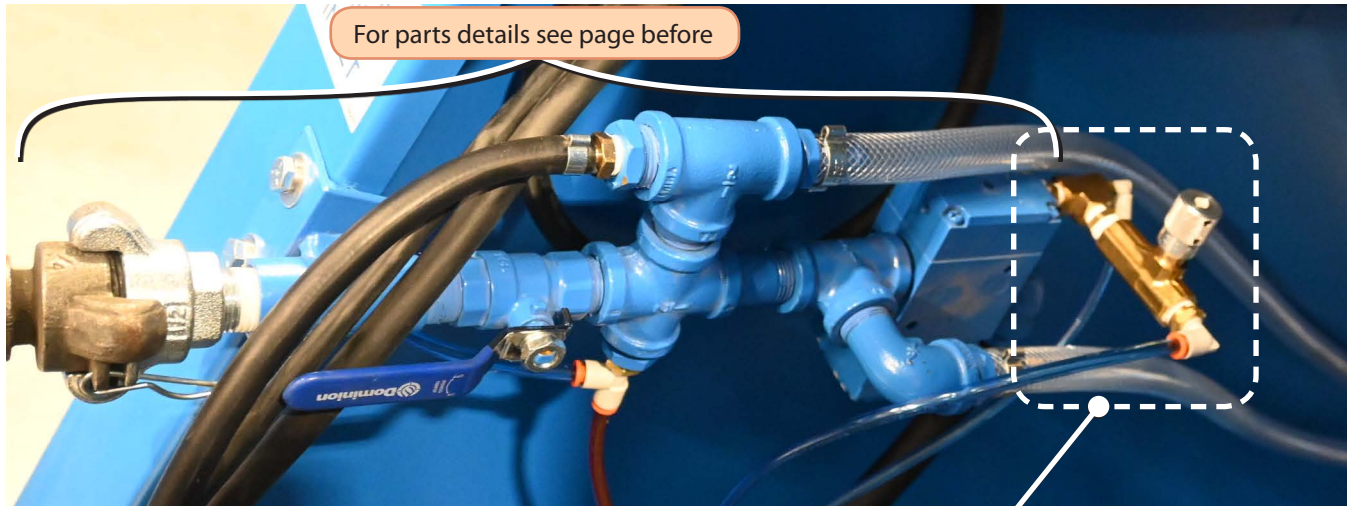
| | | | | | | |
|------|---|---------|-------|---------|--------|--|
| DC3- |  | Part Nb | Model | Orifice | Lenght | Threaded nozzle 1 1/4" - 14 N.P.S., straight orifice, use with NCV, all NH- except NH - 1/2" |
| | | 605313 | DC3-3 | 3/16" Ø | 3" | |
| | | 605314 | DC3-4 | 1/4" Ø | 3" | |
| | | 605315 | DC3-5 | 5/16" Ø | 3" | |
| | | 605316 | DC3-6 | 3/8" Ø | 3" | |

AIR PRESSURE MANIFOLD - STANDARD 1/2" PIPING



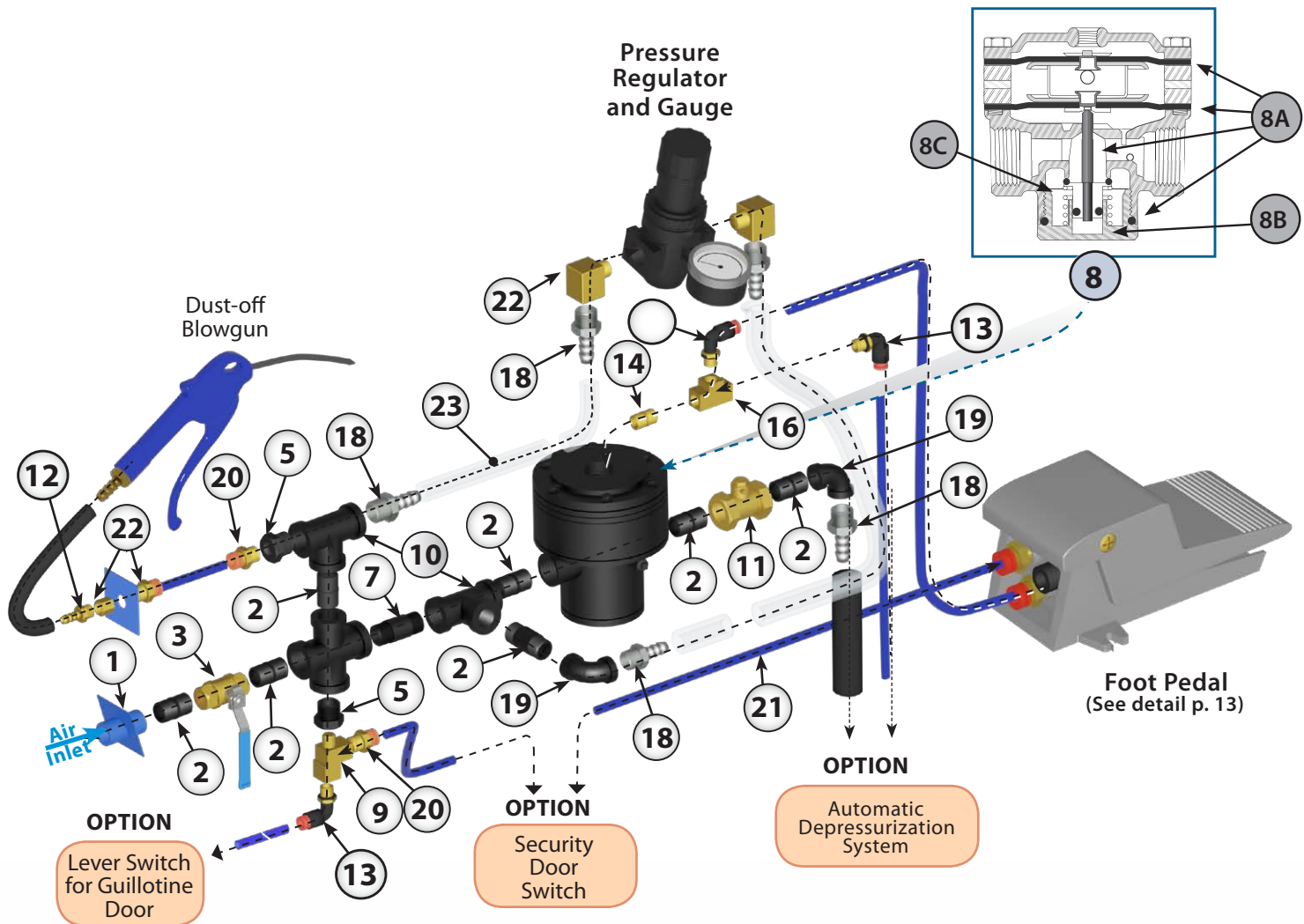
| # | Part # | DESCRIPTION | # | Part # | DESCRIPTION |
|----|--------|---------------------------------------|----|--------|--|
| 1 | 630301 | 1/2" MPT Nipple | 11 | 324503 | 1/4" MTP x 1/4" TU Bulkhead Push-in |
| 2 | 632745 | 1/2" MPT x 1/4" FPT Reducer | 12 | 608519 | 1/2" Pilot Valve (see details p. 13) |
| 3 | 632270 | 1/4" FPT x 1/4" Hose Fitting | 13 | 608287 | 1/2" MPT Muffler |
| 4 | 630328 | MF 1/2" FPT "T" | 14 | 632002 | 1/8" Hex. Nipple |
| 5 | 632760 | 1/2" MPT x 1/2" Hose Fitting | 15 | 632018 | 1/8" PL T-Street |
| 5A | 632730 | 1/2" PL MF Elbow Fitting | 16 | 324561 | 1/8" NPT 1/4" TU @ 90° Push-in Fitting |
| 6 | 932108 | 1/2" MPT x 3" Lg. Nipple | 17 | 630327 | 1/2" Cross |
| 7 | 630340 | 1/2" FF PA Elbow | 18 | 632226 | 1/4" T-Street |
| 8 | 324560 | 1/4" NPT 1/4" TU @ 90° Push-in Fiting | 19 | 324571 | 1/4" Blue Poly. Tube |
| 9 | 610390 | 1/2" Inlet Ring | 20 | 324558 | 1/4" MTP 1/4" TU Push-in Fitting |
| 10 | 608102 | 1/2" FPT Ball Valve | 21 | 606104 | 1/2" Clear Nylon Hose |

AIR PRESSURE MANIFOLD - STANDARD 1/2" PIPING WITH PLASTIC MEDIA OPTION



| | | |
|---|--------|--|
| 1 | 632214 | 1/8 TO 1/4" ADAPTOR |
| 2 | 608608 | 1/4" REGULATION VALVE |
| 3 | 314048 | 1/4" NPT X 1/4" TU 90° PUSH-IN FITTING |
| 4 | 324571 | 1/4" BLUE TUBING |

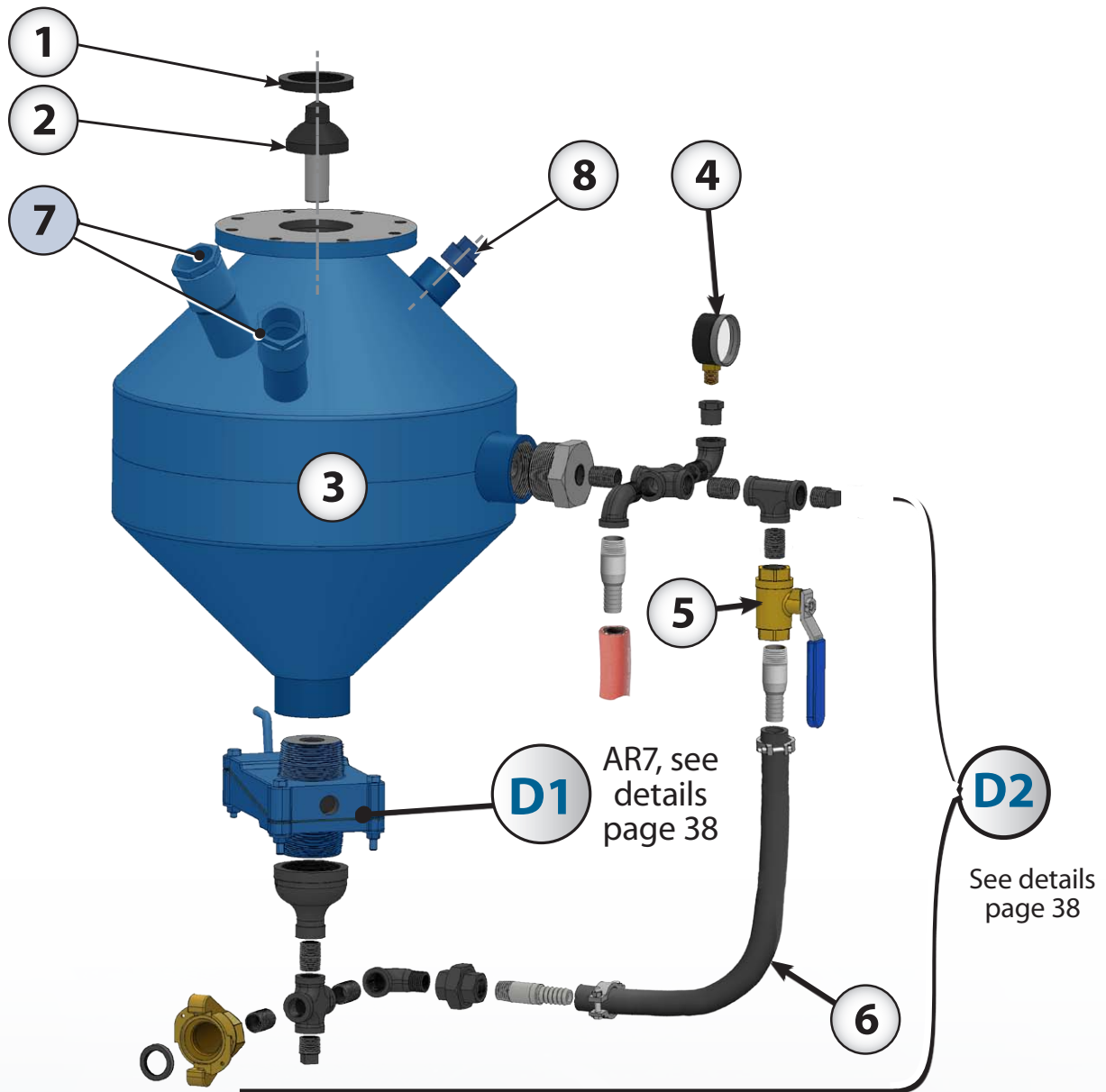
AIR PRESSURE MANIFOLD - OPTIONAL 1" PIPING



| # | Part # | DESCRIPTION |
|----|--------|--|
| 1 | 610387 | 1" Inlet Ring |
| 2 | 630601 | 1" Nipple |
| 3 | 608104 | 1" Ball Valve |
| 4 | 630629 | 1" Cross Fitting |
| 5 | 630653 | 1" x 1/4" Reducer |
| 6 | 632232 | 1/4" F x 1/4" M Elbow Fitting |
| 7 | 630605 | 1" x 3" Lg. Nipple |
| 8 | 608069 | 1" WATTS Valve (Complete Ass'y) |
| 8A | 608064 | Kit : Assembl. Diaphragm H. & B. - Ass. disc (Pop Pet) O-Ring, Valve Plug. |
| 8B | 608066 | 1" - 1 1/4" WATTS Valve Plug |
| 8C | 608071 | Recall Spring |
| 9 | 632226 | 1/4" T-Street |

| # | Part # | DESCRIPTION |
|----|--------|--|
| 10 | 630630 | 1" PA T-Street |
| 11 | 608204 | 1" Check-Valve |
| 12 | 632270 | 1/4" NPT x 1/4" Hose Barb Fitting |
| 13 | 324560 | 1/4" NPT 1/4" TU @ 90° Push-in Fitting |
| 14 | 632002 | 1/8" Hex. Nipple |
| 15 | 324561 | 1/8" NPT 1/4" TU @ 90° Push-in Fitting |
| 16 | 632018 | 1/8" PL Brass T |
| 17 | 606104 | 1" x 1/2" Reducer |
| 18 | 630690 | 1" Hose Barb Fitting |
| 19 | 630641 | 1" Elbow Fitting |
| 20 | 324558 | 1/4" MTP 1/4" TU Push-in Fitting |
| 21 | 324571 | 1/4" Blue Poly. Tube |
| 22 | 324503 | 1/4" MTP x 1/4" TU Bulkhead Push-in |
| 23 | 606104 | 1/2" Clear Nylon Hose |

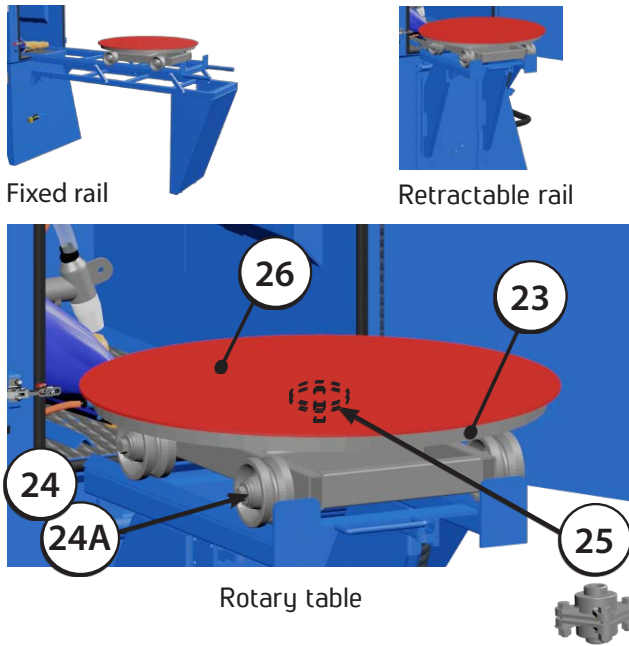
PRESSURE VESSEL - EXPLODED VIEW & PARTS



| # | STOCK | DESCRIPTION |
|---|--------|--------------------------|
| 1 | 618205 | M101P "O" RING |
| 2 | 610040 | M101P PLUNGER |
| 3 | 610313 | M101P PRESSURE VESSEL |
| 4 | 611022 | 1/4" PRESSURE GAUGE |
| 5 | 608102 | 1/2" BALL VALVE |
| | 608104 | 1" BALL VALVE (OPTIONAL) |

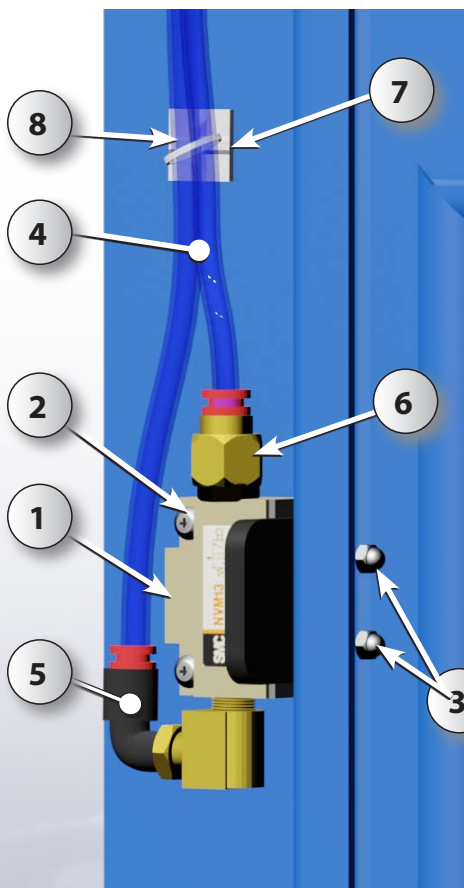
| # | STOCK | DESCRIPTION |
|---|--------|--------------------------------------|
| 6 | 606001 | 1/2" SBH HOSE (SOLD PER FOOT) |
| | 606005 | 1" SBH HOSE OPTIONAL (SOLD PER FOOT) |
| 7 | 610311 | 2" SIGHT GLASS (OPTIONAL) |
| 8 | 630671 | 1" PA MALE PLUG |

OPTION : ROTARY TABLE ON RAILS



| # | STOCK | DESCRIPTION |
|-----|--------|--------------------------------------|
| 23 | 619121 | 18" |
| | 619122 | 21" |
| | 619123 | 28" |
| | 619124 | 32" |
| | 619125 | 36" |
| | 619126 | 40" |
| | 619127 | 48" |
| 24 | 619022 | 4" WHEEL WITH «V» GROOVE C/W BUSHING |
| 24A | 619025 | BUSHING ONLY (FOR WHEEL) |
| 25 | 619023 | 1" AXLE BEARING |
| 26 | 940024 | ¼" LINATEX RUBBER COVERAGE |

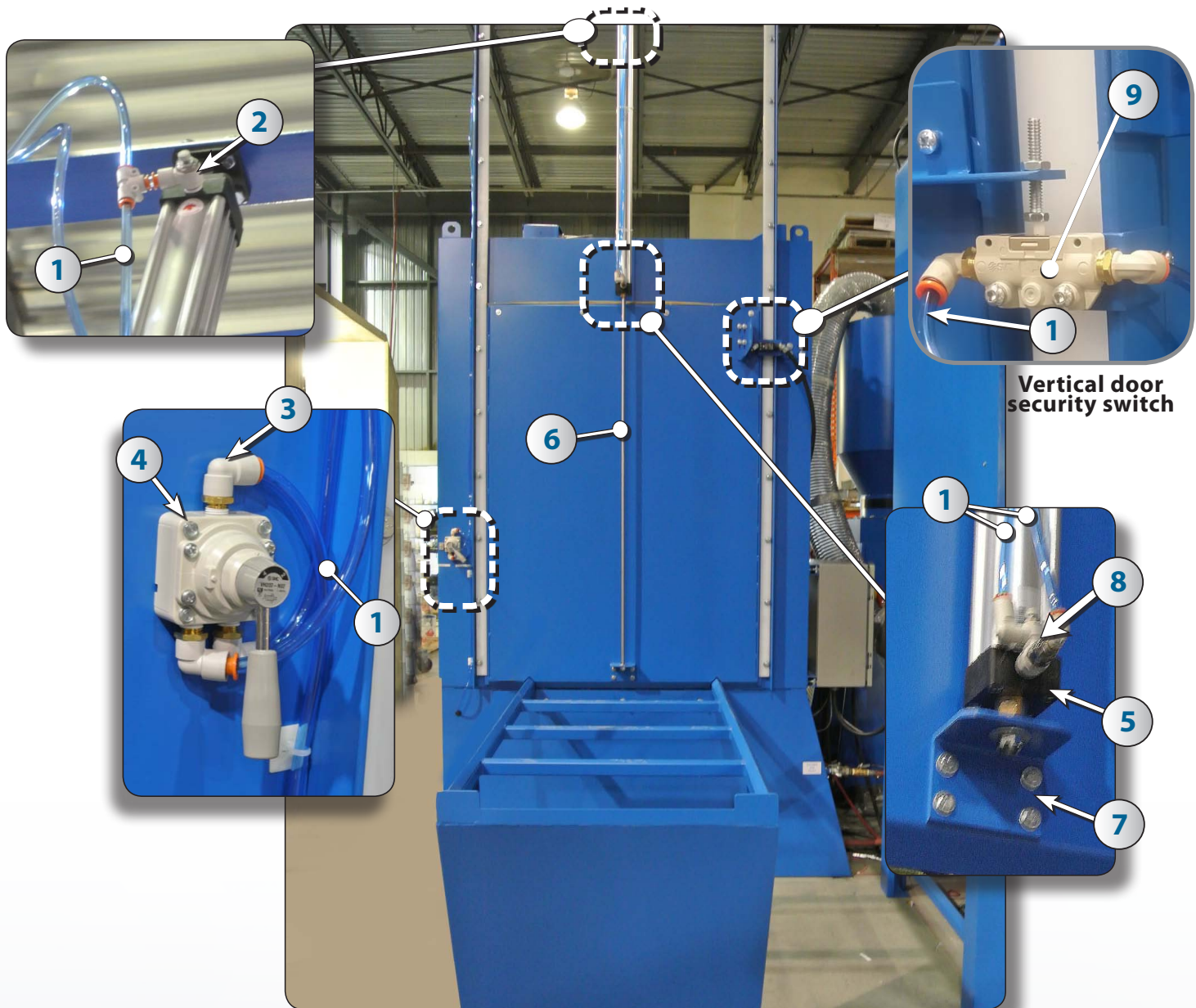
OPTION : DOOR SAFETY SWITCH - INSTALLATION KIT (600116)



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

| ID | PART NB | DESCRIPTION |
|----|---------|--|
| 1 | 908501 | THREE WAYS AIR VALVE 1/8" 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 1/4" |
| 5 | 324561 | 90° PUSH IN FITTING 1/8" NPT 1/4" TUBE |
| 6 | 324570 | STRAIGHT PUSH IN 1/4 X 1/8" |
| 7 | 616706 | NYLON TY-RAP 3 1/2" |
| 8 | 616717 | TY-RAP MOUNTING (1x2) |

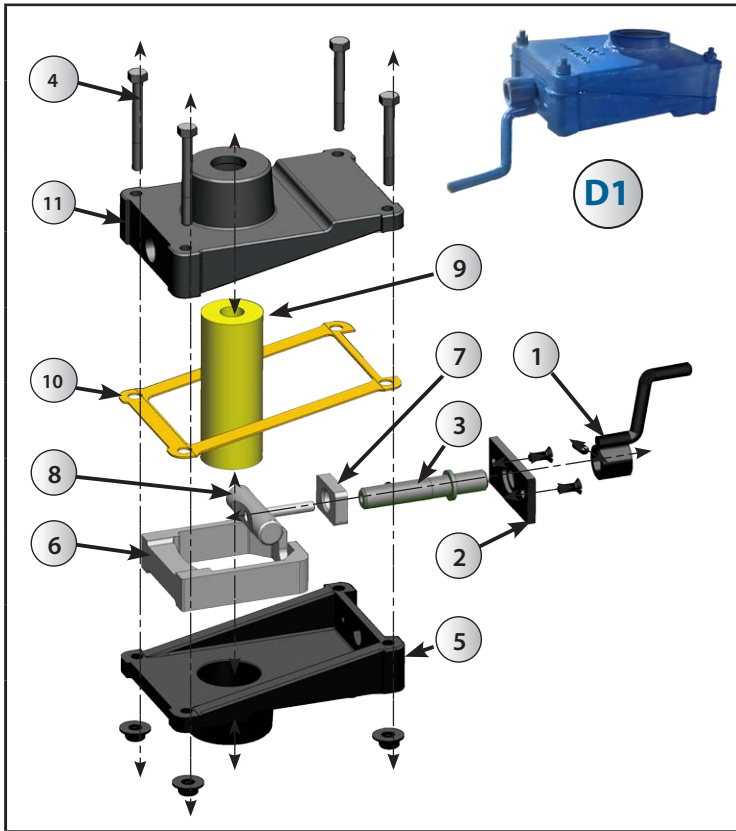
OPTION : VERTICAL DOOR WITH MANUAL COMMAND



| # | STOCK | DESCRIPTION |
|-----|--------|--------------------------------|
| 1 | 324571 | ¼" BLUE POLY. TUBING |
| 2 | 908699 | ¼" NPT FLOW CONTROL |
| 3 | 324560 | ¼" @ 90° PUSH IN FITTING |
| 4 | 908589 | MANUAL VALVE « OPEN/CLOSED » |
| 5,6 | 908820 | CYLINDER 39" STROKE |
| 7 | NPN | CYLINDER MOUNTING PLATE |
| 8 | 908659 | FLOW CONTROL WITH CHECK VALVE |
| 9 | 908501 | VERTICAL DOOR SWITCH (OPTION.) |

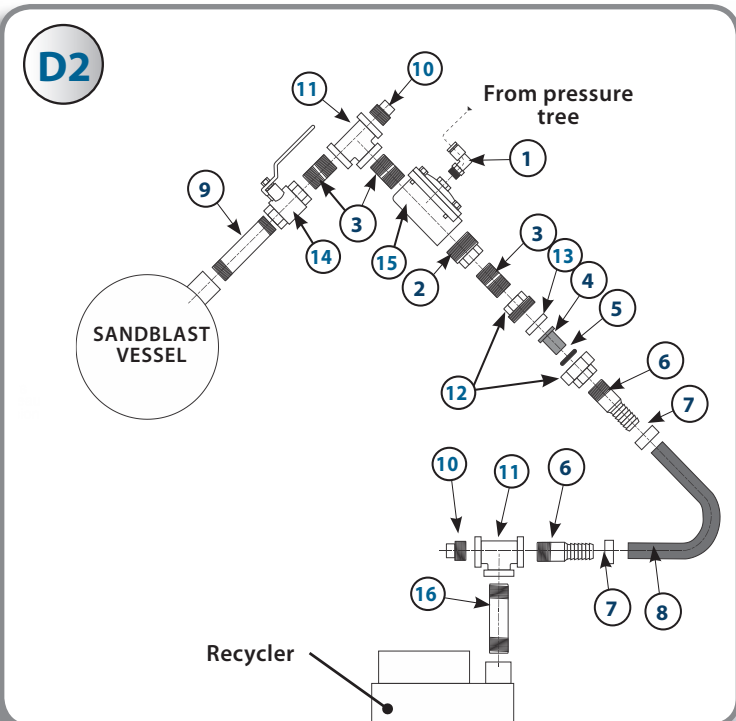
AR7 REGULATOR & DEPRESSURIZING SYSTEM - VIEWS & PARTS

AR7 ABRASIVE REGULATOR



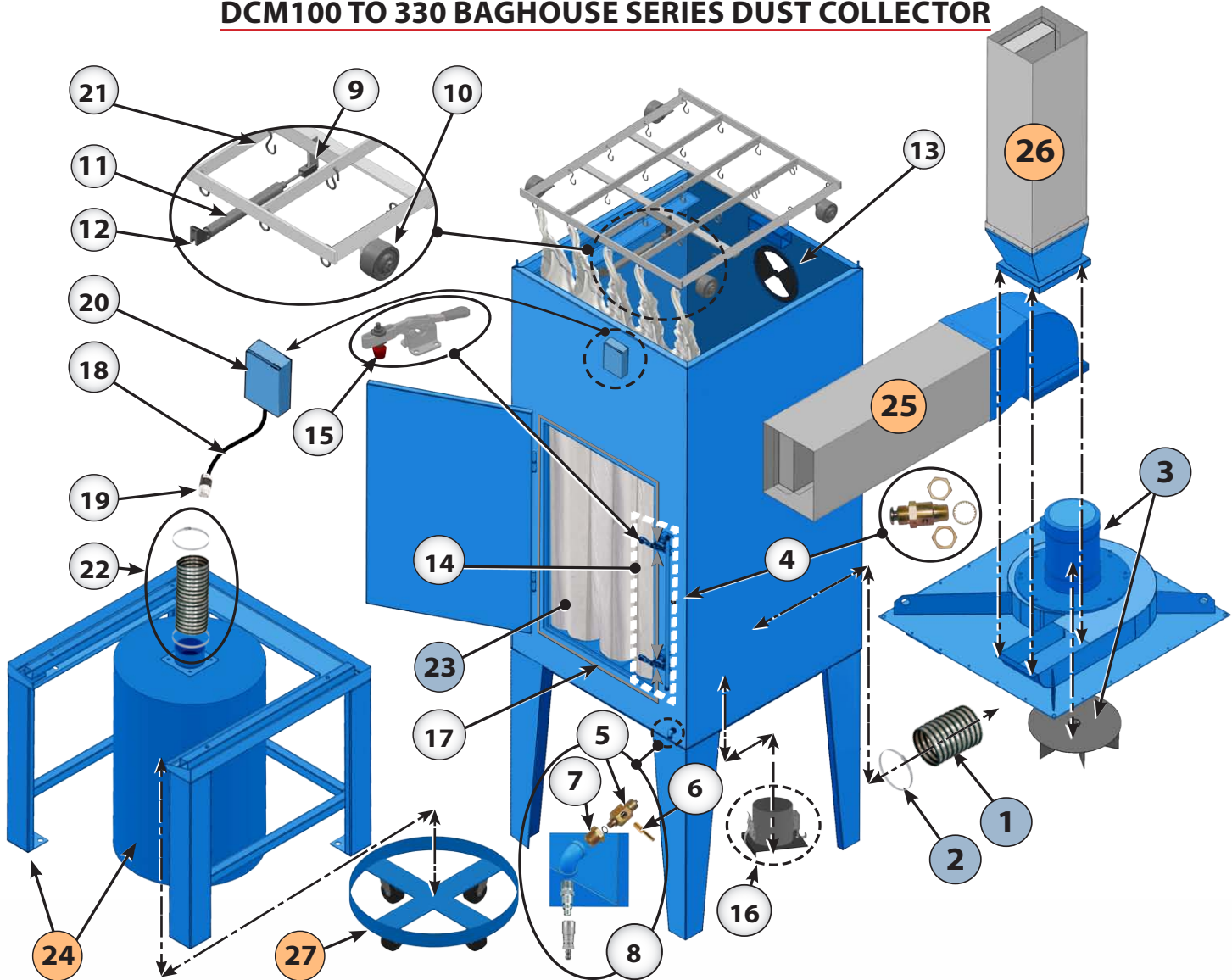
| A | 608043 | COMPLETE AR7 REGULATOR |
|----|--------|------------------------------|
| 1 | 608093 | HANDLE |
| 2 | 608091 | RETAINING PLATE |
| 3 | 608039 | REGULATION FLOW SCREW |
| 4 | 608096 | CLAMPING BOLTS (SOLD BY KIT) |
| 5 | 608047 | LOWER HOUSING |
| 6 | 608037 | CRUSHING STRIER |
| 7 | 608040 | REGULATION PLATE |
| 8 | 608036 | REGULATION TUBE |
| 9 | 618228 | RUBBER TUBE |
| 10 | 618231 | GASKET SEAL |

DEPRESSURIZING SYSTEM



| # | STOCK | DESCRIPTION |
|----|--------|--------------------------------------|
| 1 | 324560 | 1/4" @ 90° Push-in Coupling |
| 2 | 630860 | 1 1/4" 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 | 1 1/4" 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 |

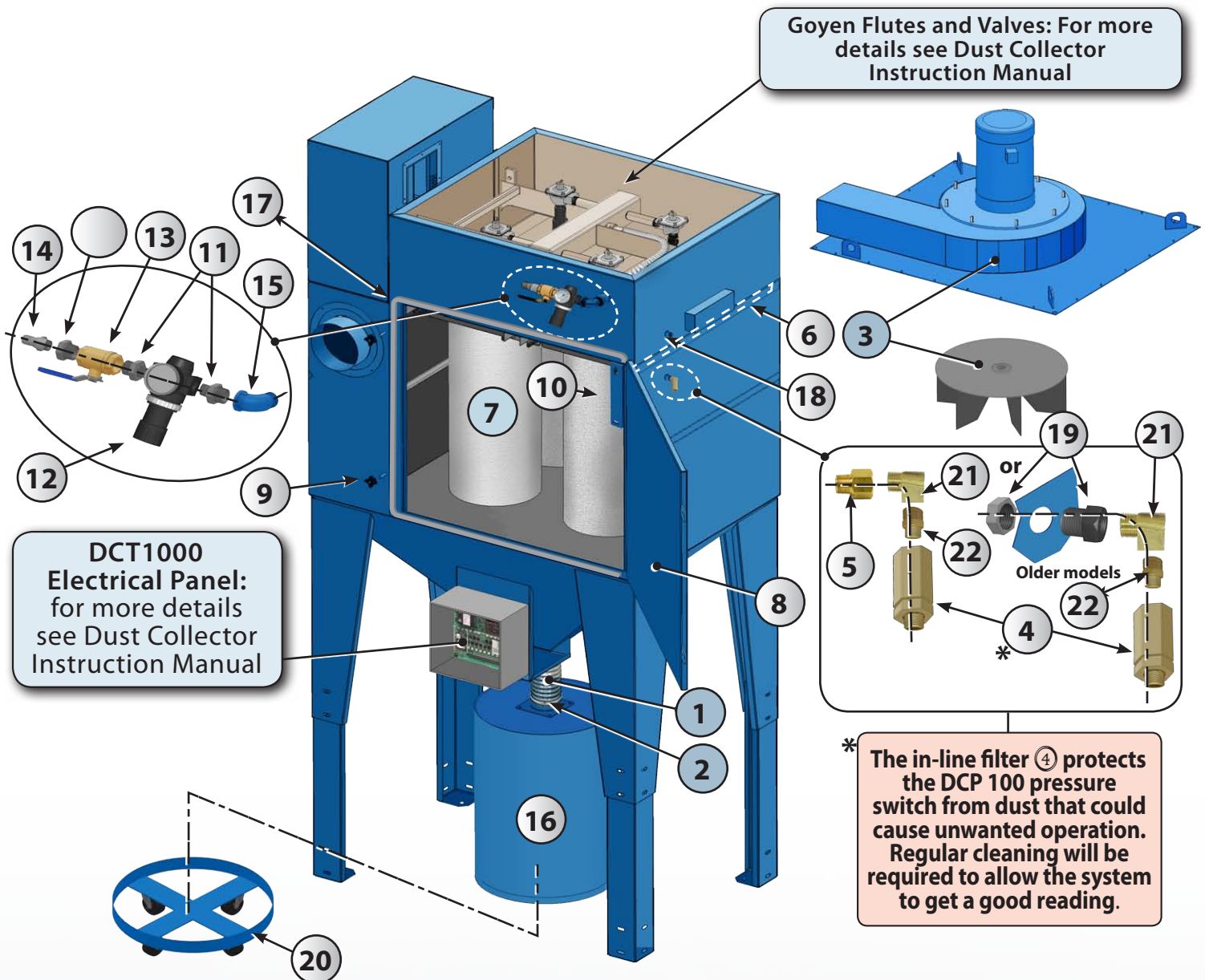
DCM100 TO 330 BAGHOUSE SERIES DUST COLLECTOR



| # | PART # | DESCRIPTION |
|----|-------------------------------|--|
| 1 | Hoses : see table page 35 | |
| 2 | Clips : see table page 35 | |
| 3 | Fan Motor : see table page 35 | |
| 4 | 608508 | Pneumatic Shacker Button |
| 5 | 608408 | Flow Adjust 10-32 Slotted |
| 6 | 632064 | 1/8" 10-32 MPT Hose Barb Fitting |
| 7 | 608409 | 1/4" Reducer pour Flow Adjust |
| 8 | -/----> | Air Inlet (1/4" M # 607222, & 1/4" F # 607219 Quick Connect) |
| 9 | 608406 | Clevis Rod |
| 10 | 619005 | 2" Roller |
| 11 | 608405 | 3/4" Ø x 3" stroke Cylinder |
| 12 | 608407 | Bracket for cylinder |
| 13 | 610280 | 8" Adjustable Air Inlet |
| 14 | 610287 | Complete Door Handle |

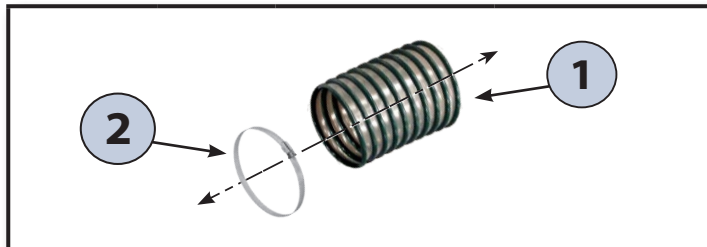
| # | PART # | DESCRIPTION |
|----|--------|--|
| 15 | 910223 | Door Toggle Stem |
| 16 | 601378 | Dust Trap |
| 17 | 618321 | "D" Type Rubber Seal (sold by foot) |
| 18 | 616575 | Electric Cable (sold by foot) |
| 19 | 616406 | Electric Plug |
| 20 | 617063 | Electric Box |
| 21 | 601309 | "S" Hook |
| 22 | 609158 | 4" Dust Hose (sold by foot) |
| 23 | | Dust Bags (see table page 35) |
| 24 | | Option : Barrel & Extension Legs (see page 35) |
| 25 | | Option : Horizontal Muffler (see page 35) |
| 26 | | Option : Vertical Muffler (see page 35) |
| 27 | | Trolley for Barrel |

DCM 600 TO 1800 CARTRIDGE DUST COLLECTOR SERIE - EXPLODED VIEW & PARTS



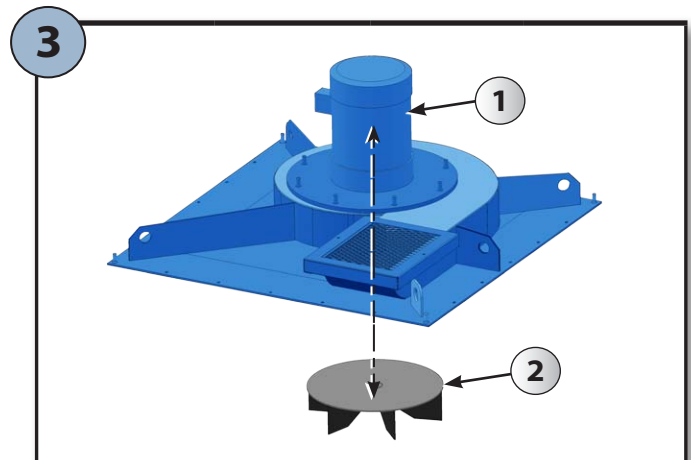
| # | PART # | DESCRIPTION | # | PART # | DESCRIPTION |
|----|--------|---------------------------------------|-----|--------|---------------------------------------|
| 1 | | Hoses : see table page 35 | 13 | 608102 | ½" Ball Valve |
| 2 | | Clamps : see table page 35 | 14 | 607222 | ¼"-¼" NPT Quick-Connect Fitting |
| 3 | | Motor : see table page 35 | 14A | 630351 | ½" @ ¼" MF Reducer |
| 4 | 611058 | ⅛" Inline Filter | 15 | 630641 | 1" MF @ 90° Elbow |
| 5 | 632248 | ¼" @ ⅛" HEX. Reducer | 16 | 901448 | 30 gal Collecting Barrel |
| 6 | NPN | Cartridge Guide | 17 | 618321 | « D » Type Rubber Seal (Sold by foot) |
| 7 | | Filtering Cartridge : see table p. 35 | 18 | 324560 | ¼" NPT @ ¼" TU Push-in Fitting |
| 8 | NPN | Access Door | 19 | 932004 | ¼" FF Bulkhead Fitting |
| 9 | 940109 | Star Knob | 20 | 919325 | Trolley for Barrel |
| 10 | NPN | Cartridge Lock Key | 21 | 630125 | ¼" MF @ 90° Elbow |
| 11 | 630651 | 1" @ ½" Reducer | 22 | 630141 | ¼" @ ⅛" Reducer |
| 12 | 608022 | ½" Complete Pressure Regulator | | | |

DUST COLLECTORS : MOTORS, HOSES AND BAGS OR CARTRIDGES
FAN MOTOR & SUCTION HOSE



BARBED SUCTION HOSES AND CLAMPS

| Fan Motor (hp) | Hose I.D. | Hose (1) | Clamp (2) |
|----------------|-----------|----------|-----------|
| 1/2 | 5" | 606168 | 624121 |
| 1 | 6" | 606169 | 624124 |
| 2 | 7" | 606171 | 624127 |
| 3 | 8" | 606173 | 624128 |
| 5 | 10" | 606177 | 624137 |



FAN MOTOR

| Power (hp) (1) | Voltages | | Fan (2) |
|----------------|----------|-------|---------|
| | 240 V | 380 V | |
| 1/2 | IST | S/O | 610525 |
| 1 | IST | S/O | 610526 |
| 2 | IST | S/O | 610527 |
| 3 | S/O | IST | 610528 |
| 5 | S/O | IST | 610529 |
| 7.5 | S/O | IST | IST |
| 10 | S/O | IST | IST |

| # | PART # | DUST BAGS |
|----|--------|-------------------------------------|
| 23 | 601316 | DC 100 : DB6HP Dust Bags (Qty : 16) |
| | | DC 160 : DB6HP Dust Bags (Qty : 25) |
| | | DC 230 : DB6HP Dust Bags (Qty : 36) |
| | 601308 | DC 330 : DB9HP Dust Bags (Qty : 36) |

FILTERING CARTRIDGES

| # | PART # | MODEL | QTY |
|---|--------|---------|-----|
| 7 | 901321 | DCM600 | 2 |
| | | DCM900 | |
| | | DCM1200 | 4 |
| | | DCM1800 | |

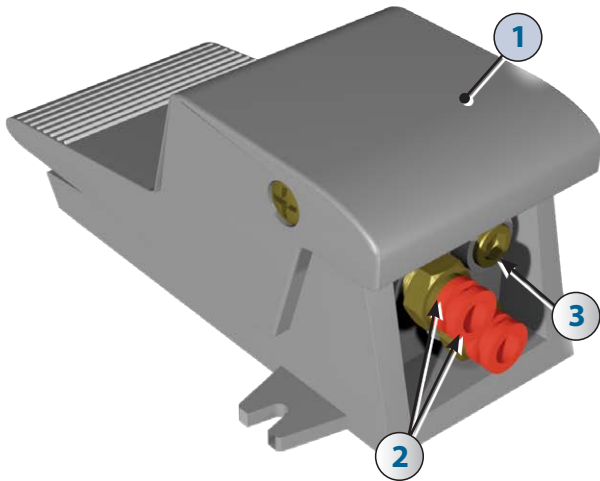


BAGHOUSE DUST COLLECTOR OPTIONS

| DCM MODEL | 24 OPTION DUST BARREL & LEGS | | HORIZONTAL MUFFLER | VERTICAL MUFFLER |
|------------|------------------------------|-----------------------|--------------------|------------------|
| | OPTION Nb. | BARREL CAPACITY (gal) | 25 | 26 |
| *DCM-100-4 | 601486 | 15 | 601434 | 601423 |
| DCM-100 | 601486 | 15 | 601434 | 601423 |
| DCM-160 | 601487 | 30 | 601435 | 601424 |
| DCM-230 | 601490 | 30 | 601436 | 601425 |
| DCM-330 | 601490 | 30 | 601437 | 601426 |

* For ECAB pressure cabinet only.

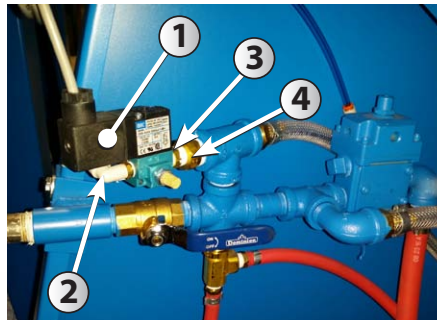
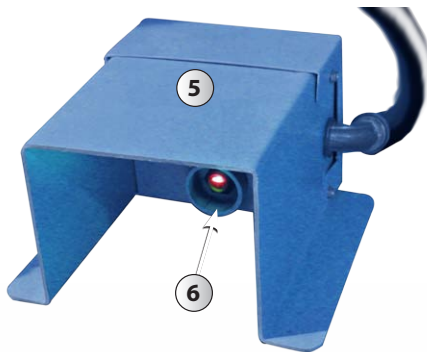
STANDARD FOOT PEDAL - PARTS DETAIL



| # | STOCK | DESCRIPTION |
|---|--------|---------------------------------|
| 1 | 908065 | Pneumatic Foot Pedal (complete) |
| 2 | 950264 | 1/4" Push-in Fittings |
| 3 | 632551 | 1/4" Brass Plug |

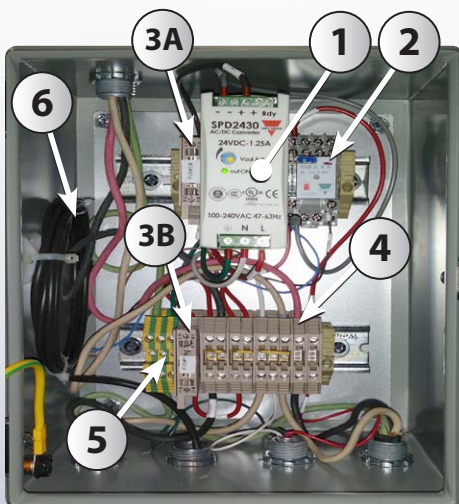
NO-CONTACT FOOT PEDAL (OPTIONAL)

PEDAL & PARTS



| # | STOCK | DESCRIPTION |
|---|--------|--------------------------------|
| 1 | 608568 | SOLENOID VALVE |
| 2 | 324561 | 1/8" PUSH-IN FITTING |
| 3 | 632214 | ADAPTER 1/8" TO 1/4" |
| 4 | 632745 | ADAPTER 1/2" TO 1/4" |
| 5 | 910525 | COMPLETE NO-CONTACT FOOT PEDAL |
| 6 | 917879 | INFRARED SENSOR CELL |

CONTROL PANEL WITH PARTS



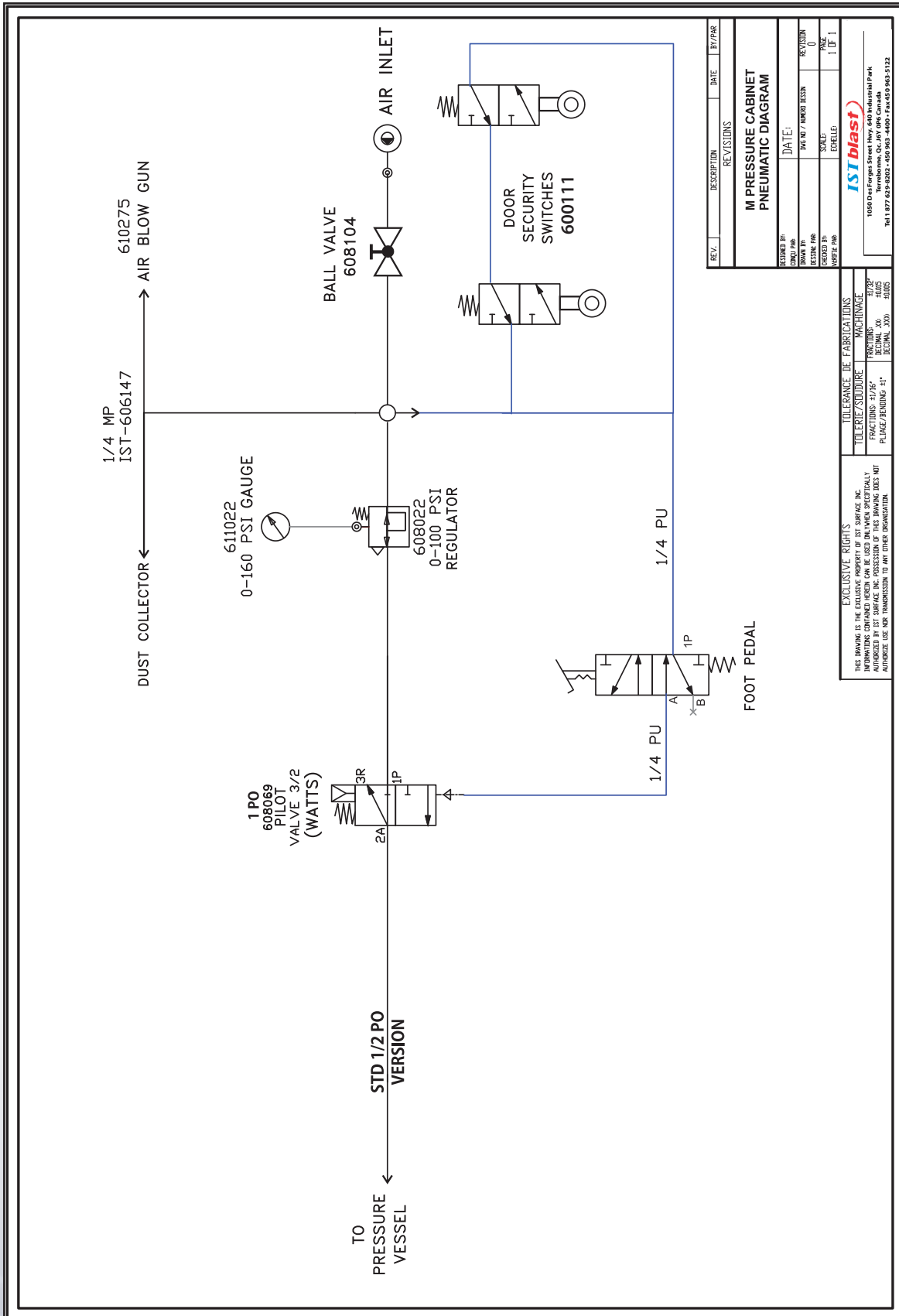
| # | STOCK | DESCRIPTION |
|----|--------|------------------------------------|
| 1 | 917618 | 24V DC - POWER SUPPLY 30W - 120/24 |
| 2 | 917877 | 24V DC RELAY |
| 3A | 917893 | MDL.2A FUSE |
| 3B | 616933 | AGC-1A FUSE |
| 4 | -/- | TERMINAL BLOCKS |
| 5 | 616865 | GROUND BLOCKS |
| 6 | 917880 | SENSOR CABLE |

RECOMMENDED SPARE PARTS

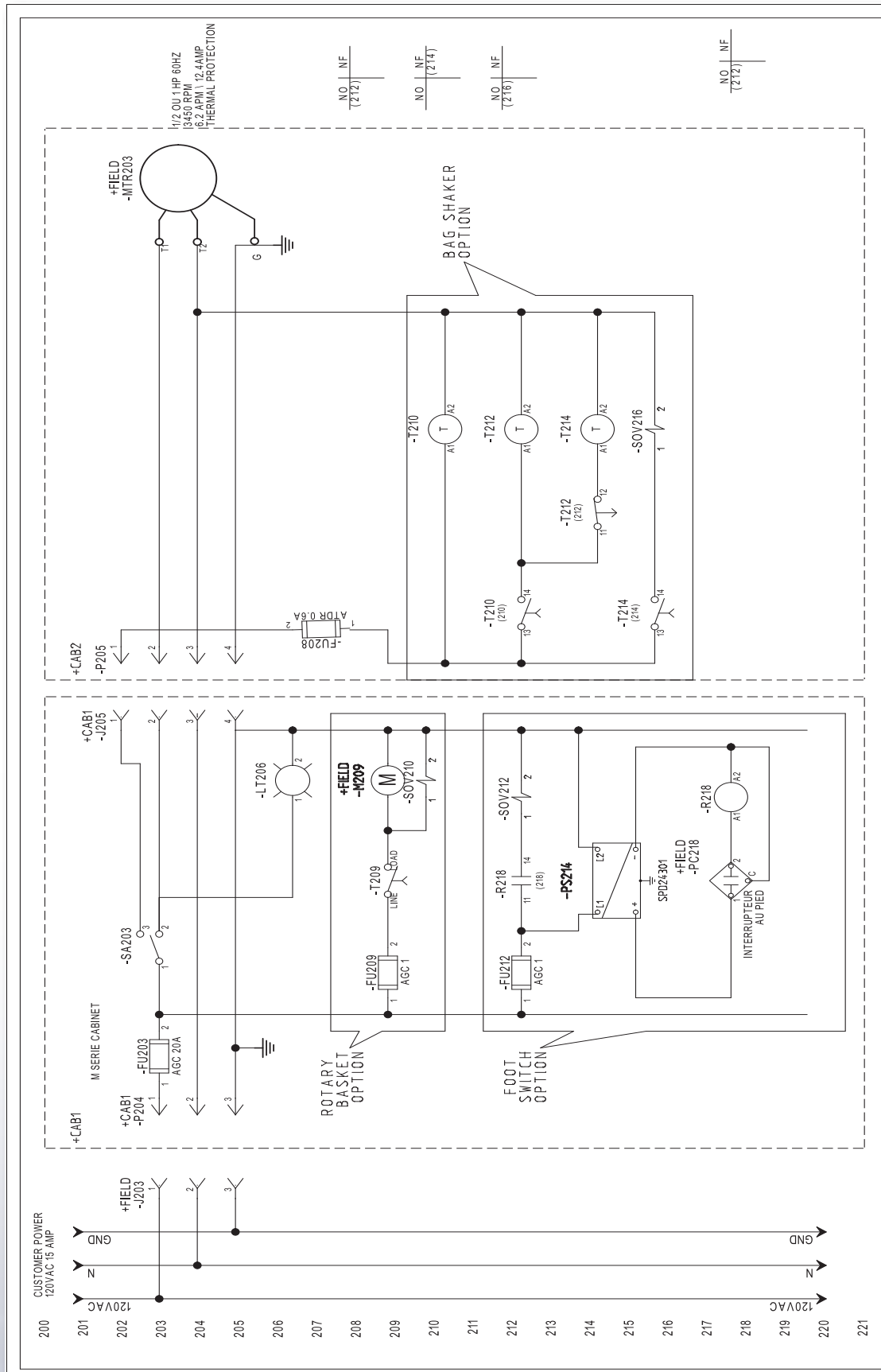
| Description | Configuration | Part No | Qty |
|--------------------------------|-------------------------------|---------|-----|
| Cabinet | | | |
| Leather Gloves | All Models | 603205 | 1 |
| Nozzle 5/16" ID* | | 405465 | |
| "Blast Hose (sold by foot)" | 2636-2844-3636-3648-4248-4848 | 606020 | 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 - 1 PH - DRAWING



| | |
|---|--|
| <p>DESIGNER: LAURENT GOLDSCHMITT</p> <p>CUSTOMER: IST SURFACE</p> | <p>Drawing Number: IST-282G</p> <p>Date: 2021-08-02</p> <p>Page: 2 / 3</p> |
| <p>Rev. Date: 2021-12-15 13:41 PM</p> | <p>M SERIE DCM 50 - 330 1PH 120V POWER AND CONTROL</p> <p>POWER AND CONTROL</p> <p>1 PHASE MOTOR</p> |
| <p>DESIGNER: LAURENT GOLDSCHMITT</p> <p>CUSTOMER: IST SURFACE</p> | <p>Rev. Date: 2021-12-15 13:41 PM</p> |
| <p>DESIGNER: LAURENT GOLDSCHMITT</p> <p>CUSTOMER: IST SURFACE</p> | <p>Date: 2021-08-02</p> <p>Page: 2 / 3</p> |
| <p>DESIGNER: LAURENT GOLDSCHMITT</p> <p>CUSTOMER: IST SURFACE</p> | <p>Rev. Date: 2021-12-15 13:41 PM</p> |
| <p>DESIGNER: LAURENT GOLDSCHMITT</p> <p>CUSTOMER: IST SURFACE</p> | <p>Date: 2021-08-02</p> <p>Page: 2 / 3</p> |

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ELECTRICAL SCHEMATIC WITH DCM 50 TO 330 BAG-TYPE - 1 PH - PARTS LIST

| Function | Localisation | Tag | Material (Cat. No.) | Series | Cat. No. Description | Supplier |
|----------|--------------|--------------------------------|---------------------|--------|---|-------------------|
| +CAB1 | -FU203 | AGC20 | | | GLASS FUSE 20 AMP | FERRAZ |
| +CAB1 | -FU203 | HXP-HHR | | | FUSE HOLDER E-3/RB-14-6-FL | BUSSMAN |
| +CAB2 | -FU208 | ATDR1 | | | FUSE 1A 600V TYPE CC TIME DELAY | FERRAZ |
| +CAB2 | -FU208 | HXP-HHR | | | FUSE HOLDER E-3/RB-14-6-FL | BUSSMAN |
| +CAB1 | -FU209 | HXP-HHR | | | FUSE HOLDER E-3/RB-14-6-FL | BUSSMAN |
| +CAB1 | -FU209 | AGC1 | | | GLASS FUSE 1 AMP | FERRAZ |
| +CAB1 | -FU212 | 10140 | | | FUSE BLOCK VISM4-4 | WIEDMULLER |
| +FIELD | -J203 | CUSTOMER | | | CUSTOMER FUSE DISCONNECT | CUSTOMER |
| +CAB1 | -J205 | 27W75 | | | PLUG 4P FEMELLE 15A | LEVITON |
| +FIELD | -L1206 | 2SLSTP2040DD20V/4SLSTP4040DD20 | | | STRIP LED 24" / STRIP LED 48" | METALUX |
| +FIELD | -M209 | 0448 (34RHE-Z4) | | | REDUCTOR MOTOR 115HP 15V 180/1 RATIO | BODINE |
| +FIELD | -MTR203 | YCN5624A-YX2 | | | MOTEUR 1/2 HP 120/60 3450RPM | JRP |
| +FIELD | -MTR203 | YCN5642A-YX2 | | | MOTOR 1HP 15-208-230/160 3450 RPM | JRP |
| +CAB1 | -P204 | 5265-C | | | Straight Blade Plug, 15 Amp, 125 Volt, Industrial Grade - Black & White | 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 SUPPLY 24VDC 300W | CARLO GAVAZZI |
| +CAB1 | -R218 | RMA4524DC | | | RELAY 4PDT 24VDC | CARLO GAVAZZI |
| +CAB1 | -R218 | SY4S05C | | | RELAY HOLDER 4 POLE | CARLO GAVAZZI |
| +CAB1 | -SA203 | R3-4371 | | | VALVE D1/4PH 1/2 | GOYEN |
| +FIELD | -SOV210 | 120WV2-EUBN-7281 | | | SOLENOID VALVE 35A-AAA-DAAJ-1UB 120V 1NC | MAC |
| +FIELD | -SOV212 | 35A-AAA-DAAJ-1UB | | | SOLENOID VALVE 35A-AAA-DAAJ-1UB 120V 1NC | MAC |
| +FIELD | -SOV216 | 35A-AAA-DAAJ-1UB | | | SOLENOID VALVE 35A-AAA-DAAJ-1UB 120V 1NC | 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 |

Customer:
IST SURFACE

Drawing number:
IST-282G

Drawing by:
LAURENT GOLDSCHWITT

Rev.:
2021-12-16

Date:
2021-12-16

Page Rev. Date:
2021-12-16 8:53:16 AM

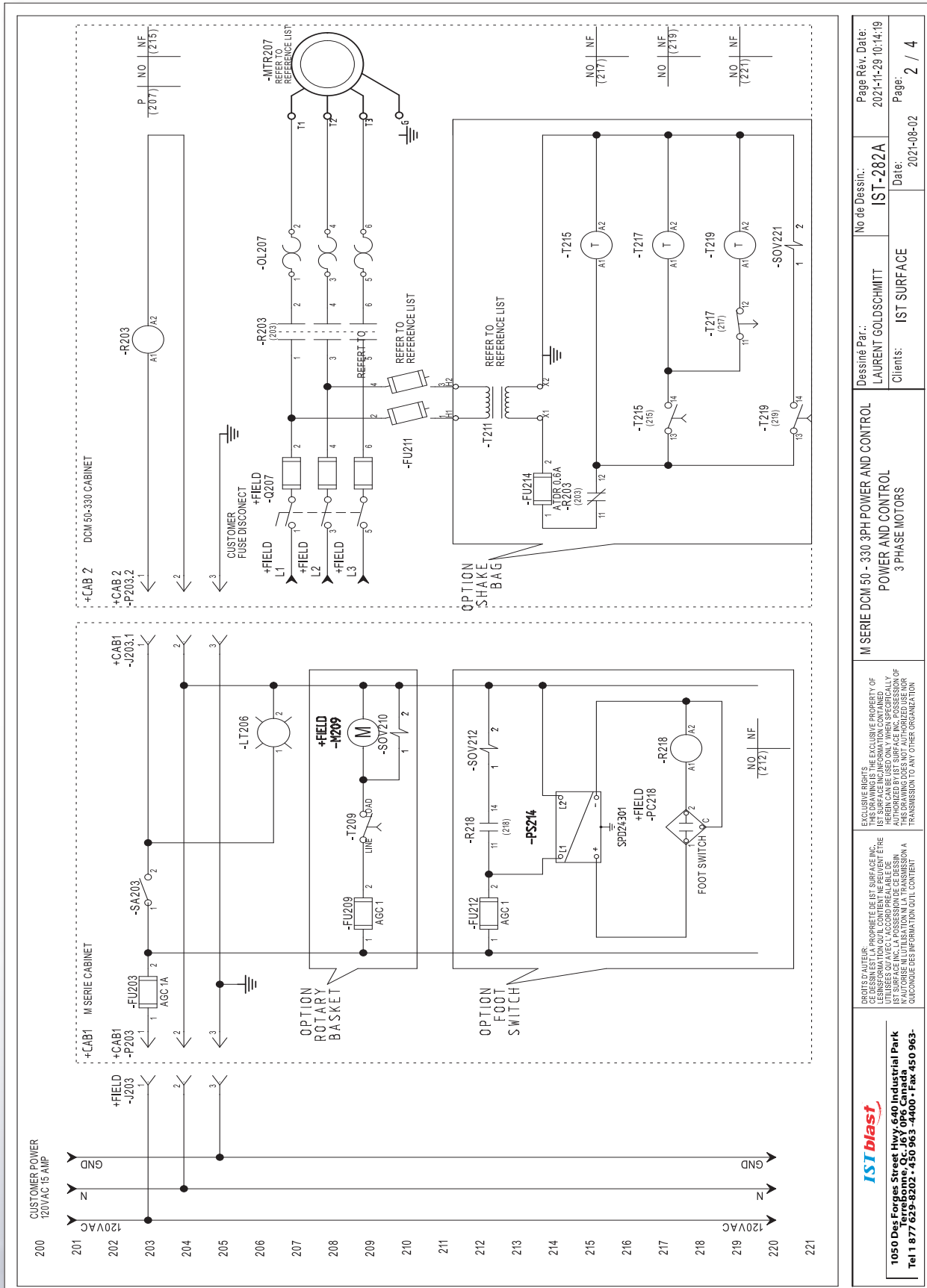
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ELECTRICAL SCHEMATIC WITH DCM 50 TO 330 BAG-TYPE - 3 PH - DRAWING



| | | | | |
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| | | Clients: IST SURFACE | Date: 2021-08-02 | Page: 2 / 4 |
| M SERIE DCM 50 - 330 3PH POWER AND CONTROL POWER AND CONTROL 3 PHASE MOTORS | | | | |
| 1050 Des Forges Street Hwy 640 Industrial Park Terrebonne, Qc J6Y 0P6 Canada Tel 1 877 625-8202 - 450 963 -4400 - Fax 450 963- | | | | |

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

| Fonction | Localisation | Tag | Material (Cat. No.) | Series | Cat. No. Description | Supplier |
|----------|--------------|---------|--------------------------------|--------|---|--------------------|
| | +CAB1 | -FU203 | HKP-HRR | | FUSE HOLDER E-3/RB-4-6-FL | BUSSMAN |
| | +CAB1 | -FU203 | AGC1 | | GLASS FUSE 1AMP | FERRAZ |
| | +CAB1 | -FU209 | AGC1 | | GLASS FUSE 1AMP | FERRAZ |
| | +CAB1 | -FU209 | HKP-HRR | | FUSE HOLDER E-3/RB-4-6-FL | BUSSMAN |
| | +CAB2 | -FU211 | REFERT TO | | REFERT TO REFERENCE LIST | SCHNEIDER ELECTRIC |
| | +CAB1 | -FU212 | 1040 | | FUSE BLOCK VISM-4 | WEDMULLER |
| | +CAB2 | -FU214 | HKP-HRR | | FUSE HOLDER E-3/RB-4-6-FL | BUSSMAN |
| | +CAB2 | -FU214 | ATDR1 | | FUSE 1A 600V TYPE CC TIME DELAY | FERRAZ |
| | +FIELD | -I203 | CUSTOMER | | CUSTOMER FUSE DISCONNECT | CUSTOMER |
| | +CAB1 | -I203.1 | 5269C | | 15 Amp 25V- Straight Blade Socket | HUBBELL |
| | +FIELD | -L1206 | 2SLSTP2040DD20V/4SLSTP4040DD20 | | STRIP LED 24" 1 STRIP LED 48" | METALUX |
| | +FIELD | -M209 | 0449 (3R49F-Z4) | | REDUCTOR MOTOR 1/5HP 115V 180V RATIO | BODINE |
| | +FIELD | -MTR207 | REFERT TO | | REFERT TO REFERENCE LIST | SCHNEIDER ELECTRIC |
| | +CAB2 | -O1207 | REFERT TO | | REFERT TO REFERENCE LIST | SCHNEIDER ELECTRIC |
| | +CAB1 | -P203 | 5266-C | | Straight Blade Plug, 15 Amp, 125 Volt, Industrial Grade - Black & White | HUBBELL |
| | +CAB2 | -P203.2 | 5266-C | | Straight Blade Plug, 15 Amp, 125 Volt, Industrial Grade - Black & White | HUBBELL |
| | +FIELD | -PC218 | GX3-AP-IE | | PHOTOELECTRIC SENSOR PNP UP TO 100MM | AUTOMATION DIRECT |
| | +CAB1 | -PS214 | SPD24301 | | POWER SUPPLY 24VDC 300W | CARLO GAVAZZI |
| | +FIELD | -Q207 | CUSTOMER | | CUSTOMER FUSE DISCONNECT | CUSTOMER |
| | +CAB2 | -R203 | REFERT TO | | REFERT TO REFERENCE LIST | SCHNEIDER ELECTRIC |
| | +CAB1 | -R218 | RMA4524DC | | RELAY 4PDT 24VDC | CARLO GAVAZZI |
| | +CAB1 | -R218 | SY4506C | | RELAY HOLDER 4 POLE | CARLO GAVAZZI |
| | +CAB1 | -SA203 | R3-437A | | SEALED TOGGLE SWITCH | SHINC INDUSTRIAL |
| | +FIELD | -SOV210 | 120M2-EUBN781 | | VALVE DIAPH 1/2 | GOYEN |
| | +FIELD | -SOV212 | 35A-AAA-DAAJ-1JB | | SOL VALVE 35A-AAA-DAAJ-1JB 120V NC | IMC |
| | +FIELD | -SOV221 | 35A-AAA-DAAJ-1JB | | SOL VALVE 35A-AAA-DAAJ-1JB 120V NC | IMC |
| | +CAB1 | -T209 | FF15MC | | 15 MINUTE TIMER | INTERMATIC |
| | +CAB2 | -T211 | LA9T | | Transformateur de contröle 50VA avec fusible inclus | SCHNEIDER ELECTRIC |
| | +CAB2 | -T215 | TM11 | | TIMER RELAY 1NO 1NC | LOVATO |
| | +CAB2 | -T217 | TM11 | | TIMER RELAY 1NO 1NC | LOVATO |
| | +CAB2 | -T219 | TM11 | | TIMER RELAY 1NO 1NC | LOVATO |

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Page Rev. Date: 2021-12-07 14:53:15

Rev.: **4 / 4**

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Customer: **IST SURFACE**

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Page Rev. Date: 2021-12-07 14:53:15

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Date: 2021-12-07

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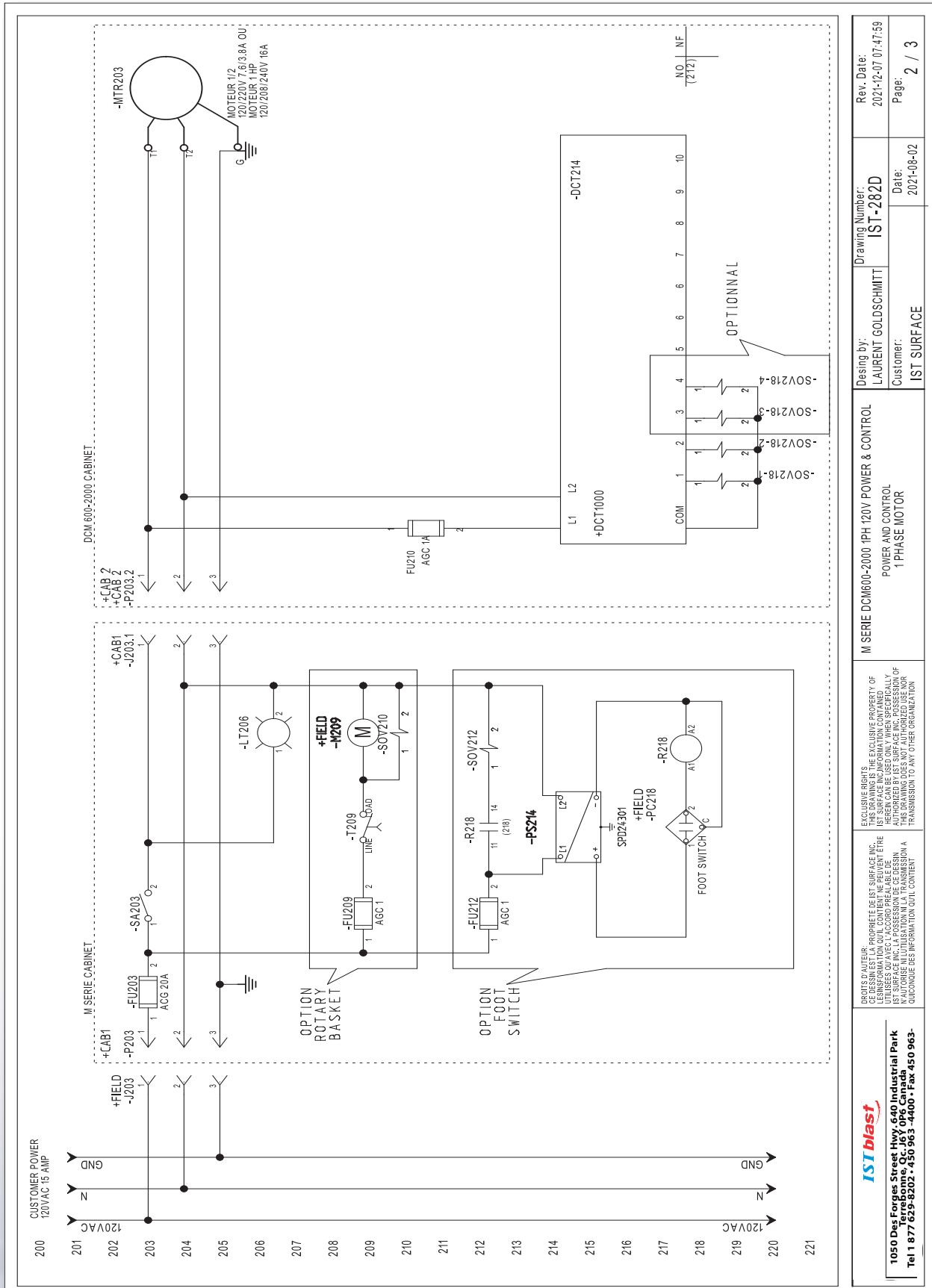
Drawing by: **LAURENT GOLDSCHMITT**

Page Rev. Date: 2021-12-07 14:53:15

Rev.: **4 / 4**

Date: 2021-12-07

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



| | | | | | | | |
|--|--|---|--|--|--|---|--|
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| <p>M SERIE DCM600-2000 1PH 120V POWER & CONTROL</p> <p>POWER AND CONTROL 1 PHASE MOTOR</p> | | <p>Drawing Number: IST-282D</p> | | <p>Page: 2 / 3</p> | | <p>N.O. NF (2/2)</p> | |

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

| Fonction | Localisation | Tag | Material (Cat. No.) | Series | Cat. No. Description | Supplier |
|----------|--------------|-----------|---------------------------------|--------|---|-------------------|
| | +DCT1000 | -DCT214 | DTC1000 | | DUST COLLECTOR TIMER CONTROLLER | DWYER |
| | +CAB1 | -FU203 | AGC20 | | GLASS FUSE 20 AMP | FERRAZ |
| | +CAB1 | -FU203 | HKP-HHR | | FUSE HOLDER E-3IRB-14-6-FL | BUSSMAN |
| | | -FU209 | HKP-HHR | | FUSE HOLDER E-3IRB-14-6-FL | BUSSMAN |
| | | -FU210 | HKP-HHR | | FUSE HOLDER E-3IRB-14-6-FL | BUSSMAN |
| | | -FU212 | 10140 | | FUSE BLOCK VUSM-4 | WEDMULLER |
| | +FIELD | -J203 | CUSTOMER | | CUSTOMER FUSE DISCONNECT | CUSTOMER |
| | +CAB1 | -J203.1 | 5269C | | 15 Amp 25V - Straight Blade Socket | HUBBELL |
| | +FIELD | -L1206 | 2SLSTP2040DD20V/4SLSTP4040DD120 | | STRIP LED 24" 1 STRIP LED 48" | METALUX |
| | +FIELD | -M209 | 0449 (3AR4BF-Z4) | | REDUCTOR MOTOR 115HP 15V 180V RATIO | BODINE |
| | | -MTR203 | YON6642A-YX2 | | MOTOR 1HP 15-208-230/160 3450 RPM | JRP |
| | | -MTR203 | YON6624A-YX2 | | MOTEUR 1/2 HP 120/60 3450 RPM | JRP |
| | +P203 | -P203 | 5266-C | | Straight Blade Plug, 15 Amp, 125 Volt, Industrial Grade - Black & White | HUBBELL |
| | +CAB 2 | -P203.2 | 5266-C | | Straight Blade Plug, 15 Amp, 125 Volt, Industrial Grade - Black & White | HUBBELL |
| | +FIELD | -PC218 | GX3-AP-IE | | PHOTOELECTRIC SENSOR PNP UP TO 100MM | AUTOMATION DIRECT |
| | | -PS214 | SPD24301 | | POWER SUPPLY 24VDC 300W | CARLO GAVAZZI |
| | | -R218 | SY4S0FC | | RELAY HOLDER 4 POLE | CARLO GAVAZZI |
| | | -R218 | RMA4524DC | | RELAY 4PDT 24VDC | CARLO GAVAZZI |
| | | -SA203 | R03-437A | | SEALED TOGGLE SWITCH | SHINC INDUSTRIAL |
| | +FIELD | -SOV210 | 120W2-EUBN7Z81 | | VALVE DIAPHR 1/2 | GOYEN |
| | +FIELD | -SOV212 | 35A-AAA-DAAL-1UB | | SOL VALVE 35A-AAA-DAAL-1UB 120V NC | MAC |
| | +FIELD | -SOV218-1 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| | +FIELD | -SOV218-2 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| | +FIELD | -SOV218-3 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| | +FIELD | -SOV218-4 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| | | -T209 | FF15MC | | 15 MINUTE TIMER | INTERMATIC |

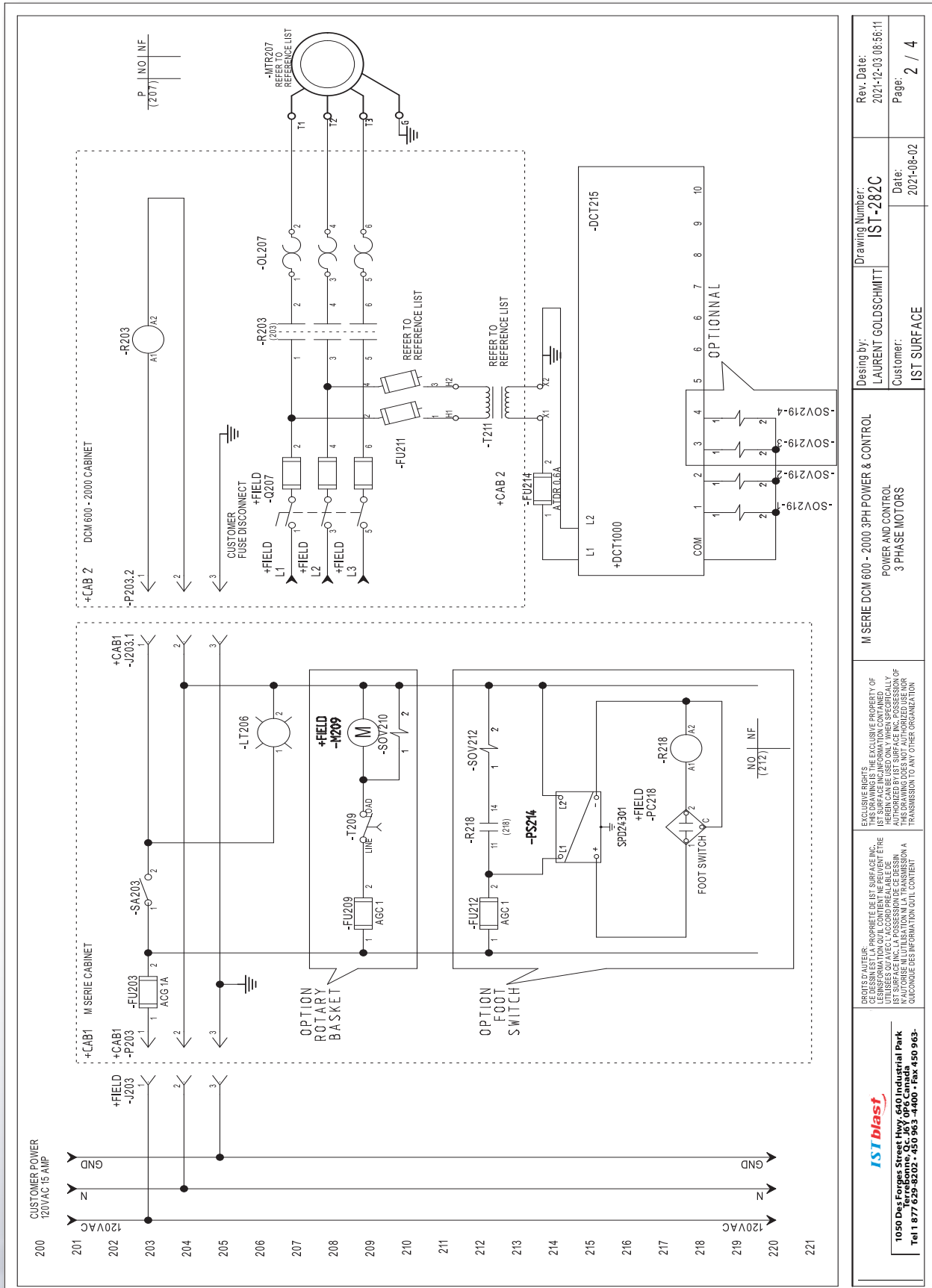
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| Customer: IST SURFACE Drawing by: LAURENT GOLDSCHMITT | Drawing number: IST-282D | Rev.: | Page Rev. Date: 2021-12-09 07:52:39 |
| | Date: 2021-12-09 | | Page: 3 / 3 |

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ELECTRICAL SCHEMATIC WITH 600 TO 1800 CARTRIDGE TYPE - 3 PH - DRAWING



| | | | | | |
|--|--|--|--|---|--|
| <p>200 CUSTOMER POWER 120VAC IS AMP</p> <p>201</p> <p>202</p> <p>203</p> <p>204</p> <p>205</p> <p>206</p> <p>207</p> <p>208</p> <p>209</p> <p>210</p> <p>211</p> <p>212</p> <p>213</p> <p>214</p> <p>215</p> <p>216</p> <p>217</p> <p>218</p> <p>219</p> <p>220</p> <p>221</p> | | <p>DCM 600 - 2000 CABINET</p> <p>-R203</p> <p>-P203.2</p> <p>-Q207</p> <p>-OL207</p> <p>-FU211</p> <p>-T211</p> <p>+CAB 2</p> <p>-DCT1000</p> <p>-DCT215</p> <p>OPTIONAL</p> | <p>M SERIE DCM 600 - 2000 3PH POWER & CONTROL POWER AND CONTROL 3 PHASE MOTORS</p> | <p>DESIGNING BY: LAURENT GOLDSCHMITT</p> <p>DRAWING NUMBER: IST-282C</p> <p>DATE: 2021-08-02</p> <p>CUSTOMER: IST SURFACE</p> | <p>REV. DATE: 2021-12-03 08:56:11</p> <p>PAGE: 2 / 4</p> |
|--|--|--|--|---|--|

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N'EST PAS À ÊTRE REPRODUIT, COPIÉ, NI
TRANSMIS, EN AUCUNE MANIÈRE, ÉLECTRONIQUE
OU MÉCANIQUE, Y COMPRIS LA PHOTOCOPIE,
L'ENREGISTREMENT, OU PAR N'IMPORTE QUEL
Système de Stockage et de Récupération
d'Informations, SANS LA PERMISSE ÉCRITE
D'IST SURFACE INC.

ISTblast
1050 Des Forges Street Hwy. 640 Industrial Park
Troy, Michigan 48066-1000
Tel 1 877-825-8282 • 483-983-9400 • Fax 483-150-9863

ELECTRICAL SCHEMATIC WITH 600 TO 1800 CARTRIDGE TYPE - 3 PH - PARTS LIST

| Fonction | Localisation | Tag | Material (Cat. No.) | Series | Cat. No. Description | Supplier |
|----------|--------------|-----------|-------------------------------|--------|---|--------------------|
| +CAB1 | +CAB1 | -DCT215 | DTC1000 | | DUST COLLECTOR TIMER CONTROLLER | DIWYER |
| +CAB1 | +CAB1 | -FU203 | AGC1 | | GLASS FUSE 1 AMP | FERRAZ |
| +CAB1 | +CAB1 | -FU209 | HKP-HHR | | FUSE HOLDER E-3IRB-14-6-FL | BUSSMAN |
| +CAB1 | +CAB1 | -FU209 | AGC1 | | GLASS FUSE 1 AMP | FERRAZ |
| +CAB1 | +CAB1 | -FU209 | HKP-HHR | | FUSE HOLDER E-3IRB-14-6-FL | BUSSMAN |
| +CAB2 | +CAB2 | -FU211 | REFERT TO | | REFERT TO REFERENCE LIST | SCHNEIDER ELECTRIC |
| +CAB1 | +CAB1 | -FU212 | 1040 | | FUSE BLOCK VISM-4 | WEDMULLER |
| +CAB2 | +CAB2 | -FU214 | ATDR1 | | FUSE 1A 600V TYPE CC TIME DELAY | FERRAZ |
| +CAB2 | +CAB2 | -FU214 | HKP-HHR | | FUSE HOLDER E-3IRB-14-6-FL | BUSSMAN |
| +FIELD | +FIELD | -J203 | CUSTOMER | | CUSTOMER FUSE DISCONNECT | CUSTOMER |
| +CAB1 | +CAB1 | -J203.1 | 5269C | | 15 Amp 125V Straight Blade Socket | HUBBELL |
| +FIELD | +FIELD | -LT206 | 2SLSTP20400D20V/4SLSP40400D20 | | STRIP LED 24" / STRIP LED 48" | METALUX |
| +FIELD | +FIELD | -MTR207 | 0449 (34R48E-Z4) | | REDUCTOR MOTOR 1/5HP 15V 1800/RATIO | BODINE |
| +FIELD | +FIELD | -OL207 | REFERT TO | | REFERT TO REFERENCE LIST | SCHNEIDER ELECTRIC |
| +CAB1 | +CAB1 | -P203 | 5266-C | | REFERT TO REFERENCE LIST | SCHNEIDER ELECTRIC |
| +CAB2 | +CAB2 | -P203.2 | 5266-C | | Straight Blade Plug, 15 Amp, 125 Volt, Industrial Grade - Black & White | HUBBELL |
| +FIELD | +FIELD | -PC218 | GX3-AP-E | | Straight Blade Plug, 15 Amp, 125 Volt, Industrial Grade - Black & White | HUBBELL |
| +CAB1 | +CAB1 | -PS214 | SPD24301 | | PHOTOELECTRIC SENSOR PNP UP TO 100MM | CARLO GAVAZZI |
| +FIELD | +FIELD | -Q207 | CUSTOMER | | POWER SUPPLY 24VDC 300W | CUSTOMER |
| +CAB2 | +CAB2 | -R203 | REFERT TO | | CUSTOMER FUSE DISCONNECT | SCHNEIDER ELECTRIC |
| +CAB1 | +CAB1 | -R218 | RMA4524DC | | RELAY 4PT 24VDC | CARLO GAVAZZI |
| +CAB1 | +CAB1 | -R218 | SV4505C | | RELAY HOLDER 4 POLE | CARLO GAVAZZI |
| +CAB1 | +CAB1 | -SA203 | RQ3-437A | | SEALED TOGGLE SWITCH | SHOCHINDUSTRIAL |
| +FIELD | +FIELD | -SOV210 | 120W2-EUBN7281 | | VALVE DIAPH 1/2 | GOYEN |
| +FIELD | +FIELD | -SOV212 | 35A-AAA-DAA-J4JB | | SOL VALVE 35A-AAA-DAA-J4JB 120V NC | MMC |
| +FIELD | +FIELD | -SOV219-1 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| +FIELD | +FIELD | -SOV219-2 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| +FIELD | +FIELD | -SOV219-3 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| +FIELD | +FIELD | -SOV219-4 | RCA25T4200 | | 1" NPT Diaphragm Valve - 1/8 NPT | GOYEN |
| +CAB1 | +CAB1 | -T209 | FF15MC | | 15 MINUTE TIMER | INTERMATIC |
| +CAB2 | +CAB2 | -T211 | LA9T | | Transformateur de contr de 50VA avec fusible indus | SCHNEIDER ELECTRIC |

| | | | |
|--|--|--|-------------------------------------|
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| Drawing number: IST-282C | | Date: 2021-12-07 | Page: 4 / 4 |
| Customer: LAURENT GOLDSCHMITT | | Drawing By: LAURENT GOLDSCHMITT | |
| <p>M Pressure Series DCM 600 - 2000 3PH POWER & CONTROL</p> <p>EXCLUSIVE RIGHTS: ISTE SURFACE INC. IS THE EXCLUSIVE PROPERTY OF ISTE SURFACE INC. NO PART OF THIS DOCUMENT OR THE INFORMATION CONTAINED HEREIN CAN BE USED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF ISTE SURFACE INC. THIS DOCUMENT IS THE PROPERTY OF ISTE SURFACE INC. AND IS LOANED TO YOU FOR YOUR USE ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.</p> | | | |
| <p>ISTblast</p> <p>1050 Des Forges Street Hwy. 660 Industrial Park Tel 1 877 629 8202 • 450 963 4400 • Fax 450 963 4400</p> | | | |

REFERENCE LIST FOR M-SERIE DCM 50 TO 330 & 600 TO 1800

| MOTOR RATINGS VOLTS INPUT, STARTER AND OVERLOAD SELECTION | | | | | | | | |
|---|--------------|--------------|--------|-------|------|-------------------|--------------|---------------------------------|
| POWER | VOLTS | AMPS | PHASES | HERTZ | RPM | STARTER | OVERLOAD | CUSTOMER FUSE TYPE AND CAPACITY |
| 2HP | 208-230/460V | 6-5,4/2,7A | 3 | 60 | 3450 | LEDD093A6ZOG70 | LRD12/LRD08 | AJT8 - AJT7/AJT4 |
| 2HP | 575V | 2,16A | 3 | 60 | 3450 | LEDD093A6ZOG70 | LRD10/LRD07 | AJT3 |
| 3HP | 208-230/460V | 8,1-7,3/3,6A | 3 | 60 | 3450 | LEDD093A6ZOG70 | LRD14/LRD08 | AJT12 - AJT10-AJT5 |
| 3HP | 575V | 2,9A | 3 | 60 | 3450 | LEDD093A6ZOG70 | LRD14/LRD08 | AJT4 |
| 5HP | 208-230/460V | 13,3-12/6,1A | 3 | 60 | 3450 | LCDD16G7/LCDD12G7 | LRD21L/LRD12 | AJT20 - AJT15/AJT8 |
| 5HP | 575V | 4,8A | 3 | 60 | 3450 | LCDD16G7/LCDD12G7 | LRD21L/LRD10 | AJT6 |
| 7.5HP | 575V | 7,1A | 3 | 60 | 3450 | LEDD093A6ZOG70 | LRD12 | AJT9 |
| 7.5HP | 460V | 8,8A | 3 | 60 | 3450 | LEDD093A6ZOG70 | LRD14 | AJT12 |
| 10HP | 460V | 12A | 3 | 60 | 3450 | LCDD12G7 | LRD16L | AJT15 |
| 10HP | 575V | 9,3A | 3 | 60 | 3450 | LCDD12G7 | LRD14 | AJT12 |

| CONTROL TRANSFORMER SELECTION | | | | | | |
|-------------------------------|----|--------|-------|-------------------|-------------|--------------|
| PRIMARY VOLTAGE | VA | PHASES | HERTZ | SECONDARY VOLTAGE | PART NO | PRIMARY FUSE |
| 600VAC | 50 | 1 | 60 | 120VAC | SCLA9TFD32X | 0,2 amp |
| 480VAC | 50 | 1 | 60 | 120VAC | SCLA9TFD32T | 0,2 amp |
| 240VAC | 50 | 1 | 60 | 120VAC | SCLA9TFD32M | 0,6 amp |

| MOTOR RATINGS VOLTS INPUT AND SELECTION | | | | | | |
|---|--------------|--------------|--------|-------|------|--------------|
| POWER | VOLTS | AMPS | PHASES | HERTZ | RPM | MAKER |
| 2HP | 208-230/460V | 6-5,4/2,7A | 3 | 60 | 3450 | YNS642A-2X4 |
| 2HP | 575V | 2,16A | 3 | 60 | 3450 | YNS642G-575 |
| 3HP | 208-230/460V | 8,1-7,3/3,6A | 3 | 60 | 3450 | NEP182TC-2X4 |
| 3HP | 575V | 2,9A | 3 | 60 | 3450 | NEP182TC-575 |
| 5HP | 208-230/460V | 13,3-12/6,1A | 3 | 60 | 3450 | NEP184TC-2X4 |
| 5HP | 575V | 4,8A | 3 | 60 | 3450 | NEP182TC-575 |
| 7.5HP | 575V | 7,1A | 3 | 60 | 3450 | NEP213TC-575 |
| 7.5HP | 460V | 8,8A | 3 | 60 | 3450 | NEP213TC-2X4 |
| 10HP | 460V | 12A | 3 | 60 | 3450 | NEP215TC-2X4 |
| 10HP | 575V | 9,3A | 3 | 60 | 3450 | NEP215TC-575 |

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M-SERIE DCM 600 - 2000 3PH POWER & CONTROL
REFERENCE LIST

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Customer: **IST SURFACE**

Revised by: **LAURENT GOLDSCHMITT**
Date: 2019-11-06

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Revised by: **LAURENT GOLDSCHMITT**
Date: 2019-11-06

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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

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 Support 5656

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

