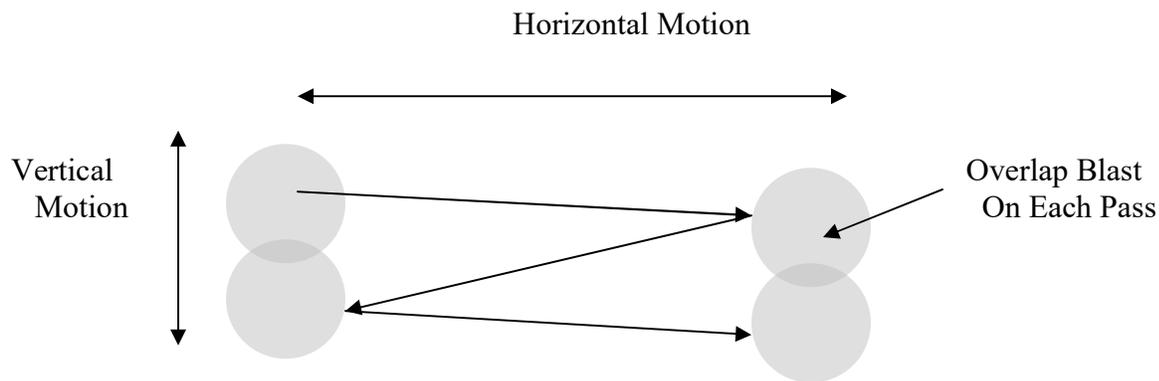


OPERATING INSTRUCTIONS FOR MODEL J AUTOMATIC SANDBLASTER

- Turn on 110 Volt power at electric disconnect switch on control panel.
- Turn on compressed air supply at hand valve on control panel. Check pressure regulators on control panel. Both should be set at 70 PSI.
- Adjust position of two horizontal limit switches.
- Adjust position of two vertical limit switches.
- Adjust horizontal speed control valve for approximately 2 seconds/foot travel speed of horizontal carriage. Operating speed should be fast enough to avoid burning stencil rubber.
- Adjust vertical speed control valve for approximately 2 minutes/foot travel speed of nozzle trolley. The vertical speed should be adjusted to provide an overlapping pattern on each horizontal pass.
- Ideal speed adjustments for horizontal and vertical provide the following nozzle motion



- The nozzle may be stopped at any position, however, operator should avoid stopping on a limit switch. Continuous contact with a limit switch will shorten life of reversing valve.
- Set tablet or marker a uniform distance from nozzle to ensure straight blasting of work.
- Start blasting with nozzle tip about 12" from face of work. Increase this distance if using a venturi nozzle, or over 100 PSI, or larger than 1/4" nozzle, or coarser than 36 grit abrasive. This distance can be decreased for faster blasting but only with careful experimentation.
- To ensure uniform blasting, allow nozzle to pass beyond lettering or other stencil patterns before reversing horizontal motion. A heavier blast will occur at the end of each stroke. Protect these areas with double stencil or end panels.
- Vertical position of nozzle trolley may be adjusted by sliding cable through wingnut clamp shown on Installation Diagram at Reference Point #6. This cable adjustment allows 30" vertical working height anywhere within 55" vertical span. Note: This adjustment not possible on models equipped with the Extended Motion Option.
- Extended Motion Option: Due to the increased vertical travel check the sandhose so it does not catch on anything in booth or is pulled too tightly.
- Park horizontal carriage at left end of track after use.

Always obtain the Material Safety Data Sheet (MSDS) for the abrasive to be used. The MSDS provides the chemical makeup of the abrasive. Do Not use abrasives containing toxic materials. Refer to OSHA 29 CFR for acceptable limits of various toxic substances and additional measures to be taken to protect operating personnel. Always use abrasives containing less than 1% of crystalline silica. Always use a NIOSH approved respirator while blasting, handling, loading and cleaning up abrasives.

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