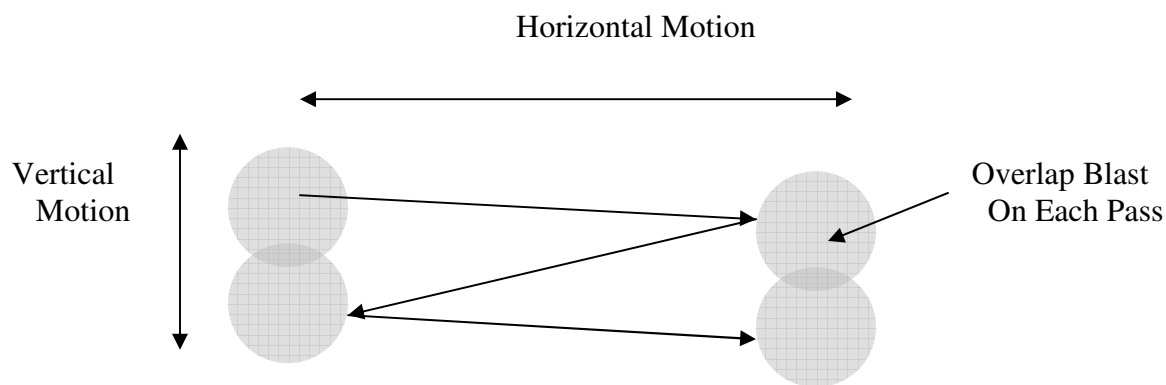


Operating Instructions for Model J Automatic Sandblaster

- 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 ¼" 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.

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