



TEXAS EQUIPMENT

Pressure Sandblaster Manual Installation and Operation

Website: [www. Texasequipment.ae](http://www.Texasequipment.ae)

Tel: + 971 6 552 9860

Fax: + 971 6 552 9861

Email: Info@Texasequipment.ae



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1 Description

1-1 Working principle

The machine adopts suction type sandblasting, which uses the compressed air to produce high-speed flow in the spray gun. The abrasive in the cyclone separator tank is sucked into the spray gun through the hose and then blasting sand on the surface of the workpiece with the compressed air flow. In order to achieve the effect of sandblasting processing.

1-2 The characters of machine

- A. Large sand-blasting volume, fast speed, strong impact.
- B. The machine is equipped with adjustable cyclone, it can separate the abrasives can be able to continue to use from the useless tiny dust, vacuum cleaner only absorb dust, it can greatly reduce abrasive consumption.
- C. The machine can be open the side door, the door size can be also decided by clients.
- D. The machine is the whole machine (dust, a pressurized tank and host).

1-3 Applications

- A. Plating need to do before sand-blasting to improve the adhesion.
- B. Cleaning: Casting pieces, stamping pieces and heat-treated pieces need to remove oxide, rust.
- C. Applying for medium and small parts (single and small batch production).
- D. It's suitable for high strength work piece.
- E. Clear up the oxide, glitch, dross of the heat treatment pieces and weldment. The quality of clearance is up to Sa2.5~ Sa3.
- F. Clear up the minor glitches and surface residues.
- G. Plating and cleaning need to do before sand-blasting to improve the adhesion.

1-4 Technical parameters

Working cabinet (L*W*H)	1200mm*1200mm*750mm
Voltage	380V 50Hz
Air Pressure	5-7bar(kg/cm ²)
Air Consumption (Approx)	2~3m ³ /min
Quantity of Process Gun	1pc
Load Capacity	≤60Kg
Motor for Dust Collector	1500W



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Machine Lighting	15W
Initial Media Charge (Approx)	5-10Kg
Weight of the machine (Approx)	300Kg

2 Installation

Sandblasting machine should be placed in the work site on the formation of a solid ground.

2-1 Air pressure source

The machine should be connected a 1.5-3(m³ /min) air compressor.

2-2 Voltage

The voltage is 380V,50Hz.

3 Preparation before Operation

Sandblasting machine should be placed on the formation of a solid ground.

3-1 Connect power

The voltage is 380V,50Hz. Connect power line to machine electric control cabinet.

3-2 Connect air pressure source

The machine should be connected with a 2-3 (m³ / min) air compressor. Adjust the pressure of air compressor below 8 bar, make Intake Gauge keep 4-7 bar.



3-3 Feed abrasive

Put abrasive into the cabinet from the mesh, the amount of abrasive is 5-10kg once.

Note you must add abrasive slowly and evenly.



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3-4 Adjust abrasive valve

Abrasive valve controls the amount of sand, you can adjust according to your actual condition. We usually adjusted before delivery.



3-5 Adjust regulator valve

Regulator valve controls the air pressure into the gun. We usually adjusted it before delivery. Usually Blast Gauge indicate 4-6bar when working.



4 Operating

4-1 Operate machine



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Turn on the power switch (green switch)	
Put your products on turntable then push small trolley into the cabinet, make sure to close the cabinet door and wait working.	
Make gun takes aim to products, treat lightly on the foot pedal, abrasive was blasted on the surface of the workpiece under the air compressor.	
When you are blasting sand, keep appropriate spray distance and angle between gun and workpiece, pls move slightly gun to make surface perfect, until you finished the working.	
After finished working, your foot remove from the foot pedal. Make sure that you open the cabinet door after you finished working, then take out the workpiece.	
When you take out the workpiece, you can use dust gun to clean the workpiece and sandblasting cabinet.	

Note: If you need to continue to working, don't turn off the power switch.

4-2 Adjust the intake valve

We usually adjusted before delivery. And you can also adjust according to your actual condition.



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4-3 Adjust the exhaust valve

The valve is in working, we usually adjusted before delivery.



4-4 Clean dust

Pls clean the dust per three hours. Operation: turn off the power switch, push the pulse for 10 times. Make the dust from the cartridge inside the dust collector fall down. Open the door and clean up.



5 Troubleshooting

Problems	Reasons	Solution
Abrasive is absorbed into dust collector bags	1.New dust collector 2.Small abrasive 3.Too much power of fan	1.It will disappear after 8 hours 2.Use bigger abrasive 3.Open ventilation door,



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		adjust the volume of wind
Abrasive fall down on the working area	Bad dust collector bag	Pls change the dust collector bag
Sight unclear when sandblasting	1.Bad dust collector bag 2.Too many dust in abrasive 3.High air pressure 4.The glass window is fuzzy	1.Clean bags by push and pull vibration valve or change bags 2.Change abrasive 3.Adjust air pressure 4.Change the glass window
Low efficiency	1.Low air pressure 2.Small nozzle 3.The abrasive used is useless(broken abrasive and too much dust)	1.Adjust to high air pressure 2.Change bigger nozzle,usually we use the nozzle of $\phi 8\text{mm}$ 3.Clear old abrasive and change new abrasive
Abrasive blasted is uneven	1.Too little abrasive 2.Low compressed air pressure 3.Nozzle is blocked 4.Wet abrasive	1.Add abrasive 2.Adjust high air pressure 3.Clean the nozzle 4.Remove the wet abrasive, add dry abrasive, check if there is water in gas pipeline

If you have any problem, don't hesitate to let me know!