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## THE PK36 Abrasive Finishing Blast Cabinet

**PLEASE READ INSTRUCTIONS BEFORE OPERATING THIS  
BLASTING SYSTEM.**

This blasting system incorporates a trigger gun system used primarily with glass bead, plastic granule or aluminum oxide abrasives. Other medias may be used. This unit needs a dust collector such as the DC1500 to assure proper media dust removal. Objects no greater than 150 pounds should be placed on the screen shelf inside the cabinet.

**WARNING:** Any blast unit will produce a powerful flow of abrasive particles. To avoid personal injury and property damage, read manual thoroughly before assembling, operating or servicing the unit. Use the unit in a controlled area where the expelled media and dust particles will not contaminate the atmosphere to be breathed or cause damage to the surroundings.

*Failure to follow these instructions could result in operator injury as well as void the warranty on the blasting system.*

- 9) Check the air supply line fittings and hose attachments to the rear of the trigger gun. Also make sure the media supply hose is attached tightly on the nipple on the underside of the trigger gun.
- 10) Place the media into the center of the hopper but do not cover the very top of the pickup tube where the rubber hose is attached.
- 11) With the air supply connected, all fittings and joints not leaking, and the unit plugged in, you are ready to test the trigger gun. Now follow these steps for startup operation.
  - a. Place the part in the cabinet. Always close and latch the lid prior to blasting. Severe injury to the skin and eyes may result from exposure to the blast stream.
  - b. After inserting your hands into the gloves, grasp the gun and depress the trigger. This should begin the blasting flow. If no flow is seen you may need to clear the pickup tube by covering the gun nozzle momentarily or check that the lid has closed and the safety valve is fully depressed.
  - c. Now you may begin finishing the part. You should move the blast stream continuously over the part in an even circular motion. The flow should not be too hard or concentrated to avoid undesirable peening.

**MAINTENANCE - NOTE: Disconnect power and air before performing any maintenance.**

All blasting systems need to be operated with a dust collection system to protect the operator and keep the workplace safe. Blasting systems are prone to plugging up or wear because of the abrasive material used and the applications. The following items should be checked as indicated.

**PLUGGED CONDITIONS** - The blast nozzle may become plugged with moist or too coarse of media. Cover the end of the nozzle with your gloved finger and operate the gun. This will blow media back through the pickup tube, keep the cabinet lid closed. If the pickup tube appears to be clogged with media this same procedure should be followed. If the media does not clear the nozzle, try dislodging the media with a drill bit held in your hand and inserted into the nozzle. You may need to get rid of the moist media.

**WEAR CONDITIONS** - This is evident when an excessive amount of dust is present in the cabinet. Dust will occur if:

1. The abrasive media is worn out. If it has lost its granular or spherical appearance or has a lot of debris from the parts being blasted mixed in. Replace it. This is usually noticed when the abrasive media that exits the nozzle looks like a smoke cloud instead of a stream.
2. A dust collector needs to be connected to the system so that excessive dust does not build up in the cabinet and blow out the vents.
3. The gun parts do wear with use. This is evident when the blast pattern is too wide and ineffective. On the trigger gun - the orifice and nozzle should be replaced by loosening the set screws on the gun assembly and disassembling. Note the location and condition of the "o" rings on the orifice. Proper installation is important.
4. The mylar shields on the bottom side of the lid may become cloudy or scratched after many uses. This may be peeled off and another shield installed. We do not recommend using the system without this shield as the lid will scratch from the abrasive easily. If you need to replace any of the items for this system, please refer to the parts list included with this manual and call your local dealer.

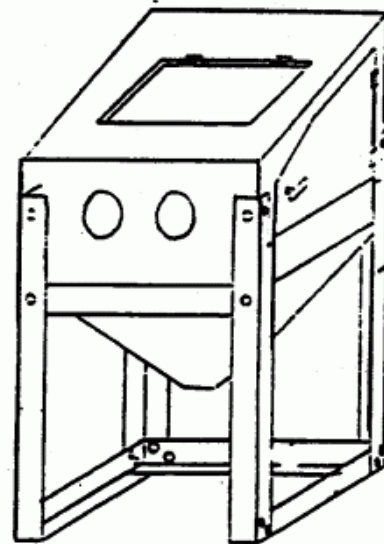
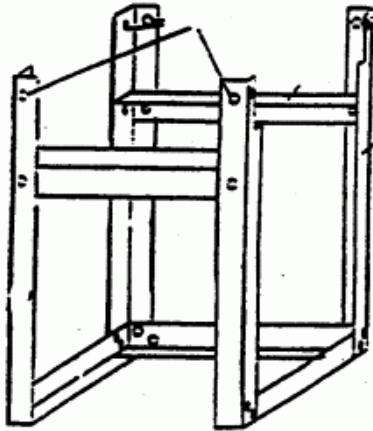
**BEFORE YOU START- DON'T** - Your PK36 blast cabinet system is designed to clean, polish, and finish with dry abrasives only. **Do Not** introduce fluids into the system for any reason. **Do Not** operate the unit with the lid or side door open. Severe injury to skin and eyes may result. **Do Not** use over 70 watt light bulb.

**DO** - On delicate parts, start out with minimal air pressure to avoid unnecessary peening or excessive abrasion. Your blasting system is equipped with a 3-prong grounded plug for protection against shock. When connecting your unit, obey all applicable electrical and safety codes including the National Electric Code (NEC) and the Occupational Safety and Health Act (OSHA). The blasting system should be plugged into an adequately grounded 3-prong receptacle. If only a 2-prong receptacle is available, have it replaced with a proper receptacle that meets the national and local codes or ordinances. Only a qualified electrician should perform this work. A grounded adapter can be used. Make sure the green lead from the adapter is properly attached to a suitable electrical ground. **NOTE:** The Canadian Electrical code prohibits the use of 3-prong adapters.

*Do clean up any spilled media because it is very slippery.*

## Assembling the PK36

- 1) Separate leg parts. (2 Side Leg Sets, 3 Single Braces)
- 2) Place 1 single brace on the floor between the 2 side leg sets. (Pay attention to the leg sets as one side is especially made to accommodate the door of blaster). Fasten brace to the leg sets with the 1/4-20 nuts, lock washers & bolts provided. Finger tighten.
- 3) Place the remaining braces between the leg sets (toward the top of the assembly are holes to fasten). Use remaining 1/4-20 nuts, lock washers & bolts. Finger tighten.



- 4) Place blast cabinet into leg assembly. (Make sure door side of blaster & door side of leg assembly line up).
- 5) Screw self tapping screws provided into cabinet in alignment with holes in leg assembly. Draw cabinet tight into legs.
- 6) Tighten all leg bolts securely to make the frame and cabinet solid.
- 7) Place the blast cabinet near a 115v/60Hz AC electrical outlet. Make sure the receptacle will accept the 3-prong plug so that the unit will be properly grounded. Also check to make sure the power source is adequate for use with this blast system. An electrician should be consulted if the proper outlet is not available or if the user in any way questions the condition of the electrical circuit.
- 8) Attach the air supply line from a compressor capable of maintaining 5 cfm at 80 psi to the inlet connection of the lid safety valve assembly found on the left side of the cabinet. Because of the variation in air supply systems, the air inlet coupling is not provided. Use the particular fitting that is compatible with your air supply system. **DO NOT OPERATE THE BLASTING SYSTEM OVER 100 PSI.**

# CYCLONE MFG. WARRANTY

This blasting system is warranted against defects in workmanship of materials in accord with the following terms and conditions:

1. Warranty extends to the original user only and does not cover cabinets used in commercial rentals.
2. Warranty on the cabinet and the equipment in the cabinet is valid for a period of one year following the date of purchase.
3. Warranty on the dust collector, if one is supplied, is 90 days.
4. Warranty does not cover maintenance items subject to normal wear, such as: nozzles, orifices, mylar shields or blasting media.
5. Warranty does not cover misuse from lack of proper maintenance or operation not in compliance with these instructions.
6. Warranty does not apply to damage in transit. In case of such damage, proper claims should be filed.

User should call the factory in the event of defective parts. **The parts will be repaired or replaced at the manufacturer's discretion.** This warranty grants the user certain legal rights. Users and purchasers may also be protected by other rights which vary from state to state.

**NOTE: Except for warranties set forth above, the manufacturer makes no other warranties of any kind, expressed or implied, including warranties of merchantability or fitness of a product for a particular purpose.**

## Replacement Parts List & Accessories Listing

* 2022	18" rubber Gloves	7002	5 CFM Trigger Gun Assembly
2048	Mylar Shields (pack of 12)	7009	5 CFM Ceramic Nozzle
* 2049	Complete Lid Assembly	7076	5 CFM Steel Orifice
* 7001	14 CFM Trigger Gun Assembly	7080	5 CFM T. C. Nozzle
7011	14 CFM Ceramic Nozzle	2005	Glove Clamps
7077	14 CFM Steel Orifice	2016	3" Vent
7080	14 CFM Tungsten Carbide Nozzle	2013	Air Hose
2031	Foot Valve Assembly	2015	Pick Up Tube Assembly
7006	Gun for Foot Valve Assembly		*Standard items on cabinet
2023	24" Rubber Gloves		