

HEALTH AND SAFETY

NOTE: NEVER USE THE BLASTING GUN OUTSIDE OF THE CABINET AND NEVER POINT THE GUN TOWARD YOURSELF OR ANYBODY ELSE. THE DOOR(S) MUST ALWAYS BE CLOSED WHEN STARTING BLASTING OPERATIONS. DO NOT AIM THE GUN AT THE SIGHT GLASS, THE GLASS WILL BECOME WEAKENED IF HIT BY THE GRIT. ALWAYS USE HARDENED GLASS.

THE BLASTING GUN SHALL NOT BE USED AS A HAMMER.

ALWAYS AIM THE GUN AT THE OBJECT TO BE BLASTED. THE BLASTING GRIT EJECTED FROM THE GUN HAS A VERY HIGH VELOCITY AND CAN CAUSE SEVERE INJURIES.

ENSURE THAT SEALS AND CUFFS ARE INTACT AND THAT THE DOOR(S) ARE CLOSED BEFORE COMMENCING BLASTING. ALWAYS WEAR PROTECTIVE GLOVES WHEN BLASTING.

WHEN CHANGING FILTERS AND CLEANING THE MACHINE, REMEMBER THAT THERE MAY BE HARMFUL SUBSTANCES IN THE FILTERS AND THE MACHINE, ACT ACCORDINGLY WHEN HANDLING HARMFUL WASTE, FOLLOW ANY OFFICIAL REGULATIONS.

WHEN CHANGING FILTERS ENSURE THAT THEY ARE MOUNTED SQUARELY AND THAT SEALS AND GASKETS ARE INTACT. WRONGLY FITTED FILTERS, CUFFS AND SEALS MAY ALLOW HAZARDOUS DUST TO ESCAPE INTO OPERATOR'S AREA AND THE ENVIRONMENT.

WHEN CLEANING THE MACHINE, USE SUITABLE PROTECTIVE EQUIPMENT, ESPECIALLY IF HARMFUL SUBSTANCES ARE SUSPECTED.

EVERY NEW MACHINE OPERATOR MUST BE AWARE OF THE MACHINE'S FUNCTION AND HOW TO PERFORM WORK SAFELY WITH REGARD TO THE HEALTH AND SAFETY HAZARDS PRESENT.

TRANSPORT

From Model 700 and upwards, there are two TRANSVERSE lifting beams on the machine. All lifting shall be from the right side. LIFTING SHALL BE PERFORMED WITH LONG LIFTING FORKS THAT REACH ACROSS THE MACHINE. NOTE: SOME MACHINES ARE TOP HEAVY AND MUST BE HANDLED ACCORDINGLY.

ELECTRICAL CONNECTION

Make certain that a qualified electrician performs all electrical work.

An earthed plug can be used. If the machine is permanently installed, it must be bolted to the floor. From Model 1100 and upward there holes in each foot. On other models, fixing eyes can be attached to the transverse lifting beams.

On models with a collection box on the door, fit this with the door held open. There is a recess in the leg framework provided to take the box.

COMPRESSED AIR CONNECTION

Apply a suitable air nipple. Depending on the model, it should be connected to the foot pedal valve or main valve. **Use Teflon sealing tape.**

If a filter-regulator is included, it must be fitted as close to the machine as possible. (Check the filter-regulator type against the proposed air consumption, see specification for actual model.)

NOTE: DO NOT CONNECT AN OIL-MIST LUBRICATOR. THIS WOULD RUIN THE BLASTING GRIT AND MAKE A GOOD RESULT IMPOSSIBLE.

Be certain to use as clean and dry air as possible.

A WATER SEPARATOR IS RECOMMENDED.

Some types of blasting grit and media may require a reduced air pressure in order to avoid damage to the surface.

Ask your supplier for advice on this.

Make certain that the air line to the machine is adequate. Inadequate air capacity will worsen the blasting results.

BEFORE COMMENCING BLASTING operations, make sure that sealing strips and cuffs are intact and the door(s) are closed.

NOTE: NEVER OPERATE THE BLASTING GUN WITH THE DOOR OPEN.

On machines with foot pedal operation, there are two pedals of which one is a **SAFETY INTERLOCK**. Both pedals must be depressed together to allow operation of the **BLASTING GUN**.

ALWAYS WEAR PROTECTIVE GLOVES WHEN BLASTING.

BLASTING AGENT

The blasting agent is poured either directly into the cabinet or into the container provided on certain models.

When choosing blasting agent: Take the advice of your supplier and refer to the list of suitable blasting agents for each machine.

When changing blasting grit, perform a **NEW START** operation on the machine. The machine shall be cleaned whenever a new or other type of blasting grit is used.

NOTE: USED BLASTING GRIT CAN CONTAIN HARMFUL SUBSTANCES; THE SAME APPLIES TO REMNANTS FOUND INSIDE THE MACHINE. IF THIS IS SUSPECTED, SUITABLE PROTECTIVE EQUIPMENT MUST BE USED AND ANY OFFICIAL REGULATIONS MUST BE FOLLOWED.

Always wear eye protection when performing blasting!

Operation of Blasting Cabinet

Always wear eye protection when handling blasting agents. The cabinet is fitted with a hardened sight glass for resistance to blasting grit wear. The foot pedal is fitted with an interlock, the entire foot must be placed on the foot pedal in order for air to be supplied to the gun.

When blasting, the optimum angle for the gun is 45 degrees and one should blast so that the jet is kept away from the sight glass. Certain blasting grits are very aggressive and can wear out the sight glass very quickly if the blasting gun is used incorrectly. Aluminium oxide belongs to the family of aggressive agents and is therefore also very effective for surface cleaning.

When blasting with glass beads

Lower the working pressure to approx. 4 bar, since the glass beads can otherwise be damaged with air pressures above 4 bar.

One should also set the switch to position 2, one or both motors (depending on model) for dust extraction. The under-pressure in the cabinet will then be lower and there will be less risk of glass beads finding their way into the filter.

The lower damper that is fitted above the grit container should be opened $\frac{1}{4}$ or completely closed, depending on the type of glass beads used.

Blasting with corundum (Aluminium oxide)

Working pressure 3-8 bar.

Switch in position 3 (both suction motors on)

The damper above the grit container should be completely open. With very small corundum 0.1 – 0.4 mm, the damper should be closed to $\frac{1}{4}$ or completely, depending on how clean the blasting object is.

For example, for painted/rusty objects, the damper can be set to $\frac{1}{3}$ open. When blasting clean surfaces, one can have the damper completely closed. In general, the finer the blasting grit, the more closed the damper should be. However this is a judgement that must be made from case to case.

The suction capacity can also be adjusted by setting the switches to position “2” which reduces the suction by about half.

However, when blasting very rusty or painted objects, paint/rust may loosen and block the gun, in which case one should open the damper completely to achieve maximum cleaning of the blasting agent. One should also clean off the strainer at the bottom of the machine regularly to prevent stoppages. The filter bag can contain about 4 kg of particles and should be sorted as combustible/hazardous waste depending on the object being blasted. The blasting grit itself is not harmful, but can be once mixed with parts of the media.

*Operation of ILB Blasting cabinets
Kungälv 2002-02-06*

Filling with new blasting agent

The blasting agent is poured into the Cyclone or into the cabinet. Maximum quantity is approx. 25 kg. The working pressure varies depending on the type of blasting agent used. For Glass Beads, the max pressure is 4 bar, higher pressure causes the beads to be crushed to dust. When using aluminium oxide the working pressure varies between 2 to 7 bar, one must test to find the “best jet” depending on the grit size, the normal pressure is between 4-6 bar.

Emptying the blasting media

Simply remove the bottom plug from the Cyclone and let the blaster media run out into a suitable container. One should also remove the upper part of the Cyclone and clean the strainer from collected debris.

Stoppages

Larger flakes of paint and other foreign objects can fasten in the suction pipe and stop the blasting gun. To prevent this, the machine strainer should be cleaned regularly to prevent stoppages. If a stoppage occurs, first unscrew the nozzle to see if there is anything stuck inside. If this solves the problem, just screw the nozzle back on again. If this does not solve the problem, refer to the description above concerning emptying the blasting media.

Service & Maintenance

Perform a simple service about once per week, where the filters, blasting agent and sight glass are inspected. Once per month, inspect the sealing cuffs for integrity and also blaster hoses and blaster nozzles. Every 6 months, check that all valves function, including any foot pedal and interlock. The bottom section that is screwed in place beneath the sumps should be checked for integrity, since the blasting grit wears heavily on it.

Blasting agent

The blasting agent should be replaced once the sight starts to become poor or it does not “run down” to the suction pipe easily. If this is not done, there is a risk that the filters will become full, which will increase the filter cost. You can check the quality of the blasting agent by simply pushing a finger down into the pile – this should be easy with a high quality agent. A blasting agent that is past its best will have a much higher resistance in the procedure above.

The above is an example of the maintenance necessary to ensure that your machine functions as well as possible.

GLASS BEADS Micro-pearls

GLASS BEADS – A polishing and cleaning agent. Used for free jet blasting or in a blasting cabinet, “hammer” off surface coatings and peen microscopic undulations without actually abrading any of the material. Excellent on stainless steel, glass, steel and aluminium.

Glass beads are made from soda glass and have a high resistance to impact and shock.

Manufactured with high precision and careful inspection of bead shape and hardness, which ensures high and even quality of the glass beads. The agent is recyclable. Recommended for nozzle air pressures of 1–4 bar.

D 0.420-0.840 mm

AC 0.150-0.250 mm

AH 0.045-0.085 mm

C 0.250-0.420 mm

AF 0.075-0.150 mm

AK 0.001-0.050 mm

BLASTING GRIT Aluminium oxide

An abrasive grit for free jet blasting and blasting cabinets. Aluminium oxide provides an effective treatment that is often used to achieve good adhesion. Good for all types of material, primarily stainless steel, glass, stone and aluminium. The grit does not generate an electromagnetic charge or corrosion.

Aluminium oxide is hard and tough. The sharp crystals retain their efficiency through their entire life and are superior when blasting other hard materials. The agent is recyclable.

K 4 0.8-1.0 mm

K 7 0.2-0.4 mm **Blasting corundum is available in sizes from**

0.001-3 mm

K 5 0.6-0.8 mm

K 8 0.1-0.2 mm

From K 1 to K 10

K 6 0.4-0.6 mm

Also available in white.

STEEL CORUNDUM

An aggressive abrasive agent for use in free jet blasting and pressure blasting cabinets. Steel grit is generally used industrially for blasting forged, cast and rolled goods. Steel grit is sharp. Thanks to the many sizes available, it is easy to adapt to most types of blasting work. It provides rapid and efficient abrasion.

Steel grit is made from melted pig iron that is granulated, heat treated and sieved under carefully controlled conditions. The agent is recyclable. Recommended for PRESSURE BLASTING.

E.g. G-07=0.20-0.40 mm. Available in sizes from 0.10 to 1.70 mm.

STAINLESS STEEL GRIT (INOX Cr)

An abrasive and cleaning agent for use in blasting cabinets or centrifugal blasting. Stainless steel grit provides a more aggressive surface than Stainless steel shot. Stainless steel grit is an exclusive agent that is best suited to aluminium and stainless steel materials. Applications that put great demands on the cleanliness of the surface.

Stainless steel grit is superior to normal Steel grit on aluminium and stainless steel. The agent is recyclable. Recommended for PRESSURE BLASTING.

E.g. Inox Cr 30=0.15-0.50 mm. Available in sizes from 0.05 to 3.30 mm. There are also a number of other blasting materials.



FILTER REPLACEMENT

Blasting cabinet models ILB 625, 775, 1100, 1200 and Sahara

ITEM

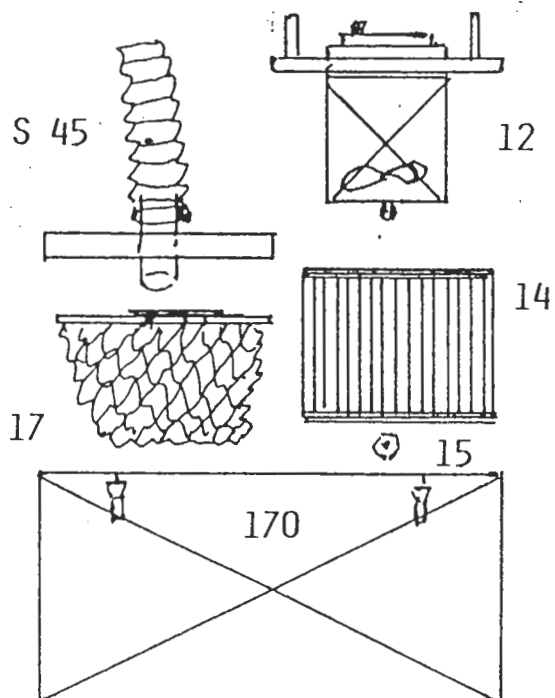
170	Filter Housing
12	Fan Motor
S45	Suction hose & filter lid
15	Micro filter lock nut
14	Micro filter
17	Coarse (Pre-) filter

COARSE (PRE-) FILTER nr. 17

Open the two latches, lift the filter lid and the suction hose straight up. Lift out and discard the filter. Replace it with a new filter, then replace the lid and close the latches.

MICRO FILTER NR. 14

Open the two latches securing the fan motor, lift the motor with the filter attached straight up, then turn the unit upside down. Release nut 15, remove the filter, check the condition of the gasket and replace the filter with a new one. Replace nut 15, make certain that the filter makes a good seal against the gasket and replace the package carefully. Close the latches.



NOTE: If there is a risk that the filters may contain harmful substances, they must be handled accordingly.

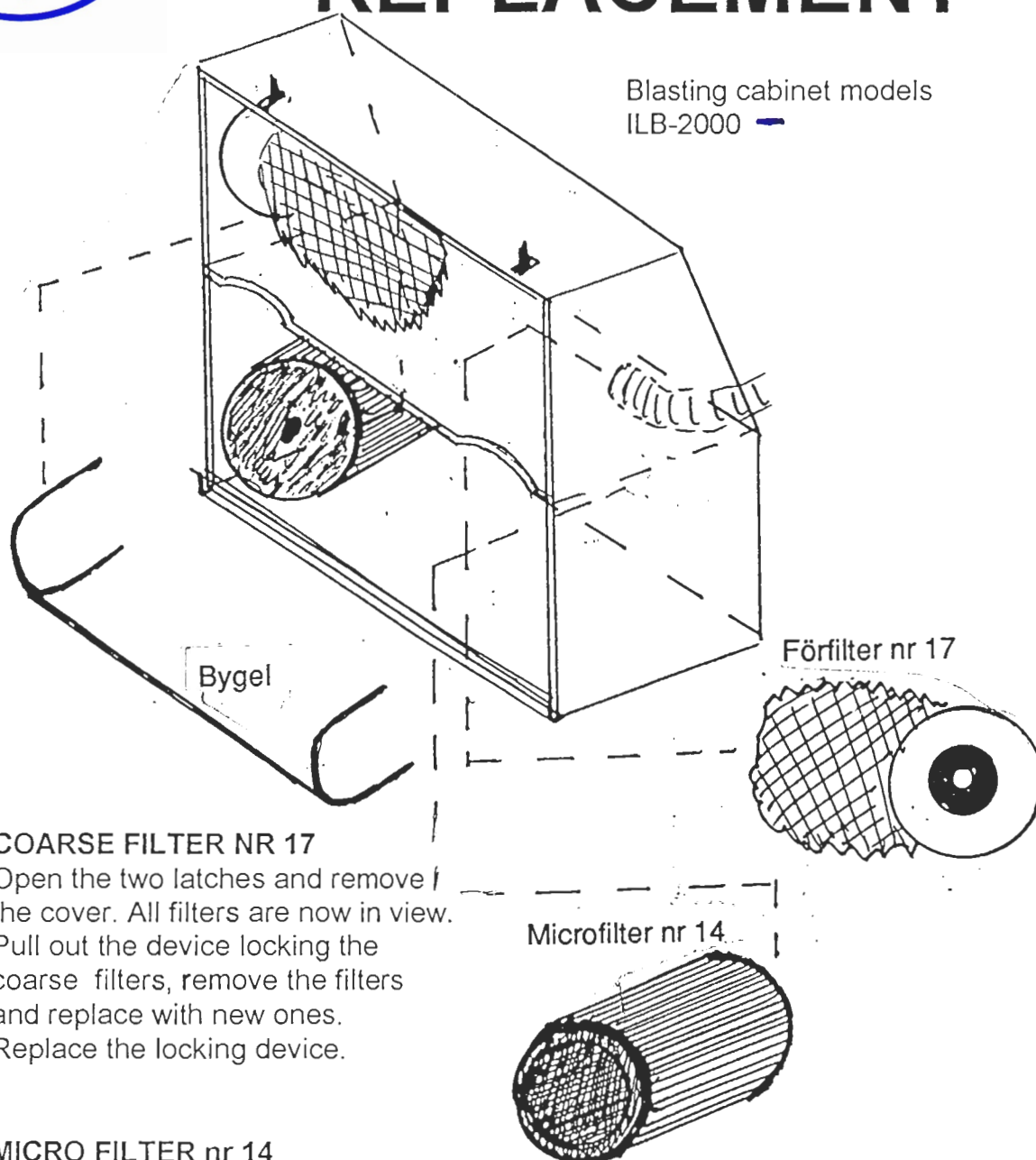
In case of electrical problems always refer to a qualified electrician.

NOTE: Only original spare parts may be used.



FILTER REPLACEMENT

Blasting cabinet models
ILB-2000 —



COARSE FILTER NR 17

Open the two latches and remove the cover. All filters are now in view. Pull out the device locking the coarse filters, remove the filters and replace with new ones. Replace the locking device.

MICRO FILTER nr 14

Unscrew nut 15, pull the filter out. Bring the new filter into position carefully and refit the nut. Make certain the filter sits squarely and seals well against the gasket. Both micro filters should be changed at the same time.

NOTE The filters may contain harmful substances and will then have to be handled accordingly.

In case of electrical problems refer to a qualified electrician.

NOTE: ORIGINAL FILTERS AND SPARE PARTS ONLY MAY BE USED.

Contact your supplier for help and advice in case of problems.



ILB-MASKINER
Kungälv

EXHAUST AIR VALVE

On some models there is a valve fitted in the lower exhaust air line. This valve can be used to reduce the flow of exhaust air when a fine grained blasting grit is being used. The object is to avoid the blasting grit being exhausted to the filter. See recommendations in the list of blasting grits.

GENERAL ON OPERATION AND MAINTENANCE

Replace the filters as shown in previous pages. Keep in mind that the filters may be contaminated by harmful substances. Make certain that all gaskets as well as the cuff seals and the strip seals are in place and in good shape. Use only the genuine spare parts and filters.

Check the BLASTING GUN regularly: a worn or defect air nozzle or blasting nozzle can cause damage to the gun. See the drawing of the gun. The gun is of ejector type.

SIGHT GLASS

The sight glass is of 4 mm hardened glass and is fitted in a rubber strip of Za type. When replacing the sight glass, use the PLASTIC tool provided. Do not use any metal objects when fitting the sight glass. Lubricate the rubber strip with liquid soap to facilitate the job.

ELECTROSTATIC CHARGES

These may occur in some cases through friction of the blasting agent against the nozzle or the object being cleaned. The charges can be made harmless by grounding the blasting gun. Your electrical installation supplier can make any necessary arrangements.

Before commencing the blasting operation, make certain that the strip and cuff seals are undamaged and that the door is closed.

NOTE: NEVER OPERATE THE BLASTING GUN WITH THE DOOR OPEN OR WITHOLUT WEARING PROTECTIVE GLOVES.

SAFETY CATCH: On models with pedal operation there is a safety catch , e.g. the two pedals both have be depressed for the main valve to open.

BLASTING GRIT/GLASS BEADS

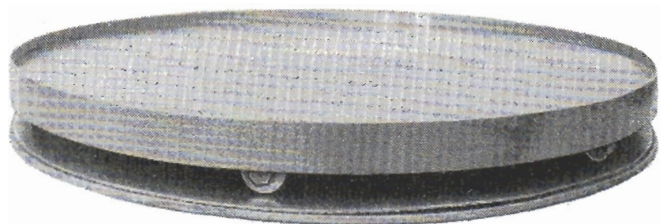
This is to be poured either into the cabinet or into the container provided on some models. To choose type of blasting grit, get the advice of your supplier and also see the list in this manual.

Whenever the blasting grit is changed, the machine should be cleaned.

NOTE: USED BLASTING GRIT MAY BE CONTAMINATED BY HARMFUL SUBSTANCES. IF THIS IS SUSPECTED, SUITABLE PROTECTIVE EQUIPMENT MUST BE USED AND ANY OFFICIAL REGULATIONS MUST BE FOLLOWED.



Tillbehör ILB Bläster



ILB 501. Vridplatta 500 Ø mm Till alla mod. över 1100.



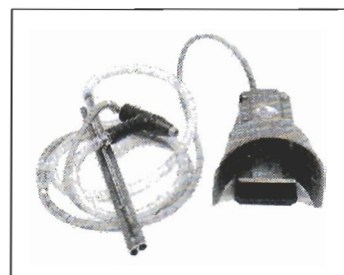
ILB 515. Filter-regulator med manometer. Alla mod. Ange L/min.



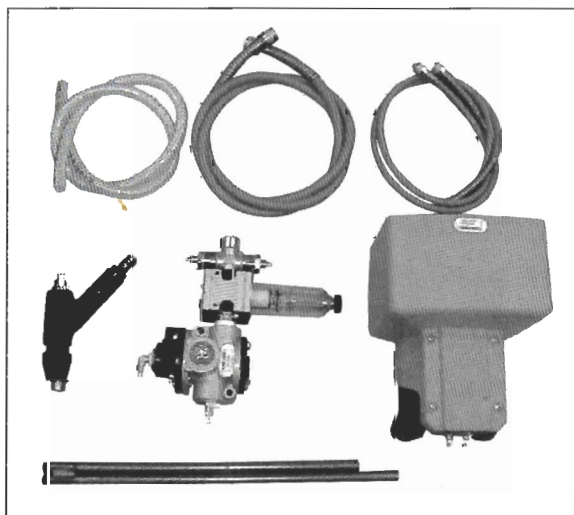
ILB 17. Förfilter till alla ILB-sugkällor.



ILB 14. Microfilter till alla ILB-sugkällor.



ILB 521-10KPL. Ca 1000 L/min. Komplet stort blästerpistol med fotmanöver.



ILB 521-15KPL. Ca 1500 L/min. Komplet stort blästerpistol med fotmanöver.



ILB 521-10. Separat blästerpistol ca 1000 L/min.

ILB 521-15. Separat blästerpistol ca 1500 L/min.

ILB 511. Extra blästermedelbehållare. Till alla mod. över 1200.

ILB 340. Förfilter till sugdel 340.

ILB 28. Sikruta blästerkabin 4-pack.

ILB 26. Tygmanschetter par.

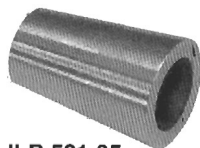
ILB 25. Handskar par.

ILB 520. Renblåsningspistol. Komplet med slang och nippel.

ILB 521-37. Nippel till blästerpistoler 521-10 och 521-15.

ILB 523. Liten blästerpistol med pistolavtryck ca 400L/min.

ILB 523-45. Nippel till pistol 523.

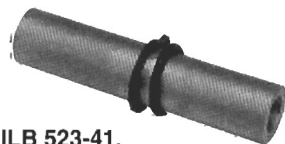


ILB 521-35. Blästermunstycke stor pistol 521.



ILB 521-36-4. Luftdysa till blästerpistol 521-10.

ILB 521-36-5. Luftdysa till blästerpistol 521-15.



ILB 523-41. Blästermunstycke till pistol 523.



ILB 523-42. Luftdysa till pistol 523.



ILB-MASKINER
Kungälv

SPARE PARTS LIST

ACCESSORIES AND CONSUMABLES FOR ILB SAND BLASTING EQUIPMENT

Item	For model:	3000	2200	2000	1500	1200	1100	775	700	625	600
Coarse (Pre-) filter	Nr 17	X	X	X	X	X	X	X		X	
Coarse (Pre-) filter	340	For 1200 S & Special									
Micro filter	14	X	X	X	X	X	X	X		X	
Cuff seal, pair	26	X	X	X	X	X	X	X	X	X	X
Gloves, pair	25	X	X	X	X	X	X	X	X	X	X
Sight glass pane, 4 pcs	28	X	X	X	X	X	X	X	X	X	X
Light glass pane, 2 pcs	27	X	X	X	X	X	X	X	X		
Fluor. tube, 230 V 18W	34	X	X	X	X	X	X	X	X		
Fan motor 240 V 850W	12	X	X	X	X	X	X	X		X	
Sealing strip 15/20-4	51	X	X	X	X	X	X	X	X	X	X
Glass pane seal L/m	62	X	X	X	X	X	X	X	X	X	X
Tube 45 mm	S45	X	X	X	X	X	X	X		X	
Tube PVC 10 mm L/m	44	X	X	X	X	X	X				
Tube PVC 8 mm L/m	46							X	X	X	X
Tube blue 12-10 Lm	50	X	X	X	X	X	X				
Tube blue 10-8 Lm	48	FOR EARLY MODELS ONLY									
Tube blue 8-6 Lm	49	X	X	X	X	X	X	X	X	X	X
Blasting gun 521-10						X	X				
Blasting gun 521-15		X	X	X	X						
Blasting gun 400 I	523							X	X	X	X
Pedal valve 68-10	68					X	X				
Pedal valve 69-15	69	X	X	X	X						
Ejector 1001	521	X	X	X	X	X	X				
Ejector 1003	523							X	X	X	X
Blasting nozzle 521	35	X	X	X	X	X	X				
Air jet 521-10	36-4					X	X				
Air jet 521-15	36-5	X	X	X	X						
Tube attachment 521	37	X	X	X	X	X	X				
Blasting nozzle 523	41							X	X	X	X
Air jet 523	42							X	X	X	X
Tube attachment 523	45							X	X	X	X
Gun kit 521-10 complete						X	X				
Gun kit 521-15 complete		X	X	X	X						
Light unit complete	503	X	X	X	X	X	X	X	X		
Pedal 68 & 69	68TR	X	X	X	X	X	X				
Turntable	501	X	X	X	X	X	X				
Blasting agent container	511	X	X	X	X	X					
Air pressure regulator	515	X	X	X	X	X	X	X	X	X	X
Throttle + 2 adaptors	502	X	X	X	X						
Cleaning air gun compl.	520	X	X	X	X	X	X				
Paint trap kit	A 85	FOR PAINTING CABINET ILB 200 & 300									
Tube attachm. incl. spring	63	X	X	X	X	X	X	X	X	X	X
T tube 1/4" - 3/8"	67	X	X	X	X	X	X				



TRANSPORT

All operations involving lifting the blasting cabinets must be performed from the right hand side, using a lifting device with forks long enough to reach across the width of the machine.

NOTE Some machines are top heavy and must be handled accordingly.

On models with a collection box under the door, fit this with the door held open. There is a recess provided to take the box.

ELECTRICAL CONNECTION

The machine must have a reliable earth connection for operator safety. The connection can be from a socket, appropriate for the power required, or the machine can be permanently connected, in which case it will have to be bolted to the floor. For this purpose there are holes in the feet of models 1100 and bigger; the other models will have to be held down by means of the lifting beams.

Make certain that a qualified electrician performs any electrical work.

COMPRESSED AIR CONNECTION

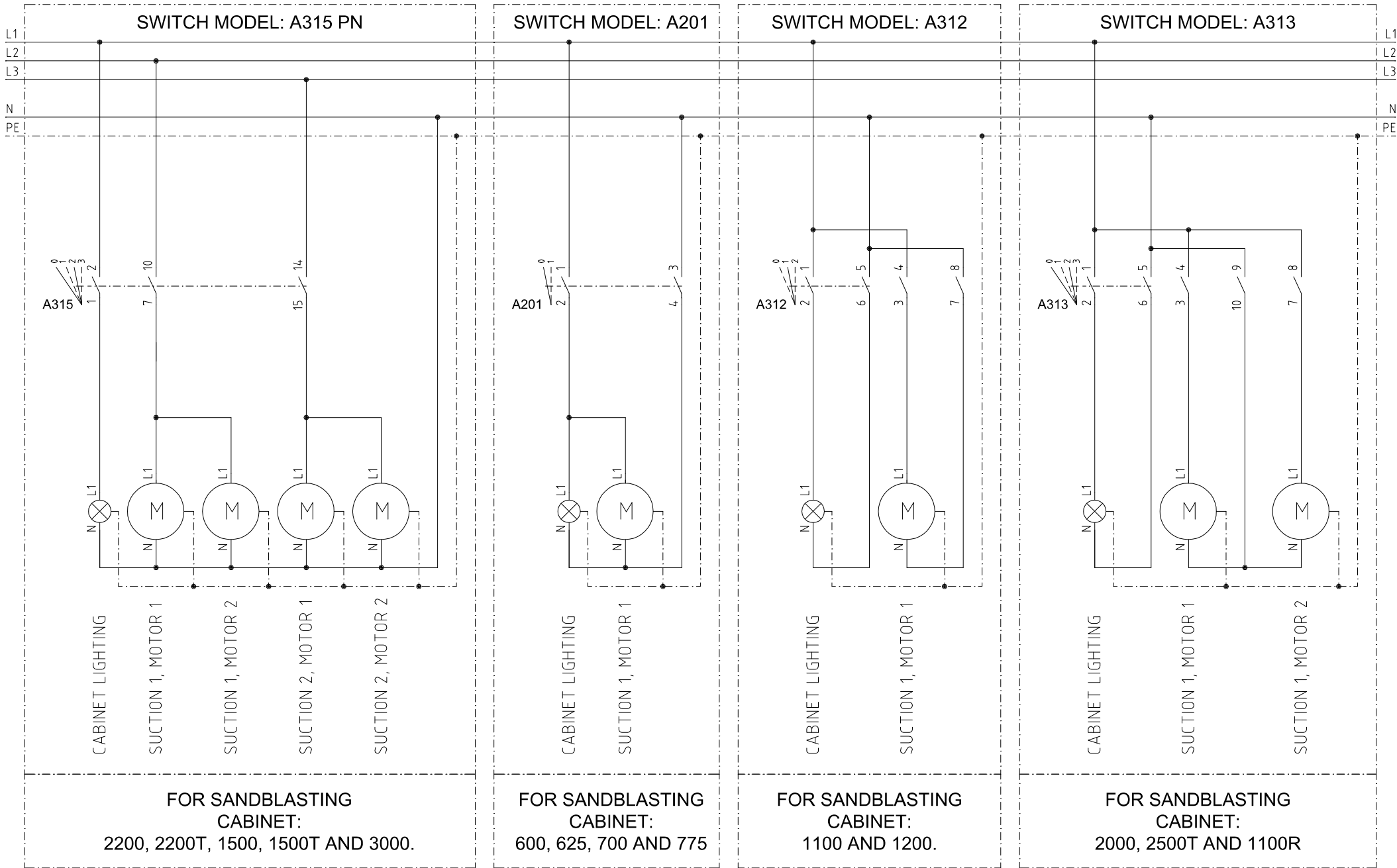
The compressed air connection is to the foot valve or to the main valve, according to model. Use teflon sealing tape on any threaded parts.

If a filter-regulator is included, it must be fitted as close to the blasting cabinet as possible, in order to ensure removal of any condensate. Check the filter-regulator type against the proposed air consumption, see specifications. Be certain to use air as clean and dry as possible.

NOTE: no tool lubricator must be connected in the air line to the machine. The oil would ruin the blasting grit (or glass beads etc.) and make a good result impossible. A condensate trap in the air line is highly recommended.

Some types of blasting grit as well as some types of work surfaces may require a reduced air pressure in order to avoid damaging the surface. Ask your supplier for advice on this.

Make certain that the air line to the machine is adequate. If the pressure indicated on the regulator gauge drops significantly when the gun is operated, the air line may be of inadequate capacity.



FOR SANDBLASTING CABINET:
2200, 2200T, 1500, 1500T AND 3000.

FOR SANDBLASTING CABINET:
600, 625, 700 AND 775

FOR SANDBLASTING CABINET:
1100 AND 1200.

FOR SANDBLASTING CABINET:
2000, 2500T AND 1100R

For Support Please Contact Us:
ILB Maskiner Development AB
Svarvaregatan 21
S-442 34 Kungälv
Sweden
info@ilb-maskiner.se



SANDBLASTING CABINET
Installation Intruccion

ILB-Maskiner Development AB

ARBETSNUMMER	RITINGSNUMMER	
	10032201-100	
KONSTRUERAD AV	RITAD AV	BLAD
M.B.	A.G.	100
DATUM	REV.	FORTS.
2010-03-22	X	--

NR.	ÄNDRING	SIGN.	DATUM