PRO-FINISH SPECIFICATIONS

Standard Cabinets (Letters following model numbers: S = Suction; P = Pressure; B = Bag; C = Collector; R = Reclaimer)

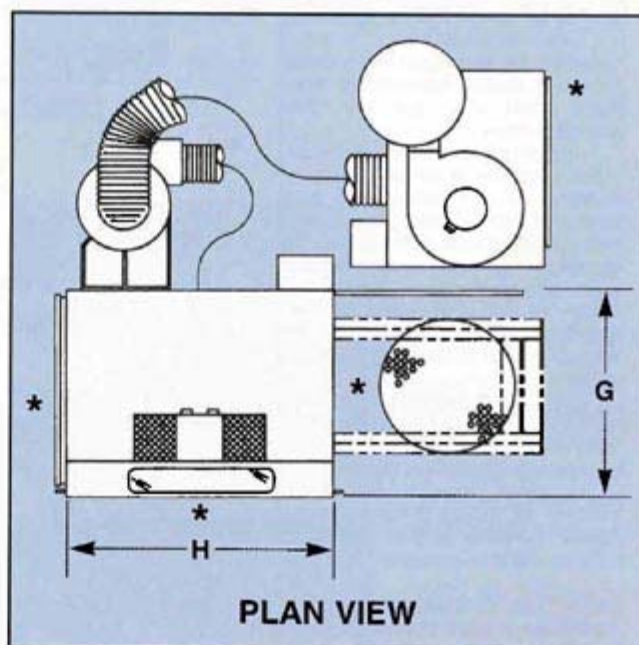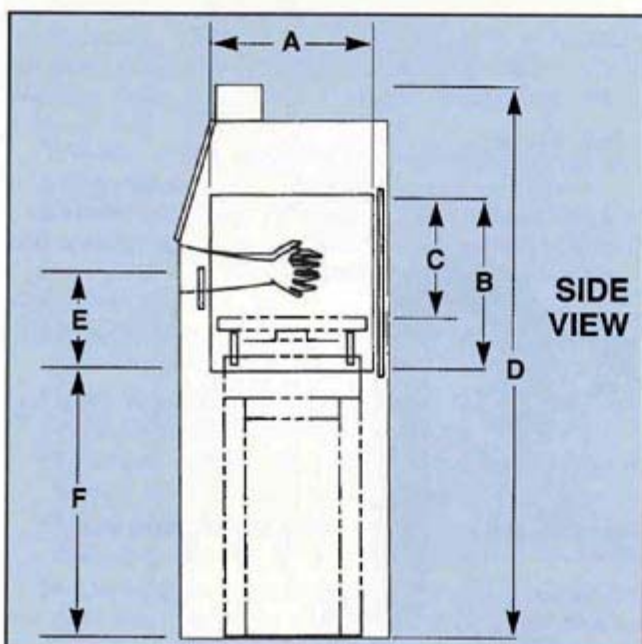| MODEL NUMBER	PART NUMBER	NUMBER OF DOORS[1]	RECLAIMER VENTILATION[2]	DUST COLLECTION[3]	BLOWER MOTOR[4]	SHIPPING WEIGHT
2636 SB	102010	1 standard		Dust bag	1 hp	421 lbs
3648 SB	103010	2 standard		Dust bag	1 hp	539 lbs
3696 SB	106010	2 standard		Dust bag	(2) 1 hp	1078 lbs
2636 SC	102011	1 standard		DCM-80A	1 hp	671 lbs
3648 SC	103011	2 standard	(Not applicable)	DCM-80A	1 hp	789 lbs
4848 SC	104011	2 standard		DCM-200	1-1/2 hp	1376 lbs
6060 SC	105011	2 standard		DCM-200A	2 hp	1669 lbs
3696 SC	106011	2 standard		DCM-80A	(2) 1 hp	1578 lbs
60120 SC*	107011	2 standard		DCM-200A	(2) 2 hp	3338 lbs
2636 SRB 2636 PRB	102000 102100	1 standard	400 CFM at 6" S.P.	Dust bag	1 hp	451 lbs 664 lbs
3648 SRB 3648 PRB	103000 103100	2 standard	400 CFM at 6" S.P.	Dust bag	1 hp	565 lbs 782 lbs
3696 SRB* 3696 PRB*	106000 106100	2 standard	400 CFM at 6" S.P.	Dust bag	(2) 1 hp	1138 lbs 1379 lbs
2636 SRC 2636 PRC	102001 102101	1 standard	400 CFM at 6" S.P.	DCM-80A	1 hp	800 lbs 914 lbs
3648 SRC-4 3648 PRC-4	103001 103101	2 standard	400 CFM at 6" S.P.	DCM-80A	1 hp	819 lbs 1032 lbs
3648 SRC-6 3648 PRC-6	103021 103121	2 standard	600 CFM at 6" S.P.	DCM-200	1-1/2 hp	1266 lbs 1479 lbs
4848 SRC-6 4848 PRC-6	104001 104101	2 standard	600 CFM at 6" S.P.	DCM-200	1-1/2 hp	1423 lbs 1636 lbs
4848 SRC-9 4848 PRC-9	104021 104121	2 standard	900 CFM at 6" S.P.	DCM-200A	2 hp	1458 lbs 1671 lbs
6060 SRC-9 6060 PRC-9	105001 105101	2 standard	900 CFM at 6" S.P.	DCM-200A	2 hp	1736 lbs 1949 lbs
7272 SRC-9 7272 PRC-9	127001 127101	1 standard	900 CFM at 6" S.P.	DCM-200A	2 hp	2700 lbs 2900 lbs
7272 SRC-12 7272 PRC-12	127023 127123	1 standard	1200 CFM at 10" S.P.	DCM-200B	5 hp	2800 lbs 3000 lbs
3696 SRC-4* 3696 PRC-4*	106001 106101	2 standard	400 CFM at 6" S.P.	DCM-80A	(2) 1 hp	1638 lbs 1879 lbs
3696 SRC-6* 3696 PRC-6*	106021 106121	2 standard	600 CFM at 6" S.P.	DCM-200	(2) 1-1/2 hp	2632 lbs 2773 lbs
60120 SRC* 60120 PRC*	107001 107101	2 standard	900 CFM at 6" S.P.	DCM-200A	(2) 2 hp	3472 lbs 3713 lbs

NOTES TO SPECIFICATIONS

1) NUMBER OF DOORS: Cabinets with a single door open on the right-hand side. An additional door on the left-hand side is optional.

2) RECLAIMER VENTILATION: The larger CFM reclaimer should be used when cleaning extremely dirty, contaminated parts; when using dusty or extremely friable media; when using high-density media; or when using multiple blast guns. Pro-Finish reclaimers can be retrofitted easily to cabinets originally purchased without a reclaimer.

3) DUST COLLECTION: Although exposed dust bags are available with 3648 and 3696 models, these cabinets should be equipped with a dust collector if operated for more than two hours per day. Dust collectors improved cleanliness and efficiency, and can be retrofitted easily to cabinets originally purchased with a dust bag.

4) BLOWER MOTOR: Standard electricals for 1 horsepower motors (115 V, 60 Hz, 1 phase, 20 amp); for 1-1/2 horsepower motors (230 V, 60 Hz, 1 phase, 15 amp); for 2 horsepower motors (230 V, 60 Hz, 1 phase, 17 amp); and for 5 horsepower motors (230 V, 60 Hz, 3 phase, 20 amp). These numbers represent full-amp draws for the dust collector and basic cabinet. Local codes determine actual circuit size. Special electricals are available.

* 3696 and 60120 models are dual-station cabinets. The 3696 consists of two 3648 cabinets joined together. The 60120 consists of two 6060 cabinets joined together.

PRO-FINISH DIMENSIONS

Standard Cabinets (See "SIDE VIEW" for A, B, C, D, E, and F. See "PLAN VIEW" for G, H, floor area and access points.)

MODEL TYPE	2636	3648/3674	4848	6060	7272
A) Door opening depth (ID)	20"	29"	41"	50"	64"
B) Door opening height (ID)	22"	32"	32"	40"	58"
C) Height from turntable to top of door opening					
Stationary manual turntable	17"	27"	27"	35"	—
Rolling manual turntable	15"	25"	25"	33"	44"
Rolling powered turntable	—	21"	21"	29"	—
Low-profile turntable	20"	30"	30"	38"	78"
D) Exterior height	72"	75"	75"	80"	84"
E) Height from enclosure floor to glove-entry midpoint	10"	10"	10"	10"	25" to 29"
F) Height from cabinet base to enclosure floor	34"	34"	34"	34"	27"
G) Cabinet depth (exterior)	26"	36"	48"	60"	72"
H) Cabinet width (exterior)	36"	48"	48"	60"	72"
Floor area	42 ft²	59 ft²	80 ft²	87 ft²	163 ft²
Access points	*	*	*	*	*

SIDE VIEW

PLAN VIEW

NOTES TO CABINET DIMENSIONS

• System shown includes cabinet, reclaimer, dust collector, turntable and some popular options. (Other configurations and options will affect dimensions, which are approximate and subject to change.) • Dust collector, reclaimer and options can be rearranged within limits to suit particular installations. • Floor areas shown indicate basic reclaimer/dust-collector sizes and include operator access points as well as turntable and platform. • Height includes reclaimer and dust-collection hose.

Dust Collectors

MODEL	DUST BAG	DCM-80A	DCM-200	DCM-200A	DCM-200B
Dimensions (DxWxH)	24"x30"x83"	21"x26"x98"	34"x39"x107"	34"x39"x105"	34"x39"x116"
With Sound Attenuator & Automatic Bag Shaker	—	29"x31"x107"	40"x41"x112"	40"x39"x112"	40"x39"x127"

NOTES TO DUST-COLLECTOR DIMENSIONS

• Filter material is cotton sateen with the exception of the DCM-200B model, equipped with needled felt • Drawing D-806862, available upon request, shows all pertinent dimensions and related information. • **Cartridge-type dust collectors available.**

ERGO-BLAST CABINETS

Empire offers a number of standard Pro-Finish variations for specialized air-blasting jobs.

Ergo-Blast systems, for instance, increase productivity by improving operator performance during extended periods of continuous blasting. These cabinets are ergonomically designed for sit-down operation and include other features to reduce fatigue. As a result, machine operators concentrate on the job at hand when working for hours on repetitive tasks rather than trying to find the best position to relieve a sore back. By removing everyday distractions, Ergo-Blast cabinets maximize production.

Ergo-Blast cabinets improve operator efficiency.

Ergo-Blast Features

• Knee-hole indentation for sitting operation
• Elevated foot rest for treadle control
• Elevated, padded arm rest that pivots
• Top-entry nozzle to take weight off operator's hand
• Cabinet sound attenuator
• Door trays to catch stray dust
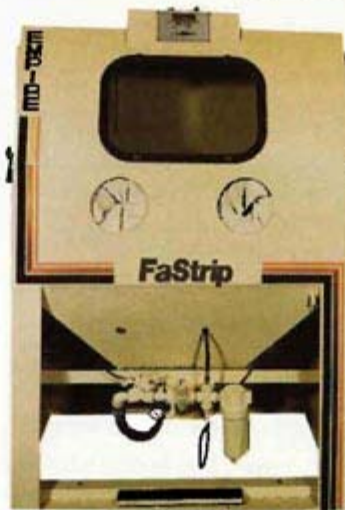
Ergo-Blast Models

MODEL NUMBER	PART NUMBER
2636 SRC ERGO	120001
2636 PRC ERGO	120101
3648 SRC-4 ERGO	121001
3648 PRC-4 ERGO	121101
3648 SRC-6 ERGO	121021
3648 PRC-6 ERGO	121121
4848 SRC-6 ERGO	122001
4848 PRC-6 ERGO	122101
4848 SRC-9 ERGO	122021
4848 PRC-9 ERGO	122121
3696 SRC-4 ERGO	124001
3696 PRC-4 ERGO	124101
3696 SRC-6 ERGO	124021
3696 PRC-6 ERGO	124121

See pages 10 and 11 for specifications and dimensions. (Example: for **2636 SRC ERGO** refer to **2636 SRC** on page 10 and **2636** on page 11.) Shipping weights for Ergo-Blast cabinets are higher than those shown for standard cabinets on page 10.
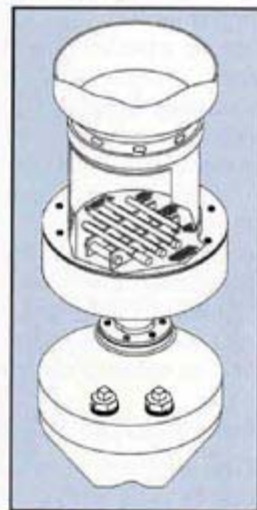
FaStrip® CABINETS

Pro-Finish FaStrip cabinets are specifically designed for use with low-density media, such as plastics, that provide fast coverage without eroding substrates. Paint stripping, for example, can be performed quickly and economically without the use of hazardous chemicals.

FaStrip cabinets deliver plastic or organic media from a large venturi nozzle coupled to a grounded, flexible blast hose. A large, vibrating screen within the reclaimer and Empire's exclusive automatic Sure-Flo media regulator, working in tandem with the MG-78 CR exhaust valve, keeps light media flowing smoothly. A magnetic separator is also included in the system to extract ferrous particles that can damage delicate substrates.

FaStrip cabinets remove old coatings quickly without damaging delicate substrates.

Magnetic separator extracts ferrous debris and can be removed easily for cleaning.

FaStrip Features

• Automatic Sure-Flo saves air, smooths media flow
• MG-78 CR exhaust valve improves media control
• Magnetic separator removes ferrous particles
• Vibrating reclaimer screen removes large debris
• Available in Ergo-Blast configurations

FaStrip Models

MODEL NUMBER	PART NUMBER
FS 3648 PRC-6	103129
FS 3648 PRC-6 ERGO	121921
FS 4848 PRC-9	104129
FS 4848 PRC-9 ERGO	122921
FS 6060 PRC-9	105129
FS 7272 PRC-9	127901
FS 7272 PRC-12	127923
FS 3696 PRC-6	106901
FS 3696 PRC-6 ERGO	124921
FS 60120 PRC 9	107901

See pages 10 and 11 for specifications and dimensions. (Example: for **FS 3648 PRC-6** refer to **3648 PRC-6** on page 10 and **3648** on page 11.) Shipping weights for FaStrip cabinets are higher than those shown for standard cabinets on page 10.

STANDARD PRO-FINISH FEATURES

No other blast cabinet on the market today offers the many practical benefits included on a Pro-Finish cabinet as standard equipment. Just look at the features. The standard components in a Pro-Finish system have been carefully designed for safety, ease of operation, reduced maintenance and increased productivity. Throughout, these cabinets are built to meet the challenges of non-stop industrial blasting.

A

Dust collector features an energy-saving air-filtration system that captures 99% of all particles one micron or larger so cabinet ventilation can be recirculated. Fan is mounted on dust collector rather than reclaimer to prevent abrasive wear to the fan housing and impeller.

Cartridge-type dust collectors, shown in balloon and available in 600 and 900 CFM models (CDC-6 and CDC-9), offer improved durability and efficiency. They also simplify cleaning and maintenance.

B

Tunable reclaimers can be adjusted to control media size. Externally adjustable tuning band requires no tools and controls the size of fines extracted from the blast media. Screen prevents oversized particles from causing clogging and an easy access door permits quick filling.

C

One-cubic-foot pressure vessel minimizes refilling time and seals automatically for fast, easy startup. Construction is ASME coded and National Board registered.

D

Rigid, dual-panel doors stand up to abrasives and seal more tightly than single-panel doors. Flush construction minimizes media spill when the door is opened.

E

Safety-door switch (Patent No. 4,505,077) prevents accidental blasting when doors are open. Complies with OSHA requirements.

F

Self-adjusting door latch assures continued tight sealing as door gasket ages.

G

Simple, pneumatic controls deliver greater reliability than electric controls employing limit switches and solenoids that often stick and burn out.
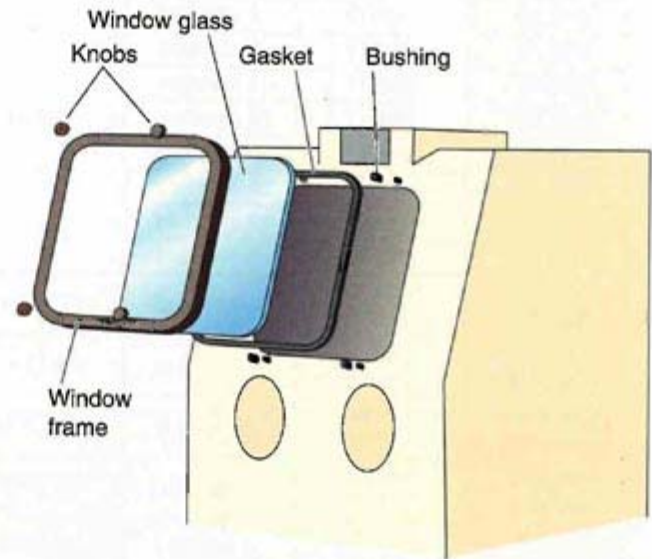
H

Wide foot treadle enables operation with either foot.

I

Moisture separator improves efficiency and reduces downtime by helping to prevent oil and moisture in supply lines from contaminating media.

J

Large, safety-glass window (14"x22") can be changed in a few minutes without tools and has rounded corners for safe handling.

Window glass
Knobs   Gasket   Bushing
Window frame

K

Kleensweep™ creates an air stream across the viewing window to reduce dust buildup and improve visibility.

Sure-Flo® media regulator (Patent No. 4,518,145), used on pressure cabinets, is easy to adjust and assures precise media regulation, as well as continuous flow. These regulators have excellent wear characteristics and, once the metering tube is worn, it can be easily replaced more quickly and economically than in any other media regulator on the market.

High-intensity flood lights reduce the chances of over blasting caused by poor visibility. Lights can be tilted to focus illumination on areas being blasted. Two lights are supplied on 2636, 3648 and 4848 models; three are provided as standard on 6060 and 7272 cabinets.

FEATURES

Because of their versatility, our indexing turntable machines handle a wide range of high-production jobs at a very attractive cost. Some of the features and options contributing to the unexcelled performance of our indexing-turntable units are listed below. **We can tailor these machines to meet your needs with a minimum of custom engineering.**

- Adjustable, fixed or vertically oscillating guns or nozzles in addition to a rotating part blow-off device. Options include an ionized station to reduce static electricity and assure cleaner parts.

- Custom fixturing and masking are available to meet special application requirements.

- Belt drive assures accurate part positioning for pick-and-place or robotic loading.

- Pneumatic, vertical-sliding doors speed up loading, constrain blast debris and reduce noise when equipped with a sound attenuator.

- You have the choice of a suction, standard-pressure or continuous-pressure blast system.

- A pull-down shade inside the viewing window protects transparent surfaces; a 1/4" rubber lining prolongs the life of metal surfaces on machine interiors.

- Automatic media-replenishing system boosts productivity by minimizing downtime for refills and returning "clean" media to the system for more consistent air-blast results.

- Urethane media-return duct, with replaceable liner, prolongs tube life and reduces maintenance costs.

- Infrared light curtain starts and stops blasting automatically. The curtain frees operators to perform other tasks while blasting is in progress.

- Large access door simplifies maintenance.

- Heavy-duty door, latch and hinges are built to last.

- Select from three standard models: Empire's 20-inch, "small-footprint" unit or larger 36-inch and 48-inch indexing machines.

- Specify six, twelve, eighteen or twenty-four work stations depending on the size of the unit you choose.

- Up to four fixtures, capable of handling as many parts, can be supplied at each index station.
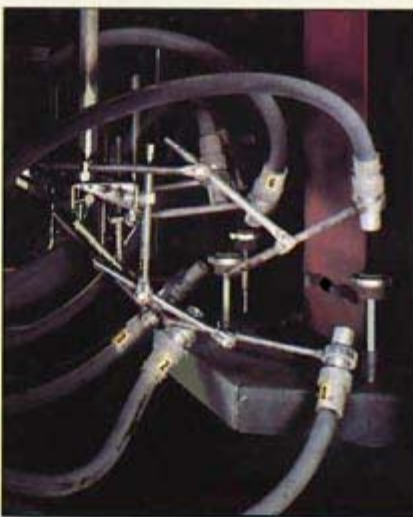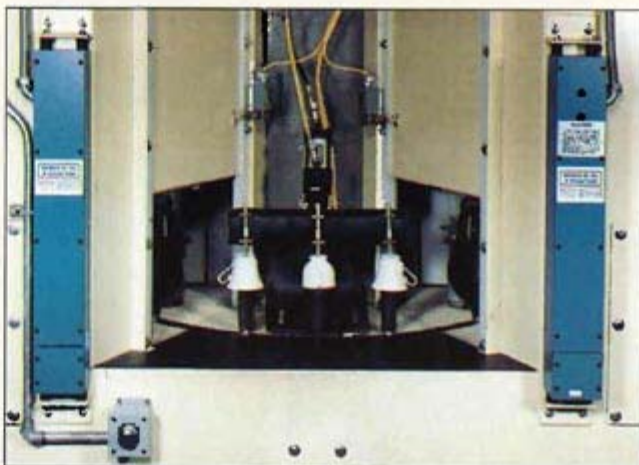
STANDARD EQUIPMENT

Model	TT-20	TT-36	TT-48
Number of stations	6	6	6
Capacity per station	20 lbs	20 lbs	20 lbs
Turntable diameter	20"	30"	48"
Maximum part size (diameter and height)	6" x 14"	12" x 20"	20" x 20"

OPTIONAL EQUIPMENT

Model	TT-20	TT-36	TT-48
Suction guns	Up to 8	Up to 12	Up to 24
Pressure nozzles	Up to 6	Up to 8	Up to 8

PART FIXTURING

The fixturing available in our indexing turntables machines is extensive and flexible. Often, Empire creates fixtures to handle different parts within the same machine.