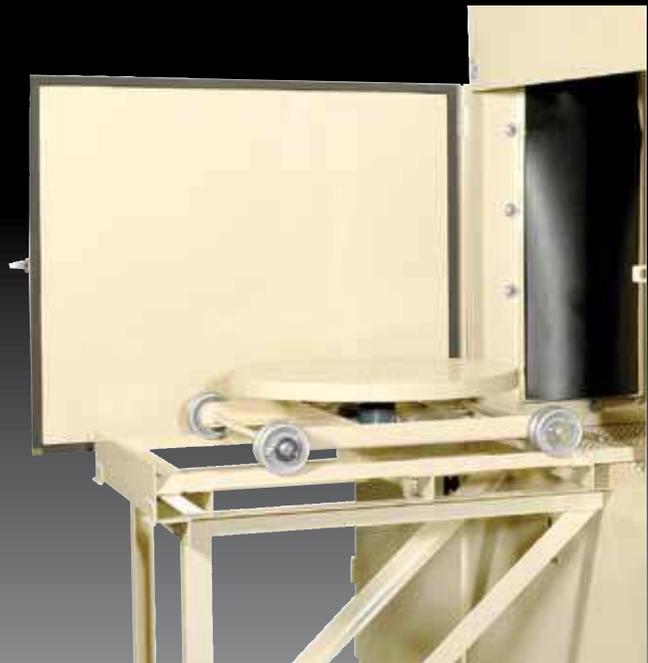


Pro-Finish® Tools to Automate

Powered movement of blast nozzles and/or workpieces automates air-blasting operations to varying degrees. For instance, using a powered turntable in combination with oscillating nozzles makes many blast-finishing processes virtually automatic when a timer package is added to control duration and on/off functions. Some techniques for automating Pro-Finish® cabinets—easily and economically—are described.

Turntables

Turntables, offered in both manual and pneumatically powered models, facilitate the handling of heavy parts and provide opportunities for automation. Turntables can be wheeled into or out of cabinets on a dolly or track, or fixed inside cabinets. Most stationary designs feature a low-profile, giving operators easy “over-the-top” access without wasting interior cabinet space.



Turntable Selection and Part Numbers

		MANUAL ROTATION TURNTABLES						POWERED ROTATION TURNTABLES					
		Stationary				Rolling		Stationary		Rolling			
CABINET MODEL	Diameter	18"	18"	24"	36"	18"	24"	36"	24"	36"	24"	36"	
	Profile	Std.	Low	Low	Low	Std.	Std.	Std.	Low	Low	Std.	Std.	
	Capacity	300#	300#	300#	300#	1000#	1000#	1000#	300#	300#	1000#	1000#	
	2636	140422	140574	140502	NA	140321	NA	NA	NA	NA	NA	NA	NA
	3648	140422	140574	140502	NA	NA	140322	NA	140504*	NA	140364	NA	
	3660	140422	140574	140502	NA	NA	140324	NA	140504*	NA	140375	NA	
	3674	140422	140574	140502	NA	NA	140322	NA	140504	NA	140364	NA	
	3696†	140422	140574	140502	NA	NA	140322	NA	140504*	NA	NA	NA	
	4848	140422	140574	140502	140503	NA	140322	140323	140504*	140505*	140364	140365	
	6060	140422	140574	140502	140503	NA	140324	140325	140504*	140505*	140375	140376	
60120†	140422	140574	140502	140503	NA	140324	140425	140504	140505	NA	NA		

*Not available with Ergo-Blast models. †Two required for both cabinet stations.

•Consult factory for 7272 turntables. •Part numbers above reflect factory installation but may be used to retrofit existing systems.

Gun Oscillators, Timers & Other Accessories

Gun oscillators, suitable for larger Pro-Finish cabinets, can be used with powered turntables and multiple nozzles to reduce the number of guns required, therefore reducing compressed-air consumption. The oscillator will blend multiple passes of the nozzle, creating a more uniform finish. Production rates increase as the benefits of manual coverage and multi-gun blasting are combined.

A radially sweeping oscillator, powered by an air cylinder, strokes as many as four blast guns through a range of up to 18 inches. Stroke length, stroke speed and on/off functions can also be controlled automatically.

Timers are employed to control the on/off functions of blast guns, oscillators and turntables. Our **60 minute spring timer** is powered mechanically and works well in

most automated applications. Empire’s **precision reset timer**, powered by a synchronous motor, always clicks down from the same preset time. This feature, along with large graduations on the timer dial, assure more accurate control of blast durations.

When using timers with pressure systems, an adequate media supply must be available for the duration of the blast process. Consequently, a larger pressure vessel and/or media-level indicator should be considered.

Automatic door clamps lock the cabinet during blasting. For environments in which passive dust emissions present a safety concern, a timer is added to allow for adequate dust evacuation before the cabinet doors are opened. When “close-to-clean-room” standards are required, delay switches are supplied.