



# ProFormer™ Cabinet Systems

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## ProFormer™ Cabinet Models

### ProFormer™ Cabinets (Pressure Systems)

MODEL DESCRIPTION	PART NUMBER	NUMBER OF DOORS	DUST COLLECTION	BLOWER MOTOR	SHIPPING WEIGHT
ProFormer 3642 PRC-6	111023	2 standard	SEM	1½ hp	1720 lbs
ProFormer FaStrip 3642 PRC-6	111028	2 standard	SEM	1½ hp	1745 lbs
ProFormer 4652 PRC-6	111043	2 standard	SEM	1½ hp	2050 lbs
ProFormer FaStrip 4652 PRC-6	111048	2 standard	SEM	1½ hp	2075 lbs

### ProFormer™ Cabinets (Suction Systems)

MODEL DESCRIPTION	PART NUMBER	NUMBER OF DOORS	DUST COLLECTION	BLOWER MOTOR	SHIPPING WEIGHT
ProFormer 3642 SRC-6	111013	2 standard	SEM	1½ hp	1625 lbs
ProFormer 4652 SRC-6	111033	2 standard	SEM	1½ hp	1930 lbs



**Never use silica sand in any Empire equipment.**



# ProFormer™ Options

## 3642 ProFormer™ Cabinets including FaStrip® (600 CFM)

	FACTORY INSTALLED	CUSTOMER INSTALLED	SEE PAGE
<b>Three-Phase Electrical Options (600 CFM)</b>			
<b>Single Source:</b>			
208 Volt, 60 Hertz	139047	139122	B6
230 Volt, 60 Hertz	139048	139123	B6
460 Volt, 60 Hertz	139049	139124	B6
575 Volt, 60 Hertz	139050	139125	B6
380 Volt, 50 Hertz	139051	139126	B6
<b>Cabinet Extended-Wear Options</b>			
Black curtain for cone	510762	510842	B21
Black curtains for front wall	141641	141643	B21
Black curtains for interior sides and back wall	510802	510882	B21
Conveying hose, heavy duty, 4" x 9'	140338	140354	B9
White curtain for cone	140882	140881	B21
White curtains for front wall	140971	140970	B21
White curtains for interior sides and back wall	140884	140883	B21
Window protector, plastic	509191	509191	B25
Window protector, screen	509201	509201	B25
<b>Reclaimer Extended-Wear Options (600 CFM)</b>			
Ultrawear lining	526184	N/A	B8
<b>Cabinet Options</b>			
2'n'1 door basket, coated	140404	140405	B20
2'n'1 door basket, standard (uncoated)	140342	140406	B20
Antistatic strap	510411	510411	B20
Armrest assembly	140596	140596	B20
Door locking clamp, right side without timer	140624	140626	B20
Door locking clamp, right side with timer	140628	140630	B20
Door locking clamp, two doors without timer	140625	140627	B20
Door locking clamp, two doors with timer	140629	140631	B20
Glove hole plugs	140623	140622	B20
Magnetic separator (included with FaStrip®)	511572	511572	B20
Oscillator assembly (horizontal only)	140424	140402	B21
Safety matting (specify length)	509002	509002	B21
System security key-lock	140864	140864	B21
Timer package, electronic	140536	140535	B21
Timer package, mechanical	140420	140421	B21
Turntable, manual, 18" stationary	140422	140422	B23
Turntable, manual, 18" stationary, low profile	141525	141525	B23
Turntable, manual, 24" rolling, includes inside/outside tracks	140322	140322	B23
Turntable, manual, 24" stationary, low profile	141526	141526	B23
Turntable, powered, 24" stationary, low profile	140825	140825	B22
Vertical door	140286	140286	B24
Vibrating reclaimer screen assembly (included with FaStrip®)	140335	140419	B25

*continued on next page*



# Options: ProFormer™ Systems

## 3642 ProFormer™ Cabinets including FaStrip®—continued

	FACTORY INSTALLED	CUSTOMER INSTALLED	SEE PAGE
<b>Pressure Cabinet Options</b>			
Blast hose, ½", top entry	140878	140879	B12
Blast hose, ¾", top entry, with ¼" Di-Carb™ nozzle	140635	140634	B26
Boron restrictor for MG-78 valve	290184	290184	B13
Constant pressure control assembly	140523	Call Factory	B26
Door sill package for one door	140896	761586	B27
Fine tuning package	140511	140512	B27
Fine tuning package with choke	140509	140510	B27
Media regulator, aerated	140374	140360	B28
Media sensor, low level	140381	Call Factory	B28
MG-78 CR valve (included with FaStrip®)	290234	290232	B29
Nozzle, ⅜" boron	502032	502032	B12
Nozzle, ⅜" Di-Carb™	501282	501282	B12
Nozzle holder, fixed	140401	140401	B29
Sight glasses for 1 cubic-foot pressure vessel (two required)	545471	545471	B29
Sure-Flo® valve, automatic (included with FaStrip®)	290188	290188	B30
<b>Suction Cabinet Options</b>			
Gun holder, fixed	140400	140400	B31
Gun package, two gun upgrade (adds one gun)	140898	140899	B31
KLEEN™ package	140920	140921	B31
Nozzle, ⅝" boron	502081	502081	B19
Nozzle, ⅝" Di-Carb™	501341	501341	B19
<b>Dust Collector Options for SEM (600 CFM)</b>			
HEPA filter	140778	140778	B8
HEPA filter, pressure differential gauge assembly	140221	140221	B8
Photohelic cartridge cleaning, automatic pulse	140810	140810	B25
Photohelic gauge assembly	140221	140221	B25
Sound attenuator/damper (85dBA)	140759	140759	B25
Sound attenuator, premium (80dBA)	141794	141794	B25
<i>(HEPA filter and sound attenuator/damper cannot be used together.)</i>			





## 4652 ProFormer™ Cabinets including FaStrip® (600 CFM)

	FACTORY INSTALLED	CUSTOMER INSTALLED	SEE PAGE
<b>Three-Phase Electrical Options (600 CFM)</b>			
<b>Single Source:</b>			
208 Volt, 60 Hertz	139047	139122	B6
230 Volt, 60 Hertz	139048	139123	B6
460 Volt, 60 Hertz	139049	139124	B6
575 Volt, 60 Hertz	139050	139125	B6
380 Volt, 50 Hertz	139051	139126	B6
<b>Cabinet Extended-Wear Options</b>			
Black curtain for cone	510772	510852	B21
Black curtains for front wall	141642	141644	B21
Black curtains for interior sides and back wall	510812	510892	B21
Conveying hose, heavy duty, 4" x 9'	140338	140354	B9
White curtain for cone	140890	140889	B21
White curtains for front wall	140975	140974	B21
White curtains for interior sides and back wall	140892	140891	B21
Window protector, plastic	509191	509191	B25
Window protector, screen	509201	509201	B25
<b>Reclaimer Extended-Wear Options (600 CFM)</b>			
Ultrawear lining	526184	N/A	B8
<b>Cabinet Options</b>			
2'n'1 door basket, coated	140404	140405	B20
2'n'1 door basket, standard (uncoated)	140342	140406	B20
Antistatic strap	510411	510411	B20
Armrest assembly (included with Ergo-Blast)	140596	140596	B20
Door locking clamp, right side without timer	140624	140626	B20
Door locking clamp, right side with timer	140628	140630	B20
Door locking clamp, two doors without timer	140625	140627	B20
Door locking clamp, two doors with timer	140629	140631	B20
Glove hole plugs	140623	140622	B20
Magnetic separator (included with FaStrip®)	511572	511572	B20
Oscillator assembly (horizontal only)	140424	140402	B21
Safety matting (specify length)	509002	509002	B21
System security key-lock	140864	140864	B21
Timer package, electronic	140536	140535	B21
Timer package, mechanical	140420	140421	B21
Turntable, manual, 18" stationary	140422	140422	B23
Turntable, manual, 18" stationary, low profile	140574	140574	B23
Turntable, manual, 24" rolling, includes inside/outside tracks	140322	140322	B23
Turntable, manual, 24" stationary, low profile	140502	140502	B23
Turntable, manual, 36" rolling, includes inside/outside tracks	140323	140323	B23
Turntable, manual, 36" stationary, low profile	140503	140503	B23
Turntable, powered, 24" rolling, includes inside/outside tracks	140364	140364	B22
Turntable, powered, 24" stationary, low profile	140825	140825	B22
Turntable, powered, 36" rolling, includes inside/outside tracks	140365	140365	B22
Turntable, powered, 36" stationary, low profile	140505	140505	B22
Vertical door	140285	140285	B24
Vibrating reclaimer screen assembly (included with FaStrip®)	140335	140419	B25

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# Options: ProFormer™ Systems

## 4652 ProFormer™ Cabinets including FaStrip®—continued

	FACTORY INSTALLED	CUSTOMER INSTALLED	SEE PAGE
<b>Pressure Cabinet Options</b>			
Blast hose, ½", top entry	140878	140879	B12
Blast hose, ¾", top entry, with ¼" Di-Carb™ nozzle	140635	140634	B26
Boron restrictor for MG-78 valve	290184	290184	B13
Constant pressure control assembly	140523	Call Factory	B26
Door sill package for one door	140897	761587	B27
Fine tuning package	140511	140512	B27
Fine tuning package with choke	140509	140510	B27
Media regulator, aerated	140374	140360	B28
Media sensor, low level	140381	Call Factory	B28
MG-78 CR valve (included with FaStrip®)	290234	290232	B29
Nozzle, ⅜" boron	502032	502032	B12
Nozzle, ⅜" Di-Carb™	501282	501282	B12
Nozzle holder, fixed	140401	140401	B29
Sight glasses for 1.5 cubic-foot pressure vessel (two required)	545471	545471	B29
Sure-Flo® valve, automatic (included with FaStrip®)	290188	290188	B30
<b>Suction Cabinet Options</b>			
Gun holder, fixed	140400	140400	B31
Gun package, two gun upgrade (adds one gun)	140898	140899	B31
KLEEN™ package	140922	140921	B31
Nozzle, ⅝" boron	502081	502081	B19
Nozzle, ⅝" Di-Carb™	501341	501341	B19
<b>Dust Collector Options for SEM (600 CFM)</b>			
HEPA filter	140779	140779	—
HEPA filter, pressure differential gauge assembly	140221	140221	—
Photohelic cartridge cleaning, automatic pulse	140810	140810	B25
Sound attenuator/damper (85dBA)	140759	140759	B25
Sound attenuator, premium (80dBA)	141794	141794	B25

*(HEPA filter and sound attenuator/damper cannot be used together.)*





# ProFormer™ Parts

## ProFormer™ Electrical Options

### Standard Wiring

ProFormer™ systems are wired for a 230 volt, 60 Hertz, single-phase (3 wire) electrical source.

**IMPORTANT!** Systems must be wired at the factory to match the customer's electrical supply. If the electrical supply at the installation site differs from 230V/60Hz/Single-Phase (3wire), specify the appropriate part number(s) shown on the next two pages.

### Part Numbers for Three-Phase Options

NOMINAL VOLTAGE/FREQUENCY	208V/60Hz	230V/60Hz	460V/60Hz	575V/60Hz	380V/50Hz*
	<b>PART NUMBERS</b>				
Single source, Factory installed	139047	139048	139049	139050	139051
Single source, Customer installed†	139122	139123	139124	139125	139126

\* 50 Hertz systems may not convey heavier media, especially when using multiple guns, large nozzles and at high altitudes. Consult factory.

† Customer installed part numbers apply if machine now has standard wiring. Customer installation is not recommended. Electrical parts are not returnable.

### Part Numbers for Single-Phase Options

PART FUNCTION/DESCRIPTION	FACTORY INSTALLED PART NUMBER	CUSTOMER INSTALLED PART NUMBER
<b>115V/60Hz/1Ph supply requires 30 Amp service:</b>		
<b>Contactor &amp; Rewiring</b>	139110	139111†
<b>220V/50Hz*/1Ph supply requires:</b>		
<b>50 Hertz motor</b> for 3-wire supply	139040	NA
Add <b>Transformer .5KVA</b> for 2-wire supply**	139115	NA

\* 50 Hertz systems may not convey heavier media, especially when using multiple guns, large nozzles and at high altitudes. Consult factory.

† Customer installed part numbers apply if machine now has standard wiring. Customer installation is not recommended. Electrical parts are not returnable.

\*\* Add **PN 139116** (1.0KVA Transformer upgrade) instead of PN 139115 if cabinet is equipped with a **2'n'1 door-basket attachment** (PNs 140342 or 140404).

### NOTES on Electrical Components

- If no electrical disconnect is provided, the customer is responsible for providing appropriate disconnecting means adjacent to this equipment for each incoming power circuit. Each disconnect shall be of a type and rating suitable for the application. Refer to current editions of the **National Electrical Code** (NFPA 70) and the **Electrical Standard for Industrial Machinery** (NFPA 79). Systems with a line cord plug do not require a disconnect.
- Interconnections between cabinet, dust collector and customer's utilities are to be supplied by installer.
- Some ProFormer™ options use separate 115 volt line cords with plugs.
- Electrical components cannot be returned to the factory for exchange.
- 50 Hertz systems with reclaimers may not convey heavier media, especially when using multiple guns, large nozzles, and at high altitudes. Consult factory.
- All three-phase systems are **three wire** (three-phase conductors and a ground).
- Consult factory for other electrical options, for conformance with customer electrical specifications, or if you have questions.

### See Operating Instructions for Proper Electrical Connection

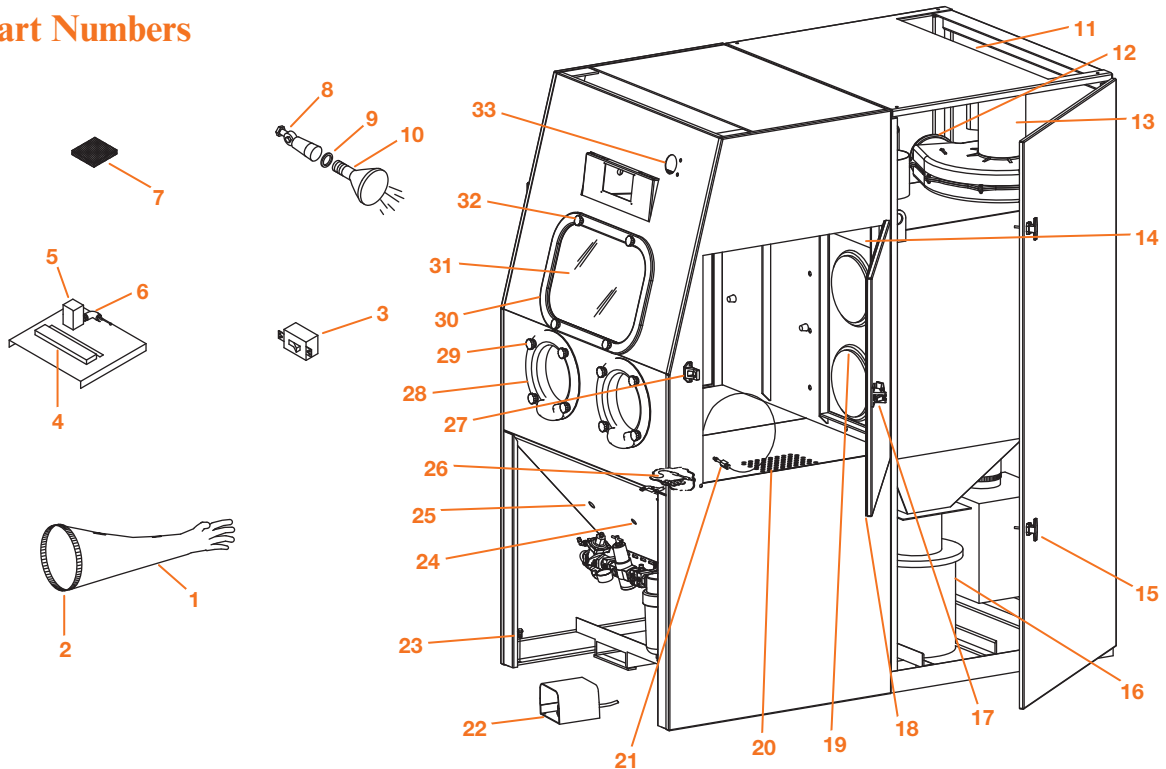
Electrical connection at installation should be performed by a competent licensed electrician following local codes, standard safety procedures and proper installation instructions.

Never use silica sand in any Empire equipment.



# Parts: ProFormer™ Cabinet Assemblies

## Guide to Part Numbers



ProFormer CABINET COMPONENTS		CABINET SIZE	
Item	Description	3642	4652
1 †	Gloves, pair	509891	509891
	Glove, left hand	510821	510821
2	Clamp, 8"	520561	520561
3 †	Switch, snap, 20 amp	534561	534561
4	Terminal strip, 15 pole	533611	533611
5 *	Solenoid valve, Standard & CSA	519001	519001
6	Adapter, 1/4" tube x 1/8" MPT, 90°	520432	520432
7	Filter, Kleensweep™ inlet (2 req.)	510491	510491
8	Light fixture with gasket	532711	532711
9 †	Gasket, light bulb (1 per bulb)	580191	580191
10 *	Floodlight bulb	532701	532701
	Light guard (not shown)	509481	509481
11	Roof cover	765023	765043
12	Dust hose, 6"	516103	516103
13	Blower assembly, 1 1/2 HP, 230/60/1	140312	140312
14	Curtain, Dust Collector	510893	510893
15	Compression latch (4 required)	509005	509005
16	Dust bucket, 5 gallon	509611	509611
	Door latch without handle hole	509371	509371
	Door catch	751242	751242
17	Spacer, catch, shim only	509381	509381
	Door latch kit (latch, spacer & catch)	300016	300016
	Gasket, 3/4" x 3/4" (specify length)	524441	524441
	Length in feet	22	28
18	Bumper, urethane	525041	525041
19	Filter SEM (2 required)	523523	523523
20	Floor section (2 required)	760697	760698

ProFormer CABINET COMPONENTS		CABINET SIZE	
Item	Description	3642	4652
21	Gun, dust off	509821	509821
	Spring (not shown)	511251	511251
	Hose with fittings, dust off gun	522631	522641
	Foot treadle	518651	518651
22 *	Valve for foot treadle	518661	518661
	Repair kit for foot treadle valve	518671	518671
	Hose assembly, 1/4" (2 required)	141406	141406
	Foot treadle assembly	140579	140579
23	Leveling bolt, 3/8" - 16 x 2" (4 req.)	551742	551742
24	Grommet, dust off hose, 1/4" - 5/8" x 7/8"	523951	523951
	Grommet, blast hose, 1" x 1 3/8"	523931	523931
25	Grommet, suction hose, 3/4" x 1 1/16"	523921	523921
	Hole seal (pressure only)	536391	536391
26 *	Interlock hose	521561	521561
27	Keeper, door	751242	751242
28	Glove-flange	555036	555036
29	Knob, 3/8" - 16 (4 required)	510461	510461
	Gasket, glove ring (not shown)	523321	523321
30	Frame, window	760291	760291
31 †Δ	Safety glass, 14" x 22"	510401	510401
32	Knob, 3/8" - 16 (4 required)	510461	510461
	Gauge, Minihelic	504201	504201
33	Manual push button (2 required)	520393	520393

### CABINET ASSEMBLY PARTS NOT SHOWN

	Spacer, window (4 required)	525931	525931
	Window kit (glass, knobs, frame, gasket, spacers and bolts)	140544	140544
	Hinge, 3"	509531	509531
	Z-strip	760151	760151
	Decal, Empire logo	564305	564305
	Decal, orange dot strip (specify length)	564301	564301
	Paint, touch-up kit	564476	564476
	Decal, Instructions/Warnings	567391	567391

\* Essential component to prevent downtime

† Recommended spare part—Consumable wear item

Δ Failure to replace glass with Empire safety glass could result in serious injury.

# Parts: ProFormer™ Reclaimer

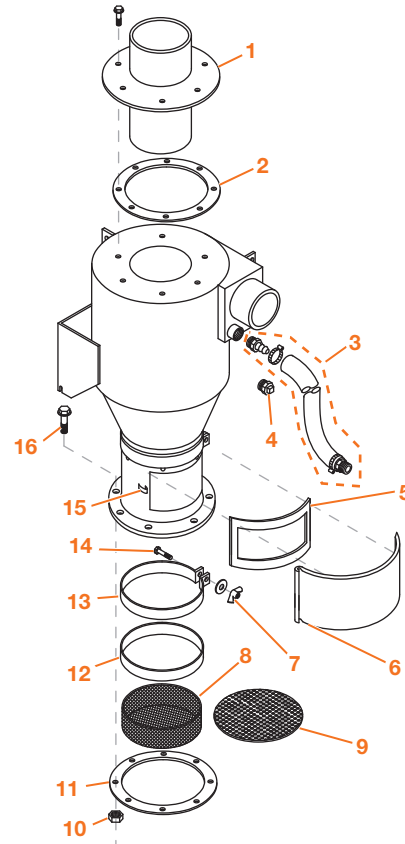
## Guide to Part Numbers

ProFormer™ RECLAIMER COMPONENTS		
Item	Description	PART #
	Complete reclaimer assembly	140796
1 *	Reclaimer top, 600 CFM	766741
2 †	Gasket, ¼" x ¼" poron PSA (specify length)	525941
3	Exhaust hose assembly	522611
4	Plug, 1" NPT (Suction systems only)	544122
5 †	Gasket, reclaimer door	524321
6	Door, reclaimer	770788
7	Wing nut, ¼" - 20	552392
8	Screen, fine 11½" OD, 8 mesh	739041
	Screen, 11½" OD, 4 mesh	739051
9	Screen, flat, 5/16", 13" OD	760711
10	Nut, 3/8" - 16 for 1-gun suction systems (8 required)	552542
	Lock washer, 3/8"	552762
11 †	Gasket, reclaimer to storage hopper	524371
12 †	Gasket, metering band	524342
13	Metering band	767581
14	Bolt, ¼" - 20 x 2"	551782
15	Latch & keeper (requires welding)	509581
16	Bolt, 3/8" - 16 x 1" (8 required)	551852

\* Recommended spare part—Consumable wear item

† Essential component to prevent downtime

Reclaimer Lining		PART #
Ultrawear lining extends life by a factor of ten.		526184



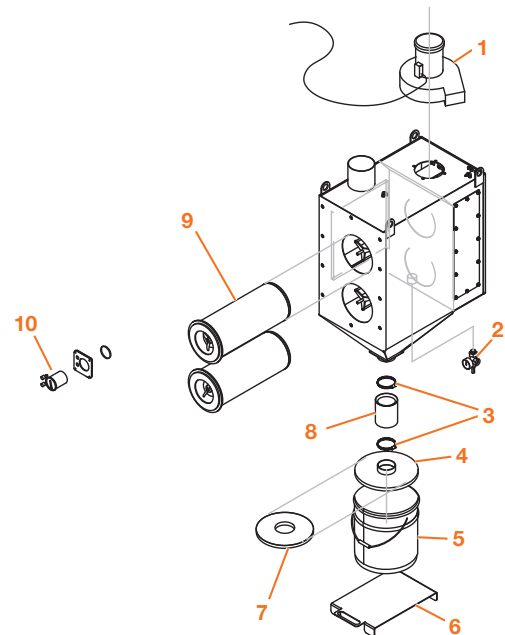
# Parts: ProFormer™ Dust Collector

## Guide to Part Numbers

SEM DUST COLLECTOR COMPONENTS		
Item	Description	PART #
1	Blower assembly (See page B9.)	—
	Collector assembly	113036
2	Air supply assembly	140851
	Regulator/gauge	517612
3	Clamps	520531
4	Cover	516106
5	Waste pail	509611
6	Dust-drum platform (obsoleted 9/09) requires 7" ID hose described in item 8	756682
7 †	Gasket, Neoprene, 9½" ID x 12" OD	515710
8	Gum rubber tube, 4" ID x 4½" long (after 9/09) Hose, 7" ID x 6" long (before 9/09)	523749 516104
9 *	Filter assembly (2 required)	523523
	Mini-helic package	550450
10	Gauge only	504201
	Push button valve only	520393
	Diaphragm valve, 2 required (not shown)	516343

\* Recommended spare part—Consumable wear item

† Essential component to prevent downtime



SEM Dust Collector Options		PART #	PART #	
HEPA filter		140778	Photohelic gauge assembly	140221
HEPA filter, pressure differential gauge assembly		140221	Sound attenuator/damper (85dBA)	140759
Photohelic cartridge cleaning, automatic pulse		140810	Sound attenuator, premium (80dBA)	141794

(HEPA filter and sound attenuator/damper cannot be used together.)





# Parts: ProFormer™ Blower (Fan & Motor)

## Blower Assembly Part Numbers

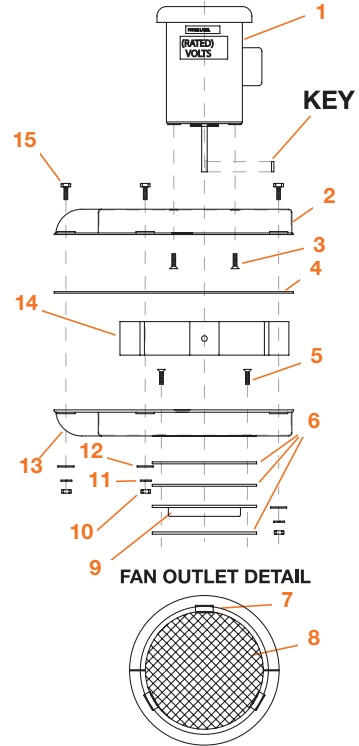
For Dust Collector Model	Horsepower	Part Number	Standard Electrical	CFM at 6" SP	Notes
SEM	1½	140312	230/60/1	600	6" SP at 600 CFM

Note: Motor starters, contactors, interconnecting wiring and ducting not included.

## Guide to Part Numbers

Item	BLOWER COMPONENTS Description	PART NUMBERS
1 †	Motor, 115-230V, 60 Hz, Single phase	549681
	Motor, 220-480V, 60 Hz, 3 phase	549721
	Motor, 550-600V, 60 Hz, 3 phase	549741
	Motor, 110-220V, 50 Hz, Single phase	549771
	Note: Part number 549681 normally supplied as standard.	
2	Housing, fan, top	753511
3	Screw, flat head 3/8"-16 x 1"	553271
4	Gasket, fan housing, 1/8" x 1/4" (5' section)	523251
5	Screw, flat head 3/8"-16 x 2 1/4" (dust collector)	553183
6	Gasket, mounting (3 required)	524361
7	Clip, fan guard (4 required)	554431
8	Guard, fan outlet	739011
9	Outlet flange 751501	
10	Hex nut, 1/4"-20	552522
11	Lock washer, 1/4"	552752
12	Flat washer, 1/4"	552882
13	Housing, fan, bottom	753521
14 †	Impeller (fan blade), 1 1/2" dia., 5/8" ID	753661
15	Bolt, 1/4"-20 x 1"	552131

† Essential component to prevent downtime

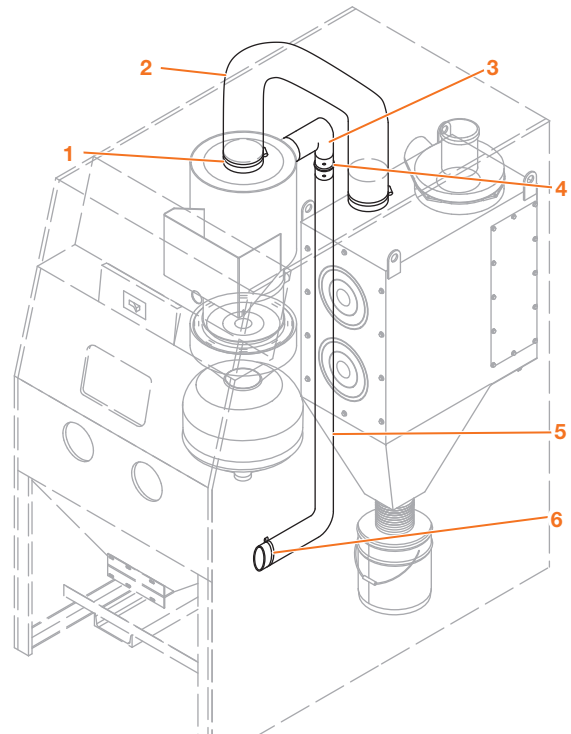


# Parts: ProFormer™ Ducting and Hoses

## Guide to Part Numbers

Item	DUCTING /HOSES Description	PART NUMBERS
1	Hose clamp, dust hose, 6"	520551
2	Standard dust hose without clamps (6" ID x 33" long)	516103
3	Urethane elbow, 4", 90°	526413
4	Duct work adapter, 4" hose to 4" urethane	769917
5	Standard conveying hose w/o clamps (4" ID x 6' long)	522351
6	Hose clamp, standard conveying hose, 4"	520531

Heavy duty conveying hose (4" ID x 9' long) is available with clamps for customer installation (**Part Number 140354**) or as a factory upgrade (**Part Number 140338**). The **Part Number** for one clamp used on heavy duty conveying hose is **522953**. Two clamps are required per hose. To order four inch, heavy duty conveying hose by the foot, use **Part Number 515921** and specify length required.



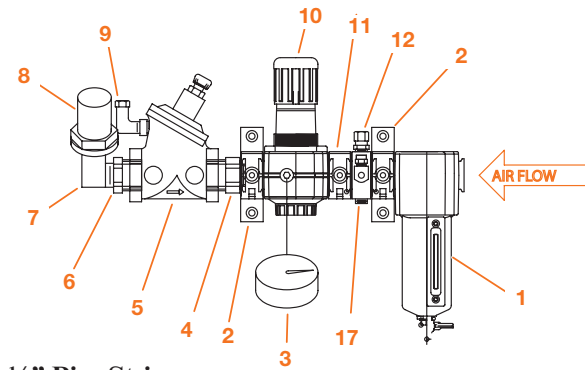
# Parts: ProFormer™ Pipe Strings

## Pipe String Assemblies

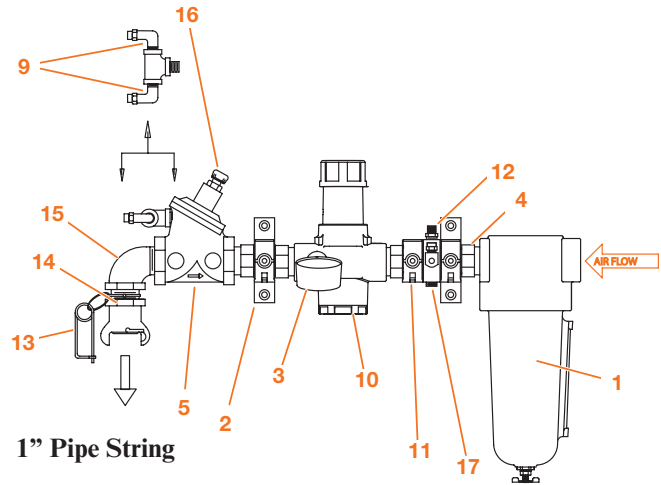
Description	PART NUMBER
½" pipe string used with one-gun suction	140279
1" pipe string used with pressure & two-gun suction	140280

## Pipe String Mounting Hardware

Description	PART NUMBER
¼" flat-head bolt (4 required)	564121
¼" washer (4 required)	552882
¼" hex nut (4 required)	552522



½" Pipe String



1" Pipe String

## Guide to Part Numbers

PIPE STRING COMPONENTS		PART NUMBERS	
Item	Description	½" String	1" String
1 †	Air filter (½" manual, 1" manual; Norgren)	504652	517271
	Element for Norgren air filter, 5µ	508012	508002
	O-ring and gasket kit for Norgren air filter	508112	505161
2	Mounting feet/quick clamp	522155	522155
3	Gauge, (550232 ¼" NPT; 550212 ⅜" NPT used on Ergo-Blast models only)	550232	550232
4	Adapter	522156	522156
5 †	Main air valve (1" Aquamatic)	517042	517042
	Diaphragm and seal kit for 1" Aquamatic	517582	517582
	Special wrench for 1" Aquamatic	518512	518512
	Repair kit for 1" Aquamatic	517583	517583
6	Bushing, 1" x ½" brass	544497	—
7	Elbow, ½" x 90°	543533	—
8	Hose barb, ½"	520362	—
9	Adapter, ¼" tube x ¼" NPT 90°	520432	520432
10 †	Air-pressure regulator (Norgren)	517141	517251
	Diaphragm and O-ring kit for Norgren regulator	508102	508161
11	Quick clamp	522154	522154
12	Hose adapter, ¼" x ¼"	520222	520222
13	Safety pin	—	510511
14	Coupling, 1" FPT, UF-100	—	505782
15	Elbow, 1" NPT street	—	543542
16	Vent	523261	523261
17	Porting block	522157	522157

† Essential component to prevent downtime



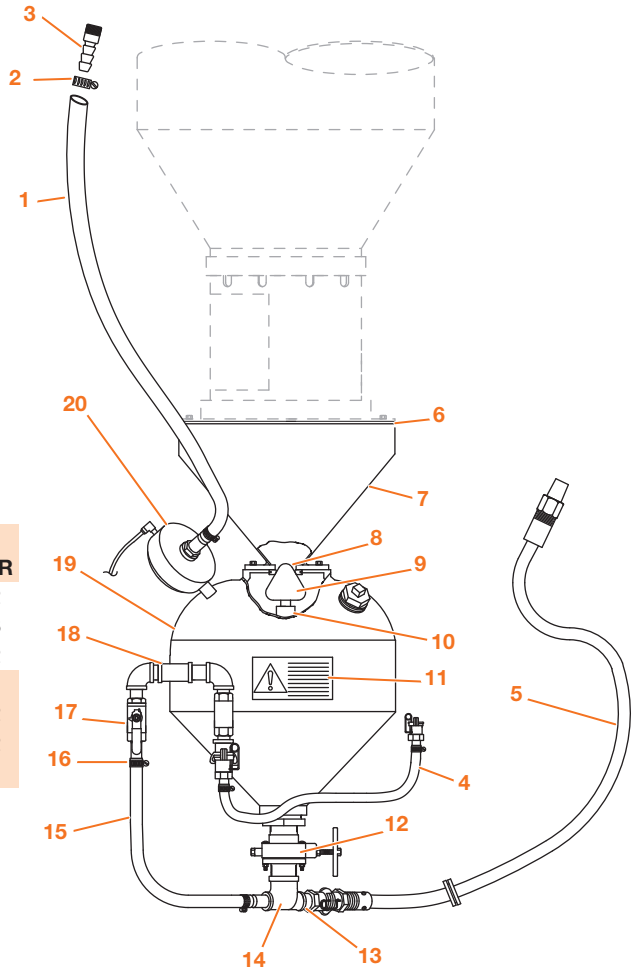
# Parts: ProFormer™ Pressure Blast Systems

## Exhaust Hose

Item	Description	PART NUMBER
1 *	Exhaust hose with 1" NPT barb ends (5'7" for standard 1 cu. ft. pressure vessel)	522611
2 †	Exhaust hose, 1" ID (Max. length: 50')	520822
3 *	Hose clamp, 2" (1 each end)	520512
	Hose barb, 1" NPT x 1" ID hose (1 each end)	520181

## Blast & Air Hoses

Item	Description	PART NUMBER
4 †	Air hose assembly, <b>3642 cabinet</b> , 1" ID x 5' long	140302
	Air hose assembly, <b>4652 cabinet</b> , 1" ID x 6' long	140303
	Air hose, 1" ID, bulk (specify length)	520912
5 *	Blast hose assembly, <b>3642 cabinet</b> , ½" ID x 9' NC/QC	522541
	Blast hose assembly, <b>4652 cabinet</b> , ½" ID x 10' NC/QC	521672
	Blast hose, ½" ID, bulk (specify length) (Nozzle adapter not included.)	520792



## Pressure Vessel

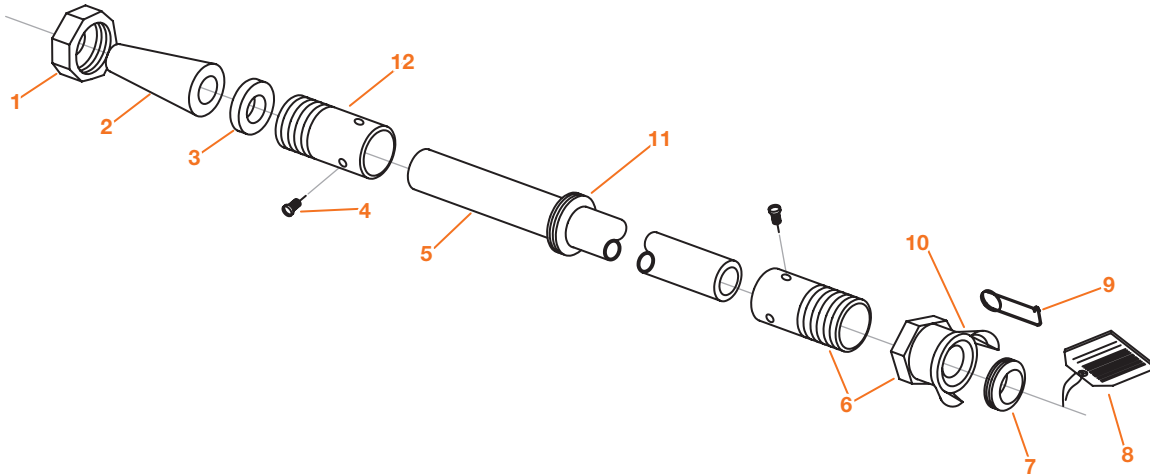
Item	Description	PART NUMBER
6 †	Gasket, reclainer to hopper	524371
7	Hopper, 1 cubic foot	760739
8 †	Sealing ring, rubber, 2½" ID	523942
9 †	Plunger, sealing, PVC coated	510431
10	Plunger guide, ½" NPT x 3½" nipple	546072
11	Label, WARNING "Do not disassemble . . ."	567332
	Label, WARNING "Flange above . . ."	567312
12	Sure-Flo® media regulator, manual (See page B13.)	290383
13	Tank coupling	505782
14	Bullhead tee, 1" x 1" x 2" NPT	545822
15	Hose, 1" ID (Specify 1.5' for 1 cu. ft. vessel; 3.5' for 3.5 cu. ft. vessel)	520912
16 †	Hose clamp for 1" ID hose (1 each end)	520581
17	Ball valve, 1" NPT	518492
18	Tee, 1" x 1" x ½" NPT	545702
19	Pressure vessel only, 1 cu. ft.	760813
20	MG-78 exhaust valve (See page B13.)	290182
	Complete pressure vessel assembly includes items 1 through 3 and 8 through 21.	140802

\* Recommended spare part—Consumable wear item

† Essential component to prevent downtime



# Parts: ProFormer™ Pressure Blast Systems



## Blast Hose Assembly, 1/2 Inch (Not for FaStrip® Models)

Item	Description	MODEL NUMBER	PART NUMBER
1 †	Nozzle adapter	NA-2	504912
2	Ceramic nozzle, 3/16" (not included)		502362
3	Nozzle washer, Ceramic nozzle 5/8" ID (10 pack)	NW-5	524041
	Nozzle washer, Di-Carb/Boron, 1/2" ID (10 pack)	NW-2	524052
4 †	Screws (4 pack) Δ	#8 x 3/8"	554242
5	Blast hose, 1/2" ID (specify length)	PBH-1/2	520792
6	Quick coupling with washer and screw package	QC-1/2	505222
7	Coupling washer (10 pack)	AHCW	524101
	Coupling washer (25 pack)	AHCW	525102
8	Tag, safety, screw/coupling	—	564822
9 †	Safety pin Δ	—	510511
10	Tank coupling, 1" FPT with AHCW	UF-100	505782
11	Grommet, blast hose	1" x 1 1/4"	523931
12 †	Nozzle coupling and screw package	NC-1/2	505232

† Essential component to prevent downtime

Δ **WARNINGS:** See page B17.

## Pressure Blast Nozzles

Nozzles for pressure blast systems are available in sizes and materials to meet any application requirement.

Size	MODEL AND PART NUMBERS					
	3/32" (#0)	1/8" (#2)	3/16" (#3)	1/4" (#4)	5/16" (#5)	3/8" (#6)
<b>Ceramic (uses NW-5 washer)</b>	<b>CN3-0</b>	<b>CN3-2</b>	<b>CN3-3</b>	<b>CN3-4</b>	<b>CN3-5</b>	<b>CN3-6</b>
Each	502342	502352	502362	502372	502382	502393
Pack of 10	503372	503382	503392	503402	503412	503422
Pack of 50	503432	503422	503452	503462	503472	503482
<b>Di-Carb™ (comes with NW-2 washer)</b>		<b>DC2F-2</b>	<b>DC2F-3</b>	<b>DC2F-4</b>	<b>DC2F-5</b>	
Each		501272	501282	501292	501302	
<b>Boron (comes with NW-2 washer)</b>		<b>NN2F-2</b>	<b>NN2F-3</b>	<b>NN2F-4</b>		
Each		502022	502032	502042		

• CN3-3 is standard with 1/2" blast hose • CN3-5 supplied with optional 3/4" blast hose. • Consult factory with special requirements.



# Parts: ProFormer™ Pressure Blast Systems

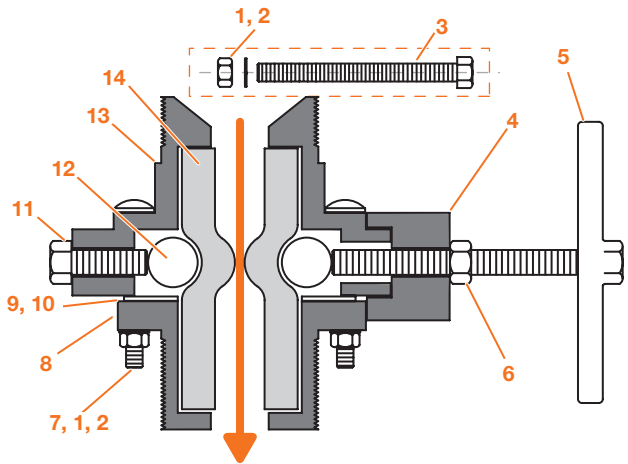
## Manual Sure-Flo® Media Regulator (Part Number 290383)

Item	Description	PART NUMBER
1	Hex nut, 3/8" - 16 (6 required)	552542
2	Lock washer, 3/8" ID (6 required)	552762
3	Hex bolt, 3/8" - 16 x 3" (2 required)	551902
4	Adapter, manual body, Sure-Flo	753372
5	Handle assembly, 1/2" - 13 x 4"	290384
6	Jam nut, 1/2"	552672
7	Carriage bolt, 3/8" - 16 x 2 1/2" (4 required)	552052
8	Flange, 2" MPT	753292
9 †	Roller stop, holder	753092
10	Screw, 8 - 32 x 1/2" (2 per assembly)	551352
11	Bolt, 7/16" - 14 x 1 1/4"	552222
12 †	Pinch roller (2 per assembly)	753632
13	Valve body, 2" MPT	753692
14 *	Metering tube, 3/4" ID (See below.)	523592

\* Recommended spare part—Consumable wear item

† Essential component to prevent downtime

Note: These fasteners are used two places to mount manual body adapter to Sure-Flo® body.



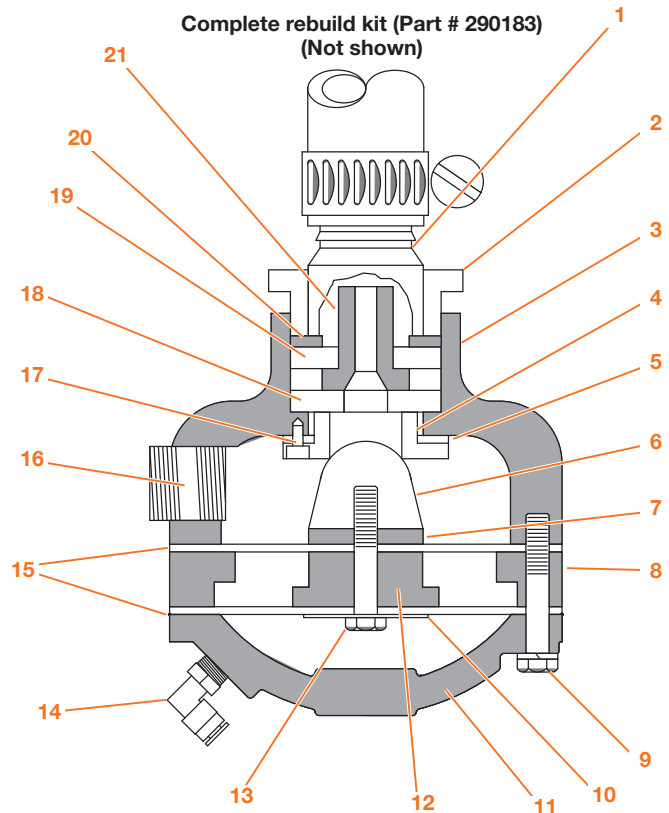
For details on the Automatic Sure-Flo® (PN 290215), See page B30.

Sure-Flo® metering tubes are available in six sizes for work with differing media types and nozzle sizes.

Metering Tube ID	Nozzle Size	Grit Range	Comments	PART NUMBER
3/8"	Small	Fine	Back out roller bolt 1/2"	525451
1/2"	Small-medium	Fine-medium	Back out roller bolt 1/2"	525782
3/4"	Medium-large	Medium	Supplied as standard	523592
3/4"	Medium-large	Medium	Use below 32° F. (red)	523512
5/8"	Medium	Medium-coarse		525792
7/8"	Large	Coarse	For high-production	525802

## MG-78 Exhaust Valve

Item	Description	PART #
	Complete assembly with ceramic restrictor kit	290182
	Complete assembly with boron restrictor kit	290582
1	Hose barb, 1"	520181
2	Reducer bushing, 1 1/4" MPT x 1" FPT	544512
3	Valve body	753332
4	Seat, valve ball (steel)	753412
5	Gasket, seat	524132
6	Valve ball	525322
7	Space washer, steel (1/2" ID x 2" OD x 1/4" thick)	553412
8	Spacer ring, outer	753402
9	Bolt, 3/8" - 16 x 2"	553892
	Lock washer, 3/8"	552762
10	Washer (1/2" ID x 2" OD x 1/16" thick)	552842
11	Valve cover	753382
12	Spacer ring, inner	753392
13	Bolt, 1/2" - 13 x 1 3/4"	551962
14	Elbow, brass (1/4" MPT x 1/4" tube)	520242
	Pipe bushing, 1/4" x 1/8"	544302
15	Diaphragm (2 per assembly)	523672
16	Pipe nipple, 1" CLOSE	546192
17	Screws, seat, 1/4" - 20 x 1/2" (pack of 3)	551122
<b>RESTRICTOR PARTS</b>		
18	Nozzle washer, NW-4 (pack of 10)	524082
19	Nozzle washer, NW-1 (pack of 10)	524062
20	Steel washer	552952
	Ceramic restrictor kit (standard)	290218
	Ceramic nozzle (standard)	502431
21	Boron carbide restrictor (replacement)	502081
	Boron carbide restrictor kit (factory upgrade)	290184



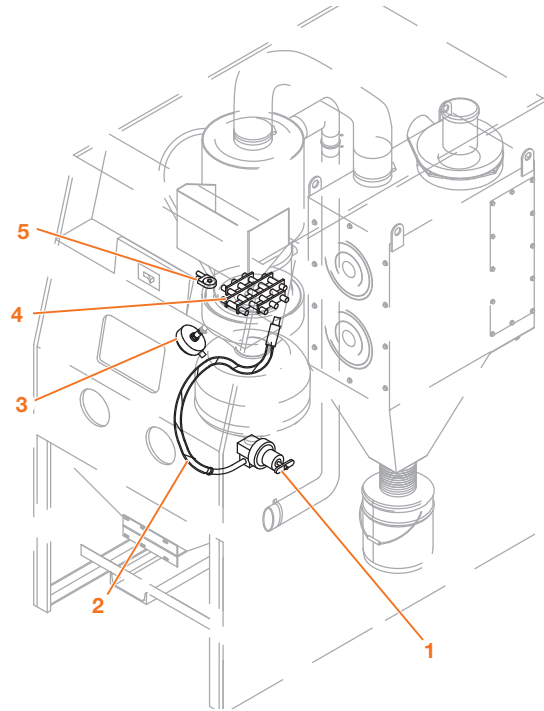


# Parts: ProFormer™ FaStrip® Blast Systems

FaStrip® blast systems share most of the pressure blast components shown on pages B7 through B13 with other ProFormer™ pressure models. Many features that are optional with other cabinets are standard with FaStrip®.

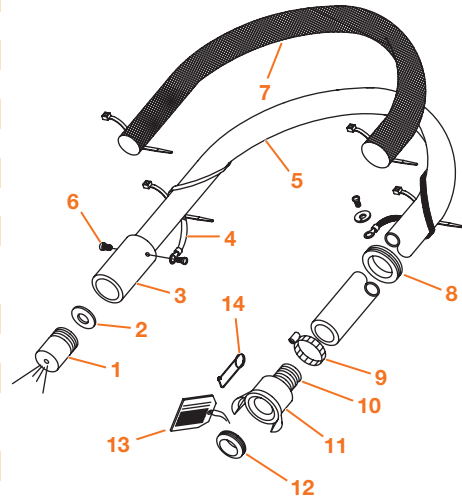
## Standard Features with FaStrip®

Item	PART NUMBERS	
	FACTORY INSTALLED	CUSTOMER INSTALLED
1 Automatic Sure-Flo® media regulator (See page B15.)	290215	290215
2 Blast hose assembly, 3/4" urethane (See below.)	140648	140648
3 MG-78 CR exhaust valve (See page B16.)	290234	290232
4 Magnetic separator	511572	511572
5 Vibrating reclaimer screen (See page B16.)	140335	140419



## Blast Hose Assembly, 3/4 Inch Urethane for FaStrip®

Item	Description	PART NUMBER
	3/4" ID blast hose assembly (includes items 1 through 14)	140648
1 *	Silicon carbide nozzle, 3/8"	502742
2 *	Nozzle washers, NW-1, 1" ID x 1 5/8" x 1/4" (pack of 10)	524062
3	Nozzle coupling, 1 1/8" ID for 3/4" hose	754571
4	Grounding wire (specify length)	529813
5	Urethane blast hose, 3/4" (specify length)	523221
6 †	Screws for aluminum & brass couplings, #8 x 5/8" (pack of 4) Δ	554232
7	Outer sheath (after 7/92) (6' required) (specify length)	580171
8	Grommet, blast hose, 1" ID x 1 3/8" OD	523931
	Grommet, blast hose, 1 1/2" x 1 3/4" (10/89 to 7/92)	523331
9	Clamp, adjustable, 1 3/4" ID	520581
10	Nipple, 1/2" NPT x 2 1/2"	546052
11	Coupling, TC-1/2, 1/2" MPT	505212
12 *	Washer, AHCW (pack of 10)	524101
	Washer, AHCW (pack of 25)	525102
13	Tag, safety. screw/coupling Δ	564822
14 †	Safety pin (MUST be used on every quick disconnect) Δ	510511



**Δ** WARNINGS: See page B17.

\* Recommended spare part—Consumable wear item

† Essential component to prevent downtime

## Blast Hose Lengths for FaStrip®

	Bulk	3642	4652
Blast hose length for FaStrip models		12'	13'
Urethane blast hose, 3/4", maximum length: 50' (specify length)	523221	—	—

## Blast Nozzles for FaStrip®

SCV-6 is supplied as standard.

Nozzle size	Silicon carbide, blue jacket					
	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"
Model	SCV-3	SCV-4	SCV-5	SCV-6	SCV-7	SCV-8
Part Number (each)	502712	502722	502732	502742	502752	502762

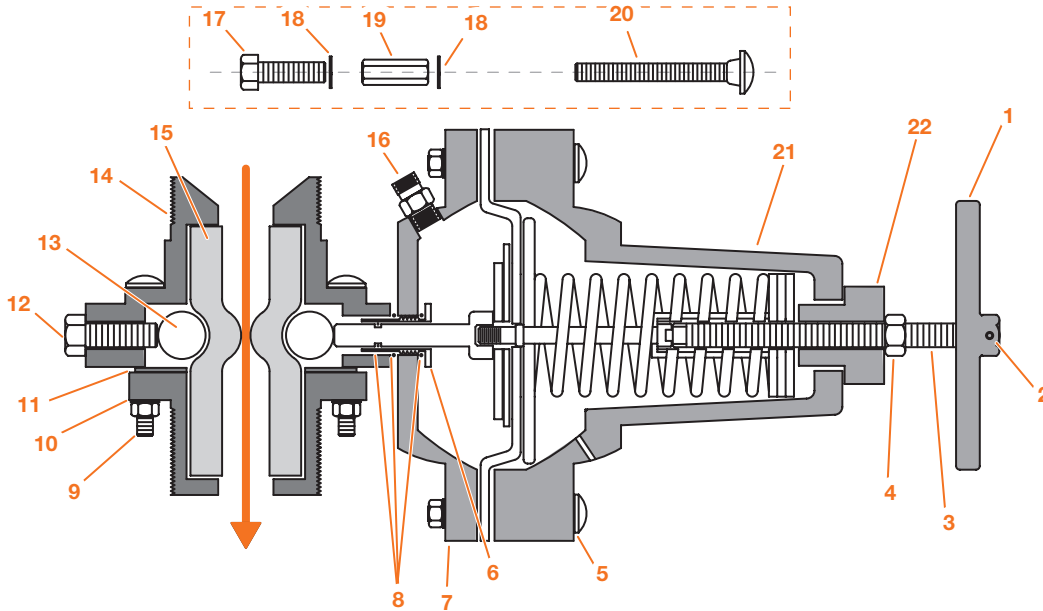


# Parts: ProFormer™ FaStrip® Blast Systems

## Automatic Sure-Flo® Media Regulator Part Number: 290215

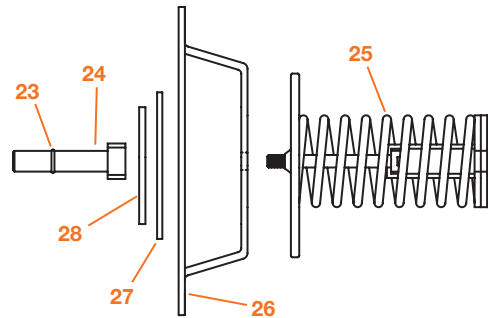
Standard with FaStrip® systems. Optional with other ProFormer™ systems.

Note: These fasteners are used two places to mount diaphragm body to Sure-Flo® valve.



Item	Description	PART #
1	Handle assembly, 1/2" - 13, Auto Sure-Flo (after 5/84) Handle only, 1/2" - 13	290217 753622
2	Set screw, 1/4" - 20 x 3/8"	551732
3	Shaft handle	505802
4	Jam nut, 1/2" - 13	552672
5	Carriage bolt, 3/8" - 16 x 2 1/2" Lock washer, 3/8" ID Hex nut, 3/8" - 16	552052 552762 552542
6	Plunger guide	753462
7	Diaphragm cover	753112
8	O-ring kit (includes 2 for guide, 1 for plunger)	561422
9	Carriage bolt, 3/8" - 16 x 2 1/2" Lock washer, 3/8" ID Hex nut, 3/8" - 16	552052 552762 552542
10	Flange, 2" MPT	753292
11 †	Roller stop holder Screw, 8 - 32 x 1 1/2" (2 per assembly)	753092 551352
12	Bolt, 7/16" - 14 x 1 1/4"	552222
13 †	Pinch roller (2 per assembly)	753632
14	Valve body, 2" MPT	753692
15 *	Meter tube, 3/4" (See page B13 for choices.)	523592
16	Adapter, 1/4" NPT x 1/4" tube	521081
17	Bolt, 3/8" - 16 x 1 1/4" (2, Auto Sure-Flo)	551852
18	Lock washer, 3/8" ID	552762
19	Nut extension, 3/8" - 16 (2, Auto Sure-Flo)	552662
20	Carriage bolt, 3/8" - 16 x 2 1/2"	552052
21	Spring enclosure	753682
22	Spring tensioner	505822

## Spring & Diaphragm Detail (Part # 290296) (Part # 290296 includes items 23 through 28.)



**WARNING: Never attempt to disassemble the spring assembly in the automatic Sure-Flo. The spring is under tension and could cause injury to personnel.**

Item	Description	PART #
23	O-ring kit (includes 2 for guide, 1 for plunger)	561422
24	Plunger	505872
25	Spring assembly	290296
26	Diaphragm, raised (after 5/84) Diaphragm, flat (before 5/84)	525012 523662
27	Diaphragm gasket	525002
28	Washer, 1/2" ID	552842

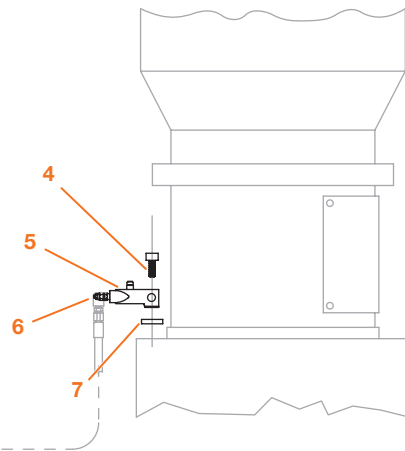
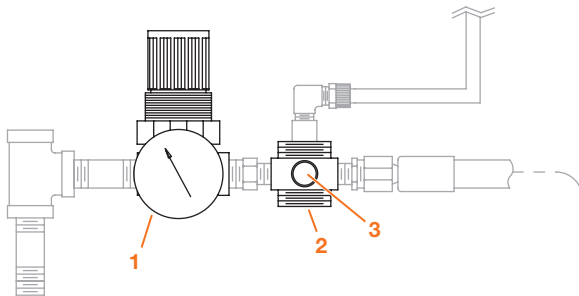
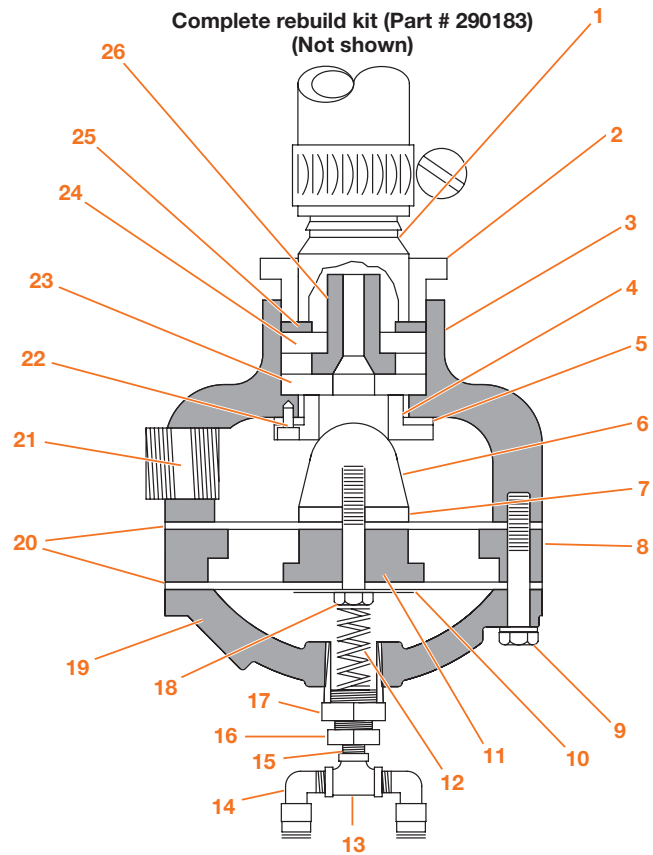
\* Recommended spare part—Consumable wear item  
† Essential component to prevent downtime



# Parts: ProFormer™ FaStrip® Blast Systems

## MG-78 CR Exhaust Valve (Part Number: 290232)

Item	Description	PART #
1	Hose barb, 1"	520181
2	Reducer bushing, 1¼" MPT x 1" FPT	544512
3	Valve body	753332
4	Seat, valve ball (steel)	753412
5	Gasket, seat	524132
6	Valve ball	525322
7	Space washer, steel (½" ID x 2" OD x ¼" thick)	553412
8	Spacer ring, outer	753402
9	Bolt, ⅜" - 16 x 2"	553892
10	Lock washer, ⅜"	552762
11	Washer (½" ID x 2" OD x ⅛" thick)	552842
12	Spacer ring, inner	753392
13	Compression spring	516313
14	Tee, ¼"	545502
15	Elbow, brass, ¼" MPT x ¼" tube (2 required)	520242
16	Nipple, ¼" close	545912
17	Pipe bushing, ½" x ¼"	544462
18	Pipe bushing, ¾" x ½"	544472
19	Bolt, ½" - 13 x 1¾"	551962
20	Valve cover	751801
21	Diaphragm (2 per assembly)	523672
22	Pipe nipple, 1" CLOSE	546192
23	Screws, seat, ¼" - 20 x ½" (pack of 3)	551122
<b>RESTRICTOR PARTS</b>		
23	Nozzle washer, NW-4 (pack of 10)	524082
24	Nozzle washer, NW-1 (pack of 10)	524062
25	Steel washer	552952
26	Ceramic restrictor kit (standard)	290218
	Ceramic nozzle (standard)	502431
	Boron carbide restrictor kit (replacement)	502081
	Boron carbide restrictor kit (factory upgrade)	290184



## Vibrating Screen Part Number: 140335

Item	Description	PART #
1	Regulator, relieving	517612
2	Air valve, pilot operated	519011
3	Breather vent	523261
4	Socket-head cap	553601
5	Vibrator	517971
6	Muffler, ⅛" bronze	517281
7	Spacer	536359





### **WARNINGS—Pressure Blast Systems**

#### **ALL SYSTEMS**

- EMPIRE will not warrant equipment or assume responsibility for damage or injury resulting from neglect or use of improper parts. Failure to follow procedures, which could cause injury and death, constitutes misuse of the product.
- Do not exceed 125 psi inlet pressure.
- Do not disassemble when pressurized or with air supply connected. Be sure all fastenings, including sight plugs, are tightened properly.

#### **PRESSURE VESSEL**

- Flange above pop-up valve must be secured before vessel is pressurized.
- Never drill, weld or otherwise alter the pressure vessel. If modifications are required, contact EMPIRE or an A.S.M.E. certified welding shop.

#### **COUPLINGS**

- Inspect couplings and blast hose daily for splits, bubbles, soft spots, wear, etc. Make sure nozzle washers are in good condition and screw heads are snug against coupling surfaces. The safety pin (PN 510511) must be in place to prevent disconnection of quick couplings.
- When assembling couplings to blast hose use only #8 x 5/8" long, self-tapping, sheet-metal screws (PN 554232) for cast brass and aluminum couplings and #8 x 3/8" long, self-tapping, sheet-metal screws (PN 554242) for all steel couplings. Use of other types of screws may create a safety hazard.

#### **AUTOMATIC SURE-FLO® MEDIA REGULATOR**

- Never attempt to disassemble the spring assembly in the automatic Sure-Flo® media regulator. The spring is under high compression and may injure personnel.

**Never use silica sand in any Empire equipment.**



# Parts: ProFormer™ Suction Blast Systems

## Guide to Part Numbers

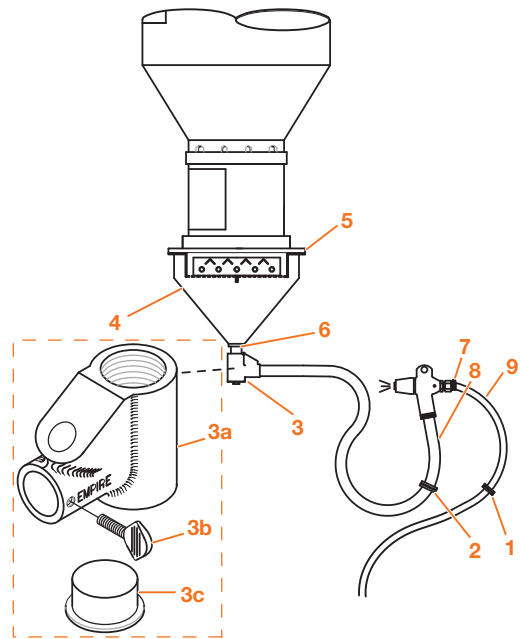
### Hopper Assembly

Item	Description	PART NUMBER
1	Grommet, air hose, 3/4" x 1 1/16"	523921
2	Grommet, blast hose, 1" x 1 3/8"	523931
3	SAR-2 media regulator, complete, 1 1/4" FPT	290156
3a	SAR-2 media regulator, body	753351
3b	Thumb screw, 1/4" – 20 x 1"	551042
3c	Plug, clean out	510121
4	Hopper, 1 gun suction	760751
5 †	Gasket, reclaimer to hopper	524371
6	Pipe nipple, 1 1/4" x 5"	546742
7	Hose clamp, 1/2" air hose (2 per hose)	520502

### Blast & Air Hoses

Item	Description	PART NUMBER
8	Blast hose section for <b>3642 cabinet</b> , 5/8" ID x 8' long	522581
	Blast hose section for <b>4652 cabinet</b> , 5/8" ID x 12' long	522601
	Blast hose, 5/8" ID, bulk (specify length)	520802
9	Air hose, 1/2" ID (specify length)	520861

\* Recommended spare part—Consumable wear item  
 † Essential component to prevent downtime





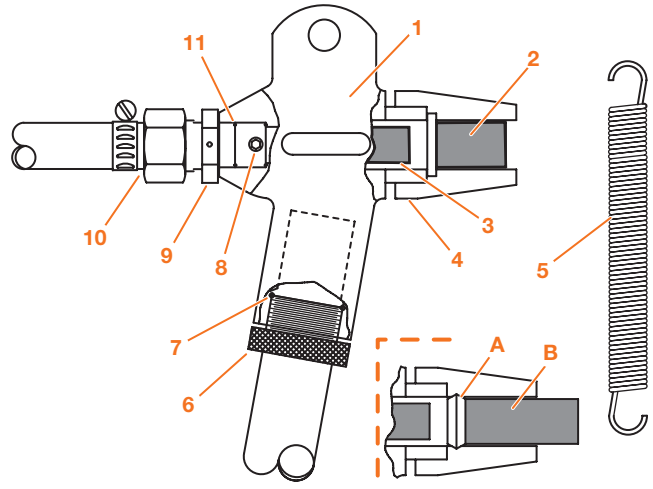
# Parts: ProFormer™ Suction Blast Systems

## MH-2 Guns

Item	Description	PART NUMBER
1 *	Gun body, MH-2 long handle	753551
2 *	Ceramic nozzle, 5/16" (standard)	502431
3 *	Air jet, 5/32" (green)	505671
4 *	Nozzle adapter, plastic	505641
5	Spring, suction-gun assist	511251
6	Nut, hose clamp, MH-2	520081
7	O-ring 1 1/16" ID x 1 5/16" OD	523881
8	Screw set, 1/4" – 20 x 3/8"	551052
9	Connector, MH-2	505631
10	Hose barb, 1/2" FPT x 1/2" hose	520402
11	O-ring, 1/2" ID x 5/8" OD (2 required)	523912

\* Recommended spare part—Consumable wear item

† Essential component to prevent downtime



### Optional for Wide-Spray Setup

Item	Description	PART NUMBER
A *	Compression ring	752453
B *	Di-Carb™ nozzle, 3/8" wide spray	503573
	Boron nozzle, 3/8" wide spray	503563

\* Recommended spare part—Consumable wear item

## MH-2 Suction Gun Assemblies

Nozzle (Air Jet) Diameters	Long-Handle Gun with			Short-Handle Gun with		
	1/4" (1/8")	5/16" (5/32")	7/16" (7/32")	1/4" (1/8")	5/16" (5/32")	7/16" (7/32")
	PART NUMBERS					
<b>Ceramic nozzle</b>	505521	505481	505491	505531	505541	505551
<b>Di-Carb™ nozzle</b>	505501	505441	505451	505561	505571	505581
<b>Boron nozzle</b>	505511	505461	505471	505591	505601	505611

• Long-handle gun with 5/16" ceramic nozzle (505481) supplied as standard.

### Nozzles for MH-2 Guns

Diameter (#)	1/4" (#4)	5/16" (#5)	7/16" (#7)
	PART NUMBERS		
Ceramic (each)	505421	502431	502441
Ceramic (10 pack)	503341	503351	503361
Di-Carb™ (each)	501331	501341	501351
Boron (each)	502071	502081	502091

### Air Jets for MH-2 Guns

Diameter	Designation	Note	PART NUMBER
3/32"	orange		505651
1/8"	yellow		505661
5/32"	green	Standard	505671
3/16"	blue		505681
7/32"	white		505691
1/4"	red		505701



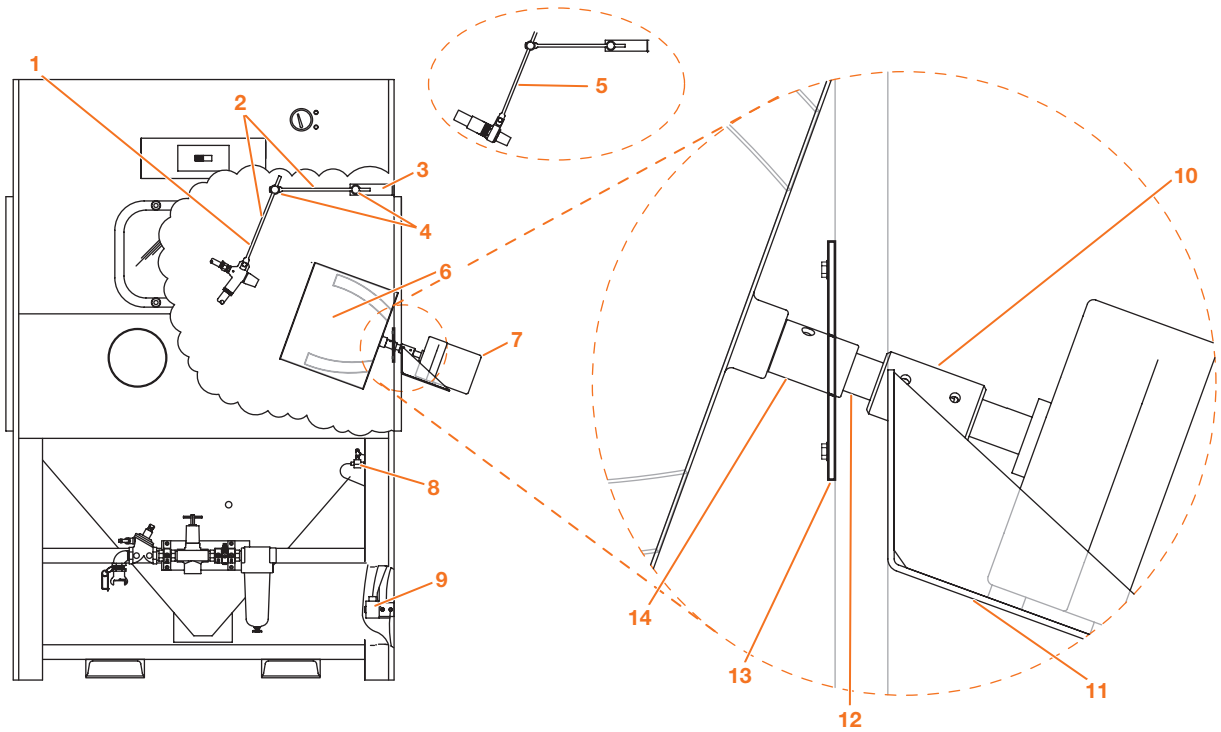
# Options Details: ProFormer™ Cabinets

## Cabinet Options (For Pressure or Suction Systems)

	PART NUMBERS	
	FACTORY INSTALLED	CUSTOMER INSTALLED
<b>Antistatic strap</b> prevents static shock to the operator.	510411	510411
<b>Armrest assembly</b> reduces fatigue.	140596	140596
<b>Door locking clamps</b> prevent unauthorized release of particulates when swing doors are opened.		
Right-door clamp with timer	140628	140630
Right-door clamp without timer	140624	140626
Clamps for two doors with timer	140629	140631
Clamps for two doors without timer	140625	140627

<b>Door mounted basket assembly</b> automates batch processing of small parts.		
Assembly with PVC-coated basket	140404	140405
Assembly with uncoated basket	140342	140406

### Door Basket Components



Item	Description	PART #	Item	Description	PART #
1	Gun holder assembly, suction (Includes 2, 3, 4)	140400	8	Shuttle valve, 1/8" NPT	518011
2	Extension arm	510731	9	Solenoid valve	518591
3	Mounting bracket	509541	10	Shaft coupling	570211
4	Knuckle assembly	560231	11	Gear motor bracket	510311
5	Nozzle holder assembly, pressure	140401	12	Shaft	510741
	Nozzle holder pressure, end arm only	509211	13	Shaft seal	523771
6	Basket, 12" x 14", uncoated	510381	14	Basket socket	753751
	Basket, 12" x 14", PVC coated	510911		Electric timer, 0 to 60 minutes (not shown)	531041
7	Motor, 1/4 HP, 115 V/60 Hz/1 ph (6 RPM)	549621			

	FACTORY INSTALLED	CUSTOMER INSTALLED
<b>Glove hole plugs</b> seal cabinet for automated operation.	140623	140622
<b>Magnetic separator</b> extracts ferrous debris during the media-reclamation process.	511572	511572



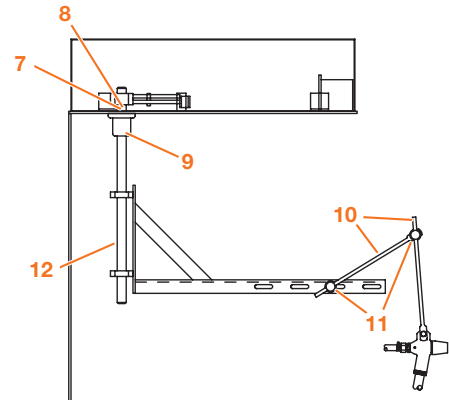
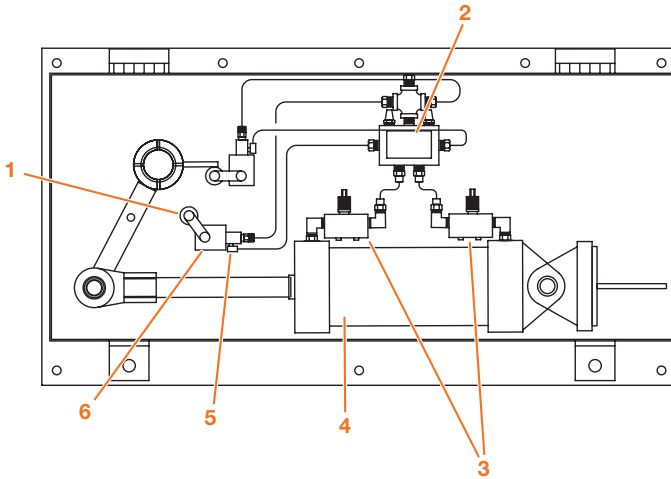
# Options Details: ProFormer™ Cabinets

## Cabinet Options (continued)

**PART NUMBERS**  
**FACTORY INSTALLED**    **CUSTOMER INSTALLED**

**Oscillator assembly** automates horizontal nozzle/gun movement. 140424    140402

### Oscillator Components



Item	Description	PART #	Item	Description	PART #
1	Cam roller	509261	8	Thrust bearing	571573
2	Air valve, 1/8" NPT	518581	9	Flange bearing	570141
3	Flow control valve, 1/4" NPT	517743	10	Extension arm	510731
4	Air cylinder	509221	11	Knuckle assembly	560231
5	Air valve, 1/8" NPT	517221		Fixed gun holder assembly (includes 10 & 11)	140400
6	Cam operator	509251		Fixed nozzle holder assembly (not shown)	140401
7	Bronze washer	761891	12	Shaft	761871

**Rubber curtains** shield cabinet interior from harsh abrasives, prolong equipment life.

(Part numbers shown below)

Cabinet Size	FACTORY INSTALLED						CUSTOMER INSTALLED					
	BLACK CURTAINS			WHITE CURTAINS			BLACK CURTAINS			WHITE CURTAINS		
	Cone	Front Wall	Side & Back Walls	Cone	Front Wall	Side & Back Walls	Cone	Front Wall	Side & Back Walls	Cone	Front Wall	Side & Back Walls
3642	510762	140641	510802	140882	140971	140884	510842	141643	510882	140881	140970	140883
4652	510772	141642	510812	140890	140975	140892	510852	141644	510892	140889	140974	140891

• Attaching these neoprene curtains requires 1/4"-20 studs, brass grommets and rubber nuts (PN 523533).

**Safety matting** protects turntables, cabinet floors and workers. (Two-foot-wide safety matting, with pockets to catch spilled media, is sold by the linear foot. Lengths required are shown below. Specify total length required when ordering.)

**PART NUMBERS**  
**FACTORY INSTALLED**    **CUSTOMER INSTALLED**  
 509002    509002

### LENGTHS REQUIRED

<b>Turntable cover</b>	<b>18" turntable:</b> 2 feet	<b>24" turntable:</b> 2 feet	<b>36" turntable:</b> 4 feet
<b>Cabinet, interior floor</b>		<b>3642 cabinet:</b> 6 feet	<b>4652 cabinet:</b> 8 feet
<b>Shop floor surrounding cabinet</b>		<b>3642 cabinet:</b> 14 feet	<b>4652 cabinet:</b> 16 feet
<b>Shop floor surrounding cabinet with rolling turntable on dolly</b>		<b>3642 cabinet:</b> 16 feet	<b>4652 cabinet:</b> 24 feet

**System-security key lock** prevents unauthorized use of the cabinet. 140864    140864

**Timer**, electronic, features ease of operation and precise control of on/off intervals. 140536    140535  
 For part replacement information, call factory.

**Timer**, mechanical, can be set for intervals of up to 60 minutes. 140420    140421  
 For part replacement information, call factory.



# Options Details: ProFormer™ Cabinets

Turntables facilitate the processing of heavy parts and provide opportunities to automate.

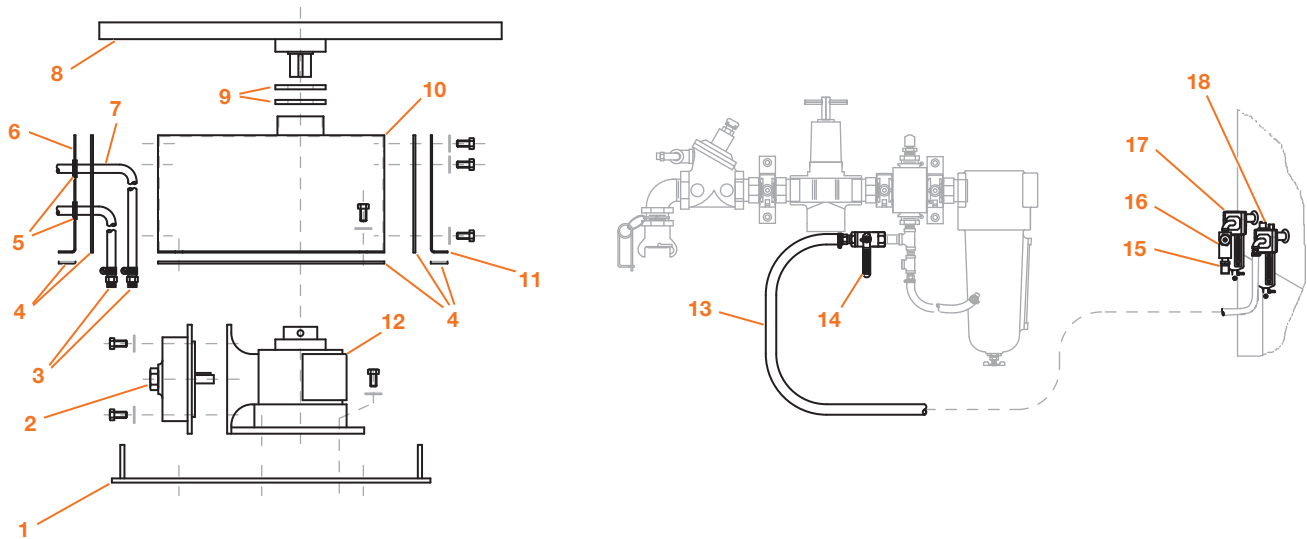
*Part Numbers shown in this table apply to both Factory and Customer installations with some field assembly required.*

## POWERED ROTATION TURNTABLES

	STATIONARY		ROLLING	
	24"	36"	24"	36"
<b>Diameter</b>	24"	36"	24"	36"
<b>Profile</b>	Low	Low	Std.	Std.
<b>Capacity</b>	300#	300#	1000#	1000#
<b>3642 Part Numbers</b>	140825	NA	NA	NA
<b>4652 Part Numbers</b>	140825	140505	140364	140365

- Powered turntables require a minimum of 30 CFM compressed air.
- Part numbers may be used to retrofit existing systems. Customer installation of low-profile turntables requires cutting, fitting and welding.

### Powered Turntable Components



Item	Description	PART #	Item	Description	PART #
1	Mounting plate	768701			
	Air motor	549891	13	Air-hose assembly (3642 ¼" x 6' long) (4652, ¼" x 7' long)	140861 140862
2	Repair kit, Gast motor	549871	14	Ball valve, ½"	518472
	Repair kit, Fenner-Stone motor	549881	15	Muffler, ½" NPT	506443
3	Hose barb, ⅜" NPT to ½" hose	520372	16	Flow-control valve, ½"	517751
4	Gasket, ⅛" x ¼" x 5' long	523571	17	Oil-vapor-removal filter, ½"	511621
5	Grommet, ¾" ID x 1 ⅜" (quantity 4)	523921	18	Lubricator, ½"	511631
6	End plate, left side	768681			
7	Air hose, ½" ID (Specify length.)	520861			
8	24" turntable top	768561			
	36" turntable top	768571			
9	Seal (2 required)	516001			
10	Cover	768641			
11	End plate, right side	768671			
12	Gear reducer	549801			

**Never use silica sand in any Empire equipment.**



# Options Details: ProFormer™ Cabinets

Part Numbers shown in this table apply to both Factory and Customer installations with some field assembly required.

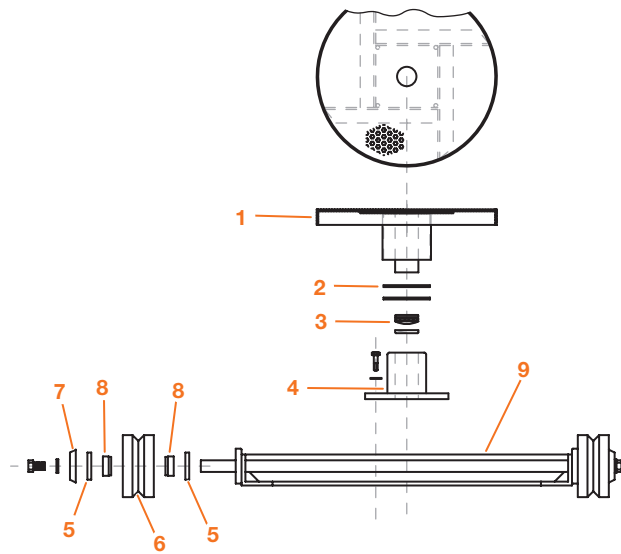
## MANUAL ROTATION TURNTABLES

Diameter	STATIONARY				ROLLING	
	18"	18"	24"	36"	24"	36"
Profile	Std.	Low	Low	Low	Std.	Std.
Capacity	300#	300#	300#	300#	1000#	1000#
3642 Part Numbers	140422	140574	140502	NA	140322	NA
4652 Part Numbers	140422	140574	140502	140503	140322	140323

• Part numbers may be used to retrofit existing systems. Customer installation of low-profile turntables requires cutting, fitting and welding.

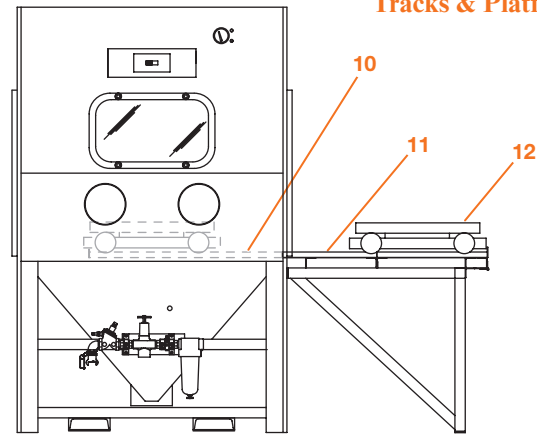
## Manual Turntable Components

### Table, Cart & Wheels



Item	Description	PART #
1	18" turntable	768581
	24" turntable	768591
	36" turntable	768601
2	Seal (5 required)	516001
3	Bearing thrust	570091
4	Bearing	570141
5	Wheel-bearing seal (2 required per wheel)	525971
6	V-groove wheel	509841
7	Outside cup	600291
8	Cotter pin 3/16" x 1 1/4"	553002
8	Hub insert	767071
9	Cart & wheels assembly	140501

### Tracks & Platforms

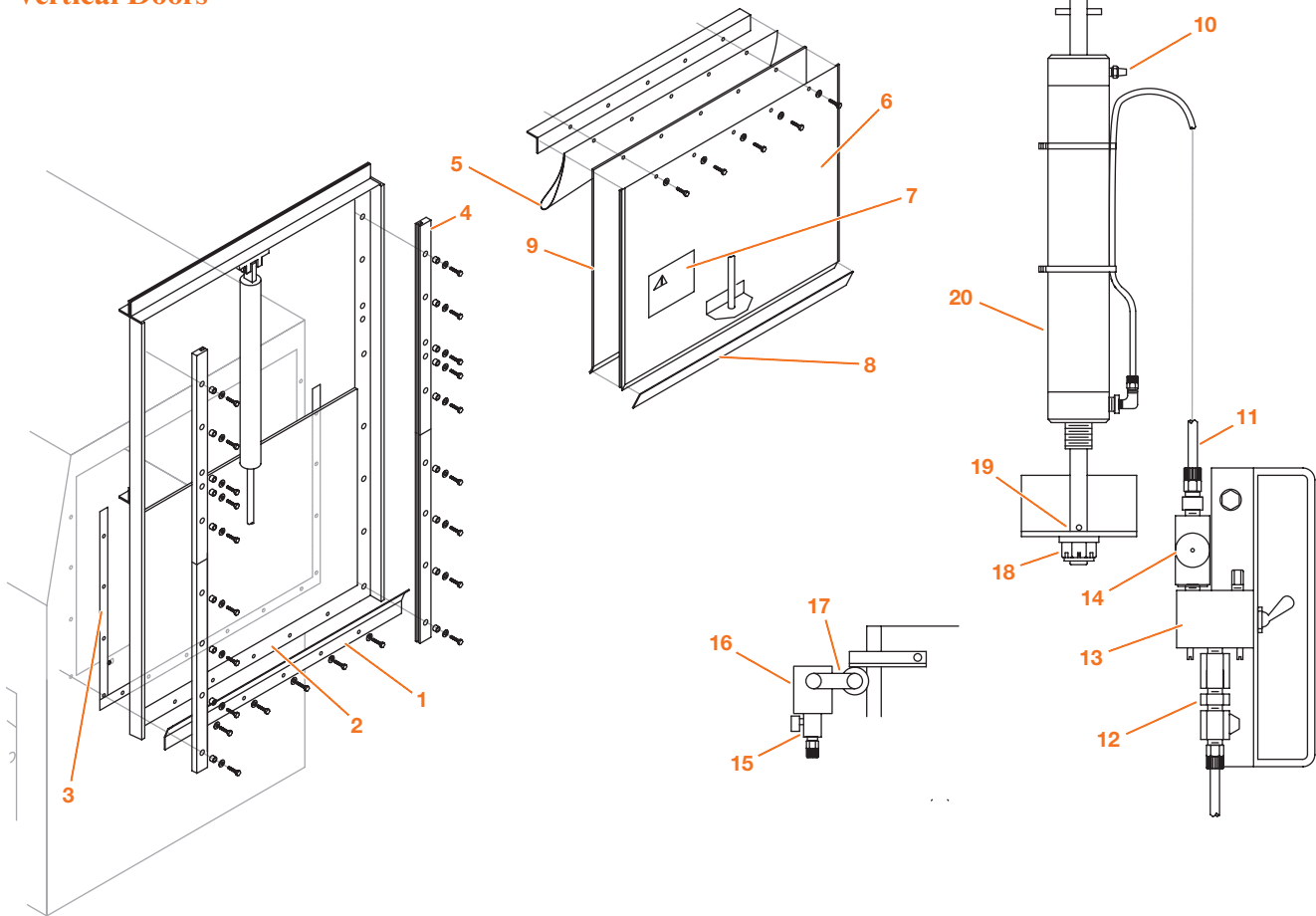


Item	Description	PART #
10	Inside track for:	
	3642 cabinet, 1 door	761001
	3642 cabinet, 2 doors	766721
	4652 cabinet, 1 door	766731
10	4652 cabinet, 2 door	766721
	Outside track	760961
12	Manual turntable with 24" dolly	140457
	Manual turntable with 36" dolly	140458



# Options Details: ProFormer™ Cabinets

## Vertical Doors



Item	Parts for Vertical Doors Description	CABINET SIZE	
		3642	4652
		PART NUMBERS	
	Vertical door, complete assembly	140286	140285
1	Lower gate	767391	767386
2	Lower gasket	526041	526042
3	Side gasket (4 required for 6060, 2 for others)	526001	525991
4	Track-guide assembly, 2 piece	767340	767340
5	Seal, vertical door	525648	525748
6	Panel, vertical door	767271	767262
7	Caution label	567221	567221
8	Seal, bottom door	526311	526316
9	Gasket, vertical door	526081	526083
10	Muffler	505722	505722
11 *	Polyester tubing ( <i>Specify length</i> )	510541	510541
12 *	Check valve, 1/4"	517572	517572
13	Air-control valve, 1/8"	518031	518031
14	Flow-control valve, 1/8"	517721	517721
15	Push button valve	517221	517221
16	Cam operator	509251	509251
17	Cam roller	509261	509261
18	Castle nut	554581	554581
19	Roll pin	554291	554291
20	Air cylinder	518863	518863
	Orifice, .062" (not shown)	510471	510471

\* Recommended spare part





# Options Details: ProFormer™ Cabinets

## Cabinet Options (continued)

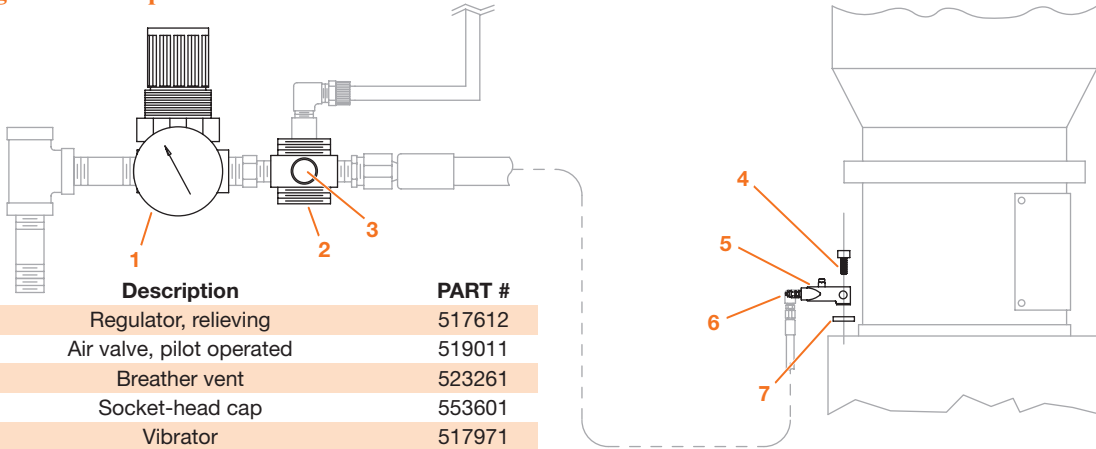
PART NUMBERS  
**FACTORY INSTALLED**    **CUSTOMER INSTALLED**

**Vibrating screen** assures smooth flow of light and fine media. (Included with FaStrip® models.)

140335

140419

### Vibrating Screen Components



Item	Description	PART #
1	Regulator, relieving	517612
2	Air valve, pilot operated	519011
3	Breather vent	523261
4	Socket-head cap	553601
5	Vibrator	517971
6	Muffler, 1/8" bronze	517281
7	Spacer	536359

**Window protector**, made of clear plastic, is recommended for use with light, less aggressive abrasives.

509191

509191

**Window protector**, consisting of a steel screen, protects against heavy and coarse media.

509201

509201



# Options Details: ProFormer™ Dust Collector

## SEM Dust Collector Options

PART NUMBERS  
**FACTORY INSTALLED**    **CUSTOMER INSTALLED**

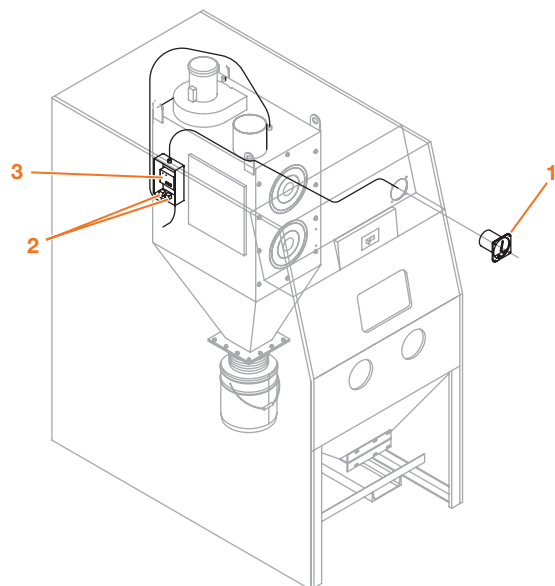
**Photohelic cartridge cleaning** improves system performance, saves operator time.

140810

140810

### Photohelic Cleaning Components

Item	Description	PART #
1	Photohelic gauge	550074
2	Solenoid valve	516338
3	Timer board	585090
	Diaphragm valve (not shown)	516343



**Sound attenuator/damper** for 600 CFM collector constrains noise to 85dBA

140759

140759

**Sound attenuator, premium** for 600 CFM collector constrains noise to 80dBA

141794

141794

**Never use silica sand in any Empire equipment.**



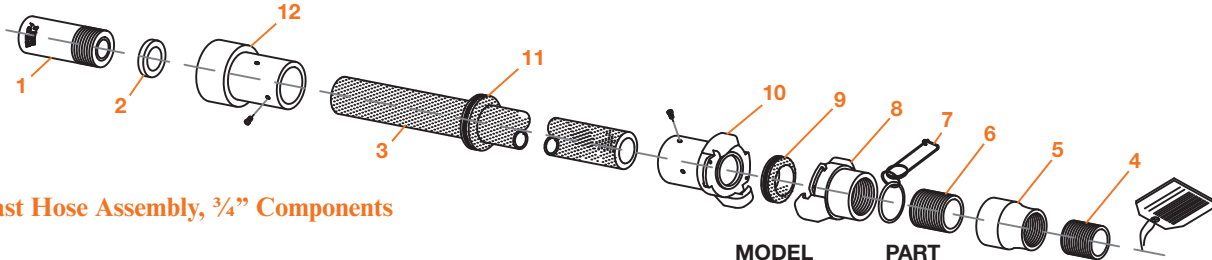
# Options Details: ProFormer™ Pressure Blast Systems

## Pressure Blast System Options

PART NUMBERS  
FACTORY INSTALLED CUSTOMER INSTALLED

**Blast hose assembly (1/2" top entry) takes weight off the operator's hands. (See page B12 for detail.)** 140878 140879

**Blast hose assembly (3/4", top entry) with 1/4" Di-Carb™ nozzle adds ease of handling, higher air/media capacity and longer nozzle life.** 140635 140634



### Blast Hose Assembly, 3/4" Components

Item	Description	MODEL NUMBER	PART NUMBER
1	Nozzle, 1/4" Di-Carb™	DC3-4	501402
2	Nozzle washer, (10 pack)	NW-1	524062
3	Blast hose, 3/4" ID (specify length)	PBH-3/4	520812
4	Pipe nipple, 1" x close	-	546192
5	Bell reducer, 1 1/4" x 1"	-	545341
6	Pipe nipple, 1 1/4" x close	-	546292
7 †	Safety pin Δ	-	510511
8	Tank coupling, 1 1/4"	-	753262
9	Quick coupling washer (10 pack)	QCW	524032
	Quick coupling washer (25 pack)	QCW	525092
10	Quick coupling with washer and screw package	QC-3/4	751062
11	Grommet, blast hose, 1 1/2" x 1 5/8"	-	523331
12 †	Nozzle coupling	NC-3/4	753212

Δ **WARNINGS:** See page B17. † Essential component to prevent downtime

**Constant pressure control assembly maintains desired pressure, improves blasting consistency.**

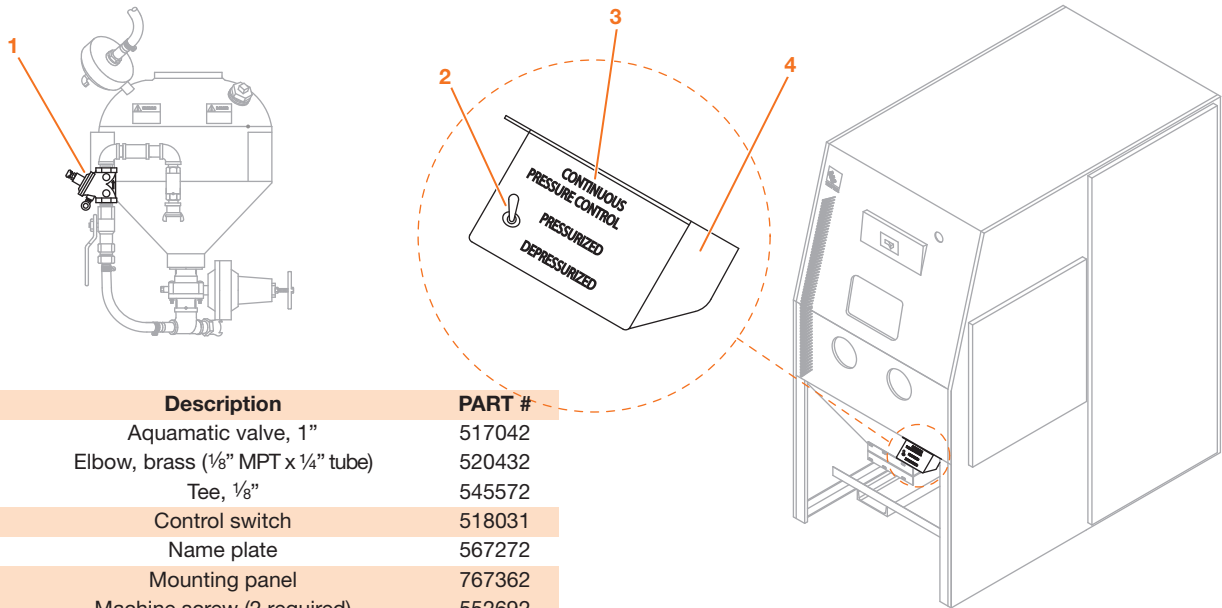
For systems with automatic Sure-Flo®

140523 141521

For systems without automatic Sure-Flo®

141520 141522

### Constant Pressure Control Components



Item	Description	PART #
	Aquamatic valve, 1"	517042
1	Elbow, brass (1/8" MPT x 1/4" tube)	520432
	Tee, 1/8"	545572
2	Control switch	518031
3	Name plate	567272
	Mounting panel	767362
4	Machine screw (2 required)	552692

**Never use silica sand in any Empire equipment.**



# Options Details: ProFormer™ Pressure Blast Systems

## Pressure Blast System Options (continued)

PART NUMBERS  
**FACTORY INSTALLED**    **CUSTOMER INSTALLED**

**Door sill package** catches dust and debris when a cabinet door is opened after blasting. (One package is required per door.)

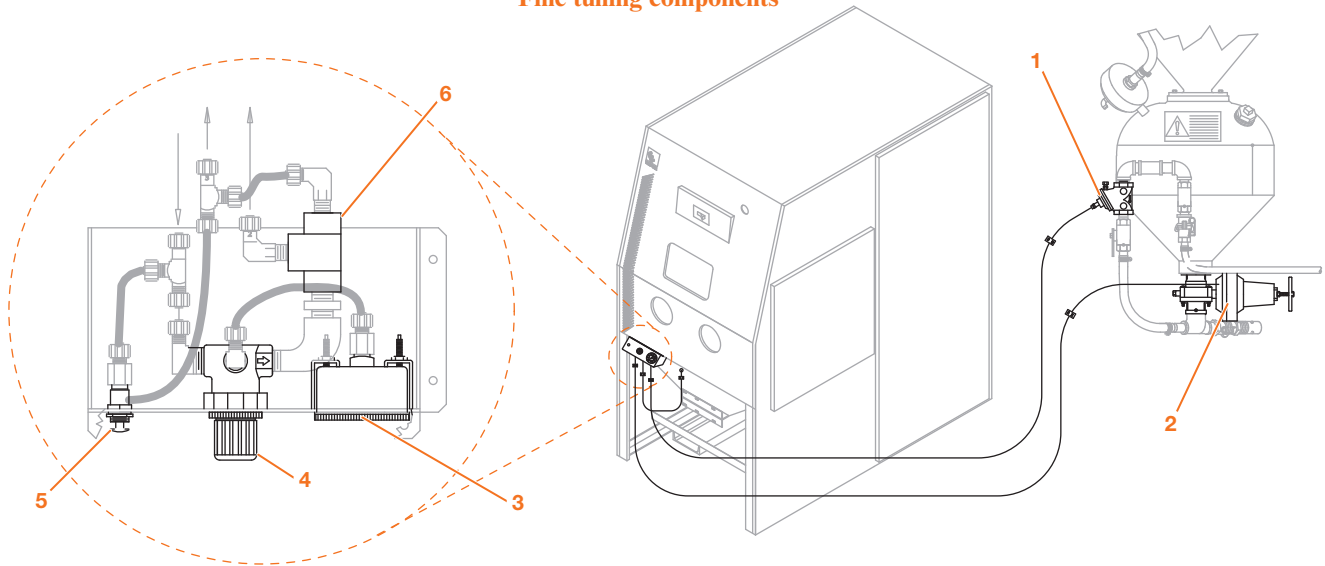
**3642 cabinets**  
**4652 cabinets**

140726    140726  
 140727    140727

**Fine tuning package with choke** enables the operator to clear clogs in the grit valve, as well as adjust the media/air mix, from the work station.

140509    140510

### Fine tuning components



Item	Description	PART #
1	Aquamatic valve, 1"	517692
2	Sure-Flo valve, automatic	290215
3	Pressure gauge	550212
4	Regulator, relieving, 1/4"	517613
5	Air valve, push button	517221
6	Shuttle valve, 1/8"	518011

**Never use silica sand in any Empire equipment.**



# Options Details: ProFormer™ Pressure Blast Systems

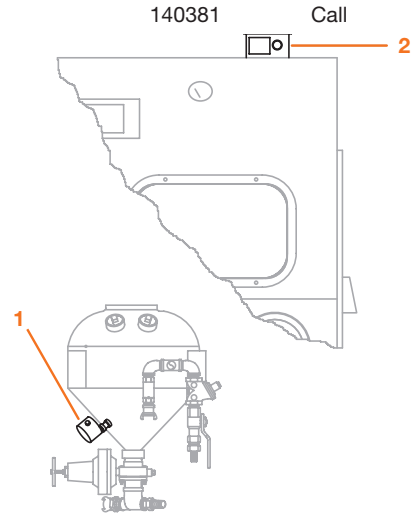
## Pressure Blast System Options (continued)

**PART NUMBERS**  
**FACTORY**    **CUSTOMER**  
**INSTALLED**   **INSTALLED**

Media low-level sensor & indicator warn when the media supply is low.

### Media Low Level Sensor & Indicator Components

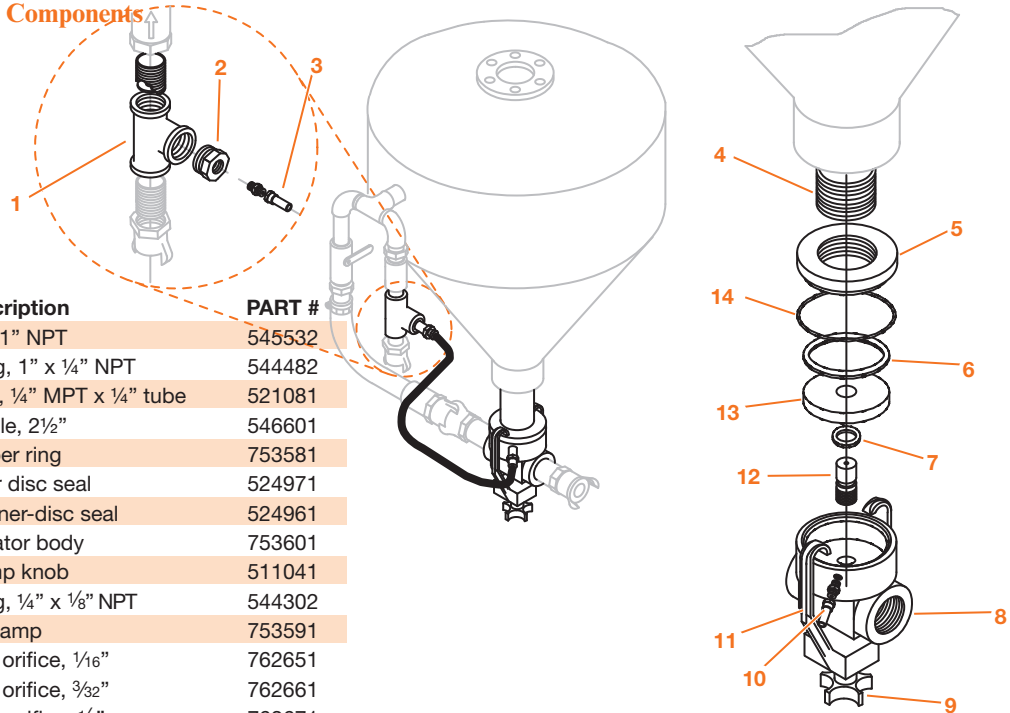
Item	Description	PART #
1	Level sensor	600880
2	Indicator lamp (red)	532743



Media regulator with aeration promotes smooth flow of fine and light grit.

### Aerated Media Regulator Components

Item	Description	PART #
1	Tee, 1" NPT	545532
2	Hex bushing, 1" x 1/4" NPT	544482
3	Connector, brass, 1/4" MPT x 1/4" tube	521081
4	Nipple, 2 1/2"	546601
5	Upper ring	753581
6	Washer disc seal	524971
7	Washer inner-disc seal	524961
8	Regulator body	753601
9	Clamp knob	511041
10	Hex bushing, 1/4" x 1/8" NPT	544302
11	Clamp	753591
12	Metering orifice, 1/16"	762651
	Metering orifice, 3/32"	762661
	Metering orifice, 1/8"	762671
	Metering orifice, 5/32"	762681
	Metering orifice, 3/16"	762691
	Metering orifice, 7/32"	762701
	Metering orifice, 1/4"	762711
	Metering orifice, 9/16"	762721
13	Metering orifice, 3/8"	762731
13	Aeration disc	511031
14	O-ring	524941





# Options Details: ProFormer™ Pressure Blast Systems

## Pressure Blast System Options (continued)

**PART NUMBERS**  
**FACTORY INSTALLED**    **CUSTOMER INSTALLED**

**MG-78 CR exhaust valve** works in combination with the automatic Sure-Flo® media regulator to improve vessel refill with fine media.

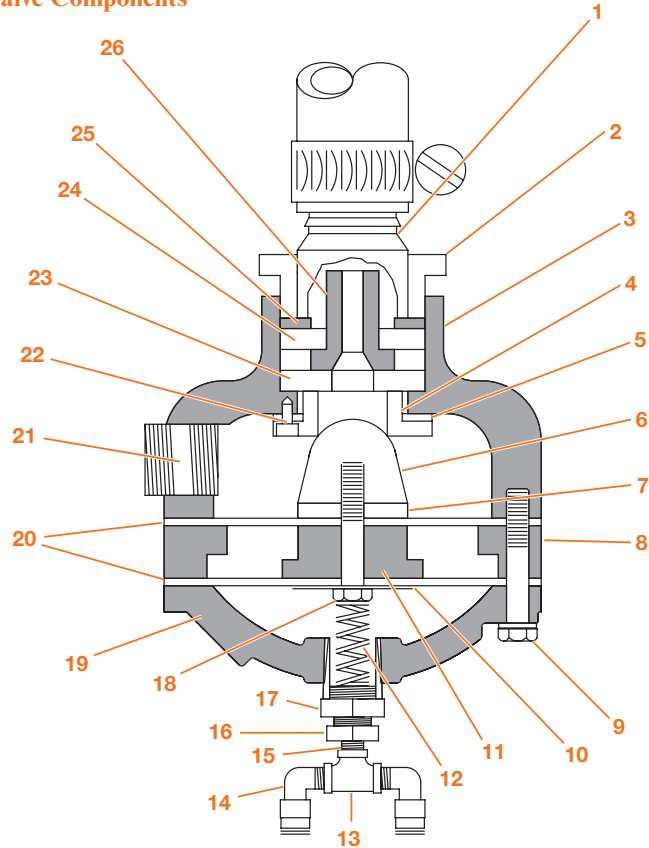
290234    290232

**Boron restrictor** extends MG-78 CR valve life.

290184    290184

### MG-78 CR Exhaust Valve Components

Item	Description	PART #
1	Hose barb, 1"	520181
2	Reducer bushing, 1¼" MPT x 1" FPT	544512
3	Valve body	753332
4	Seat, valve ball (steel)	753412
5	Gasket, seat	524132
6	Valve ball	525322
7	Space washer, steel (½" ID x 2" OD x ¼" thick)	553412
8	Spacer ring, outer	753402
9	Bolt, ⅜" - 16 x 2"	553892
	Lock washer, ⅜"	552762
10	Washer (½" ID x 2" OD x ⅛" thick)	552842
11	Spacer ring, inner	753392
12	Compression spring	516313
13	Tee, ¼"	545502
14	Elbow, brass, ¼" MPT x ¼" tube (2 required)	520242
15	Nipple, ¼" close	545912
16	Pipe bushing, ½" x ¼"	544462
17	Pipe bushing, ¾" x ½"	544472
18	Bolt, ½" - 13 x 1¾"	551962
19	Valve cover	751801
20	Diaphragm (2 per assembly)	523672
21	Pipe nipple, 1" CLOSE	546192
22	Screws, seat, ¼" - 20 x ½" (pack of 3)	551122
<b>RESTRICTOR PARTS</b>		
23	Nozzle washer, NW-4 (pack of 10)	524082
24	Nozzle washer, NW-1 (pack of 10)	524062
25	Steel washer	552952
	Ceramic restrictor kit (standard)	290218
	Ceramic nozzle (standard)	502431
26	Boron carbide restrictor kit (customer upgrade)	502081
	Boron carbide restrictor kit (factory upgrade)	290184



Complete rebuild kit, MG-72/MG-78 valve, Part # **290183**, not shown

**Nozzle holder** frees the operator's hands to manipulate parts.

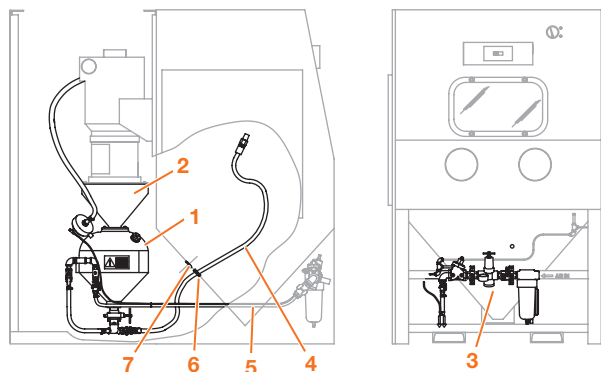
140401    140401

**Pressure conversion kit** replaces suction piping with pressure components.

—    140997

### Pressure Conversion Kit Components

Item	Description	PART #
1	Pressure vessel, 1ft <sup>3</sup> w/ manual Sure-Flo	140802
2	Storage hopper	760739
3	Pipe string, 1"	140280
4	Blast hose assembly (13') with ⅜" ceramic nozzle	140308
5	Air hose assembly, 1" ID 84" long	140304
6	Grommet, 1" OD x 1¾" OD	523931
7	Hole seal	536391
Instructions and miscellaneous components		



**Sight glasses, 1¼" NPT**, permit visual checks on the media supply within 1 cubic-foot pressure vessel.

545471    545471



# Options Details: ProFormer™ Pressure Blast Systems

## Pressure Blast System Options (continued)

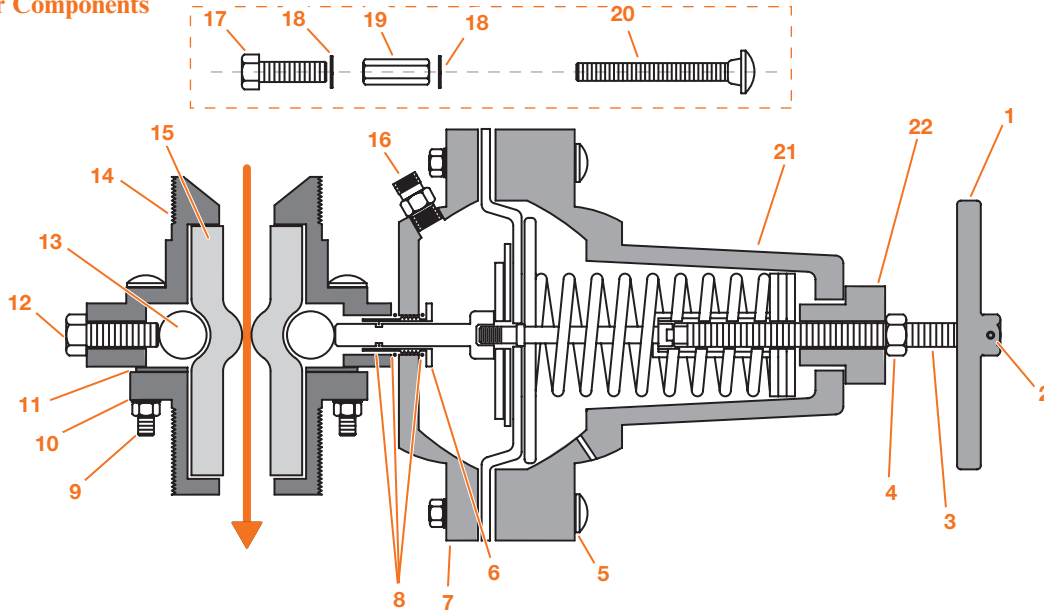
PART NUMBERS	
FACTORY INSTALLED	CUSTOMER INSTALLED

**Sure-Flo® automatic media regulator**, standard with FaStrip® models, supports fine tuning packages for more precise media control.

290215      290215

### Automatic Sure-Flo® Media Regulator Components

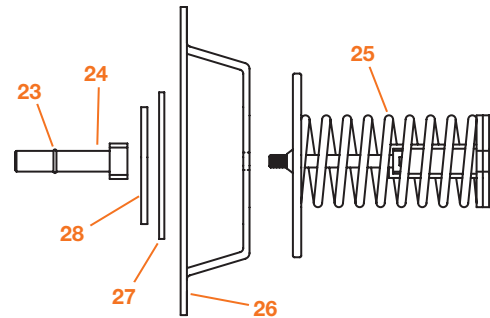
Note: These fasteners are used two places to mount diaphragm body to Sure-Flo® valve.



Item	Description	PART #
1	Handle assembly, 1/2" - 13, Auto Sure-Flo (after 5/84)	290217
	Handle assembly, 7/16" - 14 x 4" (before 5/84)	290211
	Handle only, 1/2" - 13	753622
2	Set screw, 1/4" - 20 x 3/8"	551052
3	Shaft handle	505802
4	Jam nut, 1/2" - 13	552672
5	Carriage bolt, 3/8" - 16 x 2 1/2"	552052
	Lock washer, 3/8" ID	552762
	Hex nut, 3/8" - 16	552542
6	Plunger guide	753462
7	Diaphragm cover	753112
8	O-ring kit (includes 2 for guide, 1 for plunger)	561422
9	Carriage bolt, 3/8" - 16 x 2 1/2"	552052
	Lock washer, 3/8" ID	552762
	Hex nut, 3/8" - 16	552542
10	Flange, 2" MPT	753292
11 †	Roller stop holder	753092
	Screw, 8 - 32 x 1/2" (2 per assembly)	551352
12	Bolt, 7/16" - 14 x 1 1/4"	552222
13 †	Pinch roller (2 per assembly)	753632
14	Valve body, 2" MPT	753692
15 *	Meter tube, 3/4" (See page B13 for choices.)	523592
16	Adapter, 1/4" NPT x 1/4" tube	521081
17	Bolt, 3/8" - 16 x 1 1/4" (2, Auto Sure-Flo)	551852
18	Lock washer, 3/8" ID	552762
19	Nut extension, 3/8" - 16 (2, Auto Sure-Flo)	552662
20	Carriage bolt, 3/8" - 16 x 2 1/2"	552052
21	Spring enclosure	753682
22	Spring tensioner	505822

### Spring & Diaphragm Detail (Part # 290296)

(Part # 290296 includes items 23 through 28.)



**WARNING: Never attempt to disassemble the spring assembly in the automatic Sure-Flo. The spring is under tension and could cause injury to personnel.**

Item	Description	PART #
23	O-ring kit (includes 2 for guide, 1 for plunger)	561422
24	Plunger	505872
25	Spring assembly	290296
26	Diaphragm, raised (after 5/84)	525012
	Diaphragm, flat (before 5/84)	523662
27	Diaphragm gasket	525002
28	Washer, 1/2" ID	552842

\* Recommended spare part—Consumable wear item  
 † Essential component to prevent downtime

**Never use silica sand in any Empire equipment.**



# Options Details: ProFormer™ Suction Blast Systems

## Suction Blast System Options

		PART NUMBERS	
		FACTORY	CUSTOMER
		INSTALLED	INSTALLED
Gun holder frees the operator's hands to manipulate parts.		140400	140400
Gun package supporting a second gun expands the work envelope.		140898	140899
<b>Components for Two Gun Package</b>			
Item	Description	PART #	
1	Blast hose, 5/8" (Specify length)	520802	
2	Thumb screw	551042	
3	Plug	510121	
4	SAR-2 regulator body	753351	
5	SAR-2 assembly (includes 2 through 5)	290156	
6	Pipe nipple, 5"	546742	
7	Hopper, suction, dual outlet	A03515-HOP	
8	Gasket, reclaimers/hopper	524371	
9	Arm extension	510731	
10	Knuckle assembly	560231	
	Fixed-gun holder (includes 8 & 9)	140400	
11	MH-2 gun, short handle, 5/16" jet	505541	
12	Pipe-string assembly included with customer installed (See page B10 for details.)	140280	
13	Air hose, 1/2" (Specify length)	520861	
	Ball valve, 1/2"	518472	

**KLEEN™ package** prevents dust from dropping onto the floor when cabinet doors are opened and returns pressurized media to the cabinet in the event that a blast nozzle plugs.

3642 cabinets	140357	140392
4652 cabinets	140358	140393

Suction conversion kit includes parts to switch cabinets from pressure to suction.	NA	140396	
<b>Suction Conversion Kit Components</b>			
Item	Description	PART #	
1	Storage hopper	760751	
2	Gasket, reclaimers to hopper	524371	
3	Plug	544122	
4	MH-2 suction gun with 5/16" ceramic nozzle	505481	
5	Air hose, 1/2"	522861	
6	Grommet, 3/4" ID x 1 1/8" OD	523921	
7	Grommet, 1" ID x 1 3/4" OD	523931	
8	Blast hose, 5/8"	520802	
9	Media regulator, SAR-2	290156	

Never use silica sand in any Empire equipment.