MOD-U-BLAST®

POWERED BY ALLREDI™

PRESSURE (P) SERIES BLAST CABINETS

OPERATOR'S MANUAL



SUPERIOR PERFORMANCE

AND QUALITY IN BLAST CLEANING EQUIPMENT

WARNING

READ MANUAL

Failure to read, understand & follow all safety and operation procedures in this manual can cause injury or death. Manuals that are lost, incomplete, or damaged, must be replaced immediately.

Manual #P-SERIES 2509

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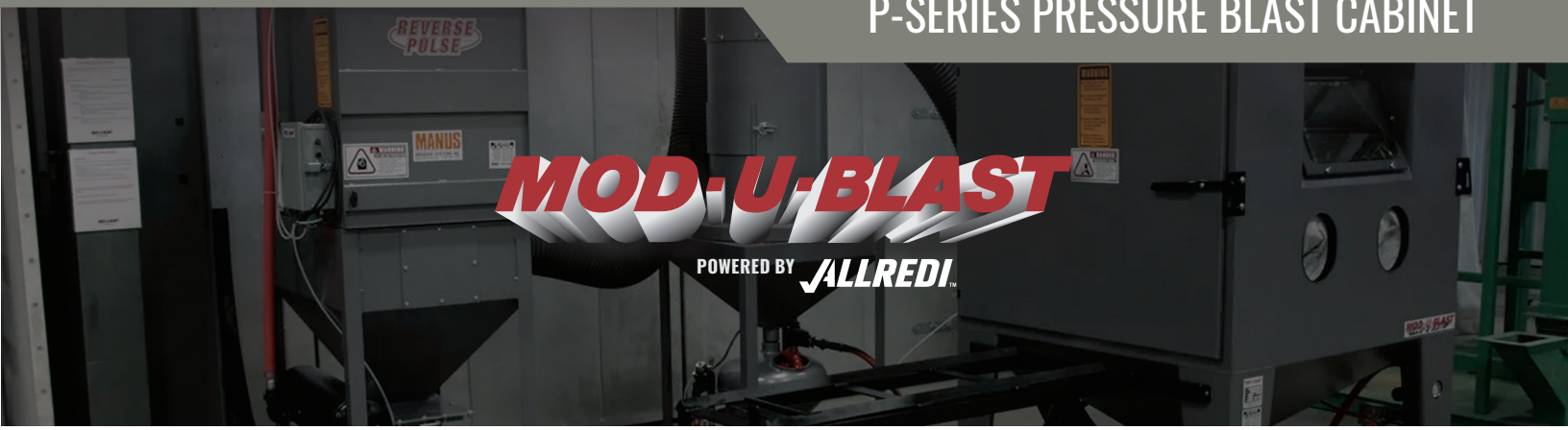
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TABLE OF CONTENTS

Important Notice . . . 3
Introduction & Important Safety Instructions . . . 4
Basic Principles . . . 5
Set-Up Requirements . . . 5 & 6
Common Media Types . . . 6
P-Series Cabinet Installation P3636-6FH & P4836-6FH . . . 7
P-Series Cabinet Installation P3636-62C & P4836-62C . . . 8
P-Series Cabinet Installation P4848-9FH, P6036-9FH & P6048-9FH . . . 9
P-Series Cabinet Installation P4848-92C, P6036-92C & P6048-92C . . . 10
P-Series Cabinet Installation with 1.0 Cu. Ft. Pot & Filter . . . 11
P-Series Cabinet Operation . . . 12
P-Series Cabinet Maintenance . . . 13
MARCO 'P' Series 0.7 Cu. Ft. Blast Pot Components . . . 14
MARCO 'P' Series Flanged 0.9 Cu. Ft. Blast Pot Components . . . 15
MARCO 'P' Series 1.0 Cu. Ft. Blast Pot Components . . . 16
P-Series Cabinet Parts . . . 17 & 18
P-Series Cabinet & Pilot Line Schematic and Parts . . . 19
Auto Air Inlet Valve Schematic (280750) . . . 20
Exhaust (Dump) Valve Schematic (EE03371) . . . 21
Exhaust (Dump) Valve Schematic (290375) (Older Style) . . . 22
Micro (Media) Valve Schematic (EE2125-107) . . . 23
P-Series Trouble Shooting . . . 24 & 25
Cabinet Lighting Electrical Schematic (New Bulb Style) . . . 26
Warranty Coverage . . . 27

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IMPORTANT NOTICE

TO DISTRIBUTORS, PURCHASERS AND END USERS OF MOD-U-BLAST PRODUCTS
The information provided described and illustrated in this material is intended for experienced, knowledgeable users of abrasive blasting equipment and supplies (products).

The products described in this material may be combined as determined solely by the user in a variety of ways and purposes. However no representations are made as to intended use, performance standards, engineering suitability, safe practices or compliance with government regulations and laws that apply to these products, products of others, or a combination of various products chosen by the user or others. It is the responsibility of the users of these products, products of third parties, and a combination of various products, to exercise caution and familiarize themselves with all applicable laws, government regulations and safety requirements.

Nor are representations made or intended as to the useful life, maintenance cycles, efficiency or performance of the referenced products of any combination of products. This material must not be used for estimating purposes. Production rates, labour performance or surface finishes are the sole responsibility of the user based on the user's expertise, experience and knowledge of industry variables.

It is the responsibility of the user to insure that proper and comprehensive training of operators has been performed and all environmental and safety precautions observed.

Mod-U-Blast Inc. provides a variety of excellent products to the surface preparation industry, and we are confident that all proficient users, operators and contractors in this industry will continue to use our products in a safe and knowledgeable manner.

Before using this product, read all instructions, literature, labels, specifications and warnings sent with and affixed to the unit.

If operation of the unit is unclear after reading this manual, contact your supervisor for instructions. It is the responsibility of the employer to read the following instructions to users of this equipment. Periodic inspection at the work site should be made by supervisory personnel to ensure the blast machine is being properly used and maintained. A copy of this owner's manual must be kept with the blast machine and readily accessible to the blast machine operators at all times.

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INTRODUCTION

This manual provides important information concerning the Mod-U-Blast Pressure Blast cabinet to ensure safe use of the equipment.



Before attempting to use this cabinet, please read these instructions for this Pressure Blast machine. This instruction manual should be kept in the pouch on the back of the cabinet.

NOTE: Attempting to operate this equipment without reading this manual will likely cause the equipment to fail, injury and/or may void the warranty.

IMPORTANT SAFETY INSTRUCTIONS



If you feel the equipment has been damaged or is in an unsafe condition, inform your supervisor and wait until the issue is resolved before using the equipment. If necessary, contact the manufacturer or an authorized representative in order to repair the damage.

IMPORTANT SAFETY INSTRUCTIONS!



WARNING: When using this Pressure Blast Cabinet basic precautions should always be followed, including the following:

1. Read all instructions before using this equipment.
2. This cabinet is meant for indoor use only.
3. Know how to stop the cabinet and release pressures quickly. Be familiar with all the controls.
4. Stay alert - watch what you are doing.
5. Never point the blast nozzle at the viewing window.
6. Do not disconnect air hoses while the system is under pressure.
7. Do not disable the safety door interlock system as this my cause unintentional blasting and injury.
8. When servicing the cabinet, disconnect and lock out the electrical & air supply.



WARNING: Check the power supply cords of this equipment at regular intervals for damage. If the power supply cords are found to be damaged, contact your supervisor and do not operate the machine until the repairs are made.



WARNING: Do NOT use this Pressure Blast Cabinet outdoors. (Indoor use only)



CAUTION: Install and use this equipment in a ventilated area free of flammable liquids or gases.



WARNING: Use proper respirator and eye protection when servicing any component in this blast system.



WARNING: Over time, exposure to any dust could result in lung medical issues or death. Use a reverse pulse dust collector with HEPA filters if lead or other toxic materials are removed from items during the blasting process.

DO NOT WELD OR GRIND ON THE BLAST VESSEL AS IT MAY CAUSE WEAK POINTS AND COULD CAUSE SERIOUS INJURY OR DEATH. THIS WILL VOID ANY WARRANTY COVERAGE.

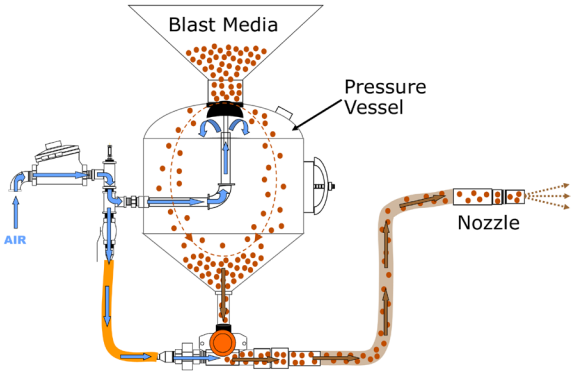
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BASIC PRINCIPLES

Mod-U-Blast Pressure Blast System Description:

Our pressure systems consists of these important components:
- Abrasive Blast cabinet
- Pressure pot
- Reclaimer
- Dust Collector
- Hepa Filter (optional with a reverse pulse dust collector)

How The Pressure Blast System Works



When the foot pedal is pressed, compressed air is introduced into the pressure vessel. The pop-up lifts and seals the vessel allowing it to pressurize which in turn pushes the media out through the metering valve at the bottom where it mixes with air and then travels through the blast hose and out the nozzle.

SET-UP REQUIREMENTS

Location

Before setting up your cabinet remember the following points:
- The Mod-U-Blast pressure blast cabinet requires a compressed air supply.
  NOTE: The compressed air supply to this unit should be dry & oil free.
- The cabinet needs a power supply (see next page for electrical information)
- This cabinet is designed to be used in a heated indoor location.
- Dust can escape from the cabinet while loading and unloading or while servicing the dust collector.

Compressed Air Requirements
- The compressed air supply should be sized according to this table below.

Compressed Air Line Size From Compressor To Blast Machine - In Inches

Pipe or Hose Length	VOLUME OF AIR IN CFM'S				
	25	30	35	40	50
25'	3/4	3/4	3/4	3/4	1
50'	3/4	3/4	3/4	1	1
75'	3/4	3/4	1	1	1
100'	3/4	3/4	1	1	1
150'	3/4	1	1	1	1

NOTE: DO NOT USE QUICK DISCONNECT COUPLERS AS THEY RESTRICT AMOUNT OF CFM'S REQUIRED TO OPERATE THESE MACHINES PROPERLY

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ELECTRICAL REQUIREMENTS

- Cabinet LED lights are always 110 volt supply.
- **Single Phase Cabinets:** For 1 Hp and lower motors plug cabinet into 110 volt supply. The blower motor is hard wired from the cabinet light box and the fan rotation is set and checked at the factory. Units with reverse pulse dust collectors will plug together with the cabinet light box.
- 2 Hp motors and up whether they are single or 3 phase power require a separate motor starter to be installed by a certified electrician. The fan must turn clockwise when viewed from the top of the motor.

COMPRESSED AIR REQUIREMENTS

Nozzle CFM Requirements

Nozzle Orifice Size	Air Pressure (psi)									
	20	30	40	50	60	70	80	90	100	125
No. 3 **	15 CFM	18 CFM	22 CFM	25 CFM	30 CFM	35 CFM	40 CFM	42 CFM	45 CFM	55 CFM
No. 4	27 CFM	32 CFM	41 CFM	47 CFM	54 CFM	61 CFM	68 CFM	74 CFM	81 CFM	98 CFM
No. 5	42 CFM	50 CFM	64 CFM	77 CFM	89 CFM	101 CFM	114 CFM	126 CFM	137 CFM	165 CFM

** Standard nozzle in P-Series cabinets. Nozzle CFM's listed above are with using a new nozzle - cfm numbers will increase as the nozzle becomes worn.

COMMON MEDIA TYPES

Glass Bead Ordering Information

Stock No.	Description	Size	Stock No.	Description	Size
71003	#3 (20-30 mesh) glass bead	20 Kg	71008	#8 (70-100 mesh) glass bead	20 Kg
71004	#4 (30-40 mesh) glass bead	20 Kg	71010	#10 (100-170 mesh) glass bead	20 Kg
71005	#5 (40-50 mesh) glass bead	20 Kg	71011	#11 (120-200 mesh) glass bead	20 Kg
71005	#6 (50-70 mesh) glass bead	20 Kg	71013	#13 (170-325 mesh) glass bead	20 Kg
71007	#7 (60-80 mesh) glass bead	20 Kg	71100	MGA MANUS Glass Abrasive	20 Kg

Aluminum Oxide Ordering Information

Stock No.	Description	Size	Stock No.	Description	Size
70080	80 grit Aluminum Oxide	50 lbs.	70180	180 grit Aluminum Oxide	50 lbs.
70100	100 grit Aluminum Oxide	50 lbs.	70220	220 grit Aluminum Oxide	50 lbs.
70120	120 grit Aluminum Oxide	50 lbs.			

10X - EpiX Ordering Information

Stock No.	Description	Size	Stock No.	Description	Size
KX1068	EpiX MP (70 to 90 grit)	50 lbs.	KX1078	EpiX LP (100 to 120 grit)	50 lbs.

Other Medias are available - please contact your Mod-U-Blast dealer for further information

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P-SERIES CABINET INSTALLATION P3636-6FH & P4836-6FH

Installations vary depending on the type of dust collector used. Refer to the serial tag for the cabinet model number.

Installation for cabinets with the reclaimer attached to the cabinet and using a dry filter dust collector (sock filters)

NOTE: Pressure cabinets using a dry filter dust collector will have the exhaust motor mounted on top of the cabinet reclaimer.

1. Remove all components from the pallets and/or packaging, and then refer to Fig. A, (below) for cabinet & dust collector preferred placement and flex hose connection. (see arrows)
2. When placing all components make sure to allow full access to the cabinet doors, reclaimer, dust collector hopper and for any future service needs.
3. Attach the flex hose from the reclaimer fan housing to the dry filter dust collector (flex hose supplied and located inside the dust collector).
4. Place the foot pedal at the front of the cabinet.
5. Minimum of 3/4" compressed air line will need to be attached (customer supplied) to the inlet side of the moisture separator mounted on the right front leg of the cabinet. (Refer to the chart on page 6 for proper air supply line, if distance is a factor)
6. Plug in the cabinet lights via the 3 pronged, 110 volt plug attached to the light housing into a 110 volt wall receptacle.
7. See the dust collector manual for proper set-up & connections.

P3636-6FH & P4836-6FH LAYOUT

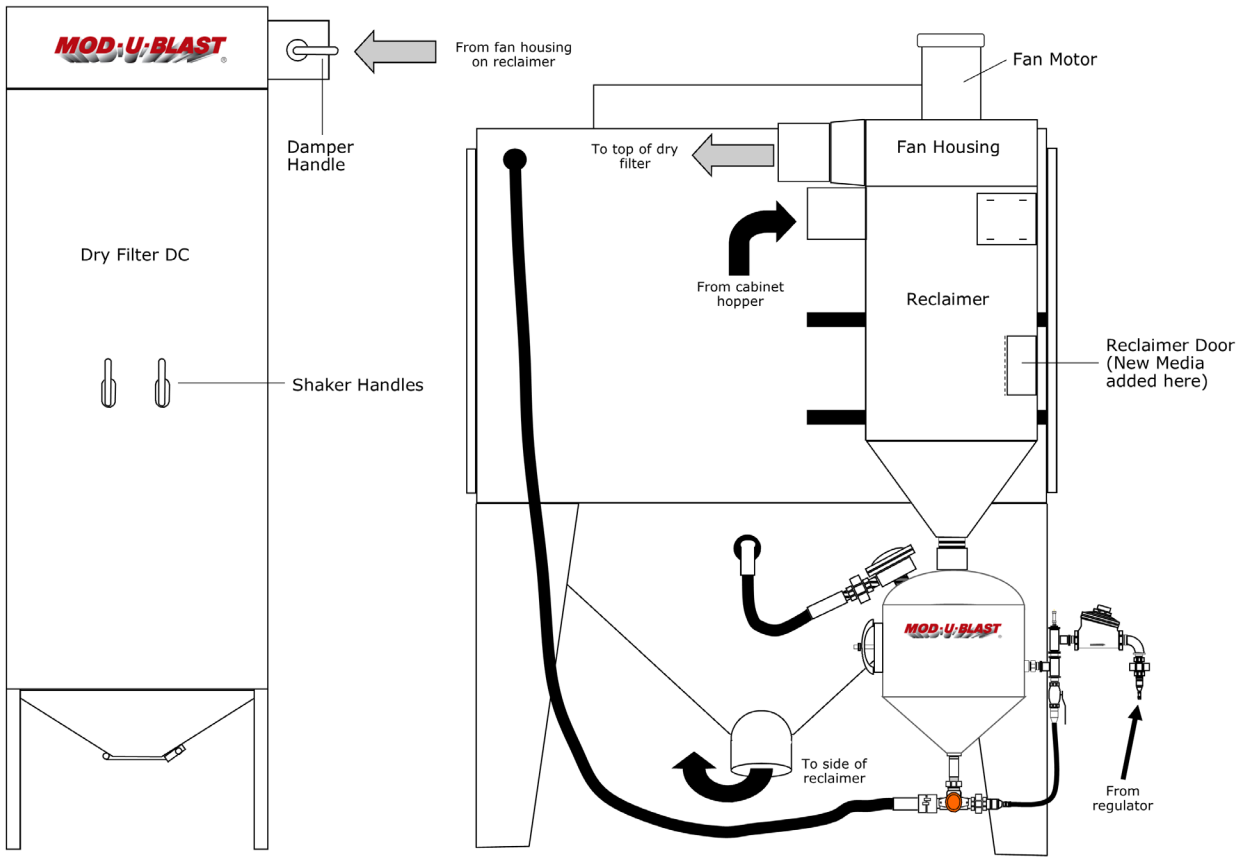


Fig. A

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P-SERIES CABINET INSTALLATION P3636-62C & P4836-62C

Installation for cabinets with the reclaimer mounted on the back of the cabinet and using a reverse pulse dust collector.

NOTE: Pressure cabinets using a reverse pulse dust collector will have the exhaust motor mounted on top of the dust collector.

1. Remove all components from the pallets and/or packaging, and then refer to Fig. B, (below) for cabinet & dust collector preferred equipment placement and flex hose connection. (see arrows)
2. When placing all components make sure to allow full access to the cabinet doors, reclaimer, dust collector hopper and for any future service needs.
3. Attach the flex hose from the top of the reclaimer to the side of the reverse pulse dust collector (flex hose supplied and located inside the cabinet.
4. Place the foot pedal at the front of the cabinet.
5. Minimum of 3/4" compressed air line will need to be attached (customer supplied) to the inlet side of the moisture separator mounted on the right front leg of the cabinet. (Refer to the chart on page 6 for proper air supply line, if distance is a factor)
6. Attached to the light box on top of the cabinet are 2 wires - one female and one male connection. Plug the 3 pronged male plug into a 110v receptacle on the wall and plug the female connector together with the male plug from the motor on the reverse pulse dust collector.
7. See the dust collector manual for proper set-up & connections.

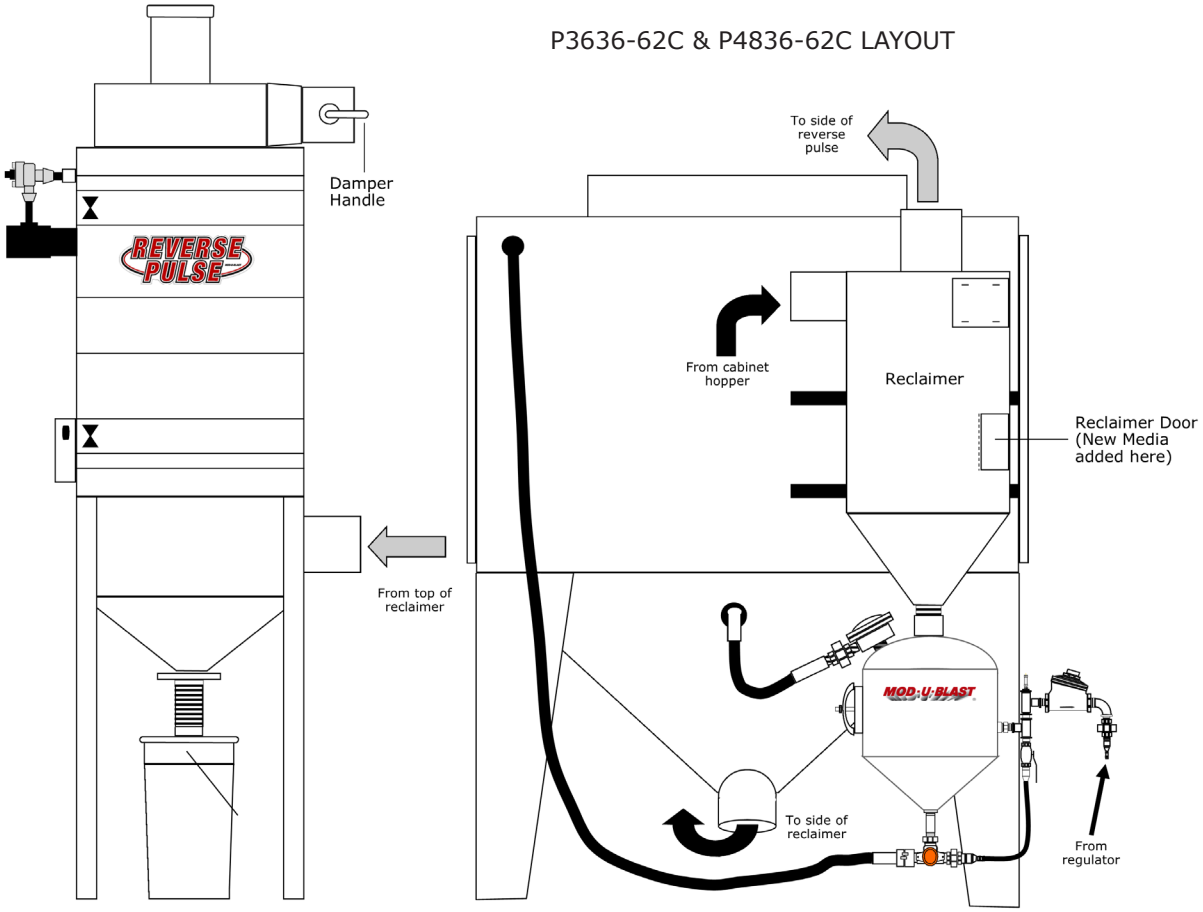


Fig. B

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P-SERIES CABINET INSTALLATION P4848-9FH, P6036-9FH & P6048-9FH

Installation for cabinets with an externally mounted reclaimer on a hopper using a dry filter dust collector.

1. Remove all components from the pallets and/or packaging, and then refer to Fig. C, (below) for cabinet preferred equipment placement and flex hose connection. (see arrows)
2. When placing all components make sure to allow full access to the cabinet doors, reclaimer, dust collector hopper and for any future service needs.
3. Attach the 6" flex hose from the bottom of the cabinet hopper to the side of the reclaimer. (This hose is heavy duty rubber lined when part of a optional wear kit)
4. Attach the 7" medium duty flex hose from the reclaimer fan housing to the side of dry filter dust collector (flex hose supplied and located inside the dry filter).
5. Attach the 3/4" air line from the regulator to the auto air valve on the pressure pot.
6. Attach the small pilot line from the rear leg of the cabinet to the auto air valve.
7. Attach the exhaust hose to the exhaust valve.
8. Attach the blast hose to the micro (grit) valve and pin the coupler.
9. Place the foot pedal at the front of the cabinet.
10. Minimum 3/4" compressed air line will need to be attached (customer supplied) to the inlet side of the moisture separator mounted on the right front leg of the cabinet. (An isolation ball valve should be installed to be able to shut off air supply when servicing)
11. Attached to the light box on top of the cabinet is a 3 pronged male plug. Insert into a 110v receptacle on the wall. This motor is a 2 hp unit and will need to be hard wired into a motor controller (optional) by a certified electrician.
12. See dust collector manual for proper set-up & connections.

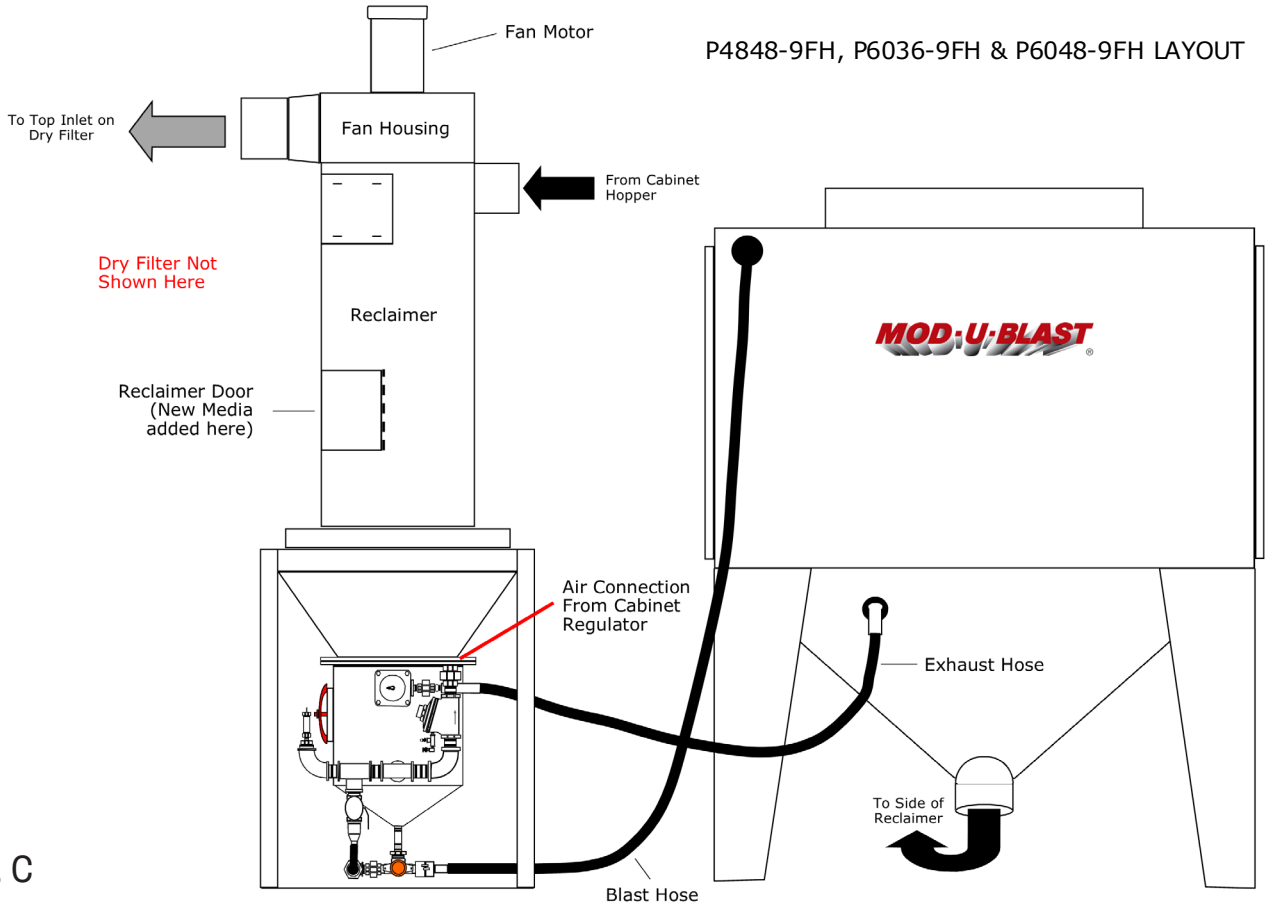


Fig. C

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P-SERIES CABINET INSTALLATION P4848-92C, P6036-92C & P6048-92C

Installation for cabinets with an externally mounted reclaimer on a hopper using a reverse pulse dust collector.

1. Remove all components from the pallets and/or packaging, and then refer to Fig. D, (below) for cabinet preferred equipment placement and flex hose connection. (see arrows)
2. When placing all components make sure to allow full access to the cabinet doors, reclaimer, dust collector hopper and for any future service needs.
3. Attach the 6" flex hose from the bottom of the cabinet hopper to the side of the reclaimer. (hose is heavy duty rubber lined when part of a optional wear kit)
4. Attach the 8" medium duty flex hose from the top of the reclaimer to the side of reverse pulse dust collector (flex hose supplied and located inside the cabinet).
5. Attach the 3/4" air line from the regulator to the auto air valve on the pressure pot.
6. Attach the small pilot line from the rear leg of the cabinet to the auto air valve.
7. Attach the exhaust hose to the exhaust valve.
8. Attach the blast hose to the micro (grit) valve and pin the coupler.
9. Place the foot pedal at the front of the cabinet.
10. Minimum 3/4" compressed air line will need to be attached (customer supplied) to the inlet side of the moisture separator mounted on the right front leg of the cabinet. (An isolation ball valve should be installed to be able to shut off air supply when servicing)
11. Attached to the light box on top of the cabinet is a 3 pronged male plug. Insert into a 110v receptacle on the wall. The motor is a 2 hp unit and will need to be hard wired into a motor controller (optional) by a certified electrician.
12. See dust collector manual for proper set-up & connections.

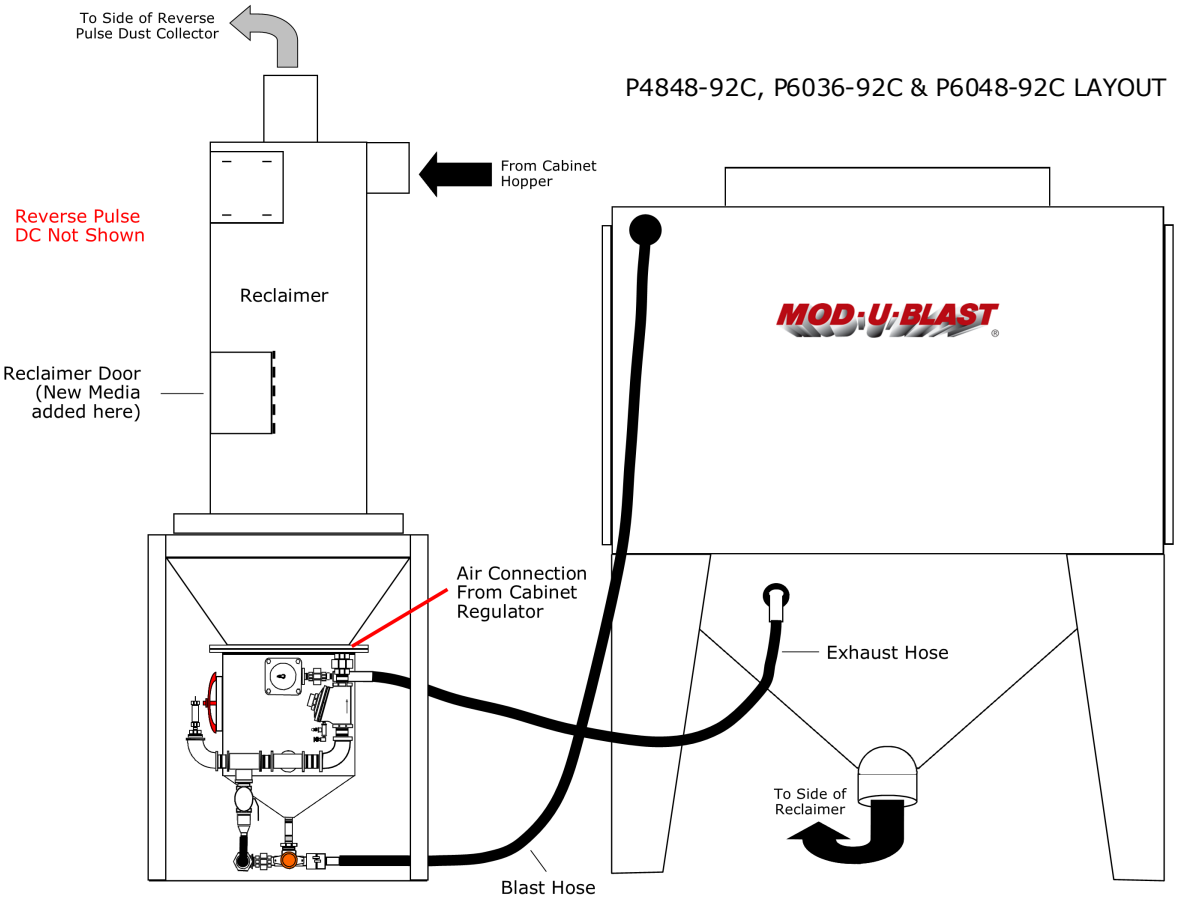


Fig. D

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P-SERIES CABINET INSTALLATION WITH 1.0 CU. FT. POT & FILTER

Installation for cabinets using a 1.0 cubic foot pressure pot with an externally mounted reclaimer using a dry filter or a reverse pulse DC.

1. Remove all components from the pallets and/or packaging, and then refer to Fig. E, (below) for cabinet preferred equipment placement and flex hose connection. (see arrows)
2. When placing all components make sure to allow full access to the cabinet doors, reclaimer, dust collector hopper and for any future service needs.
3. Attach the flex hose from the bottom of the cabinet hopper to the side of the reclaimer. (hose is heavy duty rubber lined when part of a optional wear kit)
4. Attach the medium duty flex hose from the top of the reclaimer to the side of reverse pulse DC or from the fan housing to the dry filter.
5. Attach the 3/4" air line from the regulator to the auto air valve on the pressure pot.
6. Attach the small pilot line from the rear leg of the cabinet to the auto air valve.
7. Attach the exhaust hose to the exhaust valve.
8. Attach the blast hose to the micro (grit) valve and pin the coupler.
9. Place the foot pedal at the front of the cabinet.
10. Minimum 3/4" compressed air line will need to be attached (customer supplied) to the inlet side of the moisture separator mounted on the right front leg of the cabinet. (An isolation ball valve should be installed to be able to shut off air supply when servicing)
11. Attached to the light box on top of the cabinet is a 3 pronged male plug. Insert into a 110v receptacle on the wall. The motor is a 2 hp unit and will need to be hard wired into a motor controller (optional) by a certified electrician.
12. See dust collector manual for proper set-up & connections.

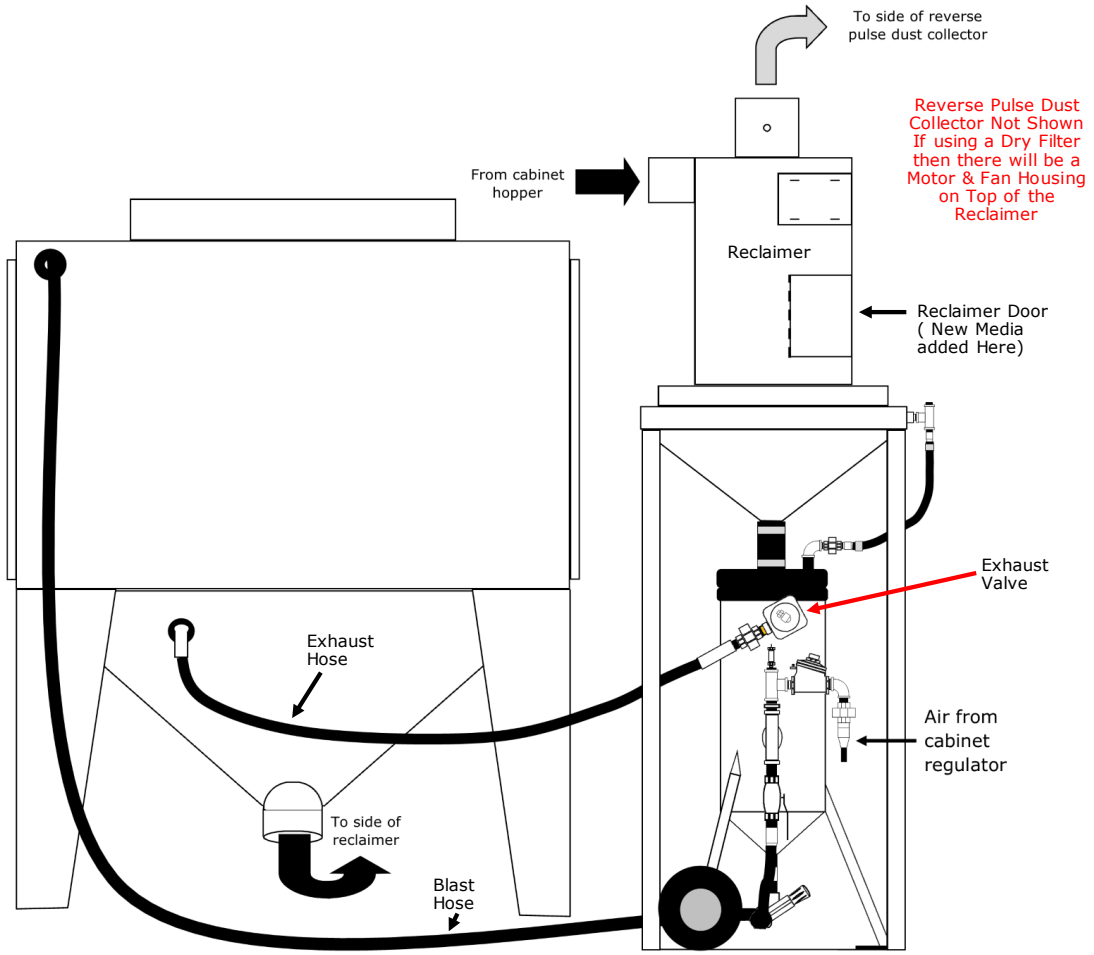


Fig. E

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P-SERIES CABINET OPERATION

Loading the Media Through the Reclaimer

1. 300 & 600 CFM systems use 0.7 cubic foot pressure pots which holds approx. 40 lbs. of media and the 0.9 cubic foot pressure pots hold 50 lbs.
2. With the exhaust fan off, add the new media through the swing door on the side of the reclaimer and pour the media through the screen into the bottom of the reclaimer hopper and into the pot.
3. Close the door on the reclaimer.

NOTE: DO NOT LOAD THE MEDIA DIRECTLY IN THROUGH THE CABINET DOORS, IF THIS IS DONE THE CABINET HOPPER HOSE WILL PLUG AND IT WILL HAVE TO BE REMOVED AND EMPTIED.

Loading Parts to be Cleaned

1. Load parts through either door on the cabinet
2. Parts need to be free of grease, oil, or water.
3. Close the door (s).

Preparation for Blasting

1. Open the compressed air used to supply the cabinet.
2. Turn on the cabinet lights & exhaust fan.
3. Adjust the regulator to desired blast pressure. (pull knob down to unlock, adjust pressure and push up to lock).
4. Open the Micro Valve at the bottom of the pressure pot located under the reclaimer about 4 turns from the bottom (CCW). (Will vary with size of the media used)

Blasting

1. Place hands into the gloves and grab the blast nozzle firmly.
2. Depress the foot pedal for the blasting to start.
3. Hold the nozzle approximately 6” to 8” from the item to be cleaned. Point nozzle at a 45° angle towards the part and use smooth, even strokes for best results. The media to air ratio will need to be fine tuned by adjusting the Micro valve. If the media flow is too heavy it will cause pulsating of the blast stream and media flow that is too light will not produce satisfactory results. Adjustments to the media valve should be made in 1/4 turn increments until proper media to air ratio is obtained.

Finish Blasting

1. To finish blasting, release pressure from the foot pedal.
2. Once the pot pressure has been evacuated into the hopper of the cabinet the pop-up in the pressure pot will drop to allow the good media that was reclaimed to fall back into the pot for reuse.
3. Use the blow gun inside the cabinet to blow off the part (s) that were just cleaned and allow the dust to clear before removing them from the cabinet.
4. Turn off the cabinet lights and the exhaust fan.

After Blasting Dust Collector Cleaning

- For dry filter dust collectors - clean the socks by using the shaker handle on the side by going back and forth about 10 times and then empty the hopper.
- For Reverse Pulse dust collectors with manual pulsing - clean the cartridge filters by pressing the buttons on the left front side of the dust collector one at a time holding for a 2 second period. Wait 3 seconds between pulses so that the air tank fills up. Repeat 10 times each. (The manual pulse system is discontinued - only auto pulse is available)
- For Reverse Pulse dust collectors with automatic pulsing - the auto pulse box is located on the left side of the dust collector. This pulse box can remain on while blasting but the filters are best cleaned when the exhaust/blower fan is off.

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P-SERIES CABINET MAINTENANCE

Maintenance Schedules

Daily Start-Up Procedure
- Check air pressure and adjust to desired setting
- Check & adjust media flow (if necessary)
- Correct any safety issues before blasting
- Report and / or fix any operational problems

Daily Maintenance
- Pulse or shake dust filters
- Empty dust collector
- Add required media through reclaimer (DO NOT OVERFILL)

Weekly Maintenance
- Inspect gloves
- Inspect nozzle for wear
- Clean screen on blast machine
- Check lights for proper operation
- Clean / Repair safety glass and/or window protector
- Inspect blast and exhaust hoses for holes or weak spots

Monthly Maintenance
- Inspect blast coupler gaskets for wear
- Inspect air hoses for leaks or loose fittings
- Check for quick shutdown of the following:
  - Foot pedal on cabinet
  - Door safety switches

Six Month Maintenance
- Check dust filters for cleanliness
- Inspect door seals
- Check for leaks in dust hoses
- Check for leaks in the cabinet

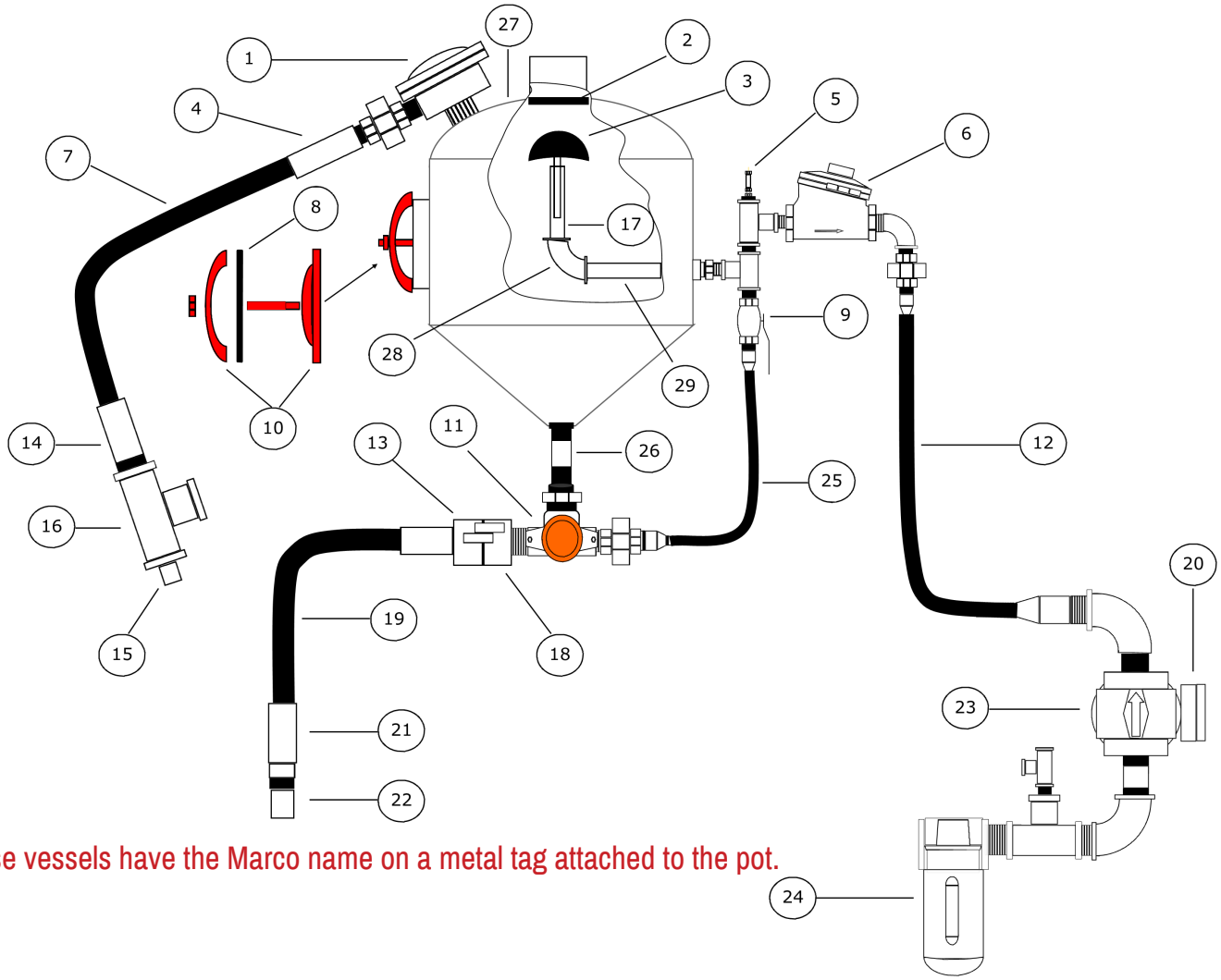
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For Supplies & Parts

Call 1.800.661.3842

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MARCO 'P' SERIES BLAST POT (0.7 CU. FT.) COMPONENTS



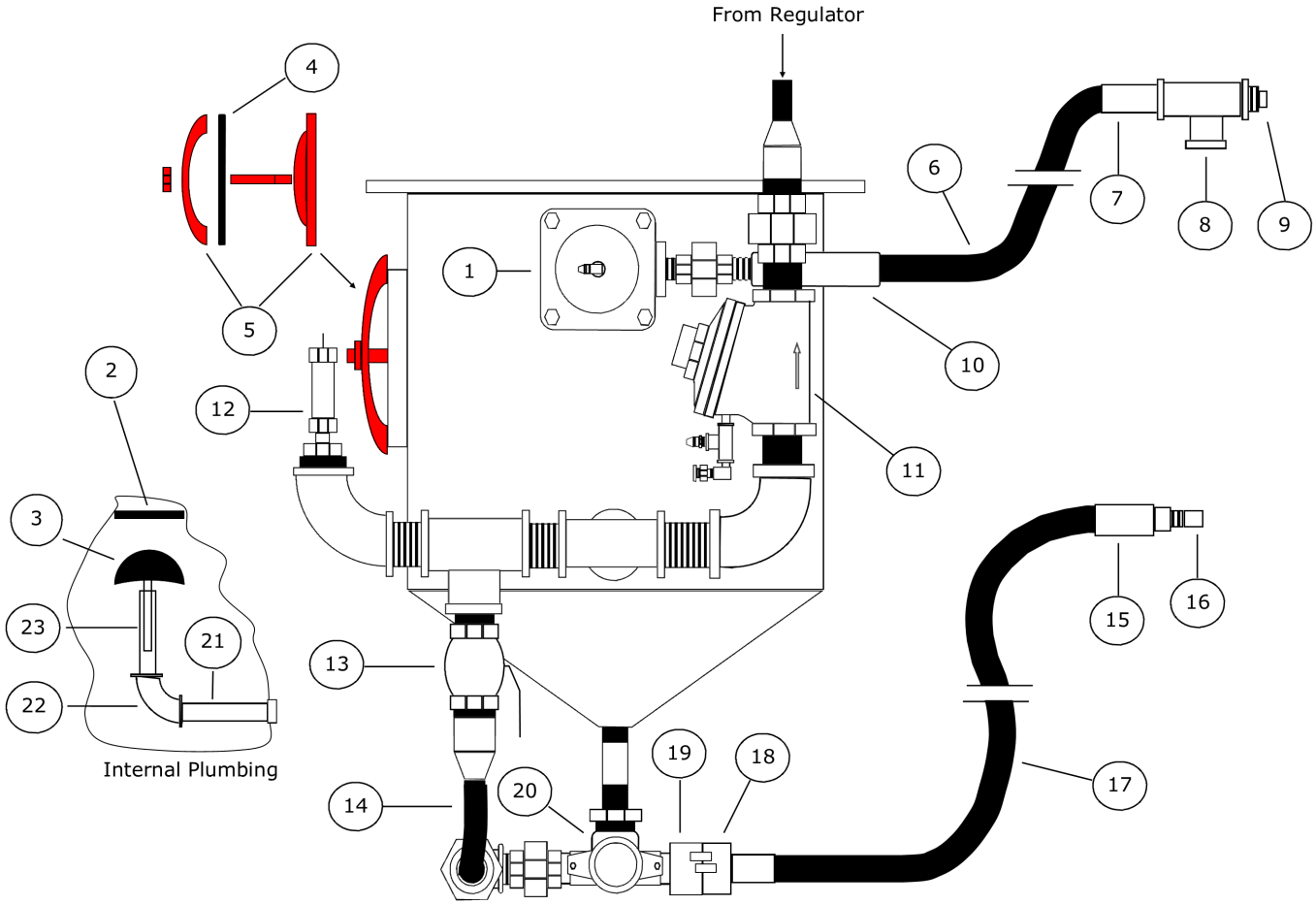
These vessels have the Marco name on a metal tag attached to the pot.

Item No.	Part Number	Description
1	EE03371	Exhaust Valve
2	MUS-10101132	Pop-Up Seal (Black)
3	MUS-1010133	Pop-Up (Black)
4	60500	Coupler (Female Threads)
5	51202-125	Pressure Relief Valve
6	280750	Air Inlet Valve
7	SB050-2	Exhaust Hose
8	22618	Gasket
9	65-775	Ball Valve (Choke)
10	MUS-10101752	Hatch Assembly
11	EE2125-107	Micro Valve
12	34 AIR	3/4" Air Hose
13	60508	Blast Hose Coupler
14	60432	Coupler (Male Threads)
15	PI-10	1" Plug
16	Tee-10	1" Tee

Item No.	Part Number	Description
17	MUS-20100569	Pipe Nipple
18	605250	Tank Coupler
19	SB050-2	1/2" Blast Hose
20	55415	Pressure Gauge
21	60499	Nozzle Holder
22	31063	# 3 Nozzle
	31064	# 4 Nozzle
	31065	# 5 Nozzle
23	50-350	3/4" Regulator
24	50-150	3/4" Moisture Separator
25	34 AIR	3/4" Air Hose
26	290181	Pipe Nipple
27	MUS-10109742	0.7 Cu. Ft Pressure Vessel
28	MUS-10101002	Elbow 1" x 1/2" - 90°
29	MUS-10109751	Pipe Nipple 1" x 4-1/2"L

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MARCO 'P' SERIES FLANGED BLAST POT (0.9 CU. FT.) COMPONENTS



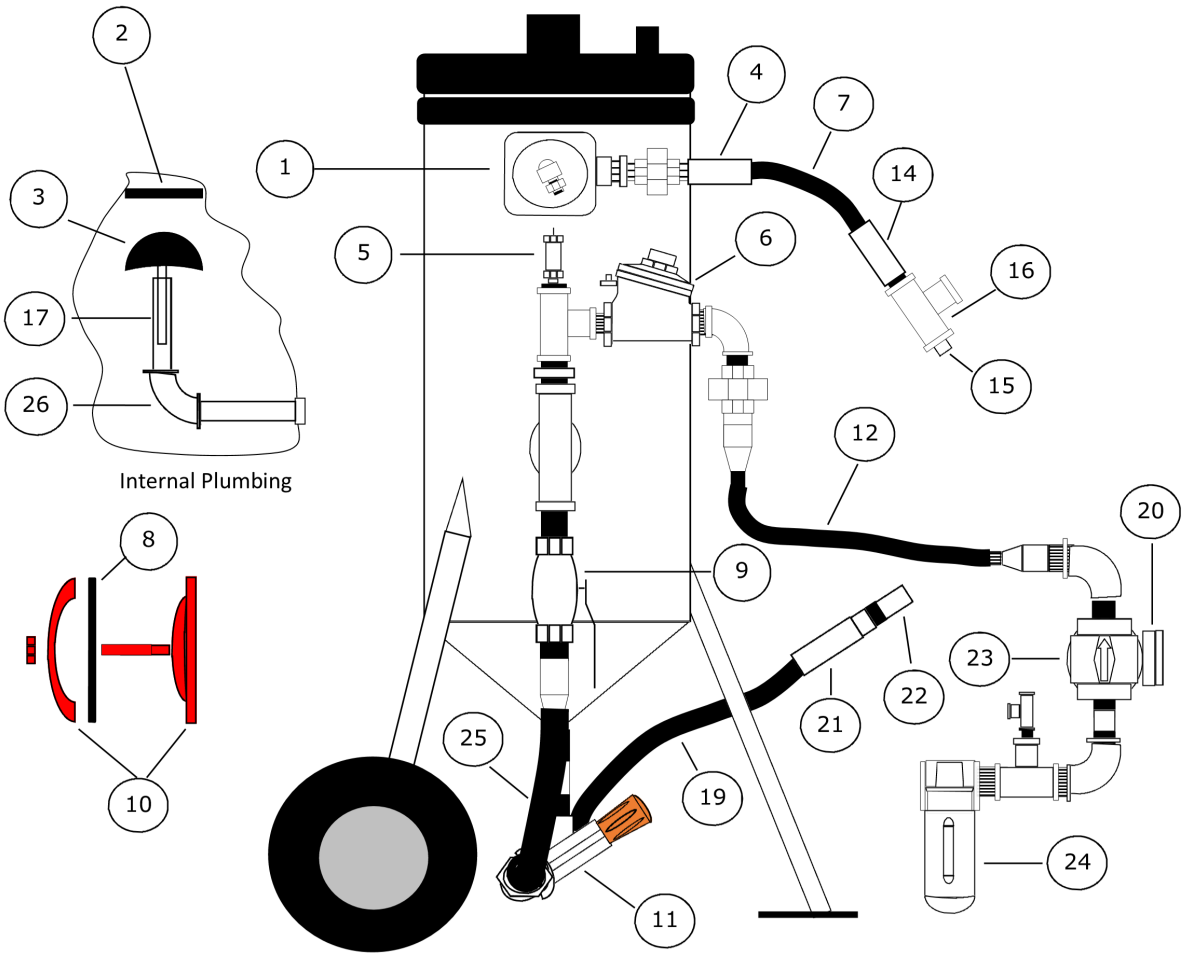
These vessels have the Marco name on a metal tag attached to the pot and they are attached to a media hopper.

Item No.	Part Number	Description
1	EE03371	Exhaust Valve
2	MUS-10101132	Pop-Up Seal
3	MUS-1010133	Pop-Up
4	22618	Gasket
5	MUS-10101752	Hatch Assembly
6	SB050-2	Exhaust Hose
7	60500	Coupler (Male Threads)
8	TEE 10	1" TEE
9	PL-10	1" Plug
10	60500	Coupler (Female Threads)
11	280750	3/4" Air Inlet Valve
12	51202-125	Pressure Relief Valve
13	65-775	3/4" Ball Valve (Choke)

Item No.	Part Number	Description
14	34 AIR	3/4" Air Hose
15	60499	Nozzle Holder
16	31063	# 3 Nozzle
	31064	# 4 Nozzle
	31065	# 5 Nozzle
17	SB050-2	Blast Hose
18	60508	Blast Hose Coupler
19	605250	Tank Coupler
20	EE2125-107	Micro Valve
21	MUS-10109831	Pipe Nipple 1" x 5-1/2"L
22	MUS-10101002	Elbow 1/2" x 1" - 90°
23	MUS-10108188	Pipe Nipple 1/2" x 4"

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MARCO 'P' SERIES BLAST POT (1.0 CU. FT.) COMPONENTS



NOTE: Part umbers 13 & 18 not shown. They connect the blast hose to the part number 11.

Item No.	Part Number	Description
1	EE03371	Exhaust Valve
2	MUS-10101132	Pop-Up Seal (Black)
3	MUS-1010133	Pop-Up (Black)
4	60500	Coupler (Female Threads)
5	51202-125	Pressure Relief Valve
6	280750	Air Inlet Valve
7	SB050-2	Exhaust Hose
8	22618	Gasket
9	65-775	Ball Valve (Choke)
10	MUS-10101752	Hatch Assembly
11	EE2125-107	Micro Valve
12	34 AIR	3/4" Air Hose
13	60508	Blast Hose Coupler
14	60432	Coupler (Male Threads)

Item No.	Part Number	Description
15	PI-10	1" Plug
16	Tee-10	1" Tee
17	MUS-10L803057	Pipe Nipple 1/2" x 7.5"L
18	605250	Tank Coupler
19	SB050-2	1/2" Blast Hose
20	55415	Pressure Gauge
21	60499	Nozzle Holder
22	31063	# 3 Nozzle
	31064	# 4 Nozzle
	31065	# 5 Nozzle
23	50-350	3/4" Regulator
24	50-150	3/4" Moisture Separator
25	34 AIR	3/4" Air Hose
26	MUS-10101002	Elbow 1" x 1/2" - 90°

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P-SERIES CABINET PARTS

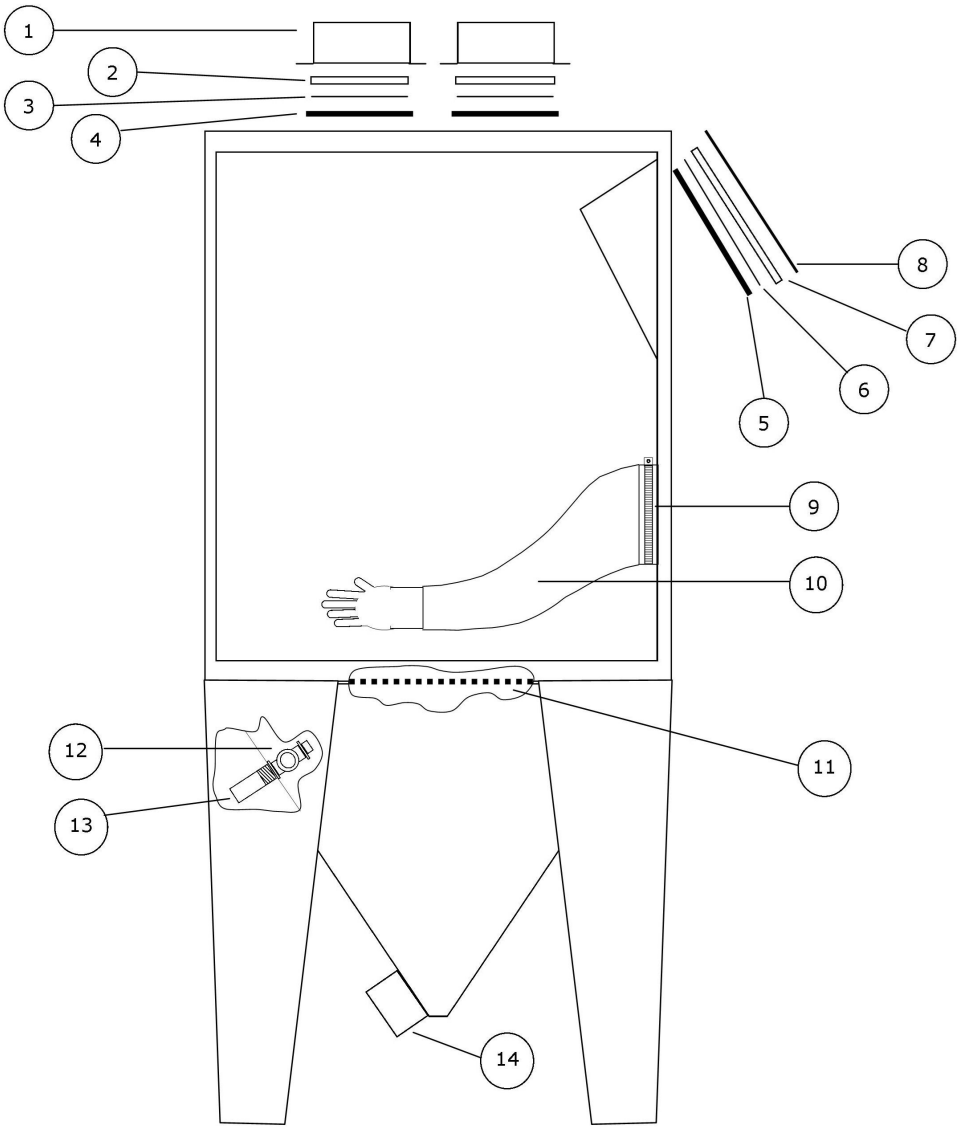


Fig. E

Item	Part Number	Description
1	ZLAMP B	LIGHT HOUSING
2	12215A	WINDOW
3	43518S	WINDOW PROTECTOR
4	16540	TRIM LOK (5 FT)
5	16540	TRIM LOK (5 FT)
6	SP-2011191	MYLAR ROLL
7	12216	WINDOW

Item	Part Number	Description
8	16053	WINDOW FRAME
9	12535	GLOVE CLAMP
10	15270	GLOVES (SET)
11	ZF4836H	PERFORATED FLOORING
12	TEE 10 & PL 10	1" TEE & 1" PLUG
13	60432	HOSE COUPLER
14	ZPL6F	CABINET HOPPER FLANGE

Item # 11 - The perforated floor listed is for a typical P4836 cabinet
Ask your representative for other pressure cabinet available floor sizes

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P-SERIES CABINET PARTS - CONT'D

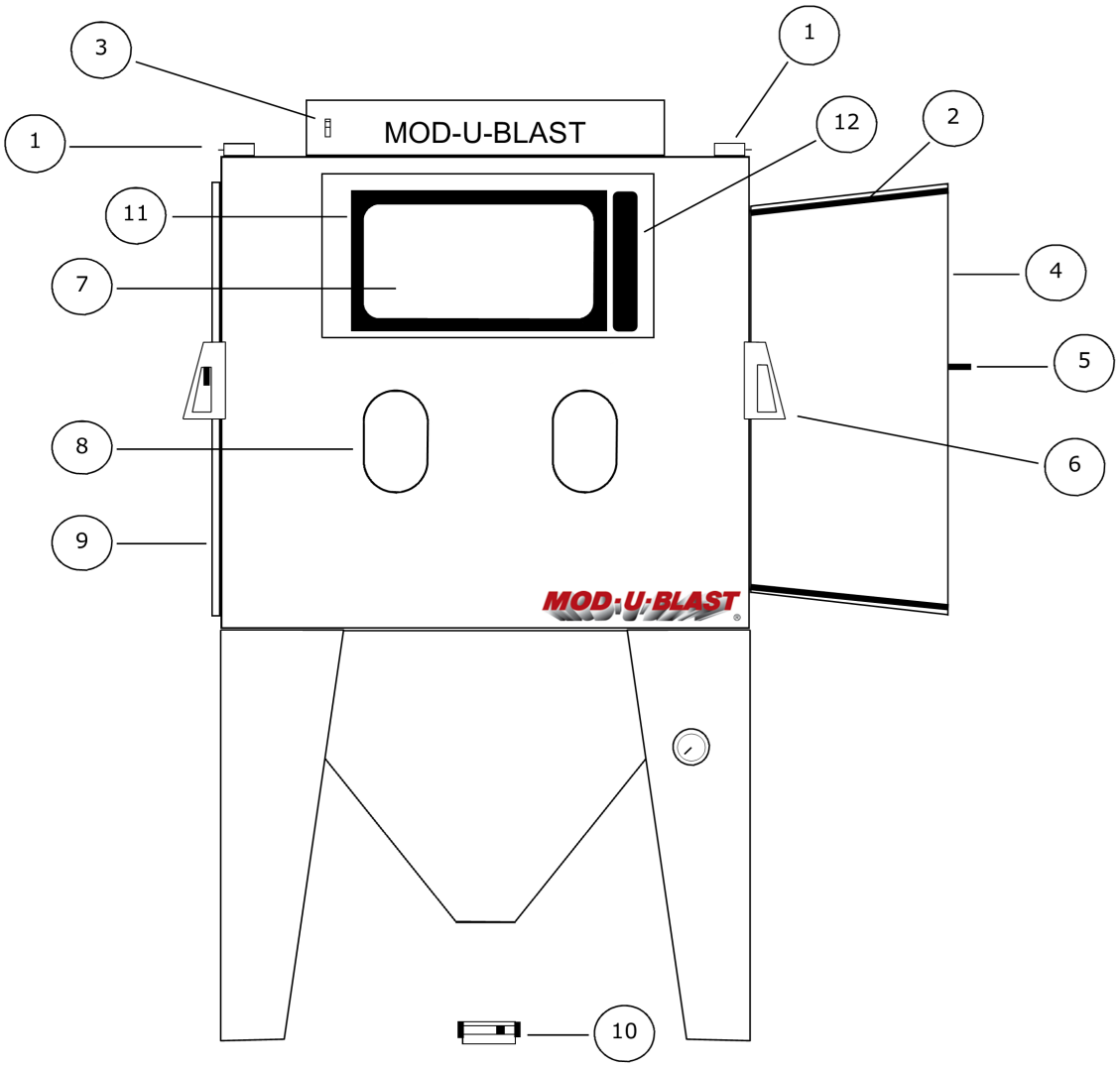


Fig. F

Item	Part Number	Description
1	12202	DOOR SAFETY SWITCH
2	12433-2	DOOR GASKET
3	16371	LIGHT SWITCH
4	ZDR36	RIGHT DOOR
5	Z-HANDLE	DOOR HANDLE
6	Z-LATCH	DOOR LATCH

Item	Part Number	Description
7	12216	VIEWING WINDOW
8	16542	GLOVE TRIM
9	ZDL36	LEFT DOOR
10	16210	FOOT PEDAL
11	16052	4 BOLT WINDOW FRAME
12	16051	MYLAR DISPENCER

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P-SERIES CABINET & PILOT LINE SCHEMATIC & PARTS

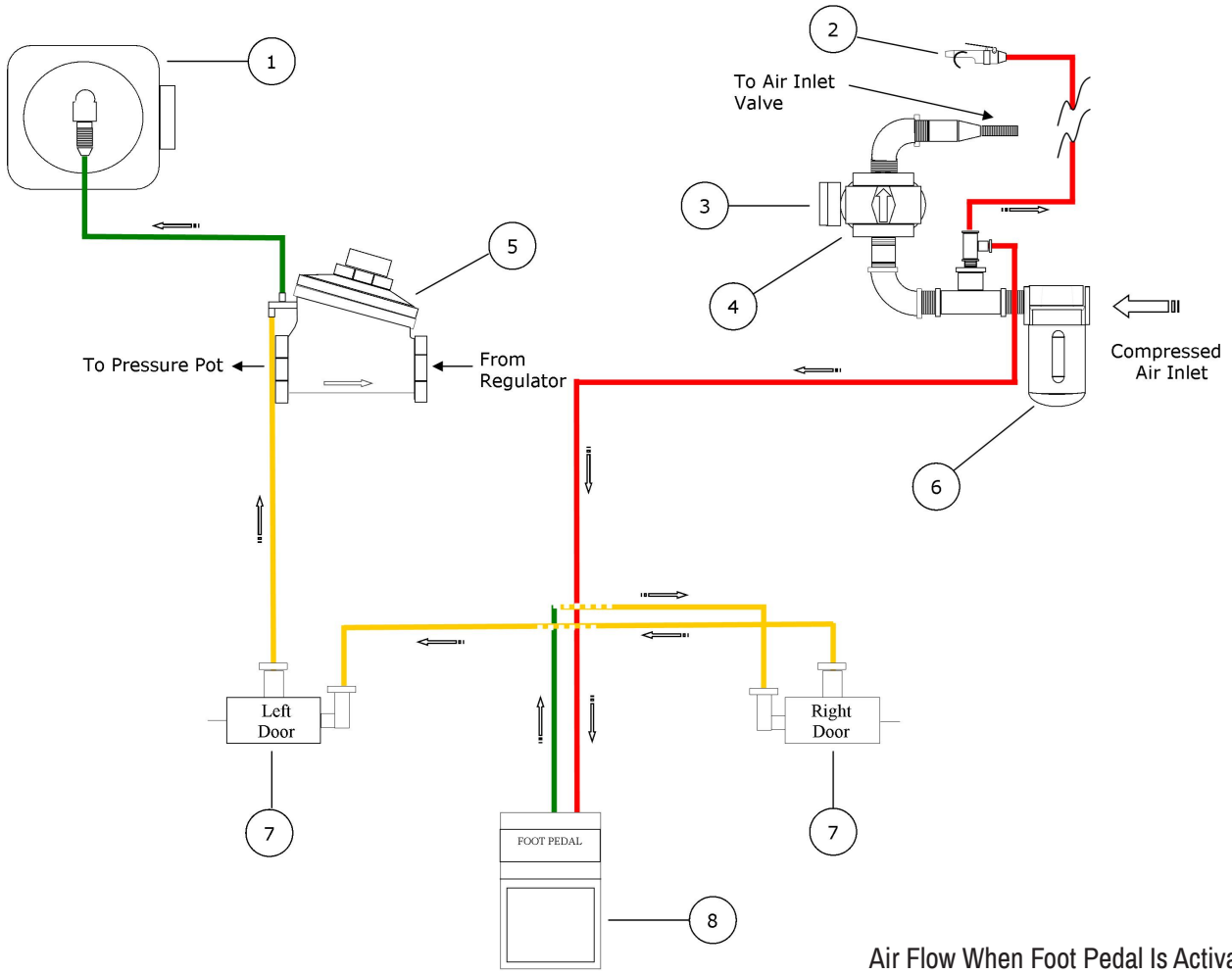


Fig. G

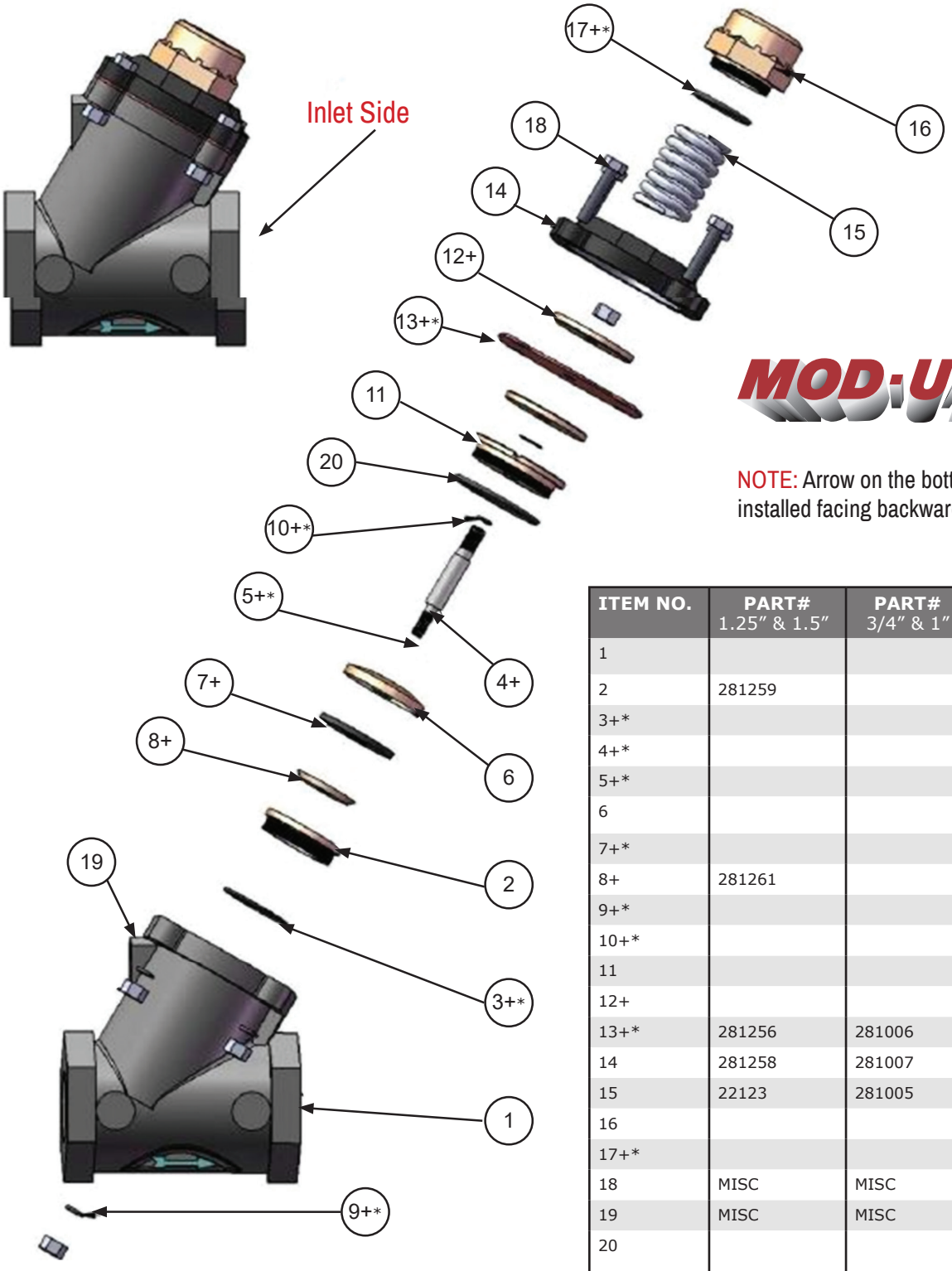
Air Flow When Foot Pedal Is Activated

Item	Part Number	Description
1	EE03371	Exhaust Valve
2	60-110P	Blow Gun
3	55-415	Pressure Gauge
4	50-350	3/4" Regulator

Item	Part Number	Description
5	280750	3/4" Air Inlet Valve
6	51-150	3/4" Moisture Separator
7	12202	Safety Door Interlock Switch
8	16210	Pressure Foot Pedal

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AUTO AIR VALVE



MOD-U-BLAST®

NOTE: Arrow on the bottom of this valve always installed facing backwards to incoming air flow.

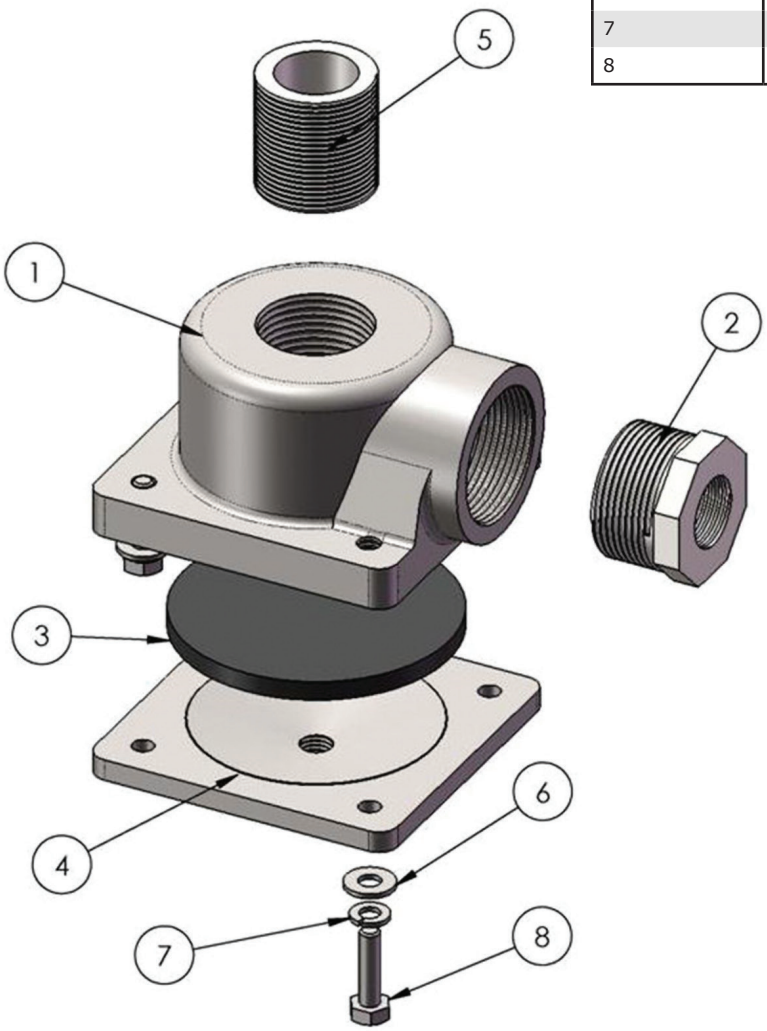
ITEM NO.	PART# 1.25″ & 1.5″	PART# 3/4″ & 1″	DESCRIPTION
1			BODY
2	281259		SEAT
3+*			O-RING/THICK
4+*			SHAFT
5+*			WASHER/COPPER
6			DISC RETAINER
7+*			RUBBER DISC
8+	281261		DISC PLATE
9+*			LOCK WASHER 1/4″
10+*			O-RING FOR SHAFT
11			RETAINER BUSHING
12+			DIAPHRAGM PLATE
13+*	281256	281006	DIAPHRAGM
14	281258	281007	CAP
15	22123	281005	SPRING
16			SPRING RETAINER
17+*			O-RING/THIN
18	MISC	MISC	BOLT-1/4″
19	MISC	MISC	NUT
20			O-RING FOR RETAINER BUSHING
-	281500		AUTO AIR VALVE 1-1/2″
-	281250		AUTO AIR VALVE 1-1/4″
-		280750	AUTO AIR VALVE 3/4″
-		281000	AUTO AIR VALVE 1″

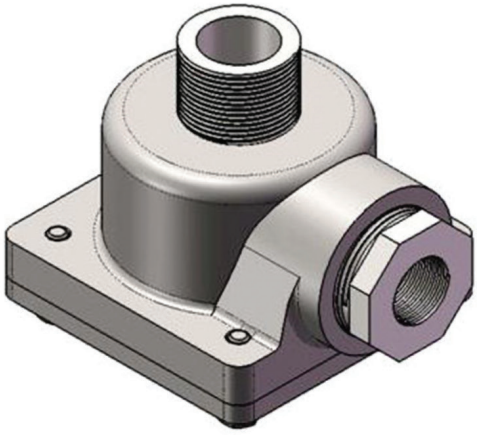
SEAL KIT:* 3/4" & 1" - PART # EE2123-006-99
1-1/4" & 1-1/2" - PART # EE212300-799
REPAIR KIT: + 3/4" & 1" - PART # 281003
1-1/4" & 1-1/2"- PART # 281253

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1” DIAPHRAM DUMP VALVE (EE03371)

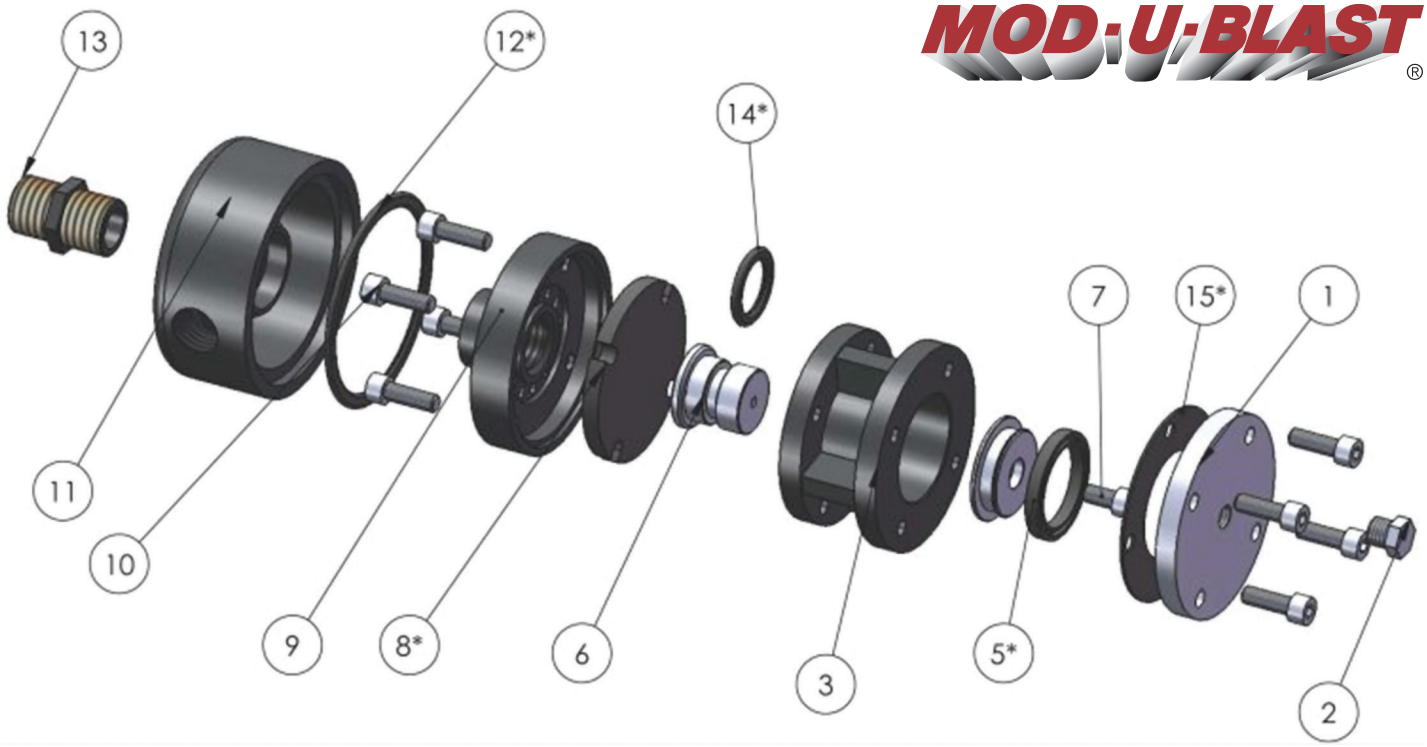
ITEM NO.	PART#	DESCRIPTION	QTY.
1		MAIN BODY	1
2		REDUCER BUSHING	1
3	EE06149	DIAPHRAGM	1
4		TOP PLATE	1
5		STEEL PIPE	1
6		PREFERRED NARROW FW 0.25	4
7		REGULAR LW 0.25	4
8		HBOZLT 0.2500-20X1X1-N	4





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DUMP VALVE (290375)





OLDER STYLE

ITEM NO.	PART#	DESCRIPTION
1	290315	BOTTOM PLATE 1/4" NPT
2	PL02	PLUG 1/4" BSP
3	290313	BLEED OFF CYLINDER HOUSING
4	290330	PISTON
5*	290331	PISTON SEAL
6	290321	BLEED OFF CYLINDER
7	290306	SCREW M8X25
8*	290325	DIAPHRAGM
9	290310	BLEED OFF MANIFOLD 3/4" NPT
10*	290306	SCREW M8X25
11	290314	TOP COVER
12*	290311	O RING FOR MANIFOLD
13	41-1305	NIPPLE 3-4 BSP
14*	290327	BLEED CYLINDER O-RING
15*	290316	GASKET

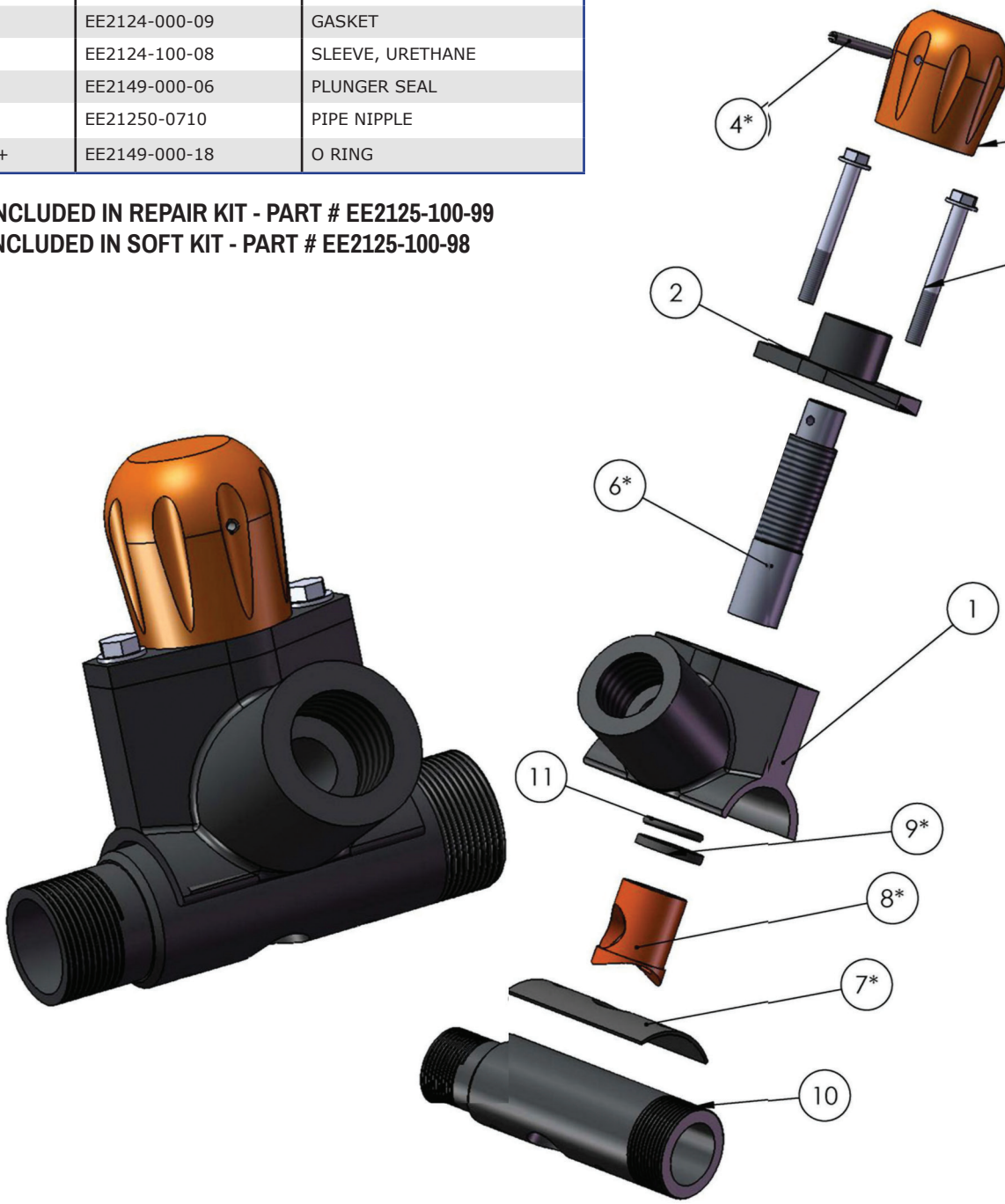
*** INCLUDED IN REPAIR KIT - PART # 290380**

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M-VALVE (EE2125-107)

ITEM NO.	STOCK NO.	DESCRIPTION
1	EE2124-000-06	BODY
2	EE2125-000-02	CAP
3	EE2125-000-01	KNOB
4*	EE2125-000-03	ROLL PIN
5	EE7010-505-56	BOLT WITH WASHER
6*	EE2125-000-05	PLUNGER
9*+	EE2124-000-09	GASKET
7*+	EE2124-100-08	SLEEVE, URETHANE
8*+	EE2149-000-06	PLUNGER SEAL
10	EE21250-0710	PIPE NIPPLE
11*+	EE2149-000-18	O RING

*** - INCLUDED IN REPAIR KIT - PART # EE2125-100-99**
+ - INCLUDED IN SOFT KIT - PART # EE2125-100-98



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P-SERIES TROUBLESHOOTING

Problem	Possible Cause	Remedy
Blast cabinet pressure pot will not pressurize	Air supply is off	Open valve from compressor to cabinet
	Insufficient air supply	Check for air supply restriction and proper inlet hose size
	Exhaust valve	Check diaphragm in exhaust valve for holes
	Pilot line (s) leaking	Check all green, red and clear hoses for leaks
	Pop-up leaking	Check pop-up and seal
	Regulator pressure off or set to low	Check pressure at regulator and adjust
No air or media from nozzle	Choke and/or media valve closed	Open the and/or adjust the media valve
	Clogged nozzle	Remove the nozzle from the coupler and clear the blockage
	Clogged blast hose	Remove the nozzle and disconnect the blast hose from the tank coupling attached to the axial valve. Blow air through the hose to see if it is plugged.
Air but no media flow from nozzle	No media in vessel	Check for media in vessel and fill if necessary
	Media metering valve closed	Open the metering valve and adjust for proper flow
	Damp media or object blocking flow at base of vessel	While trying to blast have someone quickly close and open the choke valve. (Part #9 pg. 13) If blockage persists remove the hand-way and check in blast vessel for obstructions
Media flow to heavy or pulsing when blasting	Media metering valve open or closed too much	Adjust metering valve for smooth steady stream
	Choke valve is partially closed	Open choke valve completely
Low pressure at nozzle	Nozzle worn out	Change nozzle
	Air supply hose too small	Use proper supply hose
	Hole in blast hose	Replace blast hose
	Pop-up not sealing properly	Check pop-up and seal for smoothness. Any ridges or rough areas will cause the pop-up to leak
	Hand-way leaking	Replace hand-way gasket
	Auto air valve leaking from top vent	The diaphragm may be damaged, defective or worn out - replace diaphragm.
	Choke valve is partially closed	Open choke valve completely
	Media metering valve open to far	Adjust metering valve for a smooth steady stream
	Clogged nozzle	Remove nozzle from the coupler and clear the blockage

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P-SERIES TROUBLESHOOTING - CONT'D

Problem	Possible Cause	Remedy
Poor visibility	Dirty filters	Shake or pulse filters - if problem still persists filters may need changing
	Cabinet air intake holes plugged	Check to see if the cabinet air intake holes on top are covered
	Motor rotation is in reverse	Check that motor is rotating in direction of the arrow located on top of the motor
	Hole in dust collector flex hose	Check for leaks and replace
	Worn paddle wheel	Check paddle wheel for wear and replace if needed
Static shock will blasting	Cabinet and/or operator not grounded	Ground cabinet. Attach a wrist ground strap to the operator. Avoid holding parts off of the flooring so that static can be dissipated through the cabinet
Dust leaking from cabinet	Dust socks or cartridge filters may be plugged	Check socks or cartridges for clogging and replace
	Doors leaking	Replace door seals
Dust leaking from dust collector	Improperly seated dust sock	Check all dust socks seats for proper installation
	Loose filter cartridge	Cartridges must be seated so that the seal on top compresses without crushing the filter cartridge
	Dust sock (s) or cartridges are damaged	Replace sock (s) or cartridges

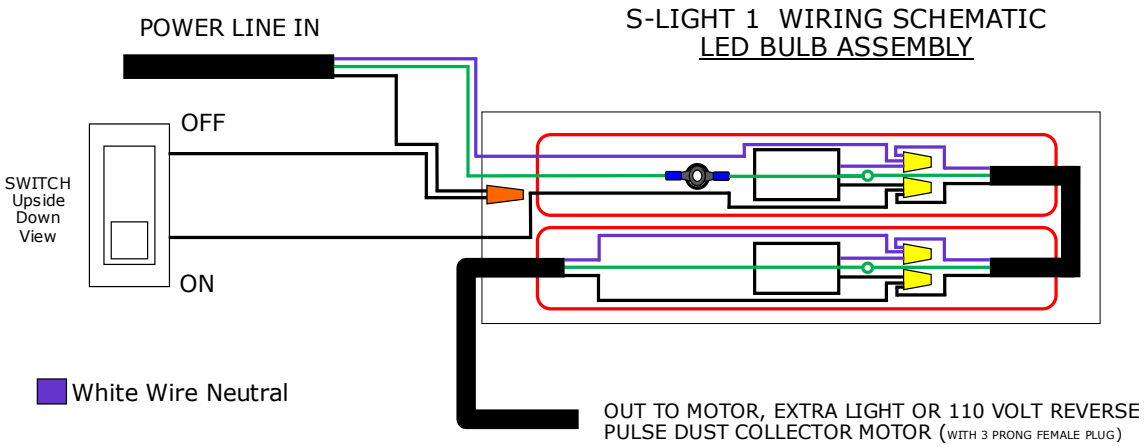
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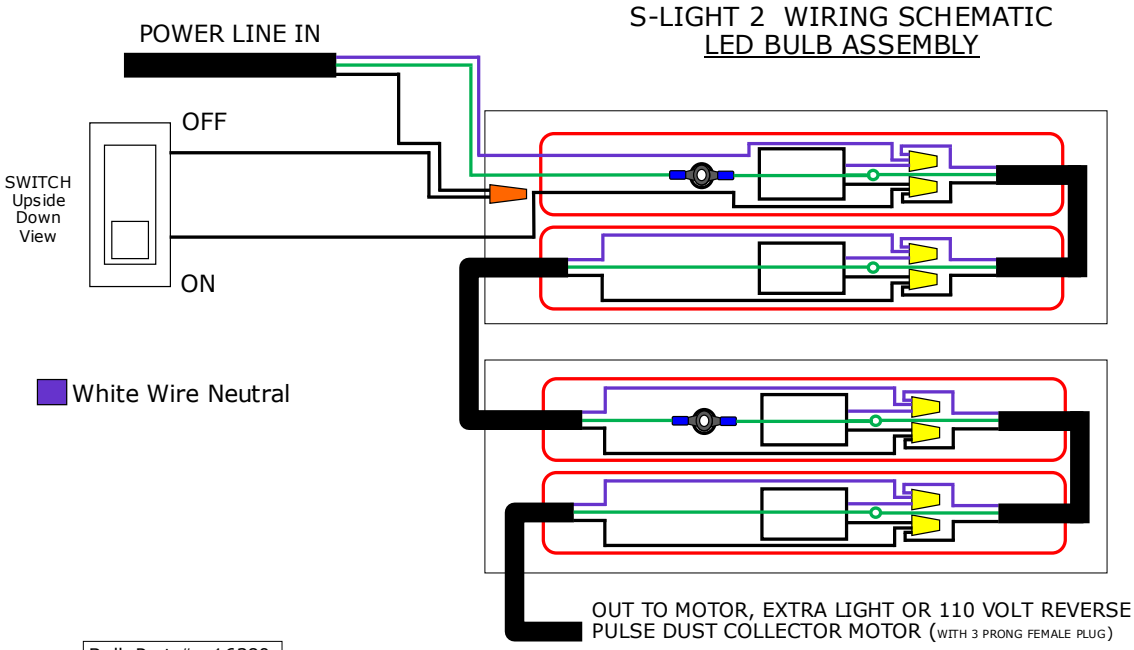
For Supplies & Parts

Call 1.800.661.3842

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P-SERIES LIGHTING LED BULBS - NEW BULB STYLE





Bulb Part # - 16380



Bulb Assembly Outlined
in RED

CHANGED TO NEWER STYLE LIGHT SCHEMATIC - AUGUST 2024

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WARRANTY POLICY COVERAGE

Allredi warrants all equipment listed in this manual that is manufactured by Mod-U-Blast to be free of defects in material and workmanship from the date of sale to the end-user. Not withstanding any special, extended or limited warranty published by Mod-U-Blast will, for a period of TWELVE (12) months from the date of sale, repair or replace any part of the equipment determined by Mod-U-Blast to be defective.

This warranty applies only when the equipment is installed, operated and maintained in accordance with Mod-U-Blast's written recommendations.

This warranty does not cover, and Mod-U-Blast will not be liable for general wear and tear, or any malfunction, damage or wear caused by faulty installation, misapplication, abrasion, corrosion, inadequate or improper maintenance, negligence, accident, tampering, or substitution of non-Mod-U-Blast component parts.

This warranty is conditional upon the prepaid return of the equipment or part claimed to be defective to an authorized Mod-U-Blast distributor for verification of the claimed defect. (Proof of purchase may be required) If found to be defective then the Mod-U-Blast distributor will repair or replace free of charge any defective part. The equipment will be returned to the original purchaser, transportation prepaid. If the inspection of the equipment does not disclose any defect in material workmanship, repairs will be made at a reasonable charge, which charges may include the costs of parts, labor, and transportation.

THIS WARRANTY IS EXCLUSIVE, AND IS IN LIEU OF ANY OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO WARRANTY OF MERCHANTABILITY OR WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE.

Mod-U-Blast's obligation and buyer's remedy for any breach of warranty shall be as set forth above. The buyer agrees that no other remedy (including, but not limited to, incidental or consequential damages for lost profits, lost sales, injury to person or property, or any other incidental or consequential loss) shall be available. Any action for breach or warranty must be brought forward within one (1) year of the date of sale.

Items sold, but not manufactured by Mod-U-Blast are subject to the warranty, if any, of their manufacturer. Mod-U-Blast will provide the purchaser with reasonable assistance in making any claim for the breach of these warranties.

The following items are <u>not covered</u> under the Mod-U-Blast Warranty policy:

- Any component or body of this equipment determined by Mod-U-Blast to be normal wear and tear.
- Parts subject to abrasive wear such as, nozzles, hoses, gloves, windows, window protectors, cabinet flooring and dust filters.

Claims will be honored only if the warranty card is returned within a period of two months from the factory shipping date.

The card can be returned to your Mod-U-Blast salesperson or mailed to the address below.

ALLREDI BLAST & ABRASIVES
6602-45 Street, Leduc, AB Canada, T9E 7C9
PH: (780) 468-2588 • FAX: (780) 465-7317

In the event of failure of this equipment Please contact an Allredi/Mod-U-Blast service centre

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