NOZZLE and AIR JET SELECTION CHART

*NOTE* - We recommend a minimum of 3/8" ID Air Hose for best results. Air requirements in cfm are listed below (3 possible nozzle/air jet setups).

**NOZZLES AND AIR JETS SOLD IN PKG OF 3 (EXCEPT 6350-90 CARBIDE NOZZLE)**

**Small**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>6314-03</td>
<td>Gold Jet 5/64&quot;</td>
</tr>
<tr>
<td>6311-03</td>
<td>Gold Jet 13/64&quot;</td>
</tr>
<tr>
<td>6317-03</td>
<td>White Jet 13/64&quot;</td>
</tr>
</tbody>
</table>

**Medium**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>6315-03</td>
<td>Silver Jet 7/64&quot;</td>
</tr>
<tr>
<td>6312-03</td>
<td>Silver Jet 1/4&quot;</td>
</tr>
<tr>
<td>6310-03</td>
<td>White Jet 1/4&quot;</td>
</tr>
<tr>
<td>6300-90</td>
<td>Grey Jet 1/4&quot;</td>
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</tbody>
</table>

**Large**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>6316-03</td>
<td>Black Jet 5/32&quot;</td>
</tr>
<tr>
<td>6313-03</td>
<td>Black Jet 5/16&quot;</td>
</tr>
<tr>
<td>6350-90</td>
<td>Black Jet 15/32&quot;</td>
</tr>
</tbody>
</table>

**MOST POPULAR SETUP IS MEDIUM NOZZLE AND AIR JET**

ROTATE NOZZLE 1/4 TURN FOR EACH ONE HOUR OF USE FOR LONGER LIFE. IMPORTANT - Nozzles and Air Jets must be changed in sets (Med Air Jet with Med Nozzle, Small Air Jet with Small Nozzle, etc.). If not changed in sets, UNIT POSITIVELY WILL NOT WORK.

AFTER AIR REQUIREMENTS are based on recommended air pressure of 80 psi. Units will operate at lower pressures for special requirements at considerably lower cfm.
**WARNING - IMPORTANT SAFETY INSTRUCTIONS**

**RESPIRATOR REQUIRED**
- A NIOSH/OSHA-approved dust respirator must be worn during operation of the cabinet and when loading, unloading, or servicing cabinet or vacuum. Even though cabinet door is closed, door is continually opened and closed while parts are loaded.

**WARNING**
- DO NOT USE SILICA SAND OR ABRASIVES CONTAINING SILICA for abrasive blasting, even within a closed cabinet - HEALTH HAZARD. The use of abrasives containing silica or other abrasives can be dangerous to your health and can lead to silicosis, shortness of breath, coughing, and other respiratory problems. PLEASE CONSULT OSHA or OTHER STANDARDS FOR SAFETY EQUIPMENT REQUIRED FOR YOUR APPLICATION.

**SLIP/FALL HAZARD.** Clean up abrasive spills immediately. Glass beads and other abrasives are as SLIPPERY AS ICE. Use caution.

**EYE PROTECTION REQUIRED.** When abrasive blasting, the use of approved safety goggles is MANDATORY to protect user from dust around the area or in case of lens breakage.

**ELECTRICAL SHOCK HAZARD.** Do not modify light, vacuum, or plug at end of power cord. NEVER operate cabinet or vacuum near water or in a damp location. Electrical receptacle in your shop must be 115 volt and grounded. If using an extension cord, it must be a 3-prong, grounded type and be the proper wire size. DO NOT USE VACUUM AS A WET VACUUM, nor for vacuuming of hazardous materials.

**HIGH PRESSURE AIR CAN BE DANGEROUS.** Abrasive Blast Cabinets operate on air pressure in ranges of 40-120 PSI. NEVER exceed 125 PSI. High pressures will result in premature wear of components.

**DISCONNECT** incoming air line when adding abrasive or when servicing valves, hoses, or power gun.

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**DANGER - BLAST HAZARDS - IMPORTANT!**

To prevent serious injury or death:
- Do not point blast directly at fingers or hands, even though wearing gloves.
- Do not point abrasive stream at lens or door opening of cabinet.
- NEVER OPEN DOOR WHILE BLASTING.

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**EXPLOSION HAZARD**

To prevent serious injury or death:
- NEVER blast items containing oils, gas, or flammable liquids, as abrasive hitting metal can spark and cause a dangerous explosion.

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**TROUBLESHOOTING: Siphon Fed Cabinets**

**PROBLEM**
- Little or no abrasive coming out of power gun
- Surging or spattering of the abrasive flow at the nozzle
- Air only coming out of the nozzle
- S-35 Gun Only: Sticking of valve in on or off position
- Wear items (These items are not guaranteed.)

**CAUSE**
- Incorrect nozzle/air jet setup
- Hose obstruction: clogged or blocked
- Obstruction in gun suction head
- A. 6045-00/0 or 6846-00 Spring
- A. Nozzle wears out

**CORRECTIVE ACTION**
- A. IMPORTANT - Nozzle and air jets are color-coded and installed in MATCHING SETS. If nozzle and air jet do not match, unit will not work. If necessary, carefully measure nozzle size in both parts (SMALL Nozzle 13/64" ID, Air Jet 1/64" ID, MEDIUM Nozzle 1/4" ID, Air Jet 7/64" ID, LARGE Nozzle 5/64" ID, Air Jet 5/32" ID).
- B. Remove hose from bottom inlet of gun suction head. Pull trigger or press foot pedal and blow air through gun. Put finger over bottom inlet of 6043-00 Gun Suction Head. A definite "suction" should be felt. If not, check that gun suction head is seated TIGHTLY against 6034-04 Air Jet Gasket and that the gasket surface is clean. When reassembling gun suction head to gun, push parts together very TIGHTLY or a loss of suction will result.
- C. Low air supply requires the use of the smaller gold nozzles and air jets. Also check your incoming air line system for clogged separators, faulty regulators and valves, or obstruction in air hose. Any minor problem in the incoming air supply can be CRITICAL. To check: connect air hose (of proper size) directly to your compressor, bypassing all regulators and separators. If air volume is increased, recheck your air line system and replace necessary parts.
- D. Abrasive can contain a considerable amount of moisture, even though it appears dry. Always purchase abrasive in sealed bags. (Before use.)
- E. Compressors (especially under heavy loads) put out moisture in a vapor form that can pass through moisture traps. We recommend a Coalescing Air Filter (3405-30) at the cabinet to eliminate moisture (extra cost option).
- A. Disconnect incoming air. Disassemble valve assembly from power gun by removing 6431-00 Nut. Clean and replace valve and spring assembly as necessary. Rust, dirt, or moisture in your incoming air system will cause this problem. A Coalescing Air Filter (3405-30) is recommended to alleviate this problem (extra cost option).
- B. Same as above. Remove obstruction and disassemble. Lightly sand the valve stem before replacing.
- A. After several hours' use, the nozzle will wear from the inside out, due to the abrasive and air mixture swirling around the inside of the nozzle. Wear always takes place on one side of the nozzle. Examine and replace nozzles as needed. (Use ceramic or carbide nozzles for longer life.) Rotate 1/4 turn after 3 hours of use for longer life.
- B. Air jet wears on one side. Change as needed (normally, one air jet for every three nozzles).
- C. Gun suction head wears from the inside out, the same as the nozzle, usually on one side. This is normal. Replace as needed (we suggest stocking a supply of nozzles, air jets, and gun suction heads).