



## SUCTION CABINETS

Pro-Finish suction cabinets cost less and are simpler to operate than pressure cabinets. They also blast continuously without the need to stop for media refills, and they simplify the use of multiple nozzles.

The results are usually comparable to those achieved with a pressure system although production rates are not as high.

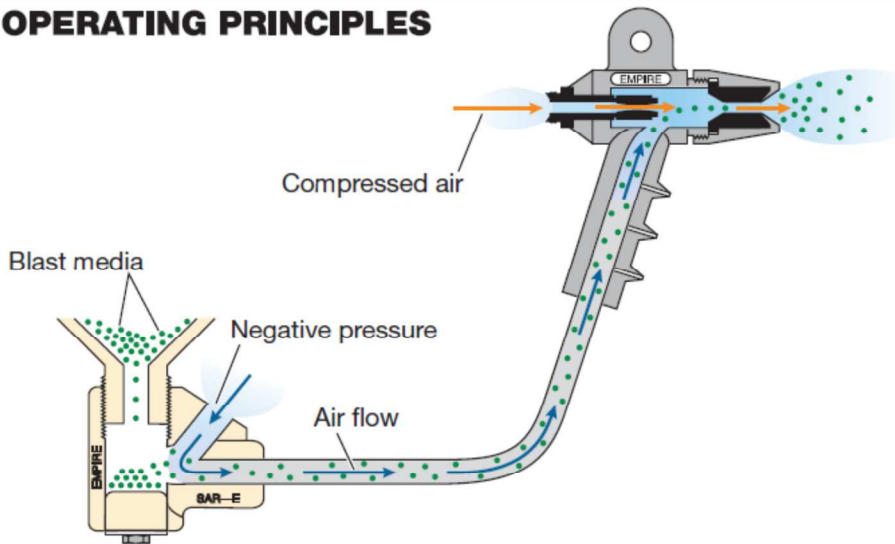
When initial cost and maintenance are primary concerns, the suction system is a good choice.

Pro-Finish suction systems come in five sizes and can be specified with a collector or dust bag on smaller units.

A media reclaimer is optional. Nevertheless, when using media that can be recovered, a reclaimer is advisable because it normally pays for itself quickly in terms of reduced waste and high-quality, repeatable results.

Pro-Finish suction cabinets are available with many factory options that contribute to ease of operation, reduced maintenance and greater productivity. Plus, Pro-Finish's modular design lets you upgrade to a pressure system in the field at any time, enabling you to build on your original investment.

## OPERATING PRINCIPLES



## SUCTION SYSTEMS

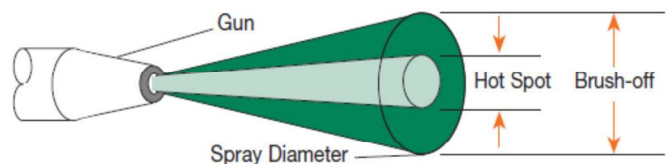
### Suction-Blast Air Requirements (SCFM)

Pressure (PSI)	30	40	50	60	70	80	90	100
1/4" nozzle, 3/32" air jet	6	7	8	10	11	12	13	15
1/4" nozzle, 1/8" air jet	10	12	15	17	19	21	23	26
5/16" nozzle, 5/32" air jet*	15	19	23	27	31	37	38	42
7/16" nozzle, 7/32" air jet	31	38	45	52	59	66	73	80

\*Unless otherwise specified, this nozzle is supplied.

4 SCFM = 1 compressor horsepower.

### Suction-Blast Spray Diameters



Gun ID	Distance from Workpiece					
	6"	12"	18"	6"	12"	18"
1/4"	1-3/8"	2-5/8"	-	2-3/4"	-	1"
5/16"*	1-1/2"	3-1/2"	1-3/4"	4-1/2"	-	3-3/4"
7/16"	2"	3-3/4"	2"	4-1/2"	-	3-3/4"

\* Standard nozzle

Brush-off

Hot Spot



**EMPIRE**  
ABRASIVE EQUIPMENT

# Pro-Finish® Blast Cabinets

• Rugged • Versatile • Designed to Meet Your Surface-Finishing Needs



If your operations involve cleaning with chemicals, acid etching or dipping, liquid honing, wire brushing, sanding, deburring, grinding or peening, moving up to a Pro-Finish® cabinet will normally expedite work, improve quality and eliminate the environmental problems associated with chemical finishing.

Built for production blasting, these rugged cabinets enable you to perform a long list of tasks ranging from blending surface flaws to removing foreign matter, such as carbon from pistons, without affecting tolerances. By simply varying air pressure and blast media, you can perform almost any surface-finishing job more quickly and precisely than with alternative methods.

Pro-Finish cabinets can be specified with either suction or pressure blast systems—a pressure system

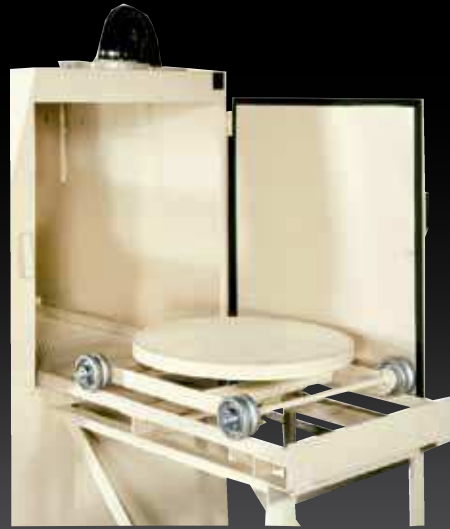
being the preferred choice for faster production and more precise control of media at both high and low operating pressures. In addition, they are available in seven sizes and loaded with standard features that reduce operating and maintenance costs.

Modular design, plus an extensive range of factory options, lets you select a system that's just right for your applications.

For additional information about our extensive line of Pro-Finish blast cabinets, go to the next page, contact Empire or your local Empire distributor, and visit our web site at [www.empire-airblast.com](http://www.empire-airblast.com)

## Pro-Finish® Options

- **Turntables** facilitate handling of heavy parts. (*Manual turntable with dolly and outside platform shown to right.*)
- **Additional nozzles or guns** (up to a total of two nozzles with pressure and up to four guns with suction) automate the blasting process when synchronized with powered oscillators and turntables.
- **Rotating basket** with timer speeds processing of smaller parts.
- **Fixed-gun holder** with adjustable arm frees both operator hands for parts blasting.
- **Extended-wear options** prolong equipment life while minimizing maintenance and downtime. Options include: rubber curtains in black or white; window protectors; heavy-duty, media-conveying duct; and DiCarb® or boron nozzles. Reclaimers can be upgraded with replaceable wear plates and urethane or Ultrawear linings.
- **Automatic bag shaker** frees operator for other tasks with bag-house dust collectors.
- **Fully automatic photohelic controls** purge dust from cartridge-type collectors without operator assistance.
- **Rubber safety mats**, placed around Pro-Finish cabinets, keep the immediate work area clean and reduce operator fatigue.



## Standard Features

- Rubber, cloth-lined gloves
- Ergonomic glove rings with operator armrests
- 90-watt spotlights
- Dust-off gun
- Pneumatic foot-treadle control
- 14" x 22" safety-glass window
- General purpose filter
- Leveling bolts
- OSHA door switch
- 14-gauge construction
- 3/16" perforated floor with 1000-lb capacity
- Sure-Flo® media regulator (pressure systems)
- One-cubic-foot ASME pressure vessel (pressure systems)

## General Specifications

Cabinet Model	2636	3648	3660	3674	4848	6060	7272
Interior Dimensions (DxWxH)*	26x36x30	36x48x36	36x60x36	36x74x36	48x48x36	60x60x44	72x72x62
Overall Dimensions, Cabinet Only (DxWxH)*	28x42x70	38x54x72	38x66x72	38x80x72	50x54x72	62x66x78	74x78x89
Door Opening (HxW)*	22x20	32x29	32x29	32x29	32x41	40x50	58x64
Standard Number of Doors	1	2	2	2	2	2	1
Ceramic Pressure Nozzle, Diameter	3/16"	3/16"	3/16"	3/16"	3/16"	3/16"	3/16"
Ceramic Suction Nozzle – Air Jet, Diameters	5/16" – 5/32"	5/16" – 5/32"	5/16" – 5/32"	5/16" – 5/32"	5/16" – 5/32"	5/16" – 5/32"	5/16" – 5/32"
Pressure – Suction Piping, Diameters	1" – 1/2"	1" – 1/2"	1" – 1/2"	1" – 1/2"	1" – 1/2"	1" – 1/2"	1" – 1/2"
Reclaimer Ventilation Rate (CFM)	400 or 600	400 or 600	600 or 900	900	600 or 900	900	900 or 1200
Exhaust Fan Motor, Horsepower	1	1 or 1 1/2	1 1/2 or 2	2	1 1/2 or 2	2	2 or 5

\*Dimensions are nominal (inches).

## BEST WARRANTY IN THE INDUSTRY

Three-years limited on parts

## Empire Air-Blast Products

- A complete range of cabinets
- Robotic, turntable and in-line automation
- Blast rooms and blast booths
- Portable blasters
- A full line of parts and accessories

**NEVER USE SILICA SAND IN ANY  
EMPIRE EQUIPMENT**

Information subject to change without notice.

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