

SANDBLASTER
BASE 2-3

 **USER AND MAINTENANCE MANUAL**



1. TECHNICAL DETAILS

Height	445 mm
Width	415 mm
Depth	305 mm at base – 400 mm overall
Net and Gross weight	11,8 Kg – 14,3 kg
Voltage	230 V - 50 Hz (different tensions available on demand)
Absorption	60 W - 1,4 A
Lighting	Energy-saving 42 LED circuit
Dust filtering system	Possibility to add-on the built-in WAFIS system or PRO-3; compatible with traditional extractors

Devesting pressure	min 2,5 BAR - max 6,0 BAR
Air consumption	100 l/min at 4 BAR
Blasting nozzle	Ø 3,0 mm tungsten carbide nozzles
Abrasive grainsize min - max	mesh 80 (200µ) – mesh 36 (500µ)

Microblasting pressure	min1,5 BAR – max 6,0 BAR
Air consumption (Ø0,8mm)	15 l/min at 2 BAR
Air consumption (Ø2,0mm)	120 l/min at 4 BAR
Standard nozzles	2 x Ø 0,8 mm tungsten carbide nozzles
Abrasive grainsize min - max	mesh 270 (50µ) – mesh 60 (250µ)

2. DESCRIPTION

BASE 3 is a sandblasting unit designed for devesting and finishing operations in the Dental and Jewellery branch.

The main features of the machine are: the ergonomic layout of the working chamber, the safety of use, and the trouble-free structure of the mechanical installation. **BASE 3** is equipped with useful accessories and ensures a fast, practical and accurate work. The unit consists of a devesting projector and of 2 **EASY tanks**, featuring a pressure discharge system and an instant stop of the blasting jet. The unit can thus operate with **three different abrasive media**.

The sandblasting process originates toxic dust which must not be inhaled; for this reason, **it is absolutely forbidden to operate the machine if a proper suction system has not been previously connected to the sandblaster.**

DENTALFARM has developed the so-called W.A.F.I.S. (WATER AIR FILTERING SYSTEM), a patented solution which eliminates airborne dust thanks to the combined action of water and air pressure, in compliance with hygiene and safety regulations. The WAFIS system can be easily connected on the top left side of the machine and starts automatically when the sandblaster switches on.

DENTALFARM ranges also include **PRO-3** and **PRO-3 Shake** suction units, which can be easily connected to any sandblasting machine.

3. TECHNICAL REFERENCE REGULATIONS AND TEST PROCEDURES

The appliance is mass-manufactured by DENTALFARM in compliance with technical and safety rules in force, as provided for by the Machinery Directive 2006/42 EEC.

Careful inspection and full routine testing is carried out singularly on each machine which is furtherly processed by an automatic testing installation assuring compliance with the fixed limits

According to International regulations, this unit has been classified as AEE (electric and electronic device, whose correct operation depends on electric currents and electromagnetic fields) and as a consequence, at the end of its lifetime, it can not be treated as normal waste material but it must be disposed separately, complying with Directive 2002/96/EEC.

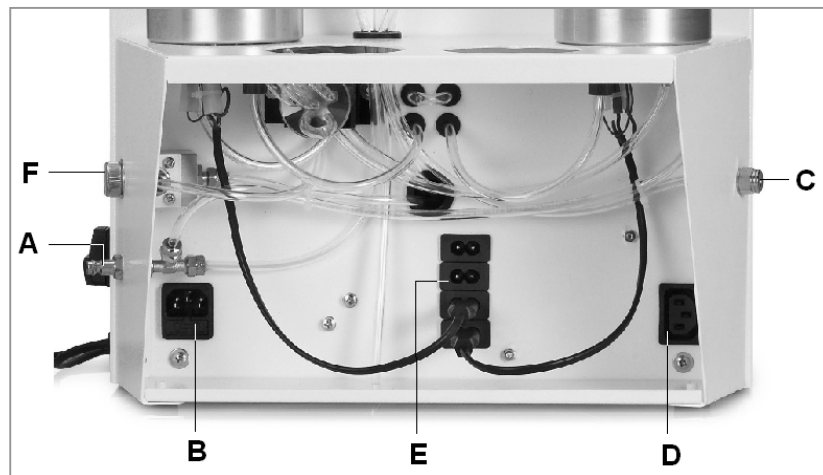


4. INSTALLATION INSTRUCTIONS



Installation of this machine is quite easy but must be carried out paying utmost attention in order to avoid any mistake which may originate problems, inconveniences and even damages during operation.

1. Place the machine on a proper workbench, which must be stable and strong enough to hold the machine safely. Keep a sufficient distance (10/15 cm) on the right side of the machine for the pipes, the feeding cables, as well as in order to access the shutter and the filter (F). If a built-in WAFIS system is present, preferably choose a workbench and a position (for instance at the rim of the bench) so that the exhaust pipe can fall perpendicularly into the collection tank.



2. Insert the quick clutch fitting on the male intake (A) located on the right side of the unit and connect the pneumatic feeding pipe (polyethylene or rilsan, with diameter \varnothing 8x6) to the pipe-fitting. It is also possible to use a \varnothing 12x6 elastic feeding pipe, by using the fitting supplied with the unit.
3. Connect the electric feeding cable to the pre-fitted electric socket on the unit (B) and plug into an approved 220v AC - 50Hz network socket with ground connection.
4. Install the preferred suction system; WAFIS, PRO-3 or any other. The built-in WAFIS should be installed on the top left side of the unit: unscrew the 4 screws fixing the black collection intake and mount the WAFIS, unscrew the cap (C) and replace it by the pipe-fitting delivered in the package, put together with the other portion of pipe and plug the feeding cable into the electric socket (D).



PRO-3 suction units should be connected by inserting the collection pipe into the pre-fitted intake.

Any other suction system can be connected to the black collection intake by means of flexible piping; the inside manifold fits a \varnothing 30mm pipe, the outside manifold fits a \varnothing 40mm pipe.



5. Adjust the air flow to avoid the machine being under vacuum. Slightly turn the mobile section of the adjusting valve when the suction system is on and stop when you notice that the gloves are still slightly inflated.
6. Lift the window and **fill the hopper with the appropriate compound** (observe the indications below as for dimensions of nozzles and correct working pressure).

Name	Code	Description
CROMCOR	AP-036	Brown corundum, grainsize 36 (500 μ) for chrome-cobalt (may be used with nozzle \varnothing 3,5 – white cap – upon request)
OROCOR	AP-046	White corundum, grainsize 46 (350 μ) for non-precious alloys (may be used with standard nozzle \varnothing 3,0)
SUPERCOR	AP-060	White corundum, grainsize 60 (250 μ) for precious alloys (may be used with standard nozzle \varnothing 3,0)
OROBLAST	AP-300	Glassbeads, 200 μ – for satin-finishing of any metal (may be used with standard nozzle \varnothing 3,0)

7. **Microblasting tanks (EASY tanks) are identical in layout, but can feature different components (calibrated dosing system) and external nozzles which vary according to the abrasive mixture they can dispense;** it is therefore necessary to observe the indications written on the identifying labels. Should you need to use an abrasive compound of different grain Lift the window and fill the hopper with the appropriate compound (observe the indications size (not listed below), it is possible to request the components and to replace them.

Strictly observe the following parameters, based on the abrasive grainsize.				
TREATMENT	TANK (dosing system)	RECOMMENDED PRODUCT	NOZZLE DIAMETER	PRESSURE
Surface roughness on metals for composites	A1072G (coarse)	AP-060 Orange label (AL2O3 60 - 250μ)	2,0 mm (RMN046)	4 BAR
Surface roughness on metals for composites	A1072M (medium)	AP-120 Pink label (AL2O3120 - 105μ)	1,2 mm (RMN043)	3/4 BAR
Surface roughness on metals for ceramic or resin	A1072M (medium)	AP-150 Green label (AL2O3150 - 95μ)	0,8 mm (RMN044)	3/5 BAR
Surface roughness on metals for ceramic	A1072M (medium)	AP-180 Red label (AL2O3180 - 80μ)	0,8 mm (RMN044)	3/5 BAR
Sculpture on ceramic	A1072S (fine)	AP-270 Yellow label (AL2O3270 - 50μ)	0,5 mm (RMN045)	3/5 BAR
Satin-finishing on any type of metal	A1072M (medium)	AP-090 MICROBLAST White label	Higher precision 0,8mm Higher speed 1,2 mm	3/4 BAR 4/5 BAR

A longer nozzle with \varnothing 0,8 mm size (RMN044L) is available on request to carry out cleaning operations on ceramic prosthesis without metal support.

<u>/!\ WARNING:</u>	Very fine abrasives are highly sensitive to moisture and must be stored in a dry place, after the can has been accurately sealed and the antimoisture packet has been duly introduced into the can (if needed, replace them periodically). When filling the abrasive containers, check the condition of the abrasive product; if the moisture rate is too high (bad flowability and presence of clots), it is recommended to heat the abrasive in order to allow it to dry up completely. It is also of utmost importance to check the condition of the compressed air which in no way must contain evidence of moisture or of any polluting agents (oil, grease or rust).
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5. INSTRUCTIONS FOR USE

- Press the switch to illuminate the working chamber and feed the operating controls.

<u>/!\ ATTENTION:</u>	May we remind that the sandblasting process will start only provided the suction system is operating – as a consequence, the filtering system MUST always be installed and OPERATED BEFORE you start to work.
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- Lift the window to introduce the pieces to be treated into the working chamber.
- Turn the selector switch knob to choose the type of blasting procedure you prefer – references marked on the label are herewith specified.

POSITION OF THE POINTER	SELECTED FUNCTION
YELLOW	DEVESTING OPERATIONS
GREEN	MICROBLASTING FROM THE GREEN TANK
WHITE	MICROBLASTING FROM THE WHITE TANK

- Press the foot control: when **removing investment**, air gets to the projector and mixes up with abrasive coming from the working chamber, thus delivering the air-abrasive mixture necessary to carry out the treatment; in case of **microblasting**, air enters the selected tank putting it under pressure, it gets mixed with abrasive micrograins and will then be dispensed by the spraying nozzle.
- Adjust the working pressure by means of the pressure adjusting device located next to the pressure gauge: lift the knob and turn it rightwards (to increase) or leftwards (to decrease). To lock the knob, push the knob back down.


NOTE	The abrasive used for finishing operations (tanks) cannot be re-utilized and will fall inside the working chamber, thus mixing up with corundum. This phenomenon will not affect your work (except if microbeads are being used), but the abrasive shall be replaced more frequently.
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The microprojectors are ideally positioned in the middle of the working chamber to facilitate use with both hands. We recommend to put back them in place on their holders at the end of the work.

The window is made of anti-scratch polycarbonate material, resisting to the rebounding abrasive grains. We recommend to use a soft cloth to clean it and to remove the dust from inside and the use of protection sceens (code 1000532).

6. MAINTENANCE

Many of the components of any sandblasting machine are subject to wear: this is caused by the circulation of abrasive media; the instructions for a careful maintenance of the machine as well as the operations to replace the damaged or worn out parts are specified here below.

 <u>ATTENTION:</u>	Before carrying out any maintenance operation inside the working chamber or technical repair of the connections, remove the feeding cable both from network socket and from the rear of the machine; in such a way, both the electric and pneumatic installation of the unit will be fully disconnected. Should you have any doubts or difficulties, get in touch with our Technical Service to avoid any risks or damages.
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Cleaning of the 5my filter

A 5my filter, mounted under the base of the container, prevents fine dust from damaging internal components. Remove the inspection cap every 2-3 months and blow the filter with compressed air to clean it from dust sediment.

Replacement of the polycarbonate window

Although the window is anti-scratch, it can be damaged by an extensive use (or a bad maintenance). Replacement is very simple: locate the screws which fix the window to the hinges and unscrew them.

Replacement of the plastic protection screens of the glass window

Remove the fixing clips, clean accurately the glass and place a new protection screen.

Replacement of gloves

The gloves are made of highly resistant rubber, but are subject to the natural ageing of rubber and to the action of sweat (produced by hands). This cause them to dry up. To replace them, unscrew the flange screws and fit a new pair of gloves into the proper seat.

Replacement of the fluorescent lamp

Move leftwards the plastic screen, then pull the lamp leftwards and take it out of its holder. Re-assemble the screen on the metallic container, paying attention to properly bend and fit the edges. Should this operation be too complicated, it is possible to remove the complete lighting group by unscrewing the two fixing screws placed on the upper part of the chamber.

Replacement of the devesting nozzle

The devesting nozzle, even if it is made of tungsten carbide, known as a very hard material, will inevitably wear out, due to the continuous flow of abrasive and will therefore need to be replaced periodically. Remove the nozzle cap and insert a new group, paying attention to thoroughly fit it into the plastic body.

Replacement of nozzles

Nozzles of the microblasting tanks are also subject to wear and need to be replaced. To do this, unscrew the ring nut and assemble the new nozzle.

Replacement of abrasive media

To replace used abrasive media, pull the machine forward, lift the internal filtering grid, remove the cap from the bottom of the working chamber and let abrasive flow out, collecting it into a proper container.

Replacement of parts subject to wear (pipe, pipe-fittings, microprojector body)

The polyurethan pipe, the connection fitting and the microprojector body where abrasive flows will inevitably wear out and need to be replaced regularly. To replace the microprojector body, follow the same instructions specified for the nozzle; to replace pipes or pipe-fittings, capsize the unit and work under the container. It is also possible to disconnect each tank for easier operation, simply unscrewing the nuts fixing it to the housing.

Replacement of tank internal components

Should it be necessary to replace the tank internal components like joints, air injectors, abrasive outlet pipe, please contact our Technical Service.

Removal of a microblasting tank for repair purposes

The new tank units have been studied to facilitate your task during installation and removal.

1. Unscrew the the feeding pipe ring nut and disconnect the pipe
2. Unscrew the plastic ring nut and detach the microprojector pipe
3. Unscrew the two nuts fixing the tank to the holder, and unclutch the tank.

7. TROUBLESHOOTING

Problem: **THE MACHINE DOES NOT START**

Possible cause	Remedy
Lack of tension	Check: - magnetothermic switch - socket supply switch - fuses of the feeding board
Lack of distribution in the machine	Check: - socket connection - network fuse Should this malfunction repeat, contact our TECHNICAL SERVICE.

Problem: **NO LIGHTING**

Possible cause	Remedy
Bad electrical connection	Check that the electrical plug is correctly plugged in.
Shutter is damaged	Check connections and operation (some dust could have oxidized contacts so that they seized up). Try to blow with compressed air and replace if needed.

Problem: **NO AIR IS COMING OUT**

Possible cause	Remedy
Bad pneumatic connection	Check connection to the compressor.
Internal pipes are clogged	Check connections and condition of pipes up to their end (nozzles).
Air filter is clogged	Check and disassemble, if needed, the moisture collection glass and replace the internal filtering element.

Problem: **THE BLASTING JET IS UNSTEADY (devesting)**

Possible cause	Remedy
Compressor is not efficient enough	Verify the characteristics of the compressor, as this must provide a minimum power of 150 l / min (to ensure proper performance) and a 100 l tank (to ensure capacity).
Working pressure is not suitable for the metal to be treated.	Observe the prescriptions contained in the detail table of this manual.
Abrasive not suitable	As above.
Abrasive is exhausted	Replace with new abrasive.
Nozzle is not suitable or is worn out.	Observe the prescriptions contained in the detail table of this manual. Replace if needed.

Problem: **NO ABRASIVE IS DISPENSED, ONLY AIR COMES OUT (devesting).**

Possible cause	Remedy
Nozzle is worn out.	The nozzle is \varnothing 3,0 mm, in case of excessive wear and alteration of the diameter, replace it.
Nozzle is not properly positioned, so abrasive is not dispensed.	The nozzle must entirely come out of the nozzle cap.

Problem: **NO AIR COMES OUT FROM THE PROJECTOR (devesting)**

Possible cause	Remedy
The internal projector nozzle is clogged.	Remove the cap and clean the injector.
Solenoid valve is clogged.	Close air inlet, remove the coil and the core and clean; eventually get in touch with our Technical Service.

Problem: **NOZZLE-HOLDER CAP COMES OUT DURING WORK (devesting)**

Possible cause	Remedy
Both piping and nozzle are clogged.	Close up the end of the nozzle and press the foot-control; the operating air flow will thus be inverted, eliminating any obstruction from inside the pipes. Should this irregularity repeat too often, remove abrasive from the hopper and filter it.
Worn out and powdery abrasive.	Replace the abrasive, as this could be mixed with fine particles or investment residuals which will never go through the nozzle spraying hole.

Problem: **INTERNAL AIR LEAKAGE**

Possibile causa	Azione correttiva
Condensate discharge on the filter.	The condensate discharge is carried out by the lifting of a ball cock. A sufficient level of pressure must be provided for the valve to close.
Internal pipes are disconnected	Check the state of the piping. Polyethylene pipes might not be perfectly calibrated; try to cut out a small portion from the end of the pipe and insert it into the pipe-fitting; if needed, replace the pipe.

Problem: **THE BLASTING JET IS UNSTEADY**

Possible cause	Remedy
Nozzle is clogged or worn out.	Unscrew nozzle fixing nut, clean both the hole and microprojector components (especially the thread) - re-assemble without forgetting the seal washer. If necessary, replace the damaged parts.
Microprojector feeding pipe is worn out, bent or clogged	If the pipe is worn out or bent, replace it. If it is clogged, disassemble the nozzle and let air come out.
The abrasive mixture is too rich in aluminium oxide, i.e. loss of sharpness	Abrasive container is overfilled, discharge it. Pipe bending under the containers may collect abrasive at the end of the work, when the valve releases pressure; it is possible to limit this reaction reducing this pipe bending at the minimum.
Damp aluminium oxide causing bad flowing.	Empty the tank, possibly disconnect it from the machine and turn it upside down, blow with clean air in order to dry up all the internal pipings, then heat and dry up the abrasive product and fill in again.

Compressed air filled with condensation or oily particles.	Fine abrasive compounds are particularly sensitive to moisture and, as mechanic pickling agents, they
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	hold the polluting agents. Therefore it is important to protect the efficiency of the product installing adequate filtering and drying systems on the air installation.
Grainsize of the aluminium oxide is not compatible with the abrasive metering system inside the container.	Verify compliance with the indications printed on the tank label and with the comparative tables (abrasive grainsize / nozzle diameter / internal dosing system).
The blasting jet is not efficient	<p>Uninsufficient pressure.</p> <p>The 5my filter is clogged, unscrew the inspection cap and clean it.</p> <p>The solenoid valve is dirty: get in touch with Dentalarm Technical Dept.</p>

Problem: NO ABRASIVE COMING OUT, INTERNAL LEAKAGE.

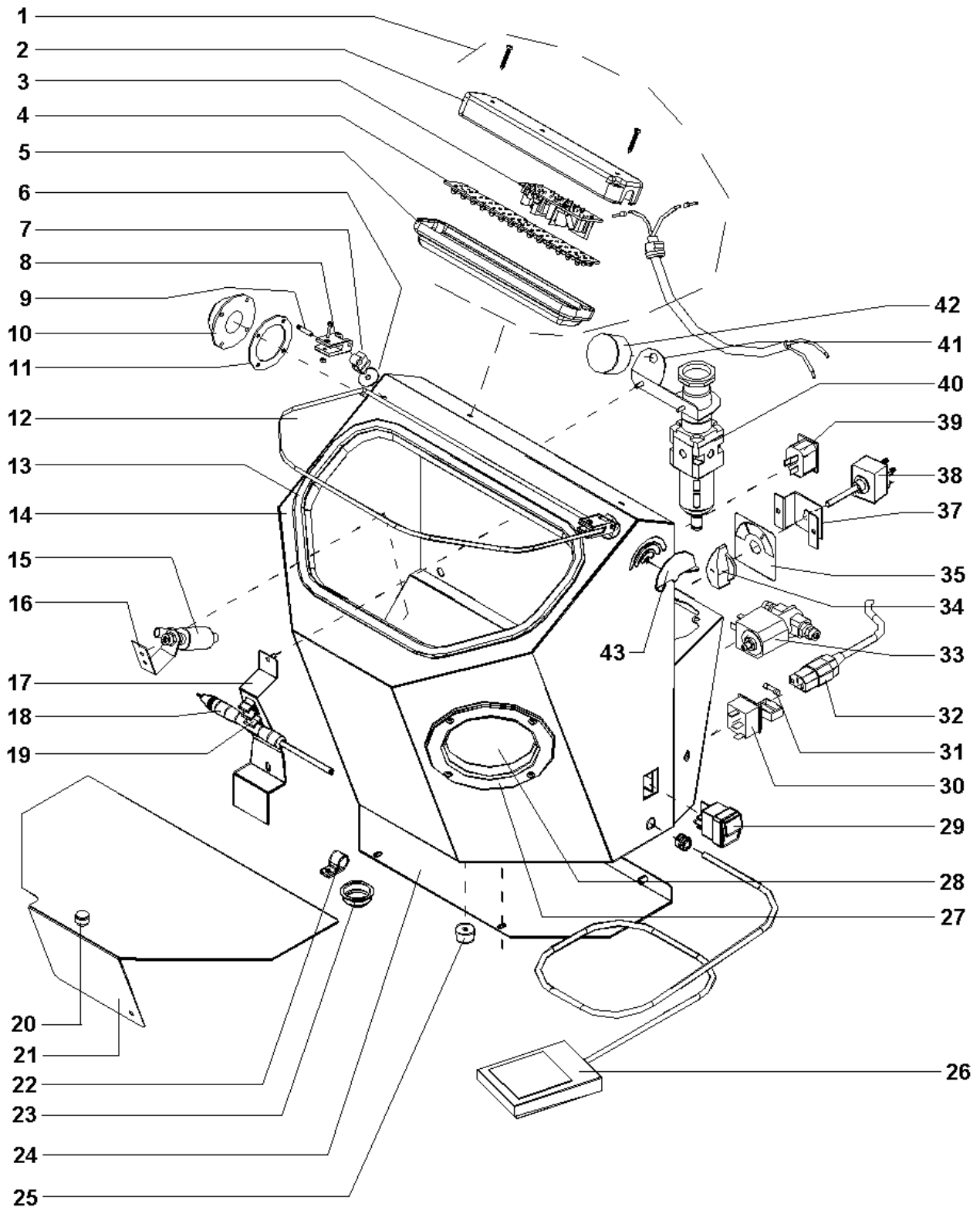
Possible cause	Remedy
Worn pipe-fittings or punched microprojector pipe.	The components of the circuit located after the tank - in which the abrasive circulates - are subject to wear. It is recommended to prevent any possible break by replacing these components each 6-12 months, according to the workload.

Problem: ABRASIVE TANK IS NOT UNDER PRESSURE

Possible cause	Remedy
Joints are not perfectly airtight	<p>Check whether cap is correctly tightened.</p> <p>Disconnect the container from the machine, disassemble and clean it.</p>

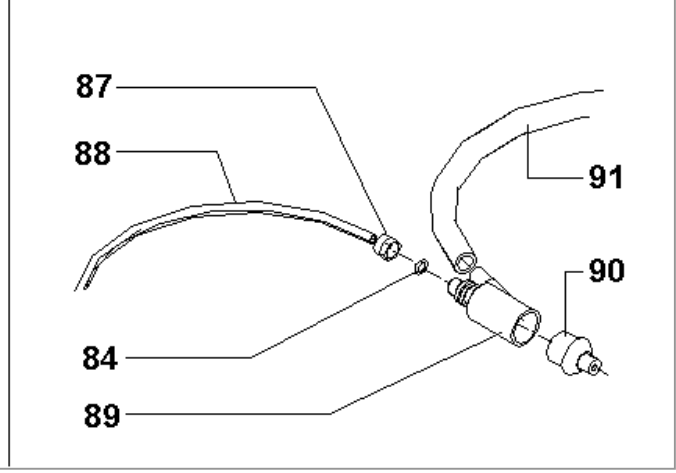
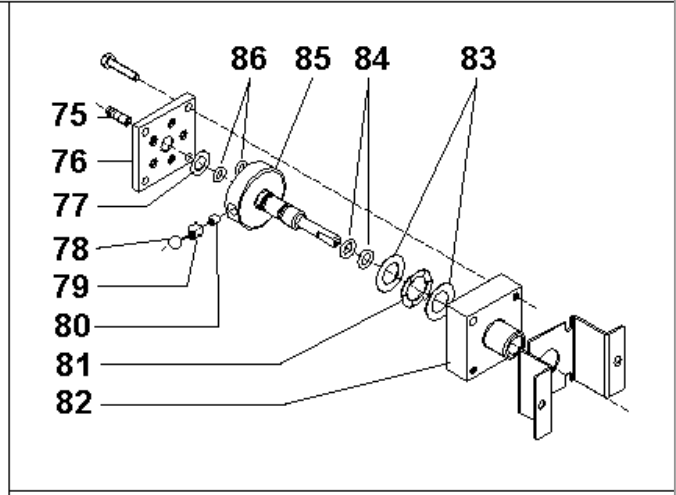
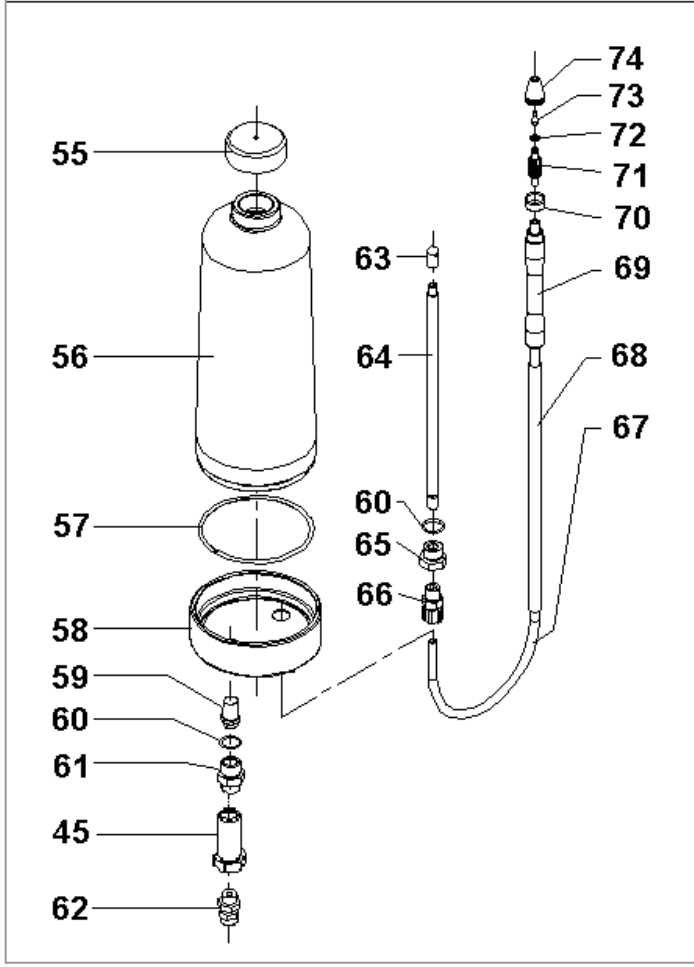
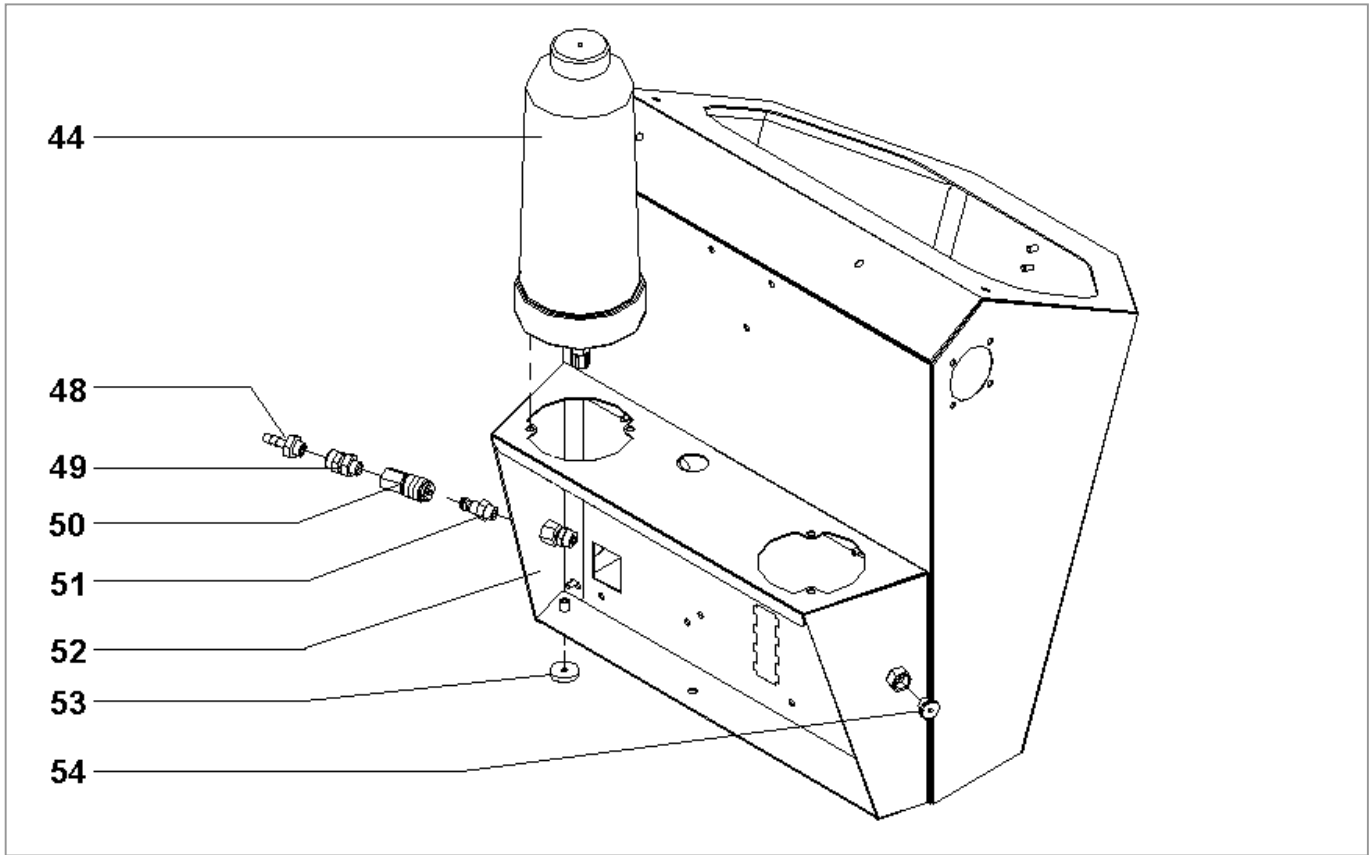
8. EXPLODED DRAWING AND SPARE PART LIST - BASE 3 table 1

POS.	CODE	DESCRIPTION
1	1000534	COMPLETE LRD LIGHTING SYSTEM
2	1072037	LIGHTING SYSTEM BASE
3	1072040	ELECTRONIC BALLAST
4	1072041	42 LRD CIRCUIT
5	1072038	LIGHTING SYSTEM COVER
6	1069010	PVC WASHER FOR HINGE
7	1054019A6	HINGE FIXED PART HOLE 6mm
8	RCB016A	HINGE MOVABLE PART
9	RMBL028	PIVOT FOR HINGE
10	RWA007	SUCTION HOSE
11	RWA006	JOINT FOR SUCTION HOSE
12	1072029	POLYCARBONATE WINDOW FOR BASE MODELS
	1000532	CONF. x 6 GLASS PROTECTION SCREEN
	RCB042	PROTECTION SCREEN FIXING CLIPS
13	1064015	GLASS JOINT
14	1072021	WORKING CHAMBER
15	RS521	DEVESTING PROJECTOR COMPLETE
16	1072028	PROJECTOR SUPPORT
17	1073009	SUPPORT FOR 2 MICROPROJECTORS
18	1000605	COMPLETE MICROPROJECTOR (specify colour and nozzle)
19	NEA123	CLIP
20	NVT151	MALE KNOB M4x10
21	1072025	ABRASIVE FILTERING GRID
22	NEA115	PLASTIC RING D. 14
23	NVP030	PLASTIC CAP D.=31
24	1072024	LOWER CLOSURE
25	NVG049	RUBBER FOOT H=19
26	NEC050	ELECTRIC FOOT CONTROL
27	RCB017	GLOVE FLANGE
28	RCS130	PAIR OF GLOVES
29	NEC018	PROTECTED BIPOLAR SWITCH
30	NEA046	PLUG AND FUSEHOLDER
31	NEA071	RAPID FUSE 5x20 - 6,3 A
32	NEV013	ELECTRIC CABLE WITH 3x1 PIN/PLUG
33	NES030	3-WAY-SOLENOID VALVE-220v
34	NVT141	GRADUTATED KNOB
35	1072032	SELECTOR SWITCH LABEL- BASE
36	RCS059	NUT FOR VALVE M12x1
37	1069003	SELECTOR SWITCH SUPPORT
38	1000510-4A	4-WAY-SELECTOR SWITCH COMPLETE
39	NEA047	FEMALE PLUG
40	NPS029	FILTER AND REDUCER 1/8
41	1072026	REDUCER AND PRESSURE GAUGE HOLDER BASE/MICRA
42	NPS040	PRESSURE GAUGE 0-6 1/8
43	1072033	COVER ON SUCTION HOLE - BASE/MICRA

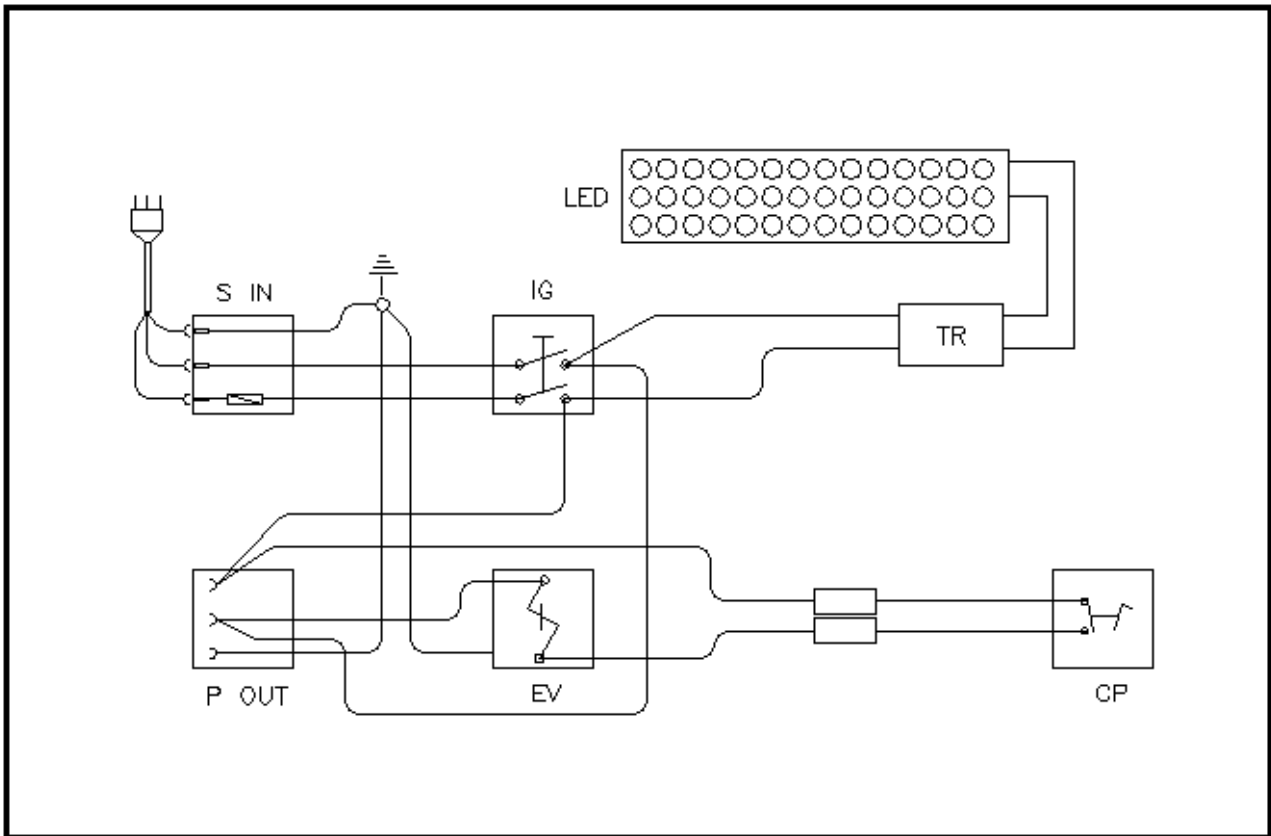


EXPLODED DRAWING AND SPARE PART LIST BASE 3 - table 2

#	CODE	DESCRIPTION
44	100072N	EASY TANK COMPLETE
45	NPV025	MICROFILTER 5my
48	NPR220	PIPE-FITTING 7 1/8
49	NPR119	STRAIGHT MALE PIPE-FITTING 8x6 1/8
50	NPR303	FEMALE RAPID FITTING 1/8
51	NPR304	MALE RAPID FITTING 1/8
52	1072022	TANK SUPPORT FOR BASE
53	NVG048	RUBBER FOOT H=12
54	NPR223	MALE CAP FITTING 1/8
55	NVT165	FEMALE CAP G1
56	1072003	COMPLETE ABRASIVE TANK
57	NPOR3300	OR JOINT 3300
58	1072002P	NYLON/GLASS TANK BASE
59	NPV020	SINTERED AIR INJECTOR
60	NPOR2043	OR JOINT 2043
61	1072004A	AIR BLOWER AND FILTER FITTING
62	NPR111	PLASTIC STRAIGHT MALE PIPE-FITTING 6x4 1/8
63	1072007	TERMINAL CAP ON ABRAISVE PIPE
64	1072006	ABRASIVE OUTLET PIPE
65	1072005	ABRASIVE PIPE ASSEMBLY PIPE-FITTING
66	NPR111P	PLASTIC STRAIGHT PIPE-FITTING M 6x4 1/8
67	NPV042	SOFT POLYURETHAN PIPE 6x4
68	NEV030	SHEATH D.= 6
69	1067005	MICROPROJECTOR ALUMINIUM HANDLE
70	1067022	HANDLE WASHER (SPECIFY COLOR)
71	1067006	MICROPROJECTOR BODY
72	NPOR2012	OR JOINT 2012
73	RMN043	TUNGSTEN CARBIDE NOZZLE D.= 1,2
73	RMN044	TUNGSTEN CARBIDE NOZZLE D.= 0,8
73	RMN045	TUNGSTEN CARBIDE NOZZLE D.= 0,5
73	RMN046	TUNGSTEN CARBIDE NOZZLE D.= 2,0
73	RMN047	TUNGSTEN CARBIDE NOZZLE D.= 1,5
74	1067007	NOZZLE LOCKING RING NUT
75	RM019	PIPE-FITTING
76	NVT048	THREADED SCREW M5
77	1048019	4-WAY SELECTOR SWITCH LOWER CAP
78	NVT051	CYLINDER PIN 2x7,8
79	1048025	AIR DISTRIBUTOR
80	1048026	4-WAY SELECTOR SWITCH PIVOT
81	1048020	4-WAY SELECTOR SWITCH UPPER CAP
82	NPR123	NYLON WASHER 1/4
83	NPOR2025	OR JOINT 2025
84	NVT046	PS RING 10/16/0.2
85	NVT047	PS RING 8/14/0.2
86	NPOR2018	OR JOINT 2018
87	NPR118	RING NUT 6x4 M10
88	NPV040	POLYETHYLENE PIPE 6x4
89	RS019	PROJECTOR BODY D.=1,5
90	RS023	TUNGSTEN CARBIDE NOZZLE D.=3,0
91	NVG011	TRANSPARENT RESIN PIPE 8x12

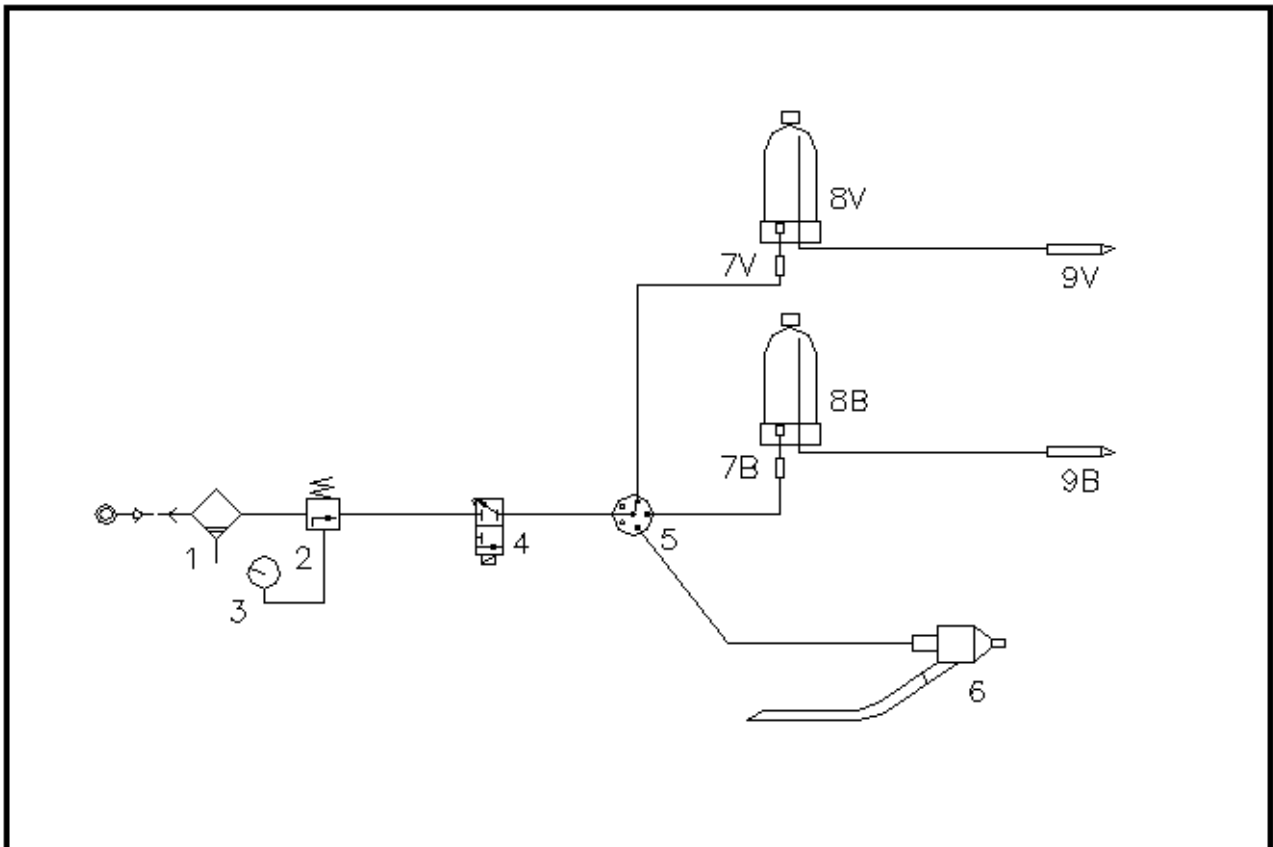


9. WIRING DIAGRAM



NO.	DESCRIPTION
S IN	PLUG AND FUSEHOLDER UNIT
IG	MAIN SWITCH
TR	ELECTRONIC BALLAST
LED	LED CIRCUIT
EV	3-WAY-SOLENOID VALVE
CP	ELECTRIC FOOT CONTROL
P OUT	FLUSH-MOUNTED SOCKET for DUST EXTRACTOR

10. PNEUMATIC CIRCUIT



NO.	DESCRIPTION
1	AIR FILTER
2	PRESSURE REDUCER
3	PRESSURE GAUGE
4	3-WAY-SOLENOID VALVE – MANUAL BLASTING
5	SELECTOR SWITCH
6	BLASTING PROJECTOR
7	5 MY FILTER
8	MICROBLASTING TANK
9	MICROPROJECTOR

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