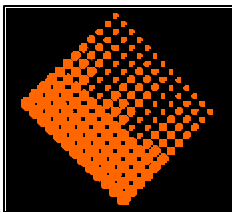


# VACUUM RECOVERY INSTRUCTIONS



## **EMPIRE ABRASIVE EQUIPMENT COMPANY**

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## **ASSEMBLY DETAIL**

Your *Vacuum Recovery* Unit has been shipped sub-assembled. The system contains:

1. 1ea. Media Storage Hopper
2. 1ea. *Vacutrans*® body assembly w/mounting pad
3. 1ea. 2" Adjustable feed Carburetor
4. 1ea. Floor media Load Hopper w/trash screen
5. 1ea. 2" x 20' hose with Camlock set one end
6. 1ea. 2" x 5 ' hose with Camlock both ends
7. 1 set "J hook" media hopper mounting Hardware

Please unpack all materials and make note of each components configuration. Once you have all the items set out, you should familiarize yourself with these and the *Vacutrans*® instructions ***prior*** to starting the installation. Review your site and determine a good location for all the components. The floor load hopper can be placed in any area where you will load media for recycling. Placement of other remaining items can be determined at this time.

Once vessel location is determined or if it part of an existing installation, make sure the pressure vessel is properly attached to the floor prior to proceeding onto the next step. This will insure a safe and trouble free operation.

### **MEDIA STORAGE HOPPER INSTALLATION:**

The system media hopper **must be properly installed** to an existing pressure vessel utilizing the "J Hook" mounting hardware provided. Improper attachment of the hopper to the vessel will result in injury to the operator or surrounding co-workers. When installing it to a competitor's pressure vessels without lifting ears, a clamp type ring, ***not provided***, can be used to safely attach the media hopper to the vessel.

During hopper placement, position the hopper to allow full access to the media-viewing window. This window provides visual access to the inside media level and allows for monitoring the system function during operation.

**WARNING: NO WELDING TO PRESSURE VESSEL IS PERMITTED!!!!!!!**

## **MEDIA LOAD HOPPER INSTALLATION:**

The media load hopper can be adjacent to the blast site, in a pit or added to an existing blast facility. After locating the position of the Media Load Hopper, fully insert the carburetor into the hopper until it makes contact with the bottom. Once in the proper location, firmly secure pipe clamp bolts and install the trash screen.

After installing carburetor, attach the 2" x 20' media hose's plain end to the outlet end, as shown, and secure with the worm clamp provided. Note the location of the carburetor-adjusting washer used for fine-tuning media recovery. Washer should be in the middle position for an initial setting for most general media conveying applications



The other end of the 2" x 20' media hose with CAMLOCK FITTING will be attached to the center inlet located at the top of the hopper. When connecting Camlock fitting, make sure ID and OD areas are clean and seals are in place. Once properly seated, securely rotate the locking levers down until they fit tightly against the Camlock body.

Failure to properly secure the Camlock fittings will effect over all operation and void the warranty.

## **VACUTRANS® INSTALLATION:**

The high Velocity Venturi Vacuum Head with mounting pad can be installed on top of the media hopper or in any remote location. Make sure the head is firmly attached and all controls are readily accessible for ease of operation.

The system includes a 2" x 5' hose, which connects between the vacuum head and the outer most Camlock connector on the top of the Media Storage Hopper. Properly secure the Camlock connectors and lock all levers as shown and stated above.

**CAUTION:** The exhaust of the Vacutrans® must be pointed or directed away from occupied areas. Adaptors are available to direct the exhaust to another area. **It is possible**, at certain times during operation, for the exhaust to send out solid materials if system becomes over full or is not adjusted properly. Again, to eliminate this potential problem, options are available to reduce output discharge or direct it to a safer area.

For longer distances, additional vacuum hose maybe required. Hose along with **information on all safety options** can be obtained through your Empire Representative.

## **INSTALLATION SUMMARY:**

Once all components have been installed, recheck all connections and verify the complete installation. Included are *Vacutrans*<sup>®</sup> instructions, which further cover installation aspects and system operation. Prior to initializing the system, check all system blast controls and interface components for proper operation.

Please contact your local Empire representative if you need any further assistance or for replacement parts.

## **SAFETY CONSIDERATIONS:**

**WARNING: Ear and eye protection must be worn at all times.**

Staying **clear** of the exhaust port when pumping material directly through the *Vacutrans*<sup>®</sup> or when installed as part of the DRUM RECOVERY MODE is **required** for safe operation. Also, under certain conditions, static electricity will build up and discharge from conveying hoses. This can be more of a nuisance than anything, but at times could **pose a danger** to the worker. Earth Grounding of the hoses and tools will solve this problem.

Another important note is that in the drum recovery mode, it is possible to collapse the drum under vacuum if the hose clogs with material. Again, this is more of a nuisance than danger. To avoid this, be sure to use the proper pickup tools with breathing provisions or be visually sure material is entering the vacuum hose at a proper rate.