



EFR

Empire Finish & Reclaim Cabinets

Section C: Table of Contents

Cabinet Models C1

Options

EFR-2636 SRB	C2
EFR-2636 SRC	C3

Parts

Cabinet Assembly	C4
Reclaimer	C5
Dust Bag	C5
Dust Collector	C6
Pipe String	C7
Blast Gun	C7

Options Details

Cabinet	C8
Dust Collector	C9

EFR Cabinet Models

MODEL DESCRIPTION	PART NUMBER	DOOR TYPE	DUST COLLECTION	BLOWER MOTOR	SHIPPING WEIGHT
EFR-2636 SRB	119001	Single	Bag	½ hp	425 lbs
EFR-2636 SRC	119000	Single	DCR-80	½ hp	675 lbs

IMPORTANT! Be sure 115 Volt, 50-60 Hertz, Single-Phase electrical source is available at the installation site. Machine must be wired for the customer's electric source.

Never use silica sand in any Empire equipment.



Options: EFR-2636 SRB

	PART NUMBERS		SEE PAGE
	FACTORY INSTALLED	CUSTOMER INSTALLED	
Cabinet Extended-Wear Options			
Black curtain for cone	510751	510831	C8
Black curtains for front wall	140642	140643	C8
Black curtains for interior sides and back wall	510791	510871	C8
White curtain for cone	140550	140558	C8
White curtains for front wall	140767	140969	C8
White curtains for interior sides and back wall	140554	140562	C8
Window protector, plastic	509191	509191	C8
Window protector, screen	509201	509201	C8

Cabinet Options

Antistatic strap	510411	510411	C8
Armrest assembly	140595	140595	C8
Door interlock safety switch	140575	140575	C8
Dust-off gun assembly	140527	140527	C8
Glove hole plugs	140623	140622	C8
Gun holder, fixed	140400	140400	C8
KLEEN™ package	140356	140391	C8
Left-side door	141345	141603	—
Nozzle, 1/4" boron	502071	502071	—
Nozzle, 1/4" Di-Carb™	501331	501331	—
Safety matting (specify length)	509002	509002	C8
Turntable, manual, 18" rolling, includes inside/outside tracks	140321	140321	C8
Turntable, manual, 18" stationary	140422	140422	C8





Options: EFR-2636 SRC

	PART NUMBERS		SEE PAGE
	FACTORY INSTALLED	CUSTOMER INSTALLED	
Cabinet Extended-Wear Options			
Black curtain for cone	510751	510831	C8
Black curtains for front wall	140642	140643	C8
Black curtains for interior sides and back wall	510791	510871	C8
White curtain for cone	140550	140558	C8
White curtains for front wall	140767	140969	C8
White curtains for interior sides and back wall	140554	140562	C8
Window protector, plastic	509191	509191	C8
Window protector, screen	509201	509201	C8

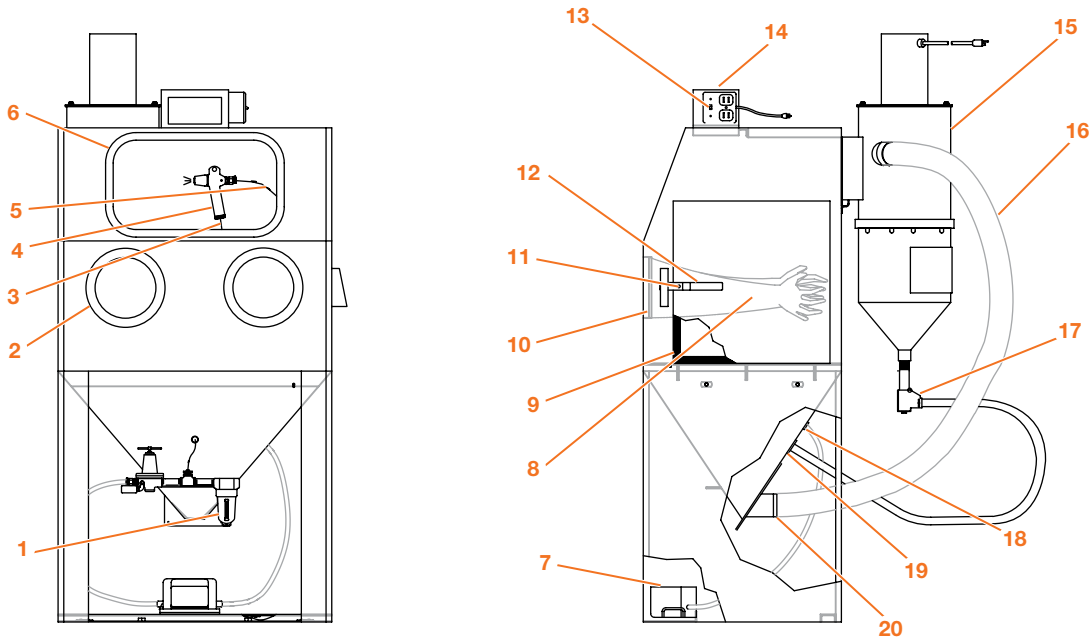
Cabinet Options			
Antistatic strap	510411	510411	C8
Armrest assembly	140595	140595	C8
Door interlock safety switch	140575	140575	C8
Dust-off gun assembly	140527	140527	C8
Glove hole plugs	140623	140622	C8
Gun holder, fixed	140400	140400	C8
KLEEN™ package	140356	140391	C8
Left-side door	141345	141603	—
Nozzle, ¼" boron	502071	502071	—
Nozzle, ¼" Di-Carb™	501331	501331	—
Safety matting (specify length)	509002	509002	—
Turntable, manual, 18" rolling, includes inside/outside tracks	140321	140321	C8
Turntable, manual, 18" stationary	140422	140422	C8

Dust Collector Options for DCR-80			
Bag shaker, automatic electric, 115 volts	140340	140390	C9
Leg extension kit	140170	140170	C9
Lid assembly for 55 gallon drum	140255	140255	C9
Manometer	140344	140398	C9



Parts: EFR Cabinet Assembly

Guide to Part Numbers



EFR CABINET COMPONENTS		
Item	Description	Part #
1	Pipe string, EFR (See page C7.)	140517
2	Glove rings	555016
3 *	Blast hose, 5/8" ID x 6' section	522571
	Blast hose, 5/8" ID (Specify length.)	520802
4 *	Blast gun, MH-2 (See page C7.)	506001
5	Air hose assembly, 1/2" ID x 7.5'	522831
6	Window kit (Includes bulleted items below)	140544
• *Δ	Safety glass, 14" x 22"	510401
• *	Gasket, window (6' section)	524451
	Gasket, 1/4" x 1/4" (Specify length.)	525941
•	Frame, window	760291
•	Knob, 3/8"-16 (4 required)	510461
•	Bolt, 3/8"-16 x 1-1/4"	551852
•	Spacer, window (4 required)	525931
	Foot treadle, EFR	518651
7	Valve, foot treadle	518661
	Repair kit for foot treadle	518671
8 *	Gloves, pair	509891
	Glove, left hand	510821
9 *	Gasket, door (7.2' section, 1 side door)	525671
	Gasket, 3/4" x 3/4" (Specify length.)	524441
10	Clamp, 8" (2 required)	520561
11	Bolt, door, 3/8"-16 x 1	551842
	Nut, 3/8"-16 (ESNA)	553952
	Handle, door	760361
	Cover, handle	509571

Item	Description	Part #
13	Light box assembly (includes bulleted items below)	141468
•	Light fixture with gasket	532711
• †	Floodlight, 150 Watt	532701
• *	Gasket, light bulb	580191
• †	Switch, on/off, 15 amp	534421
•	Line cord with plug	529601
14	Inlet filter screen	510481
	Inlet filter (2 required)	510495
15	Reclaimer assembly with blower (See page C5.)	140518
16	Conveying hose, 3" x 6'	515941
17	Media regulator, SAR-2 (See page C5.)	290156
18	Grommet, air hose, 3/4" x 1 1/16"	523921
19	Grommet, blast hose, 1" x 1 3/8"	523931
20	Hose clamp, 3" (one each end)	520521

NOT SHOWN

•	Floor section (2 required)	760541
•	Door hinge, 3"	509531
•	Z-strip, reclaimer mount	760151
•	Decal, INSTRUCTIONS/WARNINGS	567391
•	Decal, orange dot strip	564301
•	Decal, Empire logo	564305
•	Paint, touch-up kit	564476

* Recommended spare part — Consumable wear item

† Essential component to prevent downtime

Δ Failure to replace glass with Empire safety glass could result in serious injury.

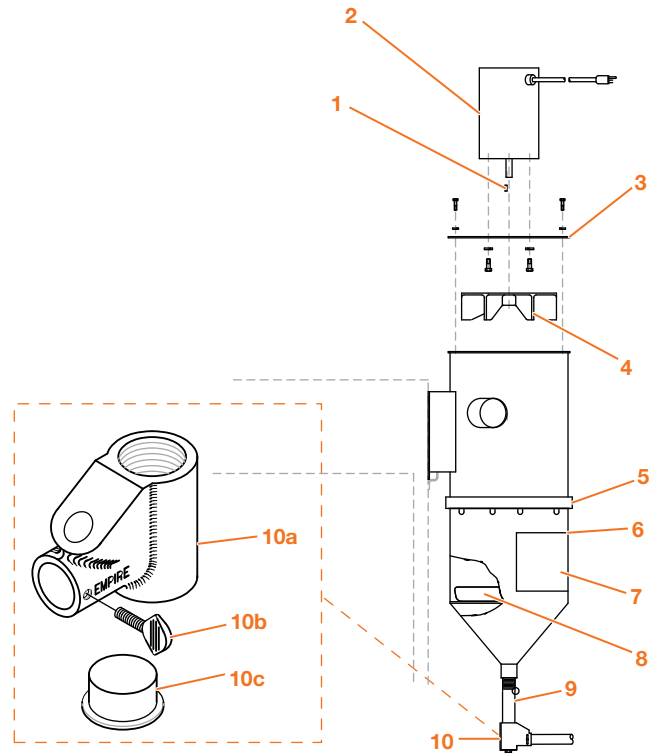


Parts: EFR Reclaimer, 300 CFM

Guide to Part Numbers

EFR Reclaimer Components		
Item	Description	PART #
	Reclaimer assembly with blower	140518
	Reclaimer assembly without blower	140519
1	Motor key, 3/16" x 1 1/2"	549811
2 †	Motor, 1/2 HP, 115-230V/50-60Hz/1 Phase	549911
3	Reclaimer top	767641
4	Fan blade, 9 3/4" diameter x 5/8" ID	754531
5	Tuning band (steel part only), solid	767581
	Gasket, tuning band, solid	524342
	Tuning band (steel part only), with slots	760701
	Gasket, tuning band, with slots	524341
6 †	Gasket, reclaimer door	524331
7	Door	760721
8	Screen	739041
9	Pipe nipple, 5"	546742
10	SAR-2 media regulator, complete, 1 1/4" FPT	290156
10a	SAR-2 media regulator, body	753351
10b	Thumb screw, 1/4" - 20 x 1"	551042
10c	Plug, clean out	510121

† Essential component to prevent downtime

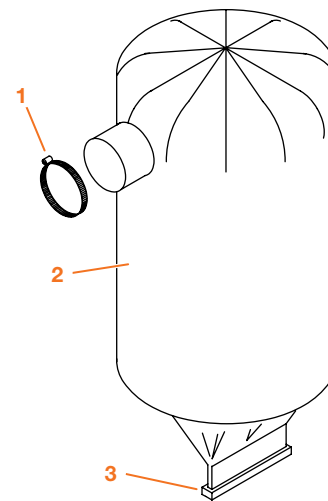


Parts: EFR Dust Bag

Guide to Part Numbers

Dust Bag Components		
Item	Description	PART NUMBER
1	Clamp, 4" adjustable	520531
2 *	Dust bag, 4" inlet, 30 sq. ft.	515841
3	Closure clamp	520461
	Blower assembly (<i>See above.</i>)	—

* Recommended spare part—Consumable wear item



* Recommended spare part—Consumable wear item

† Essential component to prevent downtime



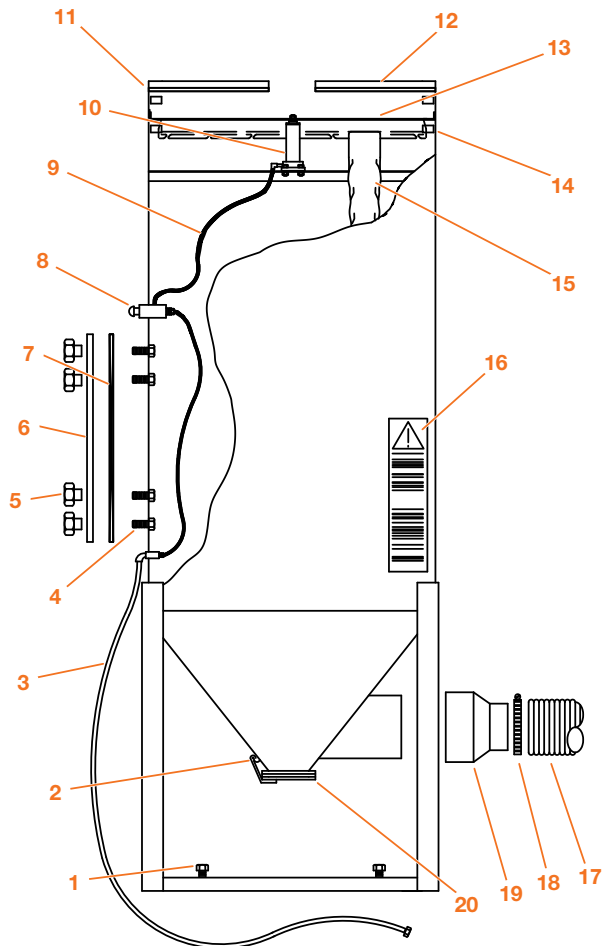
Parts: EFR Dust Collector, DCR-80

Guide to Part Numbers – DCR-80, Part Number 112100

DCR-80 COMPONENTS		
Item	Description	PART#
1	Bolt, levelling, 3/8" - 16 x 2" (4 required)	553892
2	Latch and keeper (requires welding)	509581
3	Hose with fittings, 1/4" x 16', dust collector	523161
4	Bolt, 3/8" - 16 x 1 1/4" (6 required)	551852
5	Knob, 3/8" - 16 (6 required)	510461
6	Access door, dust collector	760851
7 †	Gasket, access door, 5/8" x 5/8", 103" section	525711
	Gasket, 5/8" x 5/8" (specify length)	525061
†	Valve, push-button, 1/8" NPT & #10 - 32, "3P"	517221
8	Barbed fitting, 1/4" tube x #10 - 32, 2 per assembly	521101
	Adapter, 1/4" tube x 1/8" MPT, 90° (for air cylinder)	520432
9	Tubing, 1/4" OD (8' required)	510541
10 †	Air cylinder, standard collector and auto shaker	515981
	Air cylinder, auto-pneumatic bag shaker only	515771
11 †	Gasket, top plate, 1/8" x 1/4" (8' required)	523551
12	Top plate	760831
13	Bag-rack weldment	760861
14	Rubber bumper (8 required)	523541
15 *	Dust bag, cotton sateen (12 required)	515521
	Decal, Empire logo (not shown)	564305
	Decal, orange dot strip (not shown)	564301
	Paint, 6 oz. aerosol, beige (not shown)	564476
16	Decal, Instruction/Warning	567405
17	Dust hose, 4" x 8'	522351
18	Hose clamp, 4"	520531
19	Adapter, 6" ID x 4" OD	764691
20 †	Gasket, clean-out door, dust collector	524351

* Recommended spare part—Consumable wear item

† Essential component to prevent downtime



DCR-80 Options

Automatic bag shaker cleans bags thoroughly every time the system is turned off.

Electric shaker for all bag-house collectors

Pneumatic shaker for DCR-80

PART NUMBERS		
FACTORY INSTALLED	CUSTOMER INSTALLED	SEE PAGE
140340	140390	C10
140685	140686	Call

Leg extension kit raises collector so larger collection drum can be placed underneath.
Kit for DCR-80

140170 140170 —

Lid assembly for 55 gallon drum attaches securely to clean-out door.

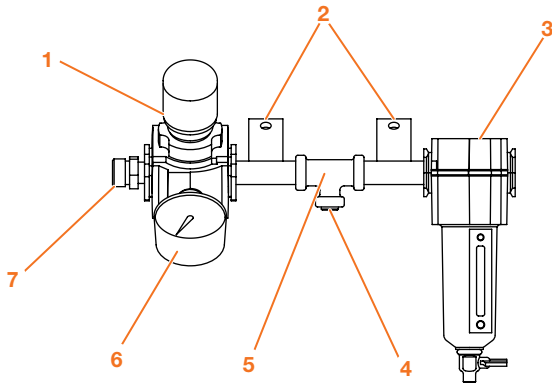
140255 140255 C10

Manometer keeps operator informed regarding bag cleanliness.

140344 140398 —

Parts: EFR Pipe String

EFR Pipe String Part Number 140517



Guide to Part Numbers

EFR Pipe String Components		
Item	Description	Part #
	Pipe string, EFR (Includes items 1 through 7)	140517
1	Regulator, 3/8", without gauge	517301
†	Diaphragm and O-ring kit for regulator	508201
2	Bracket (2 required)	767591
	Filter, manual 3/8"	504592
3 *	Element for 3/8" filter (not shown)	508012
†	O-ring and gasket kit for 3/8" filter (not shown)	508112
4	Pipe plug, 1/4"	544062
5	Reducing Tee	545672
6	Gauge, 1/4" NPT	550232
7	Connector, brass, 3/8" x 1/2"	520413

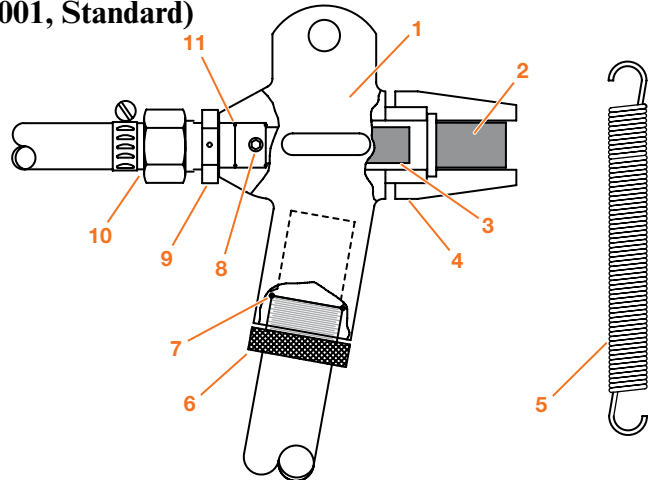
* Recommended spare part — consumable wear item
 † Essential component to prevent downtime

Parts: EFR Blast Gun

MH-2 Gun with 1/4" Ceramic Nozzle (P # 506001, Standard)

Item	Description	PART NUMBER
1 *	Gun body, MH-2 long handle	735551
2 *	Nozzle, 1/4" ceramic, 3/32" air jet (standard)	502421
3 *	Air jet, 3/32" (orange)	505651
4 *	Nozzle adapter, plastic	505641
5	Spring, suction-gun assist	511251
6	Nut, hose clamp, MH-2	520081
7	O-ring 1 1/16" ID x 1 5/16" OD	523881
8	Screw set, 1/4" - 20 x 3/8"	551052
9	Connector, MH-2	505631
10	Hose barb, 1/2" FPT x 1/2" hose	520402
11	O-ring, 1/2" ID x 5/8" OD (2 required)	523912

* Recommended spare part—Consumable wear item
 † Essential component to prevent downtime



Nozzles for MH-2 Guns, 1/4"

	PART NUMBER
Ceramic (each)	502421
Ceramic (10 pack)	503341
Di-Carb™ (each)	501331
Boron (each)	502071



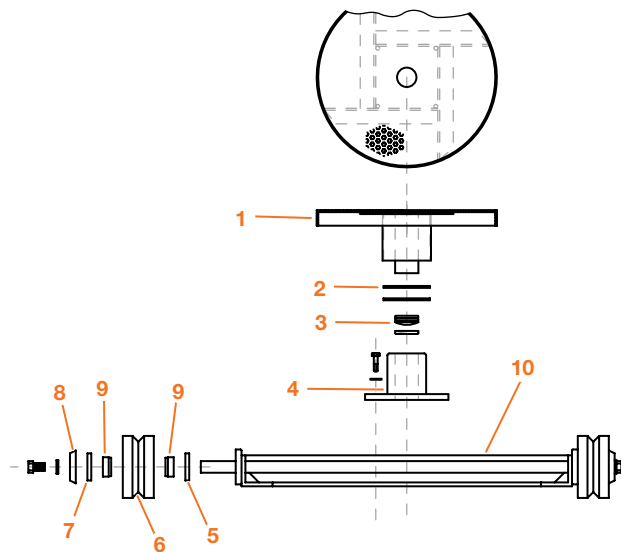
Options Details: EFR Cabinets

Cabinet Options

	PART NUMBERS	
	FACTORY INSTALLED	CUSTOMER INSTALLED
Antistatic strap prevents static shock to the operator.	510411	510411
Armrest assembly reduces fatigue.	140595	140595
Door interlock safety switch shuts down blasting when swing doors are opened. (Switch assembly)	140575	140575
Valve	518661	518661
Valve bracket	518781	518781
Valve gasket	525871	525871
Hose barb, 1/4" NPT x 1/2" hose	523121	523121
Plug, 1/4" NPT	545441	545441
Dust-off gun removes fines and debris from part surfaces. (Complete assembly)	140527	140527
Dust-off gun only	509821	509821
Hose assembly, dust-off gun	522631	522631
Grommet, dust hose, 1/4 - 5/8" x 7/8"	523951	523951
Glove hole plugs seal cabinet for automated operation.	140623	140622
Gun holder, fixed , frees operator to manipulate work pieces within the blast stream.	140400	140400
KLEEN™ package prevents dust from dropping onto the floor when cabinet doors are opened and returns pressurized media to the cabinet in the event that a blast nozzle plugs.	140356	140391
Rubber curtains shield cabinet interior from harsh abrasives. <i>Rubber nuts (Part # 523533) required.</i>		
Black curtain for cone	510751	510831
Black curtains for front wall	140642	140643
Black curtains for interior sides and back wall	510791	510871
White curtain for cone	140550	140558
White curtains for front wall	140767	140969
White curtains for interior sides and back wall	140554	140562
Safety matting protects turntables, cabinet floors and workers. (Two-foot-wide safety matting, with pockets to catch spilled media, is sold by the linear foot. Lengths required: 11 feet around cabinet without turntable; 14' around cabinet with rolling turntable; 3 feet for interior cabinet floor. Specify total length required when ordering.)	509002	509002

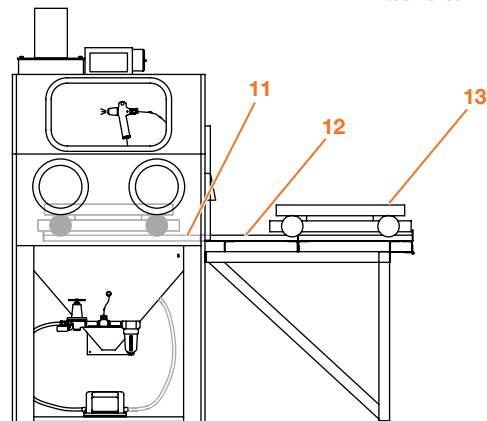
Turntables facilitate the processing of heavy parts.

Table, Cart & Wheels



Item	Description	PART #
1	18" turntable	768581
2	Seal (5 required)	516001
3	Bearing thrust	570091
4	Bearing	570141
5	Wheel-bearing seal, inner	525871
6	V-groove wheel	509841

Tracks & Platforms



Item	Description	PART #
7	Wheel-bearing seal, outer	580351
8	Outside cup	600291
	Cotter pin 3/16" x 1/4" (before 1987)	553002
9	Hub insert	767071
10	Cart & wheels assembly, EFR only	140508
11	Inside track for EFR, 1 door	760991
12	Outside track for EFR	760951
13	Manual turntable with 18" dolly	140456

FACTORY INSTALLED CUSTOMER INSTALLED

Window protector, made of clear plastic, is recommended for use with light, less aggressive abrasives.

509191 509191

Window protector, consisting of a steel screen, protects against heavy and coarse media.

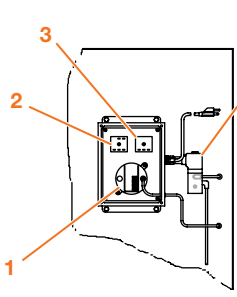
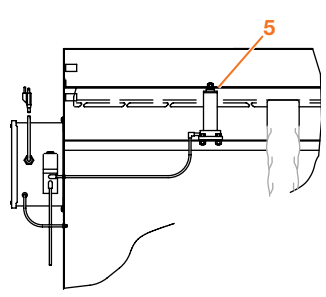
509201 509201



Options Details: EFR Dust Collector

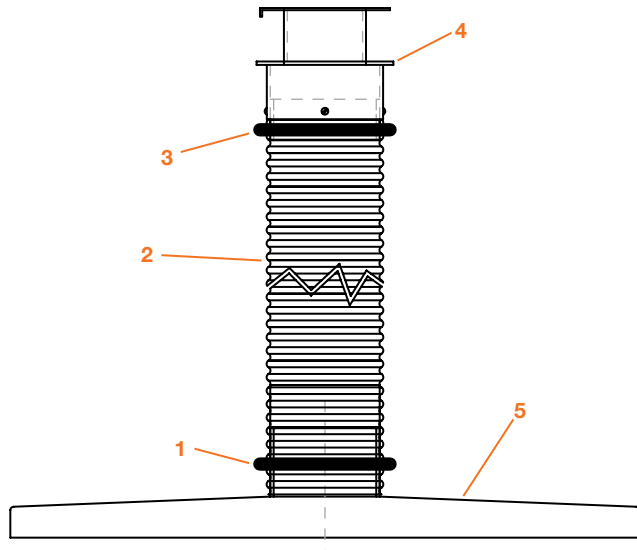
DCR-80 Dust Collector Options

		PART NUMBERS	
		FACTORY INSTALLED	CUSTOMER INSTALLED
Bag shaker, automatic electric , cleans bags thoroughly every time the system is turned off.		140340	140390
Bag Shaker, Automatic Electric Components			
Item	Description	PART #	
1	Pressure switch, differential	550311	
2	Timer	531081	
3	Flasher	535313	
4	Solenoid valve, 120 VAC	517311	
5	Cylinder (not included; standard with collector)	515981	

Leg extension kit raises collector so larger collection drum can be placed underneath.	140170	140170
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Lid assembly for 55 gallon drum attaches securely to clean-out door.	140255	140255	
Lid Assembly Components			
Item	Description	PART #	
1	Hose clamp, 4"	520531	
2	Dust hose, light-duty, 4"	522923	
3	Hose clamp, 4"	520531	
4	Adapter	760412	
5	Lid, 55 gallon drum	761007	
	Gasket for lid (not shown)	800166	



Manometer keeps operator informed regarding bag cleanliness.	140344	140398
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