



# EFR

## Empire Finish & Reclaim Cabinets

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**Cabinet Models** C1

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### **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	
<b>Cabinet Extended-Wear Options</b>			
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
<b>Cabinet Options</b>			
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	
<b>Cabinet Extended-Wear Options</b>			
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

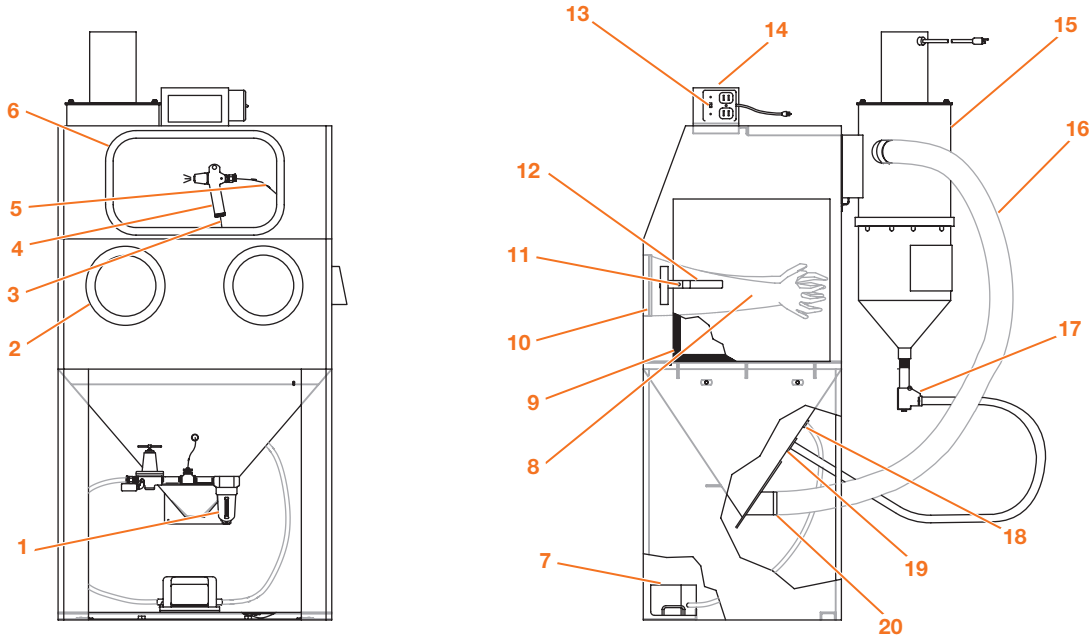
## Dust Collector Options for DCR-80

Bag shaker, automatic electric, 115 volts	140340	140390	C9
Leg extension package for 16 gallon drum	140259	140258	C9
Leg extension package for 55 gallon drum	140170/140255	140170/140255	C9
Leg extension stand (only) for 16 gallon drum	140171	140171	C9
Leg extension stand (only) for 55 gallon drum	140170	140170	C9
Lid assembly and drum, 16 gallon	113015	113015	C9
Lid assembly (only) for 55 gallon drum	140155	140155	C9
Manometer, measures pressure differential	140344	140398	C9
Minihelic gauge, measures pressure differential	140841	140842	C9



# Parts: EFR Cabinet Assembly

## Guide to Part Numbers



EFR CABINET COMPONENTS			EFR CABINET COMPONENTS		
Item	Description	Part #	Item	Description	Part #
1	Pipe string, EFR (See page C7.)	140517	13	Light box assembly (includes bulleted items below)	141468
2	Glove ring flange, bolt on	555036	•	Light fixture with gasket	532711
2	Knob, 3/8"-16 (4 required)	510461	• †	Floodlight, 70 Watt	532701
	Glove ring flange, twist on	555016	• *	Gasket, light bulb	580191
3 *	Blast hose, 5/8" ID x 7' section	522571	• †	Switch, on/off, 15 amp	534421
	Blast hose, 5/8" ID (Specify length.)	520802	•	Line cord with plug	529601
4 *	Blast gun, MH-2 (See page C7.)	506001	14	Inlet filter screen	510481
5	Air hose, 1/2" ID (specify length)	520861		Inlet filter (2 required)	510495
6	Window kit (Includes bulleted items below)	140544	15	Reclaimer assembly with blower (See page C5.)	140518
• *Δ	Safety glass, 14" x 22"	510401	16	Conveying hose, 3" x 6'	515941
• *	Gasket, window (6' section)	524451	17	Media regulator, SAR-2 (See page C5.)	290156
	Gasket, 1/4" x 1/4" (Specify length.)	525941	18	Grommet, air hose, 3/4" x 1 3/8"	523921
•	Frame, window	760291	19	Grommet, blast hose, 1" x 1 3/4"	523931
•	Knob, 3/8"-16 (4 required)	510461	20	Hose clamp, 3" (one each end)	520521
•	Bolt, 3/8"-16 x 1-1/4"	551852	<b>NOT SHOWN</b>		
•	Spacer, window (4 required)	525931	•	Floor section (2 required)	760541
	Foot treadle, EFR	518651	•	Door hinge, 3"	509531
7	Valve, foot treadle	518661	•	Z-strip, reclaimer mount	760151
	Repair kit for foot treadle	518671	•	Decal, INSTRUCTIONS/WARNINGS	567391
8 *	Gloves, pair	509891	•	Decal, orange dot strip	564301
	Glove, left hand	510821	•	Decal, Empire logo	564305
9 *	Gasket, door (7.2' section, 1 side door)	525671	•	Paint, touch-up kit	564476
	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			
12	Handle, door	760361			
	Cover, handle	509571			

\* Recommended spare part — Consumable wear item

† Essential component to prevent downtime

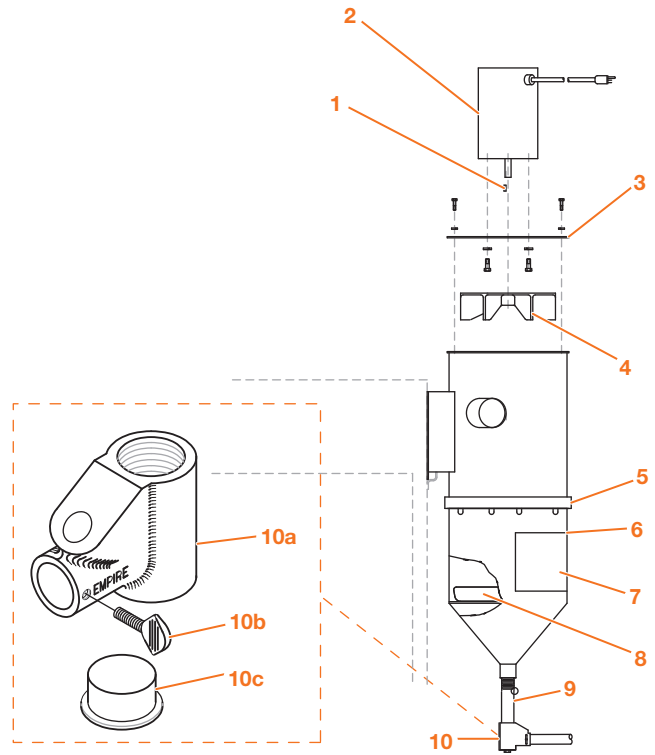
Δ Failure to replace glass with Empire safety glass could result in serious injury.

# 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

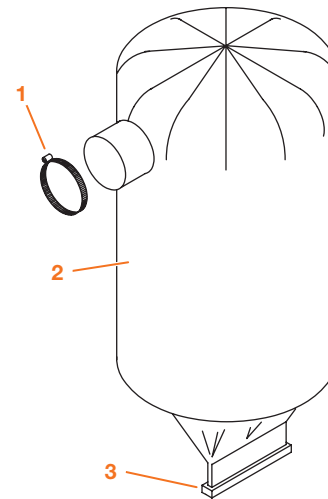


# Parts: EFR Dust Bag

## 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



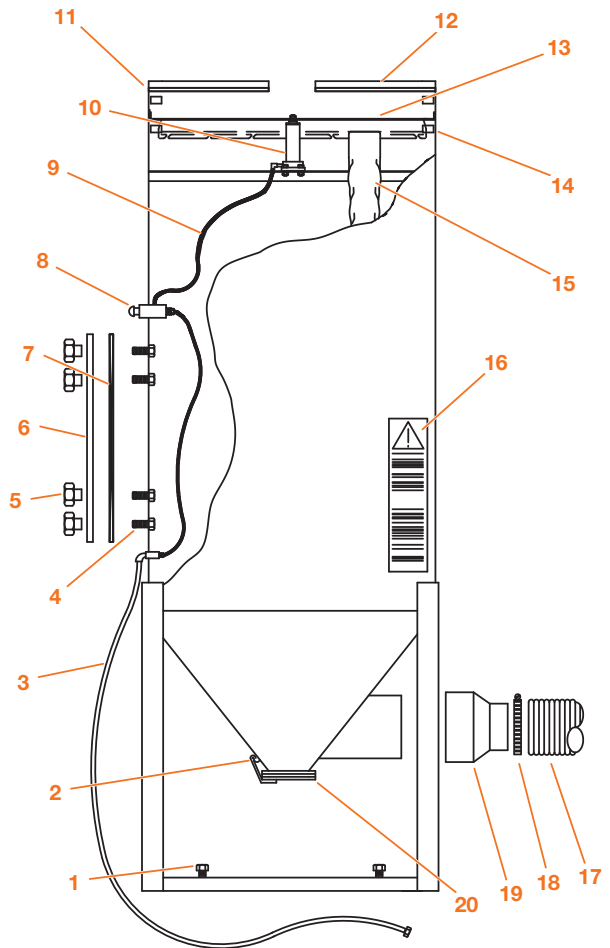
# Parts: EFR Dust Collector, DCR-80

## 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 1/2", 103" section	525711
	Gasket, 5/8" x 1/2" (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

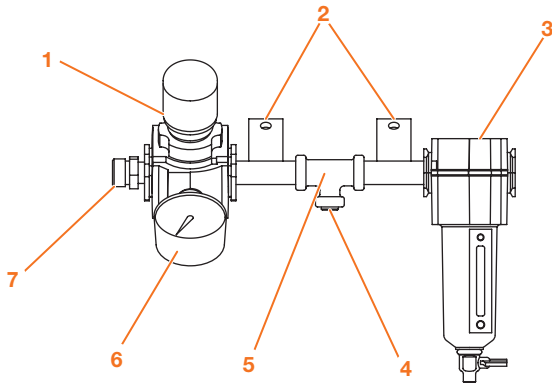


### DCR-80 Options

	PART NUMBERS		
	FACTORY INSTALLED	CUSTOMER INSTALLED	SEE PAGE
<b>Automatic bag shaker</b> cleans bags thoroughly every time the system is turned off.			
<b>Electric shaker</b> for all bag-house collectors	140340	140390	C9
<b>Pneumatic shaker</b> for DCR-80	140685	140686	Call
<b>Leg extensions</b> raise collector so larger collection drum can be placed underneath.			
Leg extension package for 16 gallon drum	140259	140258	C9
Leg extension package for 55 gallon drum	140170/140255	140170/140255	C9
Leg extension stand (only) for 16 gallon drum	140171	140171	C9
Leg extension stand (only) for 55 gallon drum	140170	140170	C9
<b>Lid assemblies</b> for collection drums attach securely to clean-out door.			
Lid assembly and drum, 16 gallon	113015	113015	C9
Lid assembly (only) for 55 gallon drum	140155	140155	C9
<b>Manometer</b> , measures pressure differential	140344	140398	C9
<b>Minihelic gauge</b> , measures pressure differential	140841	140842	C9

## 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

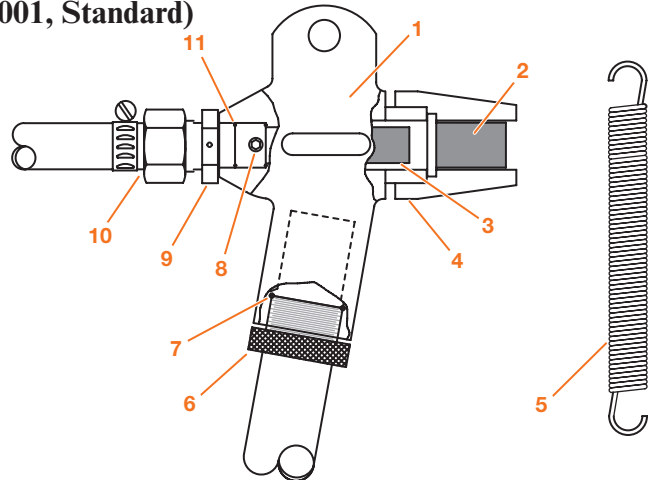
\* Recommended spare part — consumable wear item  
 † Essential component to prevent downtime

## 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	753551
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



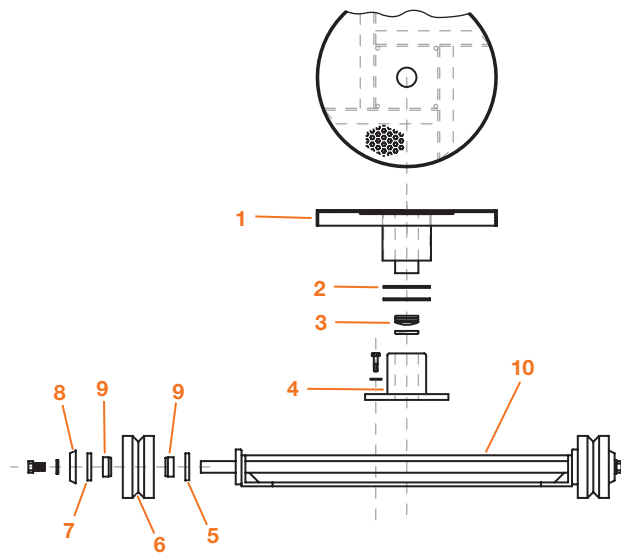
# Options Details: EFR Cabinets

## Cabinet Options

	PART NUMBERS	
	FACTORY INSTALLED	CUSTOMER INSTALLED
<b>Antistatic strap</b> prevents static shock to the operator.	510411	510411
<b>Armrest assembly</b> reduces fatigue.	140595	140595
<b>Door interlock safety switch</b> shuts down blasting when swing doors are opened. (Switch assembly)	140575	140575
<b>Valve</b>	518661	518661
<b>Valve bracket</b>	518781	518781
<b>Hose barb</b> , 1/4" NPT x 1/2" hose	523121	523121
<b>Plug</b> , 1/4" NPT	545441	545441
<b>Dust-off gun</b> removes fines and debris from part surfaces. (Complete assembly)	140527	140527
<b>Dust-off gun only</b>	509821	509821
<b>Hose assembly</b> , dust-off gun	522631	522631
<b>Grommet</b> , dust hose, 1/4 - 5/8" x 7/8"	523951	523951
<b>Glove hole plugs</b> seal cabinet for automated operation.	140623	140622
<b>Gun holder</b> , fixed, frees operator to manipulate work pieces within the blast stream.	140400	140400
<b>KLEEN™ package</b> 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
<b>Rubber curtains</b> shield cabinet interior from harsh abrasives. <b>Rubber nuts (Part # 523533) required.</b>		
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
<b>Safety matting</b> 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

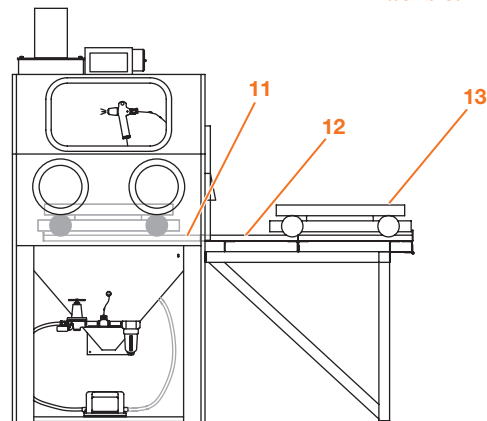
**Turntables** facilitate the processing of heavy parts.

### 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 1/4" (before 1987)	553002
9	Hub insert	767071
10	Cart & wheels assembly, EFR only	140508
11	<b>Inside track</b> for EFR, 1 door	760991
12	<b>Outside track</b> 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**

<b>Bag shaker, automatic electric</b> , cleans bags thoroughly every time the system is turned off.	140340	140390
<b>Bag shaker, automatic pneumatic</b>	Call factory	Call factory

**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

<b>Leg extension package for 16 gallon drum</b> includes stand, drum cover and 16 gallon drum	140259	140258
<b>Leg extension package for 55 gallon drum</b> includes stand and drum cover only	140170/140255	140170/140255
<b>Leg extension stand (only) for 16 gallon drum</b>	140171	140171
<b>Leg extension stand (only) for 55 gallon drum</b>	140170	140170

**Lid assembly for 16 gallon drum** (includes drum)

**Components for 16 Gallon Lid Assembly with Drum**

Item	Description	PART #
1	Drum, 16 gallon	504016
2	Gasket for lid (5' required)	800166
3	Hose clamp, 4"	520531
4	Adapter (if required)	760412
5	Gum rubber tube, 4" ID x 8" long	523750
6	Lid weldment	850099-1

**Lid assembly for 55 gallon drum** (does not include drum)

**Components for 55 Gallon Lid Assembly without Drum**

Item	Description	PART #
1	Lid weldment	760123
2	Gasket for lid (7' required)	800166
3	Hose clamp, 4"	520531
4	Adapter (if required)	760412
5	Dust hose, 4" ID x 2' long	522923

<b>Manometer</b> measures pressure differential	140344	140398
<b>Minihelic Gauge</b> measures pressure differential	140841	140842

