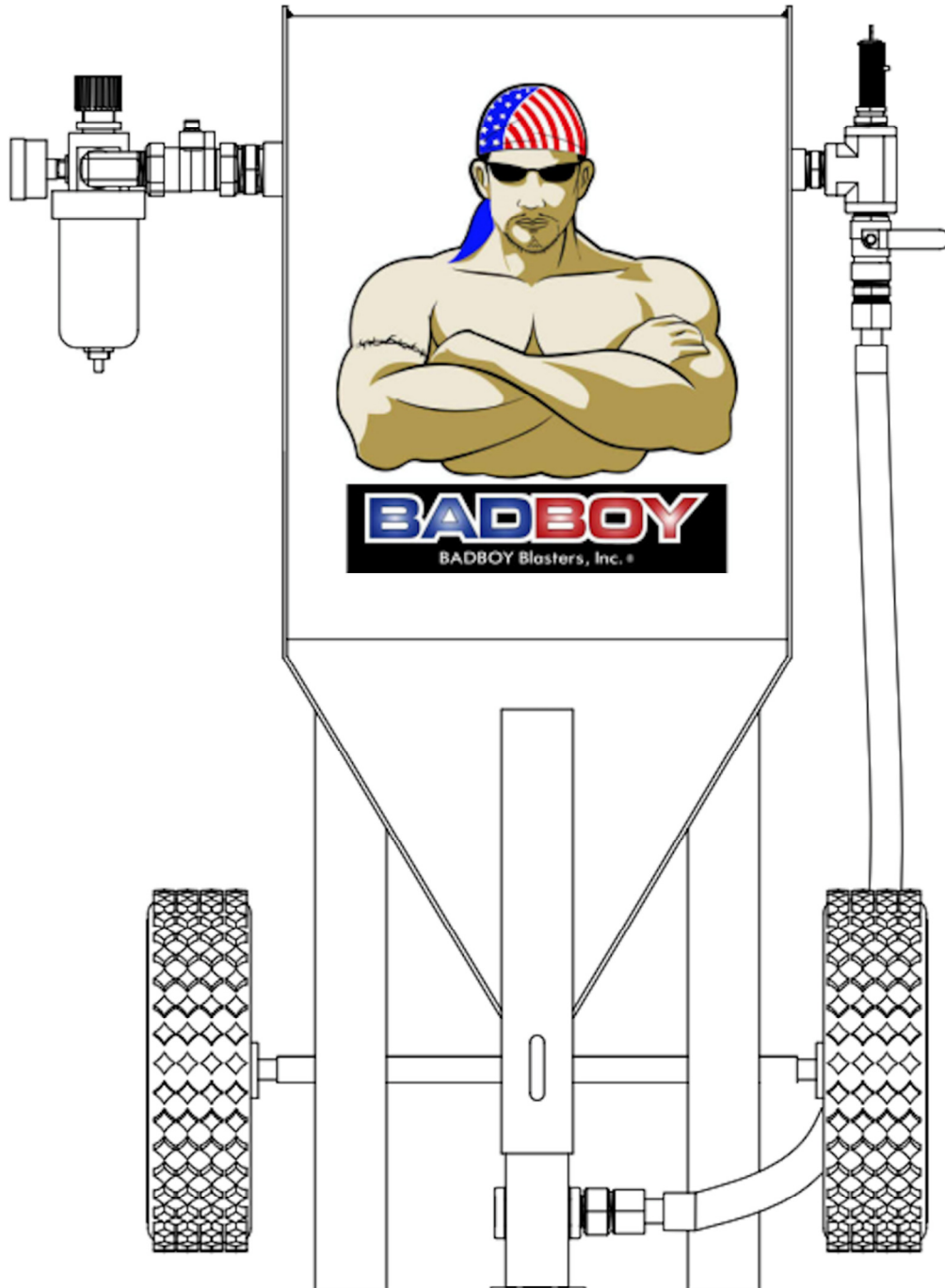


BB300DLX20-ASME

BB400DLX-20-ASME

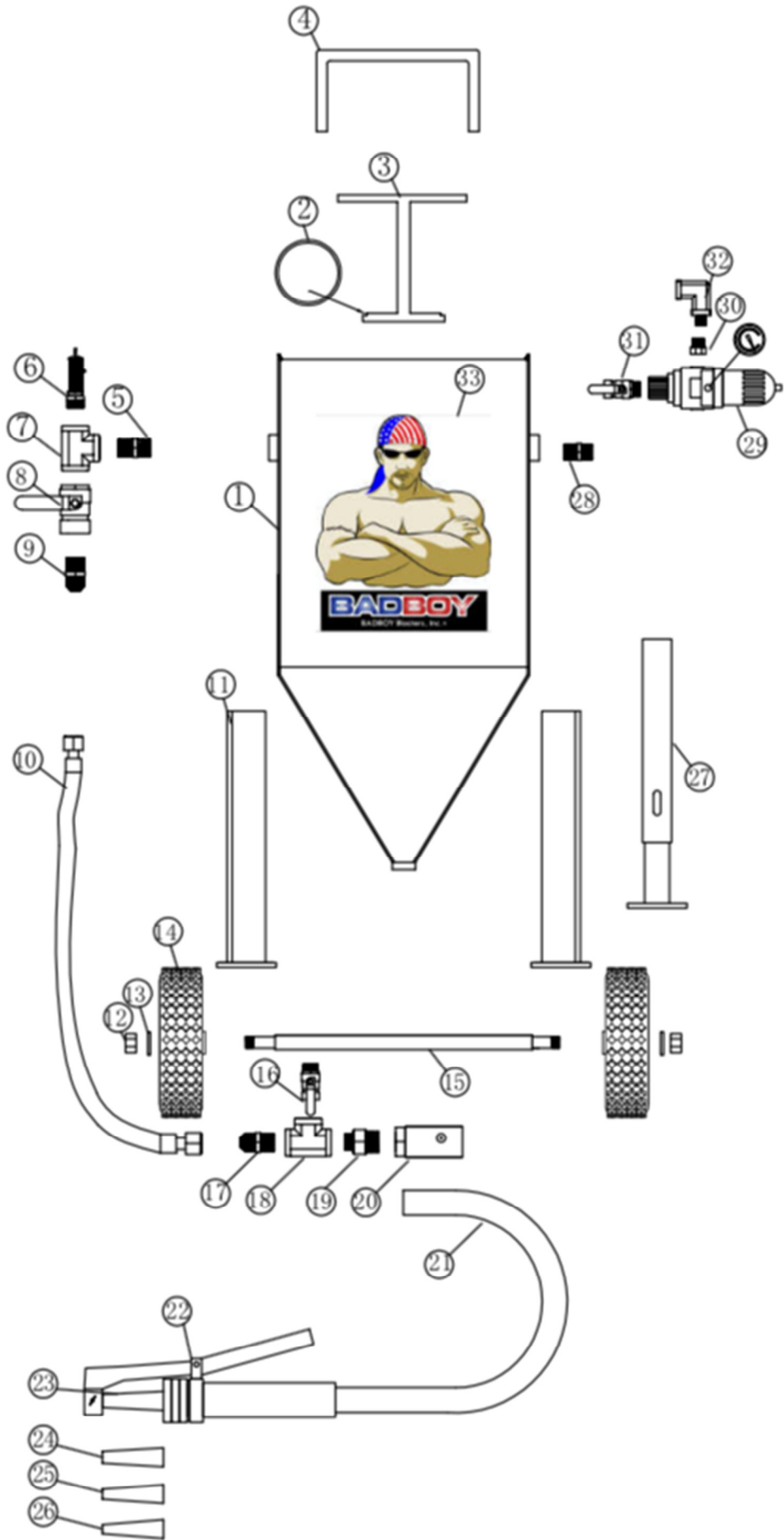


BADBOY BLASTERS MANUAL
BB300DLX20-ASME / BB400DLX-20-ASME

We take great pride in building the best sandblasters on the market today & hope you are happy with your purchase for years to come. Any questions or concerns please call us immediately at 330.454.2699 (main office) or 330.454.7485 and/or 330.413.5262 for owner & tech specialist Mark Cain.

Please find us on FaceBook, LinkedIn & If you like, leave us a review on our website at BADBOYBLASTERS.COM

BADBOY BLASTERS INC
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CANTON, OH 44705
330.454.2699 OR 330.413.5262
BADBOYBLASTERS.COM



Part Number	Part Description	Quantity	Dimension
1	Tank	1	
2	Rubber Mount	1	
3	T Stopper	1	
4	Handle	1	
5	Adapter	1	1/2"
6	ASME Safety Valve	1	
7	T Connector	1	1/2"
8	Ball Valve	1	1/2"
9	Adapter	1	1/2"
10	Rubber Hose	1	840 mm (400DLX) 1160mm(300DLX)
11	Stand	1	490mm
12	Nut	2	M16
13	Washer	2	M16
14	Wheels	2	10"
15	Wheels Shaft	1	490mm
16	Ball Valve	1	1/2"
17	Adapter	1	1/2"
18	T Connector	1	1/2"
19	Adapter	1	1/2" x 3/4"
20	Blast Hose Collar	1	
21	Blast Hose	1	
22	Blast Gun	1	BB103
23	Nozzle Spray	1	4mm
24	Nozzle Spray	1	5mm
25	Nozzle Spray	1	6mm
26	Nozzle Spray	1	7mm
27	Adjustable Stand	1	
28	Adapter	1	1/2"
29	Regulator	1	
30	Silencer	1	1/2" x 1/4"
31	Ball Valve	1	1/2"
32	Elbow	1	
33	Sticker Label	1	

SAFETY INSTRUCTIONS FOR SANDBLASTER

1. BEFORE OPENING THE TANK, release the air pressure in the media tank. To do this, turn off the air supply valve located at the air regulator, to release pressure in the tank, open the ball valve located to the right of the regulator. Caution- open ball valve slowly when releasing pressure, even though it has a built in silencer for hearing protection. The closure gasket will automatically drop when all pressure has been released. Once this falls, you can proceed with refilling.
- 2, MAINTAIN CORRECT AIR PRESSURE -Pressure should not exceed 95 PSI If it does ~ the safety valve will release if the pressure goes over 110 PSI. If this doesn't happen, stop all work immediately, and use the air compressor to reduce the excess pressure. Follow these rules or it can cause a tank explosion if not.

ASSEMBLING THE SANDBLASTER

Front leg assembly—This blaster at the factory was assembled & pressure tested. But for shipping reasons, the front leg must be removed. Assemble front leg with bolt provided. Before beginning operations, go back over each connection, double checking to ensure that all are tight and properly seated.

ABRASIVE SELECTION

The kind of sand you choose will greatly influence the amount of time needed to clean a given surface area. Sandblasting materials include silicon carbide, aluminum oxide, glass bead, black beauty, etc.

We do NOT recommend using play/beach sand in your blaster. The moisture in beach sands frequently causes plugging of the sand metering valve & hoses & will void your warranty.

CAUTION: Never use silica-based abrasives in BADBOY blast systems.

Some media is recyclable. If you elect to reuse abrasive, remember it does wear out. The sharp edges become rounder ~ and are less effective. If it's at that point you should replace the batch of abrasive you're using. **BE SURE TO STRAIN MEDIA IF REUSING. IF NOT IT WILL CAUSE REPEATED NOZZLE PLUG UP.**

******ALL SAND BLAST MEDIA/SAND MATERIAL MUST BE DISPOSED OF IN ACCORDANCE WITH THE LAWS OF YOUR STATE. ALWAYS WEAR A RESPIRATOR AND SAFETY GLASSES DURING THIS PROCESS******

The setting at the bottom of the pressure tank is very important. It's the device that meters the amount of abrasive that travels through the blasting hose during a blasting operation. By getting the valve too far open then you are filling the tank more often than needed. Yes, more media is better but there comes a point when too much will slow down the cut. Your media only cuts efficiently with media velocity. So, if media is allowed to travel through the hose in excess it can't remove as fast as it's being fed, then the velocity is taken away. The best setting to start with is the ball valve at 7 o'clock then adjust from there. Rule of thumb if the blast hose pulsates then the blast media setting is too much. Once you operate a few times you will get the hang of it. Set the pressure on the regulator at 100 psi

BE SURE TANK IS DECOMPRESSED BEFORE ATTEMPTING TO REFILL AND YOU ARE WEARING A RESPIRATOR AND SAFETY GLASSES

Open the top of the pressure tank. Once open begin to fill. Remember it takes 5lbs of media just to make the pressure tank function. The tank has a max capacity of 200-450lbs depending on your machine. It should be noted that when re-using media from the blaster to refill the pressure pot, It is wise to strain the media for any small pieces of debris. This will cause problems with the blast nozzle to plug up. It's recommended to strain the media with a colander or mesh screen.

LOADING ABRASIVES INTO THE TANK

1. Check your abrasive to be sure its dry, and won't clog the metering valve or sand outlet pipe.
2. Put on the protective clothing & eye protection.
3. Turn the air supply valve to the off position, also open tank decompression valve.
4. Watch the pressure gauge and make sure it reads zero pressure
5. Open tank and pour the abrasive inside. Be sure to get enough into the tank to do the job at hand. But if this is a big job fill the tank only 3/4 full, and reload as needed to finish the work.

TIP: if the humidity is 90-100%, the water trap won't be able to trap all of the moisture in a 3/4 full tank. Better to reduce the amount of abrasive, load more frequently, and empty the water trap more often. This will reduce the possibility of clogging the bottom of the tank or the line.

BE SURE TO GET NO FOREIGN MATERIAL IN THE TANK WHILE FILLING. THIS WILL CAUSE REPEATED PLUG UPS IF NOT FOLLOWED.

6. With the correct amount of abrasive in the tank, pull the closure gasket located in the center of the tank upward, then open the air supply valve slowly. Once there is enough pressure, you can let go of the closure gasket handle.
7. Check for air leaks at the filter cap as you begin to pressurize the tank from the compressor.

-Includes-

20 Ft I Heavy-duty 1/2" ID 1.063 OD hose industrial Blasting Hose

-Blasting hood

-Built-in Water Trap

-Built in Regulator

-Safety pressure release valve, 1/2in brass valves for air throttling and sand metering (40-100PSI)

-DEADMAN shut-off valve makes this completely safe

-4" X 10" Solid rubber wheels to prevent flat tires

300DLX tank holds 250lbs of abrasive material

400DLX holds 450lbs of abrasive material

MAINTENANCE

1. You should make every effort to protect your air compressor from any damage it may receive from your sandblasting work. Your best option is to keep the compressor in a room separate from the sandblaster, using a media hose to provide the PSI needed to do your work. A second choice is to keep the compressor up wind from the sandblasting. The greater the distance between them, the better. Other than that, you should continue standard maintenance procedures for the compressor.

2.. Some parts of the sandblaster will wear much more rapidly than others, the parts needing closest attention to are the ones that carry the air/abrasive mixture, starting with the sand hose, going through the metal fittings, & the shut off gun.

3.. If air leaks develop in any of these parts, you should stop all work, and find what needs to be repaired or replaced, When it's new, the sand hose has 2 cord piles and the walls are 1/4" thick; As the interior diameter is sandblasted, this wall becomes thinner and thinner. One way to inspect the hose and other parts affected by the blasting is to put on your protective clothing, then pressurize the system and close the nozzle shut off gun.

Close your hand loosely around the hose and run it up and down the hose across the fittings and nozzles. You'll be able to feel any leaks- You can also spot places in the hose where the wall is getting very thin.

These show up as blisters in the hose- if you find such a blister, get a new hose immediately- **If that blister breaks, the abrasive will shoot out of the side of the hose at 65 or more PSI & could cause serious injury.**

SAFETY INSTRUCTIONS

1. **KEEP THE WORK AREA CLEAN.** Cluttered areas invite injuries.
2. **CONSIDER WORK AREA ENVIRONMENT.** Don't use your sandblaster in damp, wet, or poorly lit locations. Keep work area well lit. Don't use compressors in the presence of flammable gases or liquids.
3. **KEEP CHILDREN AWAY** All children should be kept away from the work area. Don't let them handle tools, hose or extensions cords. No one should be in the area of the sandblasting who does not have the same protective equipment you are using.
4. **DRESS PROPERLY.** Wear protective clothing. A dust and abrasive hazard exists. **As a minimum, wear the hood (included), or safety goggles & a dust mask to prevent inhaling the material being removed, and heavy duty gloves.**

5. PERIODICALLY INSPECT THE SAND CARRYING COMPONENTS. These are being sandblasted on the inside whenever you use the sandblaster and will wear much more rapidly than other components.
6. SECURE THE WORK. Use clamps or a vise to hold the work if it is small or light weight. It's safer than using your hands and it frees both hands to operate the nozzle.
7. DON'T OVERREACH. Keep proper footing and balance at all times.
8. MAINTAIN TOOLS WITH CARE. Follow instructions for lubricating and changing components and accessories.
9. DISCONNECT AIR COMPRESSOR POWER. When not in use, before servicing, and when changing components.
10. AVOID UNINTENTIONAL STARTING. Be sure the nozzle valve is in the off position when not in use.
11. STAY ALERT. Watch what you are doing, use common sense, Don't operate any machine or tool when you are tired or on medications.
12. REPLACEMENT PARTS. When servicing use only identical replacement parts.

WARNING: When using tools such as your air compressor, whether powered by electric motor or gasoline engine, basic safety precautions should always be followed to reduce the risk of fire, electric shock, and personal injury.

You should review the safety instructions for your air compressor before beginning sandblasting with this machine.

Hose length: 20 feet

AIR SUPPLY REQUIREMENTS

Sandblasting requires a large volume of air at high pressure. The efficiency of your sandblaster can be adversely affected by the use of a too small air supply hose, insufficient air pressure or an overly large nozzle.

HOSE INTERIOR DIAMETER	HOSE LENGTH	NOZZLE INTERIOR DIAMETER	COMPRESSOR HORSEPOWER	CFM 125PSI	SAND USE PER HOUR	
3/8 INCH	50FT	1/8	5	19.67	200LBS	
1/2 INCH	50FT	3/16	10HP	44.15	300lbs	
3/4 inch	50ft	1/4	20HP	78.8	600lbs	

We recommend that air pressure in the range of 65- 100 PSI will provide the best results .

TROUBLESHOOTING YOUR BLASTER

Sandblasters operate on a pressure or siphon system, whether you use them for cleaning glass, metal, plastics or wood. This means that troubleshooting problems with your sandblaster will be similar, regardless of the model or brand. A sandblaster's input is high-pressure air from a compressor and the correct abrasive for the surface you're cleaning and the output of a sander is a mixture of air and the abrasive, meaning there are few places for a malfunction to occur. The majority of your problems will be due to moisture in lines, tanks or valve adjustments, if you've ruled out the lack of compressed air and other obvious problems.

- eliminate the possibility of a faulty gauge by testing your air gun to ensure you have high-pressure air available. No air is generally caused by a faulty compressor, so confirm that the air compressor output pressure gauge indicates a suitable pressure available when the compressor runs.

Clear blockages- Try activating the sandblaster gun and ensure you can see and feel the abrasive coming out of the nozzle. If you can, your sandblaster is working correctly. Don't worry, changes like this are common and often, clogged abrasive lines will clear themselves if they're bumped or clogged.

If you can feel air but no abrasive through the gun, you either have plugged up feed lines or an empty abrasive tank. If you have a pressure blaster, you may find that the mixing valve on the pressure tank is defective or obstructing the abrasive feed.

Check your nozzle- If you have adequate air and abrasive material, but you have a reduced blasting effect, try changing your nozzle. This is because the nozzle wears over time. As it gets larger, the blast pattern also becomes larger and less effective. This gradual fault can often be overlooked. An enlarged nozzle will cause your blaster to use more abrasive, so it's always a good idea to regularly change it.

Unwanted moisture- Drain condensation builds up in the compressor tank to be noticeable within a week, and even quicker if you live in a high humidity area. Getting rid of this unwanted moisture is one of the most important preventative maintenance jobs you can do. You will need to locate the drain and open it to properly dry it out. Moisture in the abrasive and air lines is the main cause of problems with sandblasters.

Tips and advice

- Complete your troubleshooting in an orderly fashion, and keep an up to date maintenance log, so you can quickly identify any possible problems before they occur.
- Never look into the sandblaster nozzle whilst the air compressor is attached to the system.
- Wear a respirator & eye protection when troubleshooting your sandblaster.