

Blast Cabinets

ACE carries a full line of versatile Blast Cabinets for jobs of all sizes. Whether you need a small siphon cabinet for your maintenance department or a large direct pressure cabinet for heavy production work, we have the cabinet you need.

See page 2



Dust Collectors

We manufacture dust collectors in a variety of sizes to meet the specific needs of your cabinet and work environment. Our dust collectors come with your choice of bag style or cartridge style filtration methods.

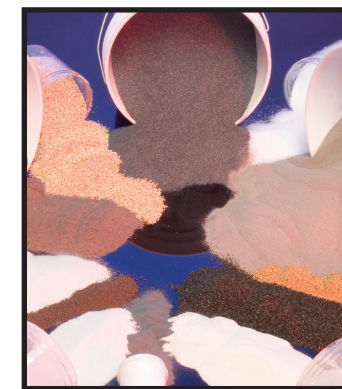
See page 14



Parts and Accessories

ACE carries a comprehensive line of replacement parts and accessories to ensure that your blasting cabinet is properly maintained and equipped for the type of work you are doing.

See page 29



Abrasive Media

We offer dozens of abrasive media choices to ensure that you always have the right media for the application.

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ACE Automotive Cleaning Equipment
For Those Who Demand Performance



ACE President Dan DePottey

ACE Company Profile

ACE was founded in January of 1976 to meet the demand for dependable, well-built abrasive blast equipment at a reasonable price.

The company's commitment to top quality, economically priced equipment has established ACE as a leading supplier of blasting equipment to individuals and industries worldwide.

ACE abrasive blast cabinets are produced by forming and welding heavy gauge steel. Every product design includes emphasis on safety and convenience considerations that serve to enhance the ruggedness and user friendliness of the product. Gun nozzles and air jets are tungsten carbide, which lasts considerably longer than ceramic. Full width openings, shielded fluorescent lighting, air safety switches, and an air regulator are features that contribute to consistently producing a superior blasting result with ease.

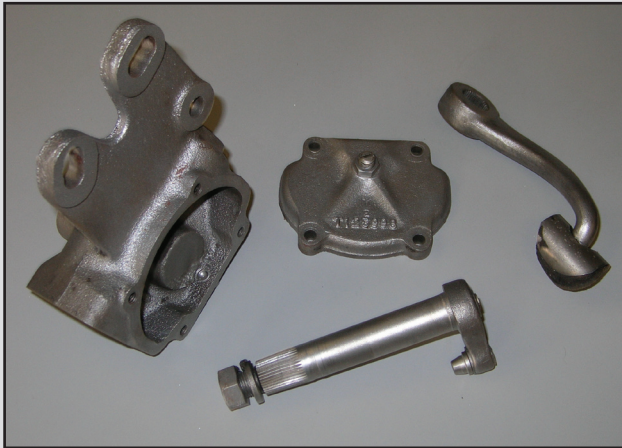
With a wide variety of stock cabinet sizes, designs, options, and the ability to custom fabricate special systems; ACE can meet almost every customer's needs.

The ACE product line also includes portable pressure blasting equipment, a variety of blasting media, and an extensive service parts inventory.

In addition to our complete product line, ACE also offers a knowledgeable technical service staff to assist you in making the proper selection of equipment and media to meet your needs and to keep your system running trouble-free.

Dedicated to producing the highest quality products and service to our customers, success at ACE is gauged by customer satisfaction.

Blast Cabinets – Siphon



Abrasive Blasting

The abrasive blasting process itself is simple: It works by rushing compressed air through a specifically designed delivery system that combines compressed air with abrasive media. This combination of air and abrasive slams into the targeted piece, cutting, etching, abrading, cleaning or otherwise changing the appearance or condition of that surface.

Abrasive blasting is valuable as an efficient, high-quality method of surface preparation. No other method of metal cleaning allows better control of the surface preparation or cleans the surface as thoroughly. By beginning with a screened abrasive, you control and obtain a consistent profile on the targeted surface. This clean, etched surface aids in adhesion and allows the coating to lock onto the surface. This combination of clean and etch greatly enhances the ability to obtain a superior quality finish. Blasting also allows access to irregularly shaped parts that can't be reached by traditional sanding or solvent cleaning methods.

Blasting is also used for other purposes beyond surface preparation, such as removing microscopic machining burrs from engine parts, etching glass, carving of names and designs in wood and stone or surface hardening of manufactured parts.

Model 7

Overall Dimensions			Openings	Window
Height	Width	Depth	Top 48" x 60"	Height 12"
92"	65"	86"	Side 20" x 30"	Width 24"
Working			Approx. Weight	Mfg. Number
40"	60"	48"	1100 lbs	101701X-A

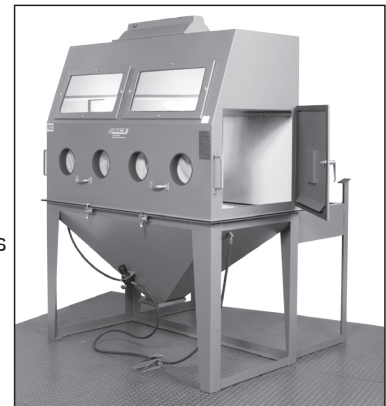
With 60" of working width and 48" of working depth, the 60 x 48 CB is a 12 CFM foot-operated blast cabinet that is as large as it is powerful. Comes with a 400 CFM dust collector (not shown) and tungsten carbide nozzle and air jet that provides you with a spacious solution that fits in most shop environments. Optional equipment includes carbon screen, turntable, 25 or 45 CFM gun, tumble basket, 600 CFM dust collector and reclaim system.



Model 8 Double Station

Overall Dimensions			Openings	Window
Height	Width	Depth	Top 30" x 60"	Height 12"
82"	62"	74"	Side 24" x 21"	Width 24"
Working			Approx. Weight	Mfg. Number
40"	60"	30"	540 lbs	102765X-A

Clam shell and side-access features make loading and unloading this roomy machine a snap. Lower hopper door allows for simple media changes and cloth lined gloves allows the operator to work in comfort and safety. Standard fluorescent lighting, 12 CFM foot pedal blast gun with tungsten carbide nozzle and air jet. Optional features include airline filter, carbon screen, double gun system, 25 or 45 CFM gun, boron carbide nozzle, tumble basket, turntable, 100, 150, 400 or 600 CFM dust collector, reclaim system and dust blow off gun.



Model 6

Overall Dimensions			Openings	Window
Height	Width	Depth	Top 48" x 48" Side 20" x 30"	Height 12" Width 24"
94"	52"	90"		
Working			Approx. Weight	Mfg. Number
40"	48"	48"	635 lbs	101699Y-A

With a clam shell design for ease in loading, this blast cabinet features a backrest welded to the unit for strength and stability. The window is also easily changed, and a hopper door makes media changes simple. 12 CFM foot pedal blast gun. Optional features include: dust blow off gun, tumble basket, turntable, 100, 150, 400, or 600 CFM dust collector.



Flip Top and Counterbalance Cabinets



Flip Top (left) cabinets from ACE feature springs to assist the operator in opening the lid of the blasting unit.

Counterbalance (right) cabinets have an enclosed spring mechanism, offering smooth movement and ease of use when opening or closing the cabinet lid.



Model 6 LA

Overall Dimensions			Openings	Window
Height	Width	Depth	Top 48" x 48" Side 20" x 30"	Height 12" Width 24"
94"	52"	90"		
Working			Approx. Weight	Mfg. Number
40"	48"	48"	720 lbs	101699X-A

This blasting cabinet opens wide to 48" x 48" and provides 40" of operating height for your most bulky projects. A 12 CFM foot-operated blast gun, and tungsten carbide nozzle and air jet are standard. Optional features include airline filter, carbon screen, rubber cotton-lined gloves, dust blow off gun, 25 or 45 CFM blast gun, boron carbide nozzle, tumble basket, turntable, 100, 150, 400 or 600 CFM dust collector and reclaim system.



Model 3

Overall			Openings	Window
Height	Width	Depth	Top 48" x 13" Side 17" x 11"	Height 12" Width 24"
63"	51"	25"		
Working			Approx. Weight	Mfg. Number
22"	48"	23"	340 lbs	101695X-A

Two side doors allow endless placement options in this foot-operated blasting unit. Featuring a 12 CFM foot pedal gun, fluorescent lighting and cloth lined work gloves; the Model 3 is a complete blasting solution with muscle. Options include airline filter, carbon screen, rubber cotton lined gloves, dust blow off gun, 25 CFM blast gun, boron carbide nozzle, tumble basket, dust collector, and turntable.

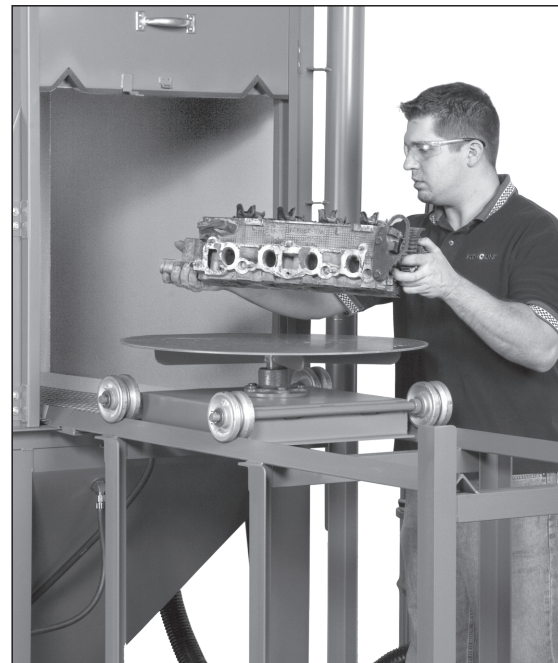


Blast Cabinets – Siphon

Model 14 VD

Overall			Opening	Window
Height	Width	Depth	Side 27" x 34"	Height 12" Width 24"
81"	51"	36"		
Working			Approx. Weight	Mfg. Number
40"	48"	36"	1100 lbs	101771S-RV

This versatile blasting cabinet features a large side opening that allows for options such as the turntable, track and vertical door shown. Standard features include fluorescent lighting, cloth lined work gloves and a 12 CFM foot-operated blast gun. Other optional features include an airline filter, carbon screen, dust blow off gun, 25 or 45 CFM gun, boron carbide nozzle, tumble basket, 100, 150, 400 or 600 CFM dust collector, and a reclaim system. Also available as Mfg. Number Model 14 in a horizontal door configuration. Turntable also optional in the horizontal door model.



The Model 14 VD shown with optional track.

Window Replacement

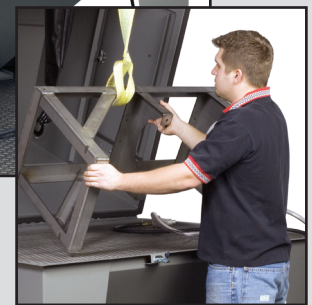


All of ACE's cabinets have an easily replaceable window. See the feature on page 6 for more information.

Model 4

Overall Dimensions			Openings	Window
Height	Width	Depth	Top 48" x 24" Side 17" x 11"	Height 12" Width 24"
65"	52"	54"		
Working			Approx. Weight	Mfg. Number
23"	48"	24"	350 lbs	101697X-A

With four feet of working width, this clam shell design has a backrest assembly standard, as well as fluorescent lighting, 12 CFM foot-operated blast gun, hopper door for easy media changes and more. Optional features include airline filter, carbon screen, dust blow off gun, boron carbide nozzle, dust collector, tumble basket and turntable.



Clam shell design permits the operator to easily load heavy objects.

Clam Shell Design

ACE offers a variety of methods of access to the blast chamber area of the cabinet.

Larger cabinets are constructed with both a side door and split-top access, also known as a clam shell. We use the term clam shell to describe the openings of these cabinets in that the entire upper section of the cabinet opens. It is hinged along the back and the top section pivots up and back allowing full access to the interior.

This large access area allows a user to load heavy items with a fork truck or crane and affords the user more blasting area because they are not limited in size by what they can get through a side door. This feature combined with our heavy duty materials make ACE units popular with customers who have large, heavy items to blast. All split-top cabinets have a spring assist mechanism and can easily be opened by a single operator.

Model 2

Overall Dimensions			Openings	Window
Height	Width	Depth	Top 42" x 24" Side 17" x 11"	Height 12" Width 24"
65"	46"	54"		
Working			Approx. Weight	Mfg. Number
23"	42"	24"	330 lbs	101696X-A

A clam shell design allows for easy loading and unloading. An excellent choice for a mid-sized flip top machine. The Model 2 blast cabinet also includes a backrest assembly, fluorescent lighting, 12 CFM foot pedal operated blast gun, and a hopper door that makes media changes simple.



Optional features include airline filter, carbon screen, dust blow off gun, dust collector, 25 CFM blast gun, boron carbide nozzle, tumble basket and turntable.

Blast Cabinets – Siphon



Window and Light Replacement

The window in the cabinet is a clear Plexiglas. ACE chooses to use Plexiglas as over time, the window will become etched by the abrasive blast process and the Plexiglas is less expensive to replace.

We also provide a thin film we call window underlayment

that protects the window from blast damage. This film is inexpensive and easy to replace. The user simply removes the wing nuts that secure the window frame to the cabinet, and then removes the frame and the window. The



used underlayment is discarded and replaced with a new piece. The user then replaces the window and frame. The entire process takes approximately two minutes.

For more information about ACE replacement windows and lamp shields, please see page 33.

Model 5

Overall Dimensions			Openings	Window
Height	Width	Depth	Top 40" x 40"	Height 12"
82"	44"	74"	Side 20" x 30"	Width 24"
Working			Approx. Weight	Mfg. Number
30"	40"	40"	500 lbs	101698Y-A

This blasting cabinet offers a flip top, clam shell design with a full 40" of work area at a height of 30". Features a steel screen work surface, fluorescent lighting and a 12 CFM foot pedal blast gun. The operator can access projects using large side door if desired.



Model 5 LA

Overall			Openings	Window
Height	Width	Depth	Top 40" x 40"	Height 12"
82"	43"	72"	Side 20" x 30"	Width 24"
Working			Approx. Weight	Mfg. Number
30"	40"	40"	550 lbs	101698X-A

This blasting cabinet offers a counterbalanced clam shell cabinet style similar to the Model 5, with a full 40" of work area at a height of 30". This unit comes complete with fluorescent lighting, steel screen work surface and cloth lined work gloves.

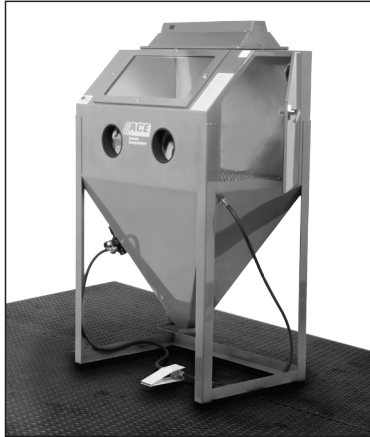
A hopper door allows for easy media changes and a foot-operated blast gun allows an operator optimal control of the 12 CFM blast gun. Options include 100, 150, 400 or 600 CFM dust collector, or the addition of a tumble basket or turntable.



Model 1

Overall			Openings	Window
Height	Width	Depth	Side 17" x 20"	Height 12" Width 24"
65"	39"	25"		
Working			Approx. Weight	Mfg. Number
23"	36"	24"	250 lbs	101694X-A

The Model 1 blasting cabinet features a foot-operated 12 CFM blast gun and tungsten carbide nozzle. Includes a tungsten carbide air jet, fluorescent light, steel screen work table, and lower hopper door for quick media changes. Other optional features include an airline filter, carbon screen, dust blow off gun, 25 CFM blast gun upgrade, and 100 CFM dust collector.



Model 1 B

Overall			Openings	Window
Height	Width	Depth	Side 17" x 20"	Height 12" Width 24"
65"	39"	25"		
Working			Approx. Weight	Mfg. Number
23"	36"	24"	250 lbs	101694Y-A

The Model 1 B features a standard valve-operated 12 CFM blast gun with tungsten carbide nozzle and air jet, and lower hopper door for quick media changes. Includes steel screen work table, side door access and an overhead skylight. This cabinet will accommodate all the optional features of the Model 1 plus a foot-operated blast gun, regulator & gauge, and 100 CFM dust collector.



Model 1 BP

Overall			Opening	Window
Height	Width	Depth	Top 36" x 13"	Height 12" Width 24"
65"	39"	25"		
Working			Approx. Weight	Mfg. Number
23"	36"	24"	250 lbs	101694L-A

With a tungsten carbide nozzle and air jet and a valve-operated 12 CFM blast gun standard, the Model 1 BP is a powerful midsize blast cabinet. Fluorescent lighting improves visibility through the easy-to-change window. Optional features include an airline filter, carbon screen, dust blow off gun, 25 CFM blast gun, and 100 CFM dust collector.



Model 1 DC

Overall			Opening	Window
Height	Width	Depth	Top 24" x 13" Side 17" x 11"	Height 12" Width 24"
65"	51"	25"		
Working			Approx. Weight	Mfg. Number
23"	36"	24"	325 lbs	101694R-DC

With welded and cross-braced legs and a 100 CFM cartridge dust collector attached, the Model 1 DC is a complete blast cabinet solution. Other standard features include a 12 CFM foot-operated blast gun, tungsten carbide nozzle and air jet, and hopper door for easy media changes. For more versatility, add a tumble basket, turntable or upgrade to a 25 CFM blast gun.



Blast Cabinets – Siphon

Model 10

Overall			Opening	Window
Height	Width	Depth	Top 24" x 13"	Height 11 1/2" Width 12"
47"	25"	21"		
Working			Approx. Weight	Mfg. Number
20"	23"	19"	150 lbs	101692Z-A

The Model 10 from ACE has a trigger operated 12 CFM blast gun, fluorescent lighting and an expanded metal work surface. Adjustable legs are standard. A ceramic nozzle is also standard. A larger version of the Mini Bench, the Budget offers an optional free standing, adjustable leg kit. Other optional features include a media tray kit, 12 or 25 CFM foot pedal gun kit, and shop vacuum.



Standard adjustable legs on the Model 10.



Model 9

Overall			Opening	Window
Height	Width	Depth	Top 18" x 12"	Height 6" Width 12"
33"	19"	17"		
Working			Approx. Weight	Mfg. Number
16"	18"	16"	95 lbs	101691X-A

The ACE Model 9 is a compact blast cabinet with all the bells and whistles of a big unit on a smaller scale. This bench model comes with a standard shop vacuum dust collector, work gloves, easy to change window, door safety switch, foot-operated blast gun with 12 CFM and a tungsten carbide nozzle and air jet. Optional features include an airline filter, carbon screen, dust blow off gun, 6 CFM blast gun, boron carbide nozzle and tumble basket.



Model 9 foot pedal.

Spot Blast

Height	Width	Depth	Approx. Weight	Mfg. Number
44"	20"	18"	80 lbs	101765SA

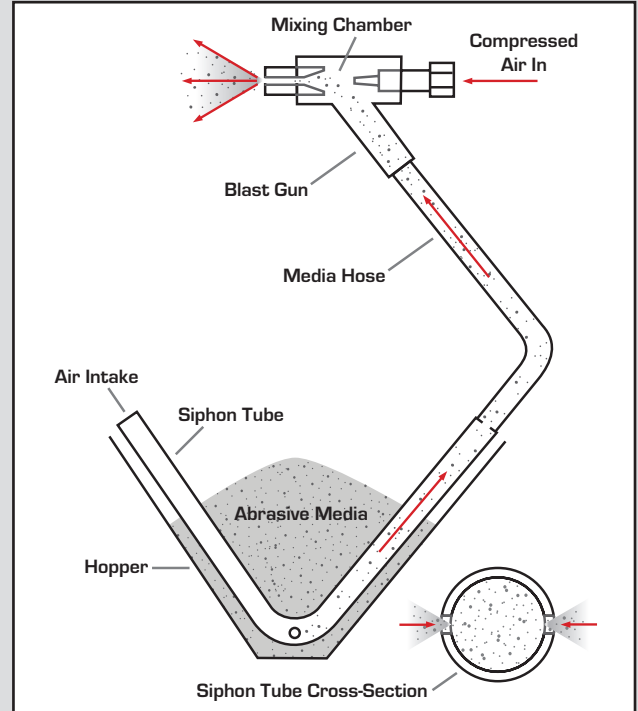


The ACE Spot Blast unit is a portable, dust free solution to your blasting needs. Low abrasive consumption recycles abrasive media separate from dust and debris. Includes a standard 12 CFM trigger gun, regulator and gauge, water filter, recycling head and a .5 micron cartridge filter. This unit weighs just 55 lbs when empty, and with a 1" blast pattern, it's perfect for small jobs and touch ups.



Spot Blast with lid open.

Other Portable Units are available on page 13, and Replacement Filter information is available on page 32.



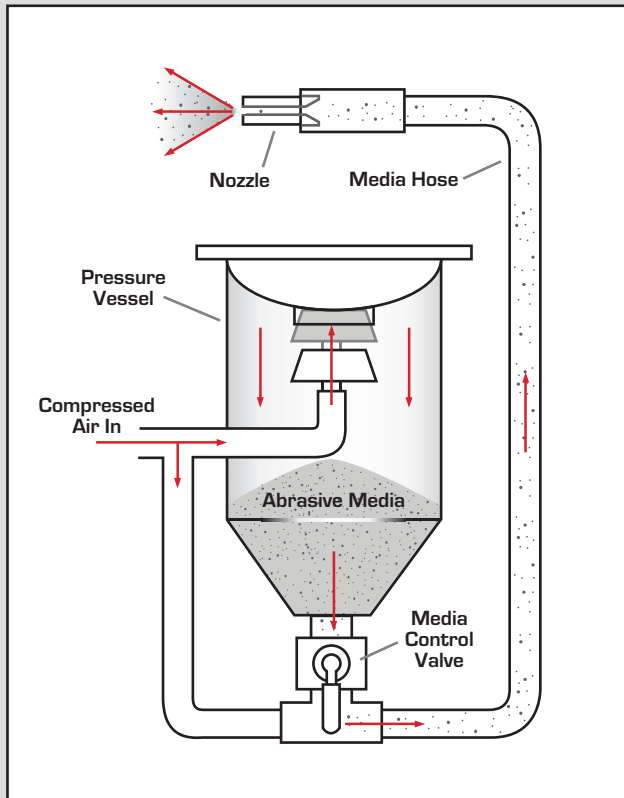
Inside a Siphon System

ACE siphon cabinets are economically priced, have a minimum number of moving parts and require less maintenance than a direct pressure system. Siphon cabinets, also known as suction cabinets, permit continuous blasting without pausing to refill abrasive media. Production rates are not as high as with a direct pressure system, but resulting finishes are comparable in quality. ACE siphon cabinets meet the challenge where initial costs and maintenance are concerns.

A siphon system works as follows: Abrasive is held in the storage hopper of the blast machine and delivered to the suction gun through a media hose. Compressed air is brought into the suction gun from the regulator through an air hose. As dry and regulated compressed air flows through the air jet, it passes through a mixing chamber before it enters the blast nozzle. Negative pressure, or suction, is created in the mixing chamber of the gun body and media is drawn into the blast nozzle, much as water is sucked through a straw. Incoming compressed air accelerates the media to a velocity of approximately 60 to 100 CFM, depending upon the air pressure selected. The CFM of compressed air required to operate a suction gun is determined by the orifice in the air jet, combined with the orifice in the blast nozzle.

Our siphon machines are available in a variety of sizes and styles with factory options available that contribute to greater productivity and ease of operation. ACE advises the use of a reclaim system when recoverable media is used. This option will typically pay for itself quickly in terms of media saved. Please see page 14 for more information about ACE reclaim models.

Blast Cabinets – Direct Pressure



How Direct Pressure Works

Pressure Systems utilize a pressure pot that when pressurized with media in the pot, accelerates the media from the pot through the blast hose to the nozzle. A direct pressure unit has the same amount of pressure in the pressure pot vessel and passing through the air line that connects to the outlet of the abrasive metering valve.

Sometimes direct pressure systems are referred to as gravity fed or equal pressure units. While the abrasive 'free flows' into the air stream, the operator can better control, or direct, the blasting process at both low and high end pressures.

In most applications, work can be done four times faster than with a siphon cabinet as the abrasive is delivered at a much higher velocity. Media Control valve shown in full open position in the illustration above. Under normal operating conditions, the valve handle would be in the 7 o'clock position.

WD 48 x 24 FT

Overall			Openings	Window
Height	Width	Depth	Top 48" x 24"	Height 12"
71"	51"	54"	Side 17" x 11"	Width 24"
Working			Approx. Weight	Mfg. Number
23"	48"	24"	600 lbs	101697WD-A

The WD 48 x 24 FT offers 6" more working width than the 42 x 24 model. Regulator and gauge, fluorescent lighting, steel screen work surface, 400 CFM dust collector, 1/8" I.D. tungsten carbide nozzle, carbon screen and cloth-lined work gloves are standard. Optional features include an airline filter, dust blow off gun, tumble basket and turntable.



WD 42 x 24 FT

Overall			Openings	Window
Height	Width	Depth	Top 42" x 24"	Height 12"
71"	45"	54"	Side 17" x 11"	Width 24"
Working			Approx. Weight	Mfg. Number
23"	42"	24"	580 lbs	101696WD-A

The WD 42 x 24 FT direct pressure blast cabinet delivers abrasive at higher velocity than does a siphon system to maximize your production rates. Clam shell opening allows easy access to projects and includes a standard 400 CFM dust collector. The foot pedal operated 1/8" I.D. tungsten carbide nozzle permits easy operation and control. Other optional equipment includes a dust blow off gun, tumble basket, turntable and more.





WD 40 x 38

Overall			Opening	Window
Height	Width	Depth	Side 33" x 26"	Height 24"
96"	42"	39"		Width 24"
Working			Approx. Weight	Mfg. Number
35"	40"	38"	795 lbs	102760R-A

ACE's WD 40 x 38 blast cabinet features a raised steel work platform for the operator and a large window for easy project viewing. Oval armports hold standard rubber cotton-lined work gloves. Other standard features include regulator and gauge, fluorescent lighting, a 14 and 11 gauge welded steel cabinet, tungsten carbide nozzle, moisture filter, media regulator, 1/2" internal diameter abrasive hose, foot pedal operation, 400 CFM dust collector and 10-120 PSI ASME code pressure pot with a media capacity of 1 cubic foot.



26" side opening allows for easy project loading.

Model 1 DP

Overall			Openings	Window
Height	Width	Depth	Top 36" x 13"	Height 12"
65"	60"	25"	Side 17" x 11"	Width 24"
Working			Approx. Weight	Mfg. Number
23"	36"	24"	320 lbs	101694Z-A

A state-of-the-art pressure pot dry blast system designed for the high volume shop seeking excellent control for blasting applications. Featuring a side mounted pressure pot for easy operation, holds up to 110 pounds of blasting media for long, uninterrupted blasting. Wide front and side doors allow for quick and easy placement and removal of objects. A convenient pressure control gauge and foot-operated 1/8" tungsten carbide blast nozzle reduce fatigue for the operator ready to get the job done. Optional 100 CFM dust collector.



WD 36 x 30

Overall			Openings	Window
Height	Width	Depth	Side 22" x 21"	Height 12"
70"	38"	31"		Width 24"
Working			Approx. Weight	Mfg. Number
24"	36"	30"	480 lbs	103098R-4

The WD 36 x 30 blast cabinet from ACE has a standard 400 CFM dust collector and ASME code pressure vessel. Other standard features include oval armports, foot pedal operation and a tungsten carbide nozzle.



Blast Cabinets – Direct Pressure

MP 36 Slot Blaster

Overall			Openings	Window
Height	Width	Depth	Top 34" x 17½"	Height 14"
76"	84"	32"	Side 35" x 3"	Width 26"
Working			Approx. Weight	Mfg. Number
36"	36"	30"	480 lbs	101760D-A

The ACE MP 36 Slot Blaster features vertical and horizontal slots and load bearing arms on both sides for easy loading of tall and wide projects ready to be blasted. Adjustable rollers aid blasting and dual floodlight lighting provides excellent visibility. With foot pedal operation and cloth-lined work gloves, this machine is built for comfort and safety. A regulator and gauge, steel screen work surface and 1/8" I.D. tungsten carbide nozzle are also standard. The 100 CFM dust collector is standard, but 150, 400 and 600 CFM dust collectors are available as options.



Inside the MP 36 Slot Blaster



100 CFM Dust Collector



Dust collector and replacement bag

ACE's 100 CFM Dust Collector is optional on most blast cabinet models. It was created especially for the removal of dust and dirt particles created while blasting within a cabinet. While the blast cabinet is in operation, the collector draws dust and dirty air from the cabinet into the canister where the heavier particles are deposited into the bottom of the barrel housing. The air is then drawn through the filter which removes the finer dust particles. This bag style dust collector requires only minor maintenance.

For more information on ACE's full range of dust collectors and replacement bags, please see catalog pages 14 and 32.

ACE-90 DM

Height	Diameter	Approx. Weight	Mfg. Number
60"	10"	75 lbs	102461D-A

The portability and 90 lb abrasive capacity of the ACE-90 DM from ACE makes this model ideal for quick touchups. Dead man handle design means the blast shuts off when the handle is released. A pull up closure plug adds to this model's convenience and its low-cost operation. Five ceramic nozzles, 10 ft. of heavy duty 1/2" I.D. abrasive resistant hose are standard. The pressure relief valve meets OSHA requirements and the tall vertical tank design makes this modular unit a handy addition to your facility. Also comes with a light duty protective hood and bump cap.



ACE-90 R

Height	Diameter	Approx. Weight	Mfg. Number
60"	10"	80 lbs	102461R-A

All the portability and convenience of the ACE-90 DM, with remote blast control, water filter and gauge, for the ultimate in operator safety. Remote blast control offers full control at nozzle handle. System shuts off at the tank. 90 lb abrasive capacity allows for 30 to 50 minutes of blast time, and the pressure relief valve and pressure relieving ball valve both meet OSHA requirements. Comes standard with a light duty protective hood and bump cap.



Abrasive Blast Engraving

Abrasive blast engraving is a process where a hard object such as glass, ceramic, or marble is engraved by abrasive media. This process is also commonly referred to as etching.

The actual etching process is controlled by attaching an abrasive blast resistant mask on the item to be blasted. The detail of this mask creates the highly detailed etched areas in the object. The durability of the mask allows the user to etch very deep in the piece, which also increases its value.

Abrasive blasting is a unique process that allows both small and large businesses to create beautiful work completely within their own facility, without the need to send artwork out to a supplier. We believe product improvements, and more variety of etched products have increased the awareness and appreciation of this attractive, artistic look to consumers.

Dust Collectors



Choosing the Right Dust Collector

ACE's dust collector system is designed for the removal of dust and dirt particles created while blasting within a cabinet. In operation, the collector draws dust and dirty air from the cabinet into the canister, where the heavier particles are deposited into the bottom of the housing. The air is drawn through the filter, which removes the finer dust particles. Filtered air is returned to the room. The dust collector you choose should match the work that you're doing at your facility.

Keep in mind that blast cleaning is by its very nature a dusty process, and the primary function of the dust collector is to maintain visibility while blasting by exchanging the air in the cabinet. To maintain this level of visibility, a dust collector should provide 6 to 8 air changes per minute. ACE's bag style dust collector filters at 50 microns, and cartridge style dust collector filters are 99.98% efficient, filtering .5-micron particles.

Primary considerations in choosing the right dust collector include noise, usage – at a time and over time, cost, maintenance, filtration, and operating area (how large, how clean, how humid and what sort of ventilation is available).

For high volume production work, we recommend the use of a reclaim system. The ACE abrasive reclaim system provides the removal of dust and dirt like a dust collector while also centrifugally separating broken down blast media, dust and foreign material from usable blast media, utilizing a direct drive pressure blower. This allows for less media waste and for prolonged media life. Reclaim systems require the addition of a pickup tube to the cabinet hopper.

Information on replacement filters is available on page 32.

400-PT Reclaim D/C

Height	Width	Depth	Approx. Weight	Mfg. Number
72"	50"	24"	345 lbs	101767PT-RD4
Vac. Hose Diameter		Vac. Hose Length	CFM	HP
4"		6' and 10'	400	1/2

The 400-PT Reclaim Dust Collector provides 400 CFM and is both an abrasive reclaimer and dust collector, separating usable media from dust and other foreign materials. The front access door is 12" wide by 21 3/4" tall, and the hopper trap door allows for easy dust removal. An easily replaced cartridge filter comes with model shown as well as an air actuated vibrator for filter cleaning and a 9" direct drive pressure blower. A 600 CFM model is also available.



400 EB Reclaim D/C

Height	Width	Depth	Approx. Weight	Mfg. Number
66"	40"	24"	175 lbs	101768EB-RD4
Vac. Hose Diameter		Vac. Hose Length	CFM	HP
4"		10'	400	1/2

The 400 EB Reclaim Dust Collector is a 400 CFM external bag media reclaimer with a large external dust bag and 1/2 hp motor standard. The removable filtering system is easy to change and makes maintenance of this model easy. The 600 CFM model (Mfg. Number 101768EB-RD6) has standard 1 hp motor for even more power in your workshop. Please see the ACE Master Product Chart on the inside cover.



400 D/C

Height	Width	Depth	Approx. Weight	Mfg. Number
72"	26"	20"	180 lbs	101716RD-4C
Vac. Hose Diameter		Vac. Hose Length	CFM	HP
4"		10'	400	1/2

ACE's 400 CFM Dust Collector features an easy to replace cartridge style filter. This design permits maximum air flow while reducing the likelihood of filter clogging. It also has a 12" x 21 3/4" access door and hopper trap door for easy dust removal. A 600 CFM model is also available, and both the 400 and 600 CFM models are available in a bag style dust collector with manual shaker. See the ACE Master Product Chart on the inside cover for more details.



150 CFM D/C Whisper Vac

Height	Width	Depth	Approx. Weight	Mfg. Number
65"	15" Diameter		65 lbs	202672-R
Vac. Hose Diameter		Vac. Hose Length	CFM	HP
2 1/2"		5'	150	1/2

The 150 CFM D/C Whisper Vac earns its name! At less than 85db at 12 inches, this model is the choice for the shop where noise reduction is an important feature. The Whisper Vac also offers higher efficiency than 100 CFM models and is a smart upgrade for businesses looking for a longer term dust collector investment. The 50 micron polyfelt bag filter is easily laundered and replaced.



100 CFM D/C Bag Style

Height	Width	Depth	Approx. Weight	Mfg. Number
59"	15" Diameter		40 lbs	201768R-B5
Vac. Hose Diameter		Vac. Hose Length	CFM	
2 1/2"		5'	100	

The 100 CFM Bag Style dust collector is an efficient and safe solution to your dust collection needs. It returns filtered air to the room, and features a self-cleaning feature in the bag. The 50 micron polyfelt bag filter can be laundered. Fabricated of 24 gauge steel, this unit requires limited maintenance.

The 201768R-B10 model (not shown) comes with 10' vacuum hose standard.



100 CFM D/C Cartridge

Height	Width	Depth	Approx. Weight	Mfg. Number
28"	18" Diameter		35 lbs	201768RD-C5
Vac. Hose Diameter		Vac. Hose Length	CFM	
2 1/2"		5'	100	

The 100 CFM Cartridge Dust Collector is the workhorse of the family. This lower profile, low maintenance, high efficiency machine has a .5 micron cartridge filter and is 99.9% efficient. Model 201768RD-C10 (not shown) comes with a standard 10" hose.



Model 2-S Soda Cabinet with Dust Collector

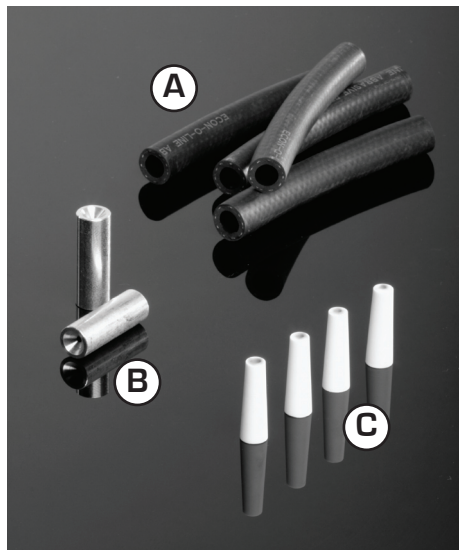
Cabinet			Dust Collector			Openings	Window
Height	Width	Depth	Height	Width	Depth	Top 23" x 42"	Height 11 7/8"
65"	55"	42"	67"	42.5"	29"	Side 17" x 11"	Width 23 7/8"
Working			Approx. Weight			Mfg. Number	
23"	42"	24"	625 lbs			101696S-A	



The Model 2-S with dust collector is a fully contained system designed for indoor use in settings such as shops, factories, and garages. The Model 2-S protects the operator from dust and other contaminants, while providing efficient cleaning and unmatched cabinet visibility. This system includes a large 42" W x 24" D x 23" H working area with hinged top and side door for easy loading and removal of items. In addition to the 300 CFM dust collector, the system also includes ASME rated pressure vessel, adjustable pressure regulator, cotton lined gloves, air safety interlock, foot pedal operation, ceramic nozzle, air blow off gun, and fluorescent lighting.

Visibility is a key component of any soda blasting cabinet system. The Model 2-S utilizes a unique dual venturi design to quickly remove the fine powder generated as the soda blast media shatters upon impact

with the item being cleaned. The 300 CFM dust collector expels this dust from two points. Larger particles fall through the grated work surface, and are removed from the bottom of the cabinet. The floating particles are vacuumed out through a second venturi located on the back of the cabinet lid at eye level, keeping the working area as clear as possible. The majority of spent media and soils are captured in the dust collector's primary filters. Any extremely fine particles are captured in the three secondary cartridge filters, keeping your work environment clean and dust free. The waste is retained in the dust collector hopper for easy removal.



2-S Nozzle Kit

Mfg. Number	Used On / With		
201245-A	Model 2-S Soda Cabinet with Dust Collector		
	Component	Description	Qty.
A	313526-A	Control Box Tubes	4
B	410108	Restrictor 7/64"	1
	410112	Restrictor 3/32"	1
C	410213	Ceramic Nozzle 3/32" ID Short	1
	410214	Ceramic Nozzle 7/64" ID Short	1
	410215	Ceramic Nozzle 1/8" ID Short	1
	410216	Ceramic Nozzle 5/32" ID Short	1

Model 2-PS

Height	Width	Depth	Approx. Weight	Mfg. Number
48"	21"	25"	145 lbs	101826-A

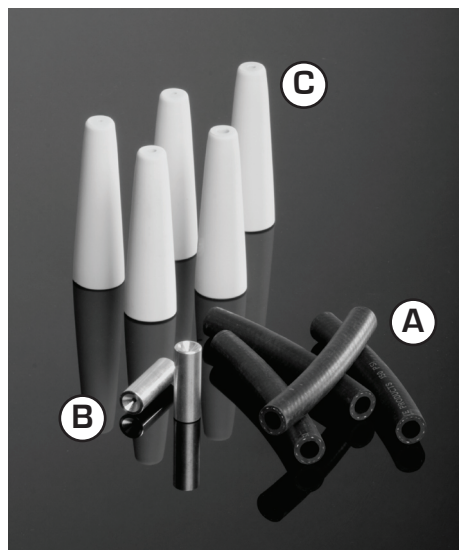
The ACE Model 2-PS Heavy Duty Portable Soda Blaster is the perfect tool for jobs such as stripping paint from cars, trucks, boats, farm and industrial equipment; mold and fire/smoke damage remediation; graffiti removal; cleaning food processing and preparation equipment; stone, statuary and swimming pool cleanup; cleaning anilox printing press rolls and much more.

The Model 2-PS features a 100 lb capacity ASME rated pressure vessel, 25ft blast hose, adjustable pressure regulator with moisture trap and remote dead man blast control at handle. The rugged steel frame with wheels provides maximum mobility and water rinse off capability makes for easy cleanup. For operator safety, the Model 2-PS comes with a blast hood and bump cap. Optional features include various nozzles and media control restrictors for operational flexibility, and blast hoses in lengths up to 75 ft.

By using the adjustable pressure regulator on the Model 2-PS, users can confidently blast hard substrates like metal, stone and concrete, or soft surfaces like wood and fiberglass.

For example, set the pressure regulator at 90 psi for stripping paint from metal car bodies. For wood or fiberglass surfaces, start at a low pressure like 40 psi and slowly increase the blasting pressure until you find the "sweet spot", where you are cleaning or stripping the surface without harming the substrate.

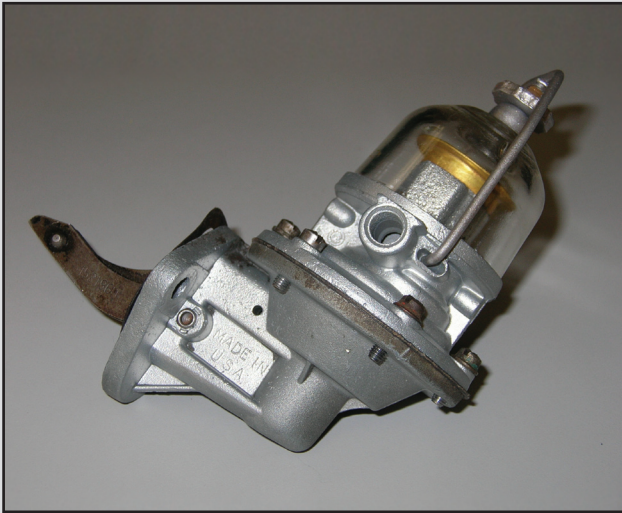
Use and maintenance are simple with the help of a fully illustrated User's Manual. In terms of performance, ease of use, price, and customer support, the ACE Model 2-PS is the best value on the market.



2-PS Nozzle Kit

Mfg. Number	Used On / With		
201244-B	Model 2-PS		
	Component	Description	Qty.
A	313526-A	Control Box Tubes	4
B	410108	Restrictor 7/64"	1
	410112	Restrictor 3/32"	1
C	448849	Ceramic Nozzle 3/32" ID	1
	448857	Ceramic Nozzle 1/8" ID	1
	448851	Ceramic Nozzle 5/32" ID	1
	448848	Ceramic Nozzle 3/16" ID	1
	448847	Ceramic Nozzle 1/4" ID	1

Soda Blasting



What is Soda Blasting?

Soda Blasting uses a form of environmentally friendly sodium bicarbonate to remove most types of coatings and soils including paint, carbon, mold, oil, dirt and more, from almost any surface. The soda blast media is a large, jagged, irregular shaped crystal of sodium bicarbonate. It is this crystal size and shape which is responsible for soda blasting's unique cleaning properties. When delivered under pressure, through a soda blaster, the crystal shatters upon impact with the item being cleaned. The shattered crystals become a fine powder once used. As a result, soda blast media is a one-time use media. It cannot be reclaimed and reused. It is very important that soda blast media be used through a soda blaster designed to maximize the cost efficient use of the media. Sand blasters and multi-media blasters are NOT designed to do this. The soda residue is water soluble.

Soda blast media is a relatively soft crystal, and when used properly, it is very gentle to the underlying substrate material being cleaned. It is non-sparking, and the process produces very little heat. As a result, soda blasting will not warp thin metal panels, and will not change dimensional or surface characteristics of metal parts, since it does not remove any of the underlying material. Soda blasting leaves a fresh looking surface on metals, and does not harm chrome, glass, bearings or rubber seals. ACE's adjustable pressure regulators allow soft materials like wood and fiberglass to be soda blasted.

Some uses by ACE customers include auto, truck, boat, motorcycle and various equipment restoration; mold and fire damage remediation; engine and transmission rebuilding; graffiti removal; furniture restoration; pool, statue and concrete cleanup and much, much more!

Performance Plus

Height	Width	Depth	Approx. Weight	Mfg. Number
29"	8"	12"	19 lbs	

This portable unit is perfect for cleaning small parts and pieces, or DIY jobs like stripping a chair. The Performance Plus has a 10 lb. capacity tank, 5 ft. blast hose, adjustable pressure regulator with moisture trap, media flow control valve, pressure relief valve, and quick disconnect fitting for your air supply. With it's light weight, blasting time



of up to 30 minutes per tankful, and carry handle, the Performance Plus is fully portable. Just load it, attach it to your air supply and it's ready to use. Though economically priced, the Performance Plus has the same high-quality construction and reliability that our customers have come to value and trust.

Performance Plus Nozzle Kit

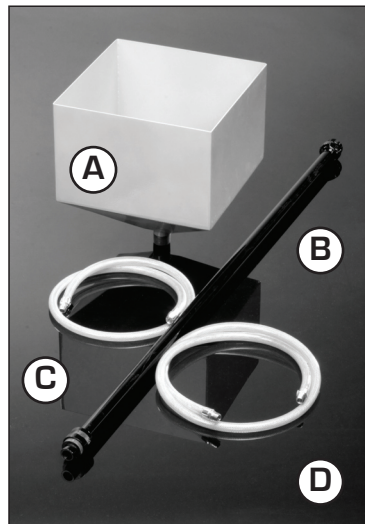
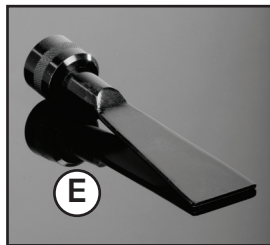
Mfg. Number	Used On / With	
201247-A	Performance Plus	
Component	Description	Qty.
410213	Ceramic Nozzle 3/32" ID Short	2
410214	Ceramic Nozzle 7/64" ID Short	1
410215	Ceramic Nozzle 1/8" ID Short	2
410216	Ceramic Nozzle 5/32" ID Short	1



Media Delivery Accessories

	Mfg. Number	Description	Used On / With
A	101837-A	Funnel	2-PS & 2-S
B	101836-A	4' Extension Wand	2-PS
C	201250-A	5' Replacement Hose	Performance Plus
D	201260-A	4' Replacement Hose	2-S Cabinet
E	101828-A	Fan Nozzle 30 CFM	2-PS

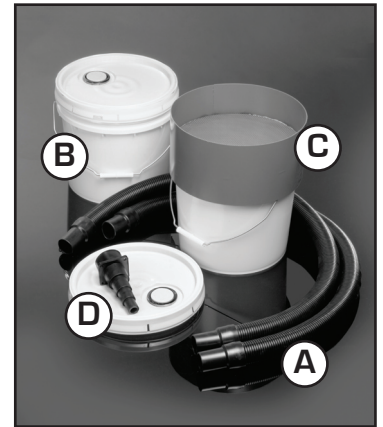
Replacement hoses, media funnel, fan nozzle and extension wand to filling for optimal media delivery.



Fill Kit

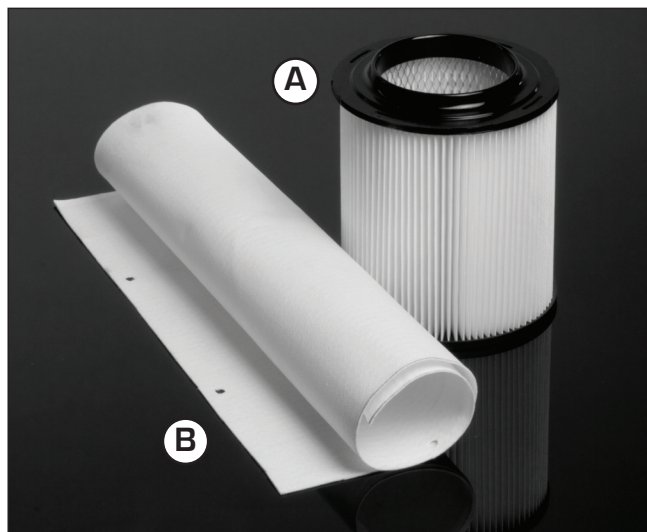
Mfg. Number	Used On / With	
101834-A	Model 2-PS and 2-S Cabinet	
Component	Description	Qty.
A	4' Hose w/ends	2
B	Buckets w/lids	2
C	Media Screen Weldment	1
D	Adapter Hose	1

The Fill Kit makes filling your 2-PS a breeze. Includes 2 - 4 ft. hoses with ends, 2 - buckets with lids, a media screen weldment and adapter hose.



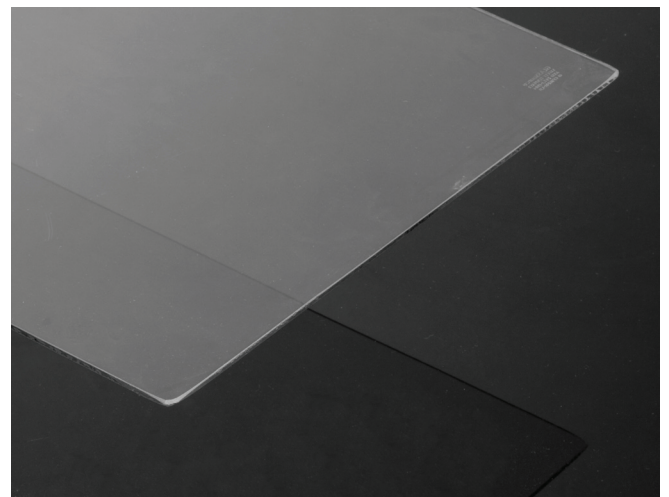
Filters

	Mfg. Number	Description	Used On / With
A	414508	Hepa Filter Cartridge	300 Soda DC
B	302038-A	Filter Fabric	300 Soda DC



Replacement Window Glass

Height	Width	Used On / With	Mfg. Number
11 7/8"	23 7/8"	2-S Cabinet	410476



The ACE Difference

ACE Automotive Cleaning Equipment For Those Who Demand Performance

More than 30 years of designing and building blast equipment and listening to customer feedback has taught us what works, what doesn't and what the end user is looking for in their equipment choices.

No one makes equipment that is more industrial strength than ACE. We feel that quality materials, tested designs and superior construction are important and we combine all of these features into every model at a reasonable price.

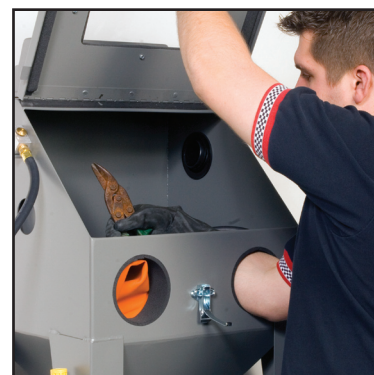
An important design feature on all ACE blast cabinets is the angle of the abrasive feed hopper. Our cabinets maintain a minimum 45 degree hopper angle to ensure that abrasives will flow to the bottom of the hopper and into the delivery system. The angle of this hopper affects how well the delivery system functions. If this angle is not steep enough, the abrasive will "hang-up" on the sides of the hopper resulting in an inconsistent blasting flow.

Attached to the bottom of the hopper is a hinged, spring-loaded trap door. This allows users to easily change abrasives to match job requirements. Other manufacturers may use one or the other of these attachment methods but this can cause the door to "flop around" making it more difficult to easily and efficiently change out the media.

Access doors and openings on our cabinets are completely gasketed minimizing abrasive dust leaks. The doors and lights are formed with edges, which not only strengthen the piece but trap the gasket, again reducing the chance of dust leakage. Dust collection air intake ports are always protected. Formed metal pockets welded over these openings eliminate abrasives from being accidentally propelled out of one of these ports.

ACE offers several methods of access to the blast chamber area of the cabinet. On all but the smallest cabinets we offer both a side door or doors and a full-width front flipper door. This full-width front flipper door has several important advantages: The room required for the cabinet in a shop is reduced by eliminating the necessary clearance for loading parts through a side door. Another advantage is that the weight of the part is carried and lifted in front and close to the person loading the machine. Loading large parts through a side door is often awkward and the weight gets harder to handle as it gets farther away from the body. In our design, the door opens upward, allowing blasting dust to fall down and back into the cabinet when the door is opened. A side door is located on the right side of the cabinet and allows the operator to load small items.

ACE is dedicated to the continuous improvement of its product line, and we are always making changes. Due to these adjustments, occasionally you may find that measurements and weights listed in this catalog are not exact. Please contact us directly if you have a specific size requirement that you are trying to meet. Thank you for choosing ACE Automotive Cleaning Equipment.



Shipping Information

UPS:

Most service parts orders are shipped prepaid & add UPS, Continental U.S., regular ground service. For RUSH orders, please request Next Day or 2nd Day UPS, (Credit card only) or for UPS charges to AK, HI, Int'l or to ship media, dust collectors, parts cleaners or cleaner solvent, call Toll-Free 888-772-3263 for cost.

Motor Freight:

Blasting equipment will be shipped via motor freight, prepaid, & add F.O.B. Grand Haven, MI. Unless otherwise requested, ACE will select the carrier. NOTE: Freight quotes are based on shipping "Direct Points Only" - No Interlines, (meaning only one (1) carrier). If necessary to Interline, (use more than one (1) carrier), we will call you prior to shipping, to advise of any additional cost. It may be more cost efficient for you to pick up your shipment at the freight terminal to avoid this extra cost, speed up your delivery and minimize the chance of damage.

Delivery Time:

Allow 7 to 14 days delivery time from the date shipped. Actual time will depend on distance to your location.

Delivery Location / Notification:

Most common carriers are not able to deliver to a residential area, as the streets won't accommodate semitrailers. The freight carrier may contact you to pick up your merchandise at their terminal. Delivery to a business with regularly scheduled hours and a loading dock is preferred. If it is necessary that you be phoned prior to delivery, please advise and we will note this on the bill of lading. However, the freight carrier may charge an additional fee for this service.

Delivery Acceptance:

It is not the responsibility of the freight carrier to unload the freight. They will only move the freight to the end of their truck (tailgate). It is the customer's responsibility to take the freight off the truck. The truck driver is not obligated to assist you, so please have adequate equipment available to help unload your shipment. The truck driver will not wait for help or equipment to arrive.

Freight Damage:

Our blast cabinets are well built and packaged securely so freight damage is rare. However, **if a carton appears damaged in any way, you must note this when signing the freight bill.** Damage claims are the responsibility of the customer & must be handled directly between you and the carrier. If requested, we will assist you with resolving any problems you may encounter in connection with a freight claim.

Returns Information:

Returned merchandise **will not** be accepted without prior approval from ACE. Please call for an RGA# (Return Goods Authorization). All returns for warranty or defect claims should include a complete description of the problem, and proof of purchase including purchase date. Returned items may be subject to a 20% restocking fee. Only returned items covered under warranty may be returned collect, all other returned goods must be sent freight prepaid.



The Manufacturing Process

Most ACE blast cabinets are constructed with 14 gauge steel bodies and 11 gauge steel legs. Metal this thick not only lasts longer in a harsh abrasive atmosphere but can also support substantially more weight than cabinets constructed of a lighter gauge metal. Also, the heavier gauge metal will resist dents when loading and moving parts around inside the cabinets.

All ACE cabinet joints are completely butt welded. This adds strength and greatly reduces the chance of air or abrasive leaks. The leg assemblies on our cabinets are welded and connected to one another, strengthening both the weight capacity and the ability to be moved about without incurring injury to the user or damage to the cabinet. Cabinets constructed of a lighter gauge metal and without connecting legs can collapse during normal industrial use.

Our arm ports are manufactured from 2" wide, 14 gauge steel and covered with a foam cushion giving the operator a comfortable place to rest his or her arms when using the machine. Ports that are narrow or merely covered with plastic are very uncomfortable to the user. The width of our inside port also allows for ease in attachment and replacement of gloves.

Blast Gun Assemblies



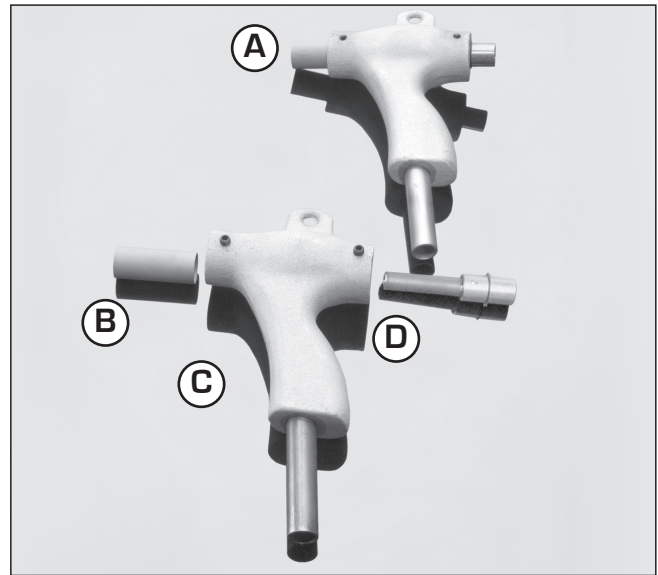
Blast Gun Assembly Construction & Replacement Parts

All ACE 12 and 25 CFM Blast Gun Assemblies are cast of aluminum. This lighter, less fatiguing gun also features a cast-in ribbed pick-up tube. You will find the machining on our gun bodies superior to that of many of our competitors, thus not only extending the life of the gun body, but also enhancing the performance of the assembly itself.

We carry a full line of replacement parts making it easy for you to keep your Blast Guns in perfect working order.

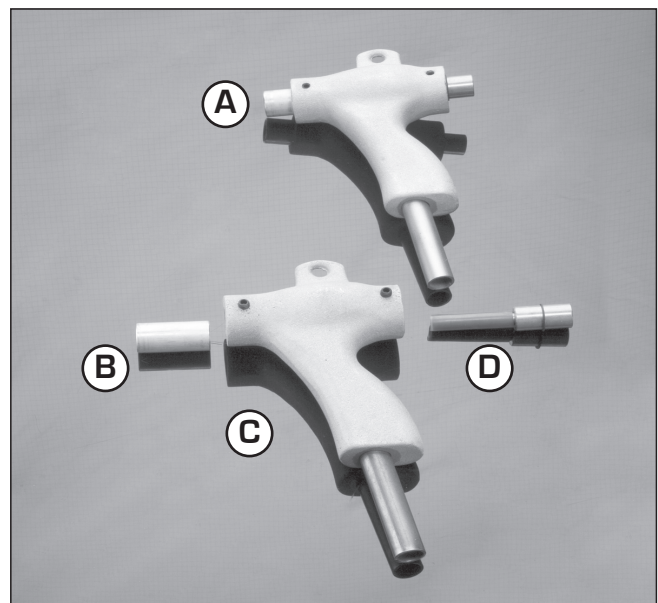
45 CFM Pistol Grip

	Mfg. Number	Description
A	201542	45 CFM Pistol Grip Complete
B	410209	45 CFM Carbide Nozzle 7/16" I.D.
C	201775	25/45 CFM Gun Body Only
D	201541	45 CFM Air Jet Assembly



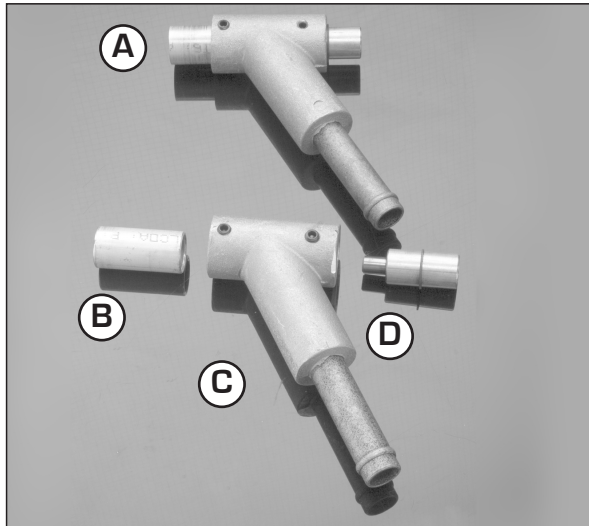
25 CFM Pistol Grip

	Mfg. Number	Description
A	201540	25 CFM Pistol Grip Complete
B	201382	25 CFM Carbide Nozzle 5/16" I.D.
C	201775	25/45 CFM Gun Body Only
D	201851	25 CFM Air Jet Assembly



25 CFM Gun

	Mfg. Number	Description
A	201381	25 CFM Gun Assembly Complete
B	201382	25 CFM Carbide Nozzle 5/16" I.D.
C	201757	25 CFM Gun Body Only
D	201383	25 CFM Air Jet Assembly 5/32" I.D.

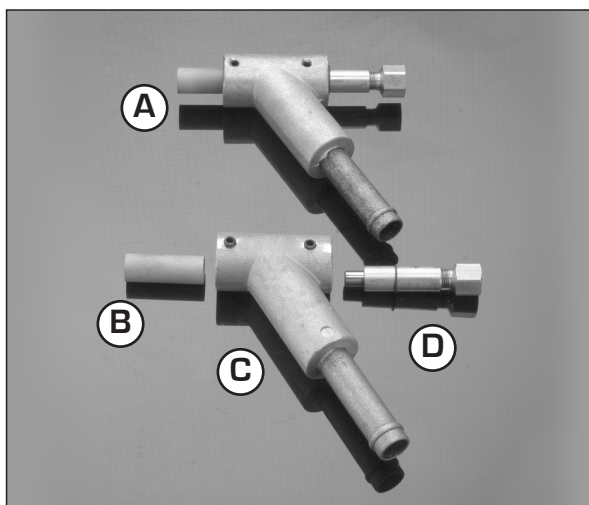


A Boron Carbide nozzle Mfg Number 410207 is also available (not shown).

12 CFM Gun

All ACE Cabinets come with 12 CFM Gun

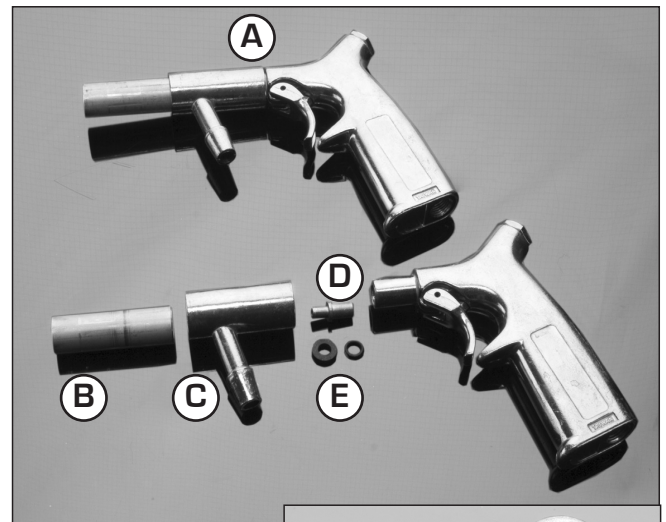
	Mfg. Number	Description
A	201379	12 CFM Gun Assembly Complete
B	410201	12 CFM Carbide Nozzle 1/4" I.D.
C	201756	12 CFM Gun Body Only
D	201394	12 CFM Air Jet Assembly 1/8" I.D.



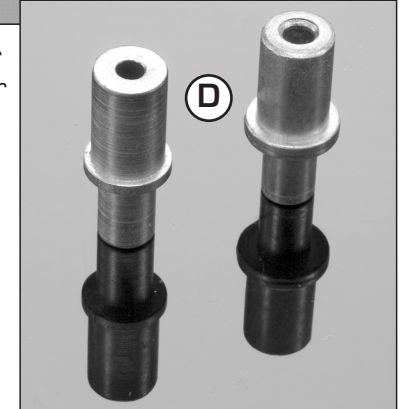
A Boron Carbide nozzle Mfg Number 410208 is also available (not shown).

Pistol Grip Trigger

	Description	Mfg. Number
A	Full Assembly	12 CFM Tungsten Carbide Nozzle 12 CFM Ceramic Nozzle 25 CFM Ceramic Nozzle
B	Nozzle	12 CFM Ceramic 25 CFM Ceramic 12 CFM Steel 25 CFM Steel 12 CFM Tungsten Carbide 25 CFM Tungsten Carbide
C	Nozzle Holder	12 & 25 CFM Trigger Gun
D	Air Jet	12 CFM 1/8 I.D. 25 CFM 5/32 I.D.
E	Washer - Air Jet Seal	12 & 25 CFM Trigger Gun



The Pistol Grip Trigger is the standard gun for Budget Blast Models and the Spot Blast Portable unit

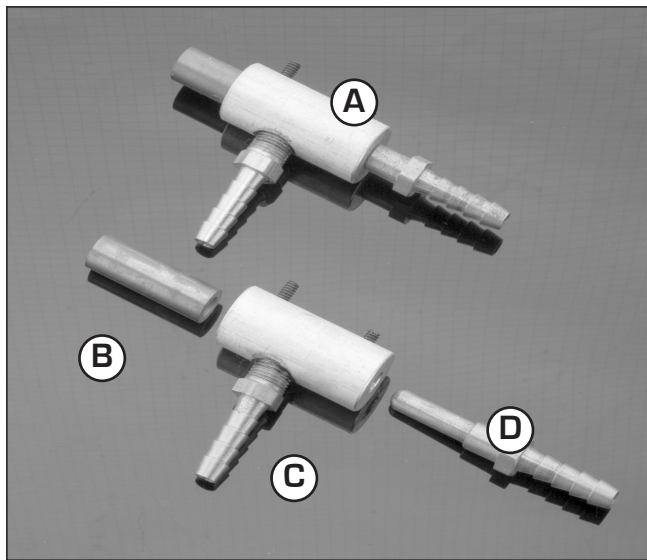


Air jet detail

Blast Gun Assemblies

6 CFM Gun

	Mfg. Number	Description
A	201538	6 CFM Gun Assembly Complete
B	410200	6 CFM Carbide Nozzle 1/8" I.D.
C	410101	6 CFM Gun Body with hose barb
D	201539	6 CFM Air Jet 1/16" I.D.



Pencil Gun

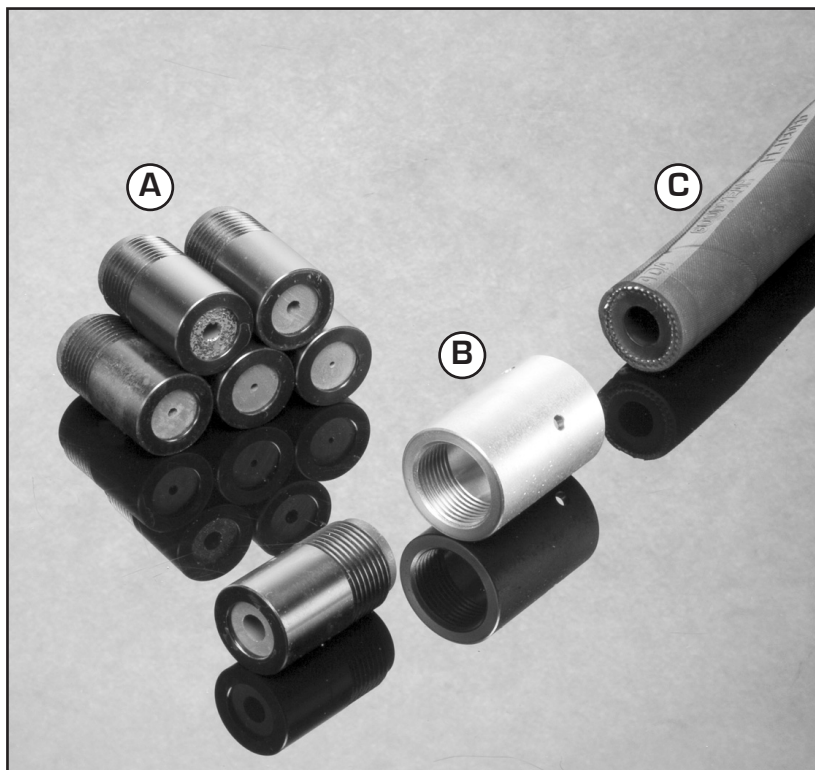
	Mfg. Number	Description
Not Shown	410250	Gun Assembly 1/16" Tip
Shown	410253	Gun Assembly 1/8" Tip

The ACE Pencil Gun allows users to finish smaller parts. The pencil gun has a 5 foot flexible hose for easy maneuverability. Abrasive flow is controlled by a thumb screw on the flow control assembly. Offered in 1/16" and 1/8" Tip Gun



Assembly options. Also available with the following nozzle options: 1/16" carbide (Mfg. Number 410251), 1/16" flat tip (Mfg. Number 410252) and 1/8" carbide (Mfg. Number 410263).

Tungsten Carbide Nozzles, Holder and Hose



	Mfg. Number	Description
A	416529	1/8" I.D. Carbide Nozzle
	416530	3/16" I.D. Carbide Nozzle
	416531	1/4" I.D. Carbide Nozzle
	416532	5/16" I.D. Carbide Nozzle
	416533	1/16" I.D. Carbide Nozzle
	416534	3/32" I.D. Carbide Nozzle
B	410461	Nozzle Holder
C	413411	1 1/8" O.D. Media Hose

All ACE direct pressure cabinets include the 1/8" I.D. nozzle, holder and media hose.

Dust Blow Off Gun

Mfg. Number	Approx. Weight
201749	2 lbs

The Dust Blow Off Gun from ACE cleans projects of dust and debris, right inside your blast cabinet. The gun mounts on the side of the blast cabinet and connects directly to the air supply. The Dust Blow Off Gun is excellent for detail work and finishing. Individual replacement components are also available.



Choosing the Right Nozzle

Nozzle Selection for Direct Pressure units

Compressors can be overtaxed by using a nozzle that is too large. A large nozzle consumes a greater amount of media within a given period. The nozzle I.D. (inner diameter) dictates the required size of the compressor. Refer to the selection chart to determine which nozzle size is appropriate to do the job with your compressor.

I.D.	CFM	PSI	Blast Area Sq. Ft./Minute	Abrasive Unit/Hr
3/32"	7	80	1/2	100 lbs
1/8"	15	80	1 to 1 1/2	150 lbs
5/32"	25	80	1 to 2 1/2	200 lbs
3/16"	40	80	3 to 3 1/2	300 lbs
1/4"	80	80	4 to 4 1/2	500 lbs

As the nozzles wear out the I.D. increases, requiring a greater volume of air. Due to this change, you may want to start with a smaller size nozzle.

Nozzle Selection for Siphon Method units

The orifice in the air jet, combined with the orifice in the blast nozzle determines the CFM (cubic feet per minute) of compressed air required to operate a suction gun. The blast nozzle orifice size should be at least twice the size of the orifice in the air jet. The chart below shows the CFM required at various pressures to properly support various air jet/ nozzle combinations.

Air Requirements CFM]	40 PSI	60 PSI	80 PSI	100 PSI
1/4" nozzle, 3/32" air jet	7 CFM	10 CFM	12 CFM	15 CFM
1/4" nozzle, 1/8" air jet	12 CFM	17 CFM	21 CFM	26 CFM
3/16" nozzle, 1/8" air jet	12 CFM	17 CFM	21 CFM	26 CFM
5/16" nozzle, 5/32" air jet	19 CFM	27 CFM	34 CFM	42 CFM
7/16" nozzle, 7/32" air jet	38 CFM	52 CFM	66 CFM	80 CFM

Ceramic Nozzles

Mfg. Number	I.D.
448847	1/4"
448848	3/16"
448849	3/32"
448850	5/16"
448851	5/32"
448852	3/8"
448857	1/8"



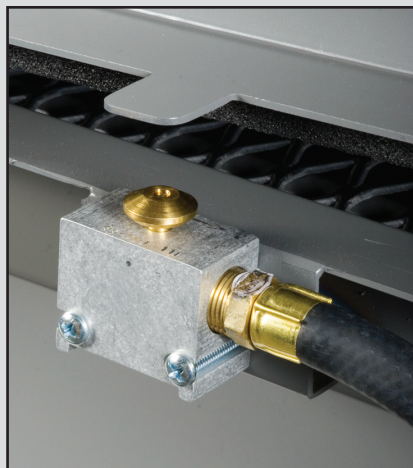
Media Delivery



Regulator and Gauge Assembly

All of our standard blast cabinets include regulator and gauge assemblies, allowing the user to control the velocity of the blast stream. With this feature, a user can control both the speed at which the work is completed and flexibility in achieving the desired finish.

Users save time because they don't need to change the pressure at their air compressor, which they may be using for a variety of air driven tools in their shop. They can simply adjust the air pressure at the cabinet.



Emergency shut-off switch

The ACE Regulator and Gauge Assembly includes a connection to the emergency shut-off switch for additional safety and security.

Air Line Filter

Mfg. Number	Port Size	Bowl Options	Elements
411119	3/4"	Polycarbonate Metal Bowl guard/twist drain	40 micron
411136	3/8"	Polycarbonate Auto Drain	40 micron
411151	1/2"	Polycarbonate Metal Bowl guard/twist drain	40 micron

ACE strongly suggests that the operator have a water/air separator installed in front of the regulator to assure that no moisture enters the system. This ensures a clean, dry flow of air to your blast cabinet and promotes a consistent and even flow from your nozzle. Moisture may lead to clogging of the abrasive media. A unique deflector plate and shroud creates a swirling of the air stream and ensures maximum separation of dirt and water. The Air Line Filter is especially recommended for humid climates.



Piggy Back Filter/Regulator

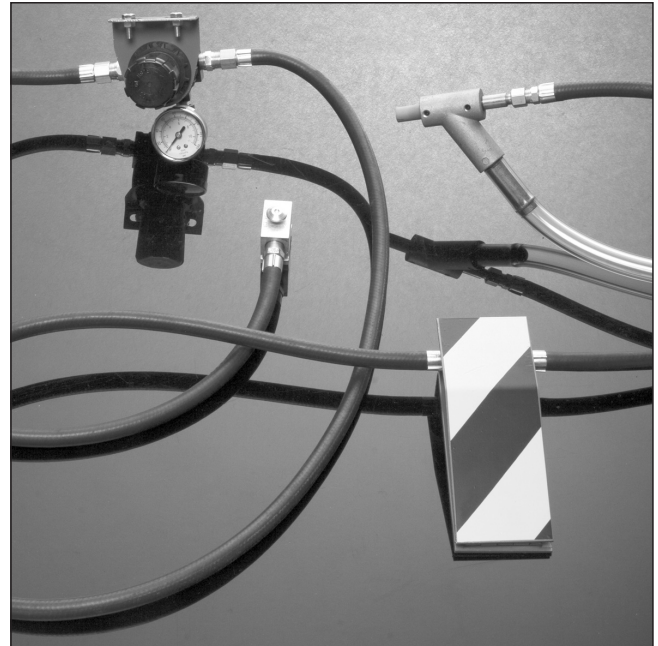
Mfg. Number	Specs
411133	3/8" for Spot Blast
411145	1/2" for ACE-90 R



Media Delivery System

	Deluxe Plus (pictured)*	Deluxe	Basic Plus	Basic
Components Included:	101804-A	101803-A	101802-A	101801-A
12 CFM Tungsten Carbide Gun Assembly	X	X	X	X
Universal Siphon Tube	X	X	X	X
Hoses and connectors	X	X	X	X
Regulator and Gauge Kit	X	X	X	
Foot pedal	X	X		
Door Safety Switch	X			
Approx. Weight	12 lbs	12 lbs	10 lbs	6 lbs

Upgrade your blast cabinet with a smooth flowing ACE Media Delivery System. The Basic Delivery System kit includes a 12 CFM Tungsten Carbide Assembly, a Universal Siphon Tube, and all hoses and connectors. The Deluxe Delivery System Kit includes all the items in the Basic Media Delivery Kit plus a Regulator and Gauge Kit. Foot pedal and Door Safety Switch options are also available for added functionality and safety.



Universal Siphon Tube

Mfg. Number	Approx. Weight
201785	2 lbs

The Universal Siphon Tube is positioned in the bottom of a cabinet hopper and pulls media into the Media Hose, and thus into the nozzle. In siphon systems, this is how the media moves from the hopper to the hose. For more information, please refer to the diagram on page 9.



Clear Abrasive Hose

Mfg. Number	Approx. Weight
413403	1/4 lbs

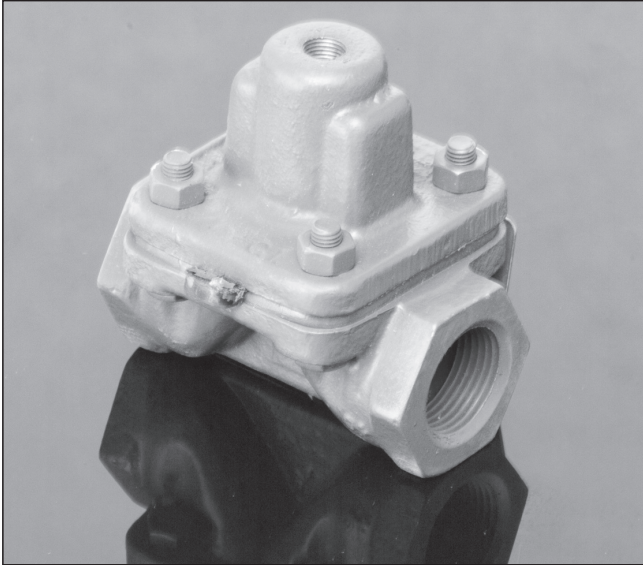
The Clear Abrasive Hose connects the Universal Siphon Tube and the nozzle. This hose has 5/8" I.D. and is sold by the foot. For more information, please refer to the diagram on page 9.



Media Delivery

Media Valve

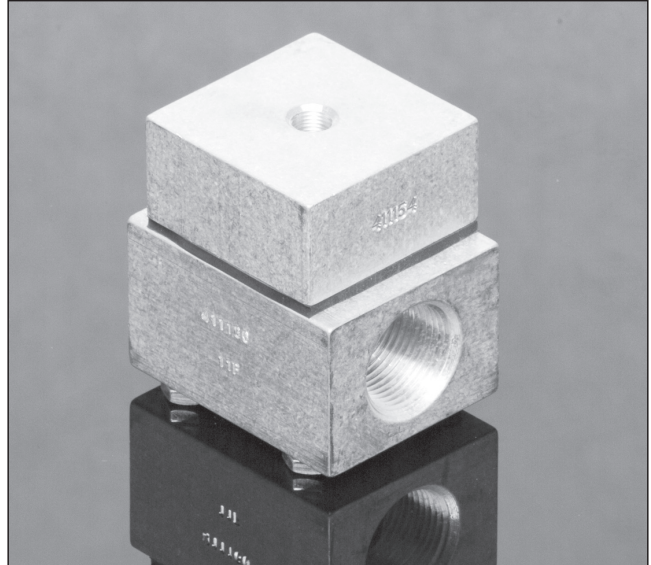
Mfg. Number	Approx. Weight
411128	2 lbs



Used on the ACE-90 R, constructed of steel.

HD Media Valve

Mfg. Number	Approx. Weight
411160	1 lb

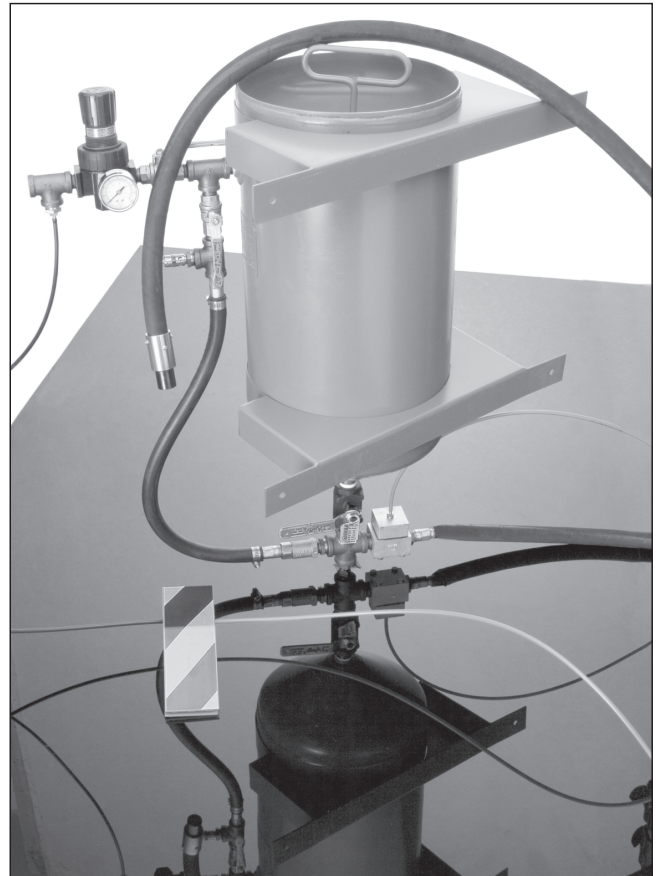


Used on the 1 DP, constructed of aluminum.

Retrofit Kit

Mfg. Number	Approx. Weight
201962	81 lbs

The ACE Retrofit Kit converts any cabinet from a siphon system to a direct pressure system. The kit mounts to the outside of the cabinet and assembly is required.



Gun Mounting Bracket

Mfg. Number	Approx. Weight
101841-A	2 lbs



The Gun Mounting Bracket provides that 'extra hand' users need to hold projects, leaving both hands of the operator free to maneuver the work. Gun Mounting Brackets can be mounted on the wall or ceiling inside any ACE blast cabinet. Blast



Bracket with gun in place

Gun can be easily put in or removed from the bracket. Telescopic functionality is designed to provide easy length adjustment, from 7 3/4" to 12 3/4", with rotation of 360 degrees.



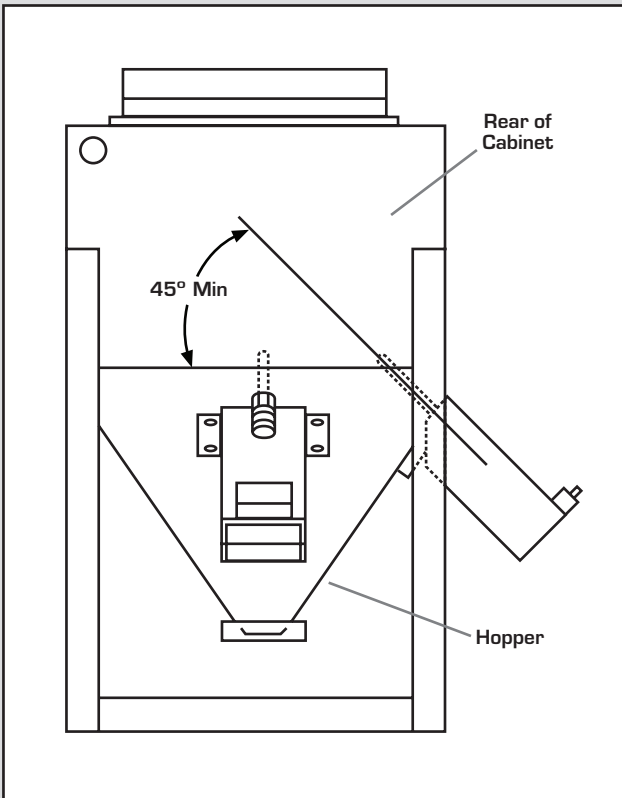
ACE Project Profile: 1946 Willy's Jeep Restoration

In 1996 the ACE team began work on this 1946 CJ-2A "Willy's Jeep" a vehicle that was made popular during the World War II era of the 1940's. It required complete dismembering of all component parts. All body paint was removed using the 2-PS Portable Soda Blaster. Surface rust spots were cleaned to bare metal with ACE's Spot Blaster filled with aluminum oxide. All component parts were blasted in a cabinet with glass bead being used on any aluminum part, and aluminum oxide used on metal components to remove rust and paint. Metal fabrication work was conducted on all problem areas, with badly damaged areas being cut out and replaced with new steel. Once washed and cleaned, the body was placed into an oven to dry completely and was then powder coated and returned to oven.

May the sun never set on the Mighty Jeep!



Accessories



Automatic Tumble System Installation

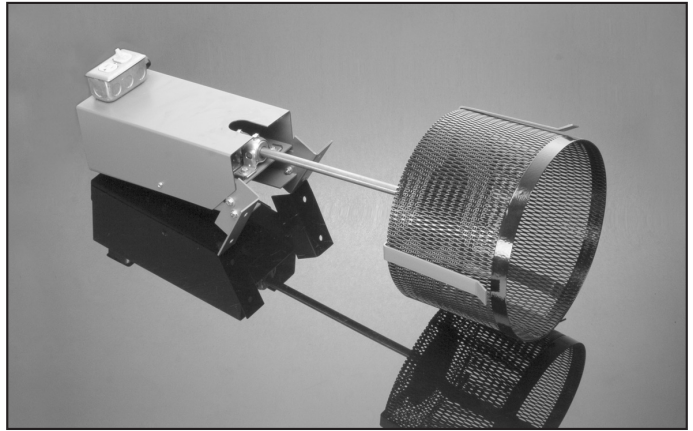
The Tumble System from ACE allows the operator to get complete coverage when blasting small objects. The system is also available with an optional timer system for "operator free" blasting.

The unit may be mounted to the side, back or hopper of the blast cabinet. When choosing the location, make sure the basket and drive shaft may turn freely with no interference.

The hopper or cabinet must be modified to include the Automatic Tumble System Installation. ACE's Tumble Baskets come in various sizes and all are PVC coated to ensure durability.

Automatic Tumble System

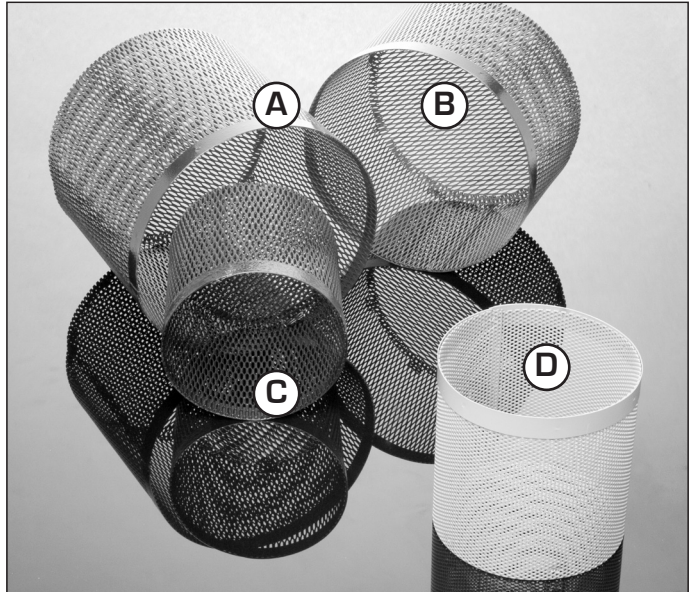
Mfg. Number	Approx. Weight	Description
101738-12	40 lbs	12" x 12" Automatic tumble basket assembly
101738-10	38 lbs	12" x 8" Automatic tumble basket assembly
101738-8	37 lbs	8" x 8" Automatic tumble basket assembly



12" x 8" Automatic tumble basket assembly

Parts Baskets

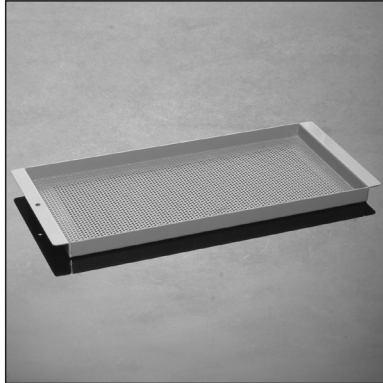
	Height	Mfg. Number	Description
A	12"	101706-A	12" x 12" parts basket, PVC coated
B	10"	101705-A	12" x 8" parts basket, PVC coated
C	8"	101704-A	8" x 8" parts basket, PVC coated
D	8"	101704P-A	8" x 8", Perforated parts basket, not coated



Parts Tray

Size	Mfg. Number	Approx. Weight
16" x 8"	201211	3 lbs

The ACE Parts Tray keeps small parts from falling through the cabinet work surface. Simply place the Parts Tray on the cabinet work surface and place small parts in the tray basket to work on them. Powder coated 14 gauge steel fabrication for a durable piece.



Wheel Roller

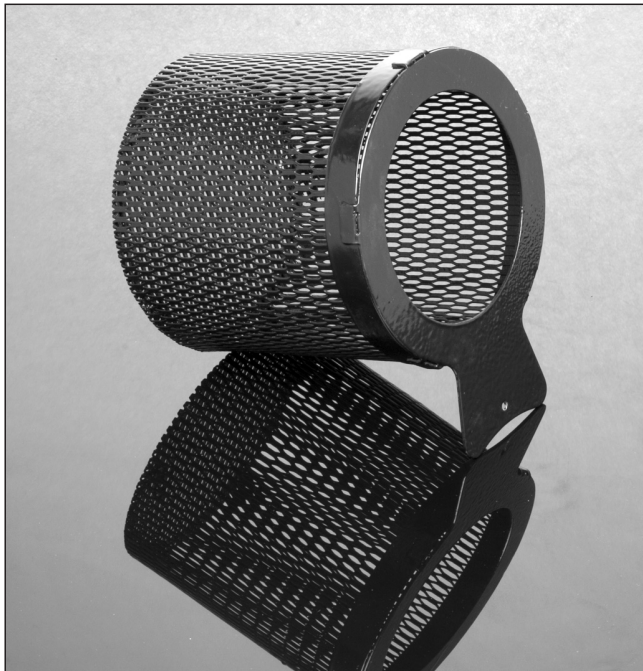
Size	Mfg. Number	Approx. Weight
13.5" x 10"	201212	3 lbs

Install an ACE Wheel Roller to easily rotate wheel rims inside your blast cabinet, just set the Wheel Roller on the work surface inside the blast cabinet and place the rim on rollers. Rotate rim as you blast to access all surfaces easily. Powder-coated 14-gauge steel fabrication with ball bearings provides a durable finish for this handy accessory.



Small Parts Basket

Size	Mfg. Number	Description
8" x 8"	201213	Small parts basket with handle. Not intended for use with Automatic Tumble System.



26" & 20" Turntables

Height	Width	Mfg. Number	Approx. Weight
8"	20"	101721-66	50 lbs
8"	26"	101720-66	65 lbs

ACE turntables are designed for use in the abrasive atmosphere of a blast cabinet. The 26" model is ideal for larger blast cabinet sizes. The hub contains sealed ball bearings, ensuring that all lubrication points are protected. The table plate is constructed of 7 gauge hot rolled steel with a weight capacity of 2000 lbs. ACE can also recess and install a turntable in any cabinet that you have ordered. Please contact customer service for installation cost and lead time. Machines with power driven turntables are also available and can be quoted on request. 20" turntable not shown.

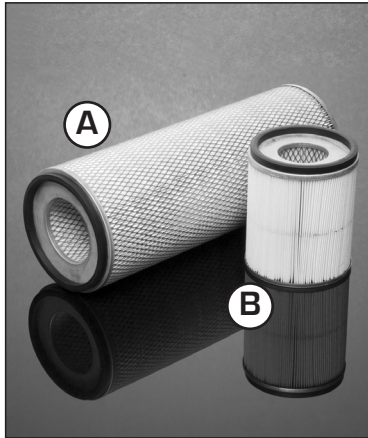


Replacement Parts

Cartridge Filters

	Mfg. Number	Approx. Weight
A	495114	9 lbs
B	495171	4 lbs

The ACE Cartridge Filter has been tested to be 99.9% efficient, filtering .5 microns. The Cartridge Filter is manufactured from cellulosic filter media with corrugation designed for dust collection applications requiring high collection efficiency and minimum air restriction. The cartridge style air filter is also easy to replace. Small filter fits 100 CFM Cartridge D/C, Spot Blast and Model 1 DC. Large filter fits 400 and 600 CFM Cartridge D/C.



Dust Collector Bag

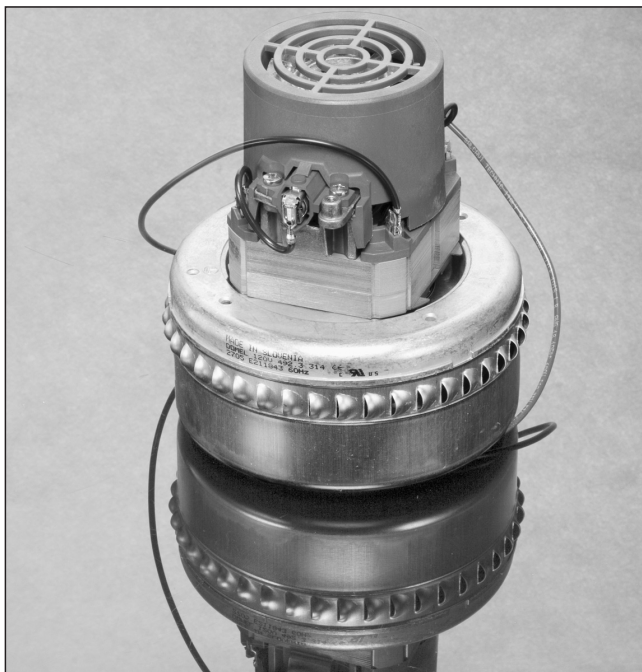
Mfg. Number	Approx. Weight
414436	2 lbs

The Dust Collector Bag from ACE is made of dense poly-felt, which is rated at 10 microns (95% efficient). It's standard equipment on the 100 CFM Bag Dust Collector, as seen on page 12 and the 150 CFM D/C Whisper Vac. When the unit is powered off, the sewn-in weight at the bottom of the bag drops, shaking up the built up dust from the bag each time the collector motor is shut off.



100 CFM D/C Motor

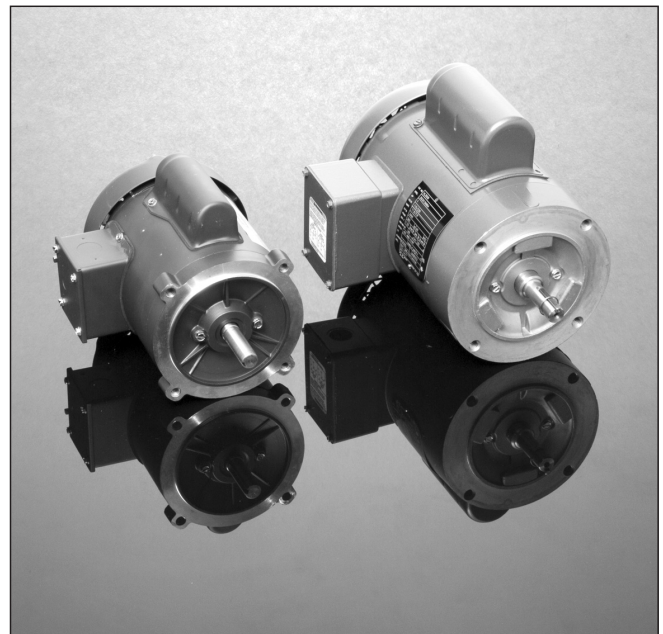
Mfg. Number	Approx. Weight
414414	5 lbs



Works with the 100 cfm Dust Collector, Model 2-S, and Model 1 DC on page 7.

1/2 & 1 HP Motors

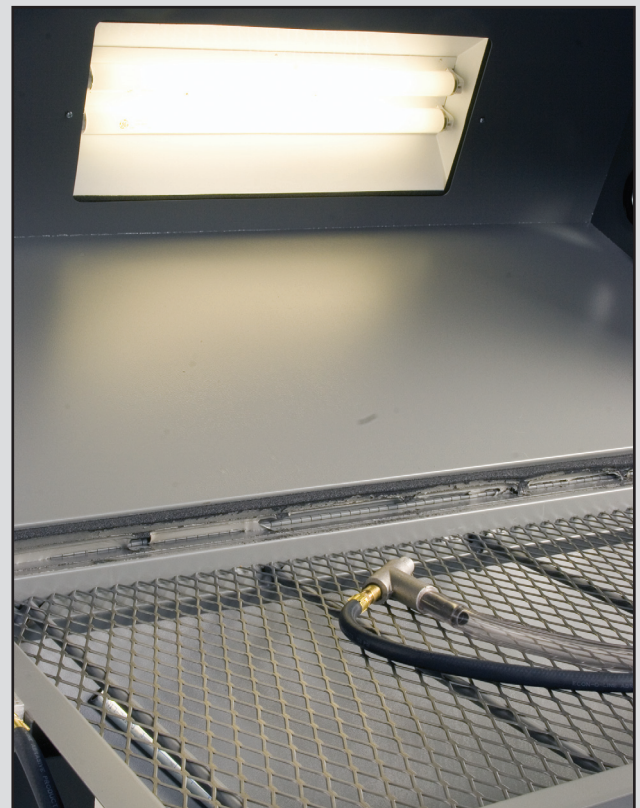
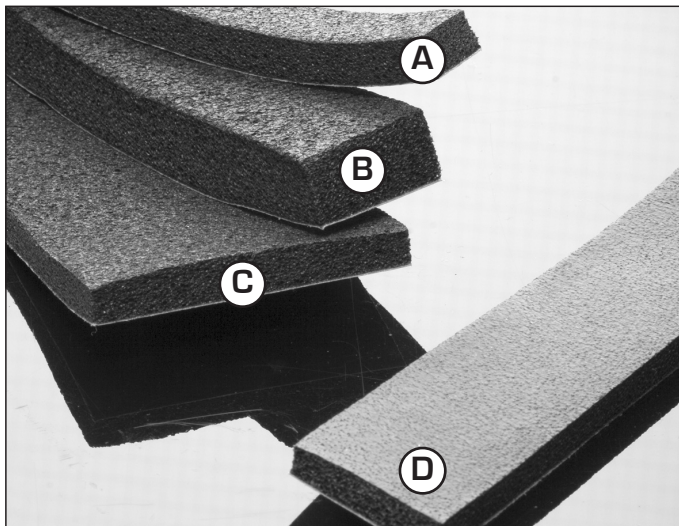
HP	Mfg. Number	Approx. Weight
1/2	414500	19 lbs
1	414501	36 lbs



1/2 HP fits 400 and 150 CFM Dust Collectors; 1 HP fits 600 CFM dust collectors

Replacement Gaskets

	Mfg. Number	Description (Note: Gaskets are sold by the foot)
A	411401	Flipper door gasket 5/16" x 1/2"
B	411403	Window/Door Gasket 1/2" x 1"
C	411402	Arm port gasket 1/4" x 2"
D	411419	Dust Collector door gasket 1/4" x 1"



Light Box Assembly

ACE light box assembly features are the result of listening to our customers to provide safer and more efficient lighting in our blast cabinets.

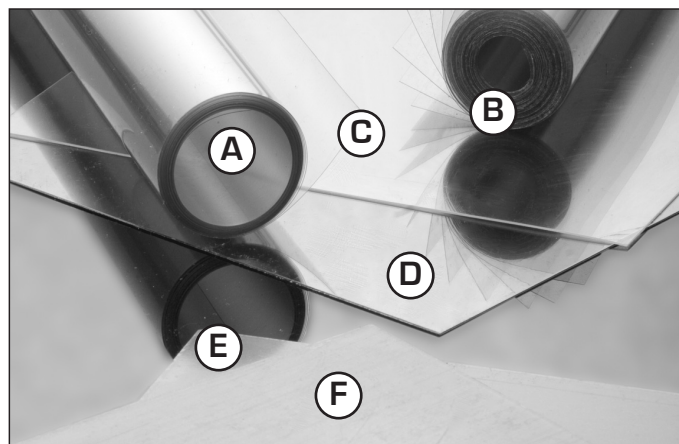
Our lights are located outside the work area and protected by a lamp shield. The placement of the light assembly eliminates the chance of accidental damage to both the bulbs and the light fixture and also reduces the chance of injury to the user or damage to the product. Spot lights located inside a cabinet can be easily broken when shifting product inside the cabinet.

Dual fluorescent bulbs featured in ACE light box assemblies provide omni-directional lighting. Unlike the spot light bulb lighting systems used by many other manufacturers, fluorescent lights reduce shadows. Spot lights provide poor lighting by casting shadows, making it difficult to see what you are doing. Our dual fluorescent bulbs are positioned across the width of the cabinet and illuminate the cabinet more evenly and efficiently.

See page 6 for Window and Light Replacement information.

Replacement Windows and Lamp Shields

	Mfg. Number	Description
A	311535	Window Underlayment Roll - 24" x 120"
B	313286	Window Underlayment 10 pack - 12" x 24"
C	411423	Lamp shield - 7" x 12"
D	411422	Lamp shield - 12" x 25"
E	411410	Window - 6" x 12"
F	411405	Window - 12" x 24"
Not Shown	411429	Window - 24" x 24"



Replacement Gloves



Glove Replacement and Measurement

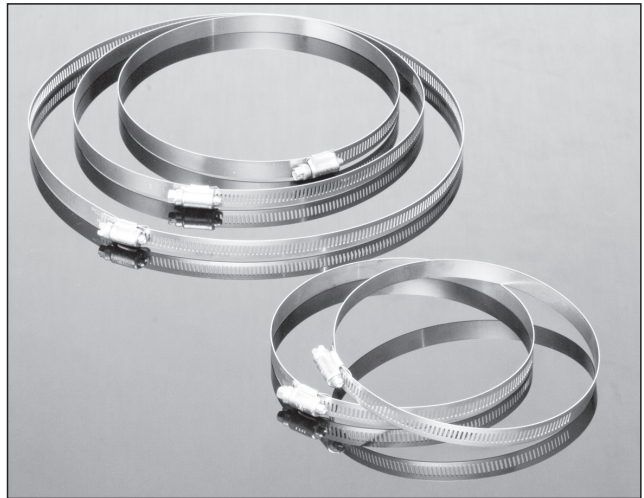
Replacement of gloves in ACE blast cabinets is a very easy process that can be completed with a screwdriver or air tool in less than 10 minutes.

When you take the measurement of the arm ports, be sure to take the vertical diameter of the opening. This is particularly important for cabinets with oval-shaped holes, such as the WD 40 x 38 or the WD 36 x 30.

ACE replacement gloves also fit most competitors' cabinets.

Glove Clamps

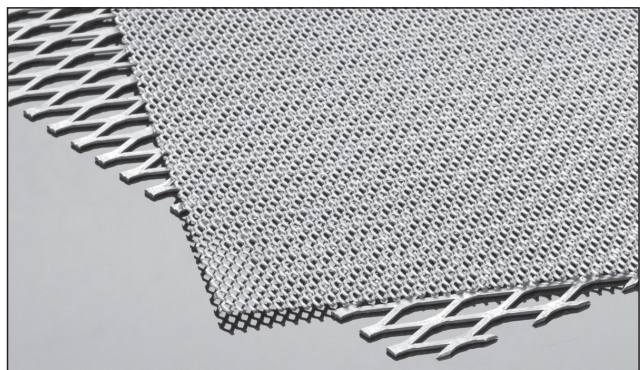
Mfg. Number	Armport Diameter
414510-2	6"
414511-2	7"
414512-2	8"
414513-2	9"



Glove clamps sold in pairs.

Work Surface

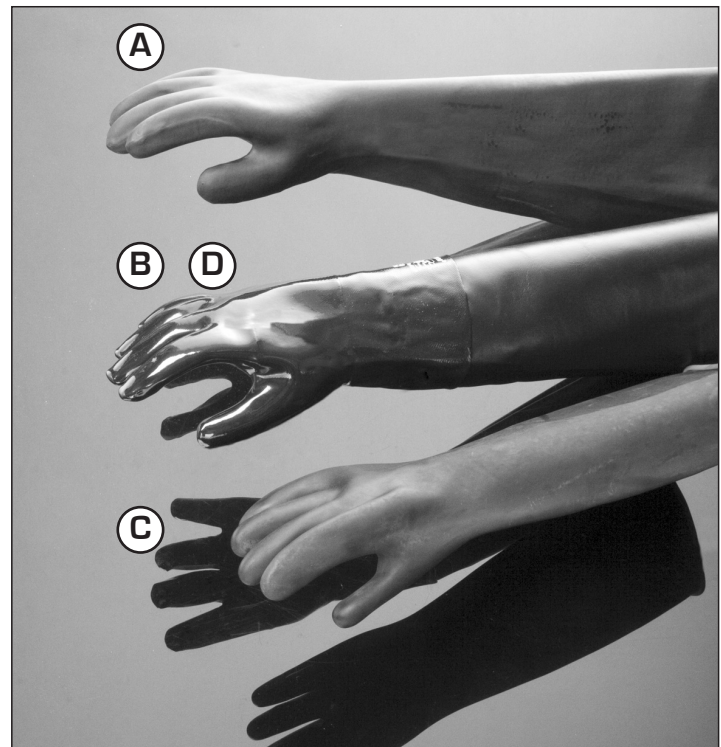
Carbon Screen Mfg. #	Approximate Dimensions	Expanded Metal Mfg. #
311137	16" x 16"	201346
311134	24" x 24"	201342
311131	30" x 24"	201344
311135	36" x 24"	201345
311140	40" x 40"	201337
311136	42" x 24"	201338
311141	48" x 24"	201347
311138	40" x 38"	202692
311139	48" x 48"	201340
203475-A	60" x 48"	201358



Replacement Gloves

	Mfg. Number	Description
A	412402	Gloves 24" x 6" Seamless Rubber Pair
B	412007	Gloves 33" x 7" Pair
C	412001	Gloves 18" x 5" Pair
D	412002	Gloves 24" x 6" Pair

ACE's gloves are designed to withstand the harsh environment within a blast cabinet. Gauntlet-style gloves are manufactured of reinforced neoprene and vinyl, with a cotton lining. ACE also offers natural rubber gloves, which are comfortable and aid in eliminating static shock as well as providing superior flexibility and feel. Gloves are available in seamless and/or cotton lined models where indicated. All ACE gloves provide excellent durability and functionality.



Replacement Gloves			
Mfg. Number	Size (Length/Armport)	Description	Used On Model #
412001	18" X 5"	Pair; Seamless Rubber	9
412402	24" X 6"	Pair; Seamless Rubber - Cotton Lined	All DP and WD Cabinets
412402-L	24" X 6"	Left; Seamless Rubber - Cotton Lined	
412402-R	24" X 6"	Right; Seamless Rubber - Cotton Lined	
412002	24" X 6"	Pair; Neoprene/Vinyl - Lined	2-S, 1, 1 B, 1 BP, 1 DC, 2, 3, 4, 10
412003L	24" X 6"	Left; Neoprene/Vinyl - Lined	
412003R	24" X 6"	Right; Neoprene/Vinyl - Lined	
412004	24" X 7"	Pair; Neoprene/Vinyl - Lined	
412019L	24" X 7"	Left; Neoprene/Vinyl - Lined	
412019R	24" X 7"	Right; Neoprene/Vinyl - Lined	
412007	33" X 7"	Pair; Neoprene/Vinyl - Lined	5, 5 LA, 6, 6 LA, 7, 8
412008L	33" X 7"	Left; Neoprene/Vinyl - Lined	
412008R	33" X 7"	Right; Neoprene/Vinyl - Lined	
412005	24" X 8"	Pair; Neoprene/Vinyl - Lined	
412020R	24" X 8"	Right; Neoprene/Vinyl - Lined	
412020L	24" X 8"	Left; Neoprene/Vinyl - Lined	
412009	33" X 8"	Pair; Neoprene/Vinyl - Lined	
412010R	33" X 8"	Right; Neoprene/Vinyl - Lined	
412010L	33" X 8"	Left; Neoprene/Vinyl - Lined	
412403	32" X 9"	Pair; Seamless Rubber - Cotton Lined	
412403R	32" X 9"	Right; Seamless Rubber - Cotton Lined	
412403L	32" X 9"	Left; Seamless Rubber - Cotton Lined	
412011	33" X 9"	Pair; Neoprene/Vinyl - Lined	14, 14 VD
412012R	33" X 9"	Right; Neoprene/Vinyl - Lined	
412012L	33" X 9"	Left; Neoprene/Vinyl - Lined	

Abrasive Media

Abrasives Overview

ACE strives to maintain a varied inventory of blasting abrasives. Utilizing a worldwide base of reputable suppliers, ACE is able to provide consistent delivery of quality abrasive products. We look forward to servicing your abrasive needs.

Cleaning, Finishing and Peening

Cleaning: Abrasive blasting removes corrosion oxides, flux slag, heat treat scale, surface discoloration and paint.

Finishing: Blasting can impart a shiny-bright, matte or etched surface to your project and will blend defects and marks.

Peening: Peening can increase the fatigue life of your work piece by hammering to leave the surface under residual compressive stress.

Choosing the Right Media Type

The type of abrasive determines cost and effectiveness of the blast-cleaning process. The variables are quality of finish desired and the time required to obtain that finish. Start with a lasting, durable abrasive using the smallest size that will do the job, then work up to the largest size that does an acceptable job in the shortest time.

Grading Abrasive Media

Abrasive media is graded based on mesh size. Mesh size refers to the number of holes in a 1" square screen. As mesh size gets larger, the number of holes per inch increases, the size of each individual hole decreases, and the media becomes finer. Size comparisons shown in chart at right.

Factors That Determine Efficiency

Shape: Particles can either be smooth or sharp. Smooth, round particles hammer the base material to impart a peened finish and to dislodge brittle scale better than sharp particles do. Sharp edged particles remove material from your project quickly, leaving an etched or matte finish.

Size: The size of the particles determines the finished roughness of your work. Large particles bring more kinetic energy to the work surface, but excessively large particles remove more material than small ones. As the abrasive works, particles break into smaller and smaller sizes.

Hardness: The harder the abrasive, the deeper it penetrates and the faster it works. Soft abrasives deform and waste kinetic energy. Brittle abrasives wastes energy by fracturing during the blasting process.

Mass: For equal size, denser particles have more kinetic energy and work faster than particles that are less dense.

Break Down Rate: This is the rate of fracture of the abrasive media during blasting. The more resistant to impact fracture, the more consistent the blasting action.

Mesh Screen Size	Comparison
16-40	Ground coffee
30-50	Fine ground pepper
30-80	Table salt
50-80	Granulated sugar

General Application Guide for Abrasive Media*						
1 = best 2 = effective 3 = acceptable		Application				
		ETCH	PEEN	DEBURR	REMOVE PAINT	CLEAN
STEEL	1 2 3	Silicon Carbide Aluminum Oxide Black Beauty Slag	Cast S.S. Shot Steel Shot Glass Bead	Steel Grit Silicon Carbide Aluminum Oxide	Soda Blast Silicon Carbide Aluminum Oxide	Soda Blast Silicon Carbide Aluminum Oxide
ALUMINUM	1 2 3	Ground Glass Glass/Aluminum Oxide Aluminum Oxide	Glass Bead Agricultural Shells Plastic Grit	Agricultural Shells Plastic Grit Glass/Aluminum Oxide	Glass Bead Soda Blast Agricultural Shells	Glass Bead Soda Blast Plastic Grit
PLASTIC	1 2 3	Ground Glass Glass/Aluminum Oxide Plastic Grit	Glass Bead Plastic Grit Agricultural Shells	Plastic Grit Agricultural Shells Glass/Aluminum Oxide	Plastic Grit Soda Blast Agricultural Shells	Soda Blast Plastic Grit Agricultural Shells
WOOD	1 2 3	Plastic Grit Agricultural Shells Soda Blast	N/A N/A N/A	N/A N/A N/A	Soda Blast Plastic Grit Glass Bead	Soda Blast Plastic Grit Glass Bead

*This chart is for comparative purposes only.