

BB2 & BB4 Basket Blasters

- Accelerate Finishing of Small Parts
- Process 300 Pounds Plus per Cycle
- Deliver Repeatable Results

Safety Door-Switch prevents blasting when door is open. Complies with OSHA.



Precision Timer handles presets of any duration. Variable speed and jog controls are also provided for the basket.

Durable Basket tumbles parts in multiple blast streams to assure uniform processing.

Three, Pneumatically Controlled Oscillating Blast Guns (BB4-3K model) increase productivity while reducing air consumption and power costs.

Unloading Chute facilitates removal of finished parts.

Empire's BB2 and BB4 Basket Blasters automate cleaning, peening and finishing of small workpieces. With certain types of parts, no other finishing method can compare to these heavy-duty production machines in terms of speed and quality results.

Operation is simple: Load parts into the unit, set the precision timer, and the Basket Blaster does the rest. By tumbling parts within abrasive blast streams, these machines deliver consistent finishes – automatically.

Empire's heavy-duty Basket Blasters feature an unloading chute to speed parts handling and a polyurethane-lined media reclaimer supported by rugged ductwork to reduce maintenance requirements.

Two models are available: a BB4-3K with a 350-pound

parts capacity and three pneumatically controlled oscillating blast nozzles that increase production rates while reducing power consumption, and a smaller BB2-3K unit with two fixed nozzles and a capacity of 300 pounds.

Put either unit to work and your parts finishing costs should start to take a tumble right away.

For additional information about our BB2-3K and BB4-3K Basket Blasters, go to the next page, contact Empire or your local Empire distributor, and visit our web site at www.empire-airblast.com

Basket Blaster Specifications

Model	BB2-3K	BB4-3K
Outside dimensions (DxWxH)		
Cabinet with reclaimer	61"x56"x74"	*61"x87"x74"*
Dust collector	26"x22"x98"	39"x34"x105"
Construction		
Cabinet	14 gauge	14 gauge
Basket	11 gauge	11 gauge
Reclaimer	11 gauge	11 gauge
Basket		
Size	30" dia. x 16" wide	30" dia. x 30" wide
Door opening	10" wide x 11" high	24" wide x 11" high
Capacity	300 lbs., 1-1/2 cu. ft.	350 lbs., 3-1/2 cu. ft.
Perforations		
Standard non-coated	5/16" dia.	5/16" dia.
Optional coated	5/16" dia. or less	5/16" dia. or less
Optional non-coated	1/8" dia.	1/8" dia.
Blast guns		
Quantity	MH-2 Short Handle 2	MH-2 Short Handle 3
Size	5/16" with 5/32" jet	5/16" with 5/32" jet
Nozzle	Di-Carb®	Di-Carb®
Oscillation	No	Yes (pneumatic)
Compressed air at 60 PSI	54 SCFM	81 SCFM
Dust collector (bag house)		
Model	DCM-80A	DCM-200
Fan size	1 hp.	1-1/2 hp.
Rated CFM at 6" S.P.	400	600
Cloth area	80 sq. ft.	200 sq. ft.
Dust collector (cartridge)		
Model	CDC-6	CDC-6
Fan size	1-1/2 hp.	1-1/2 hp.
Rated CFM at 6" S.P.	600	600
Filter area	452 sq. ft.	452 sq. ft.
Reclaimer		
Rated CFM	400/600	600

* Overall width includes oscillation stroke.

Dust Collection

In addition to bag-house units, we offer a cartridge dust collector with both basket blaster models. The vertical cartridges in the CDC-6 are easy to replace and provide a filtration area of 452 square feet which captures 99.999% of particles one-half micron or larger. With either the bag-house or cartridge collectors, air can normally be recirculated to the work-place, thereby reducing HVAC costs.



Standard Features: • Quick-release basket door • External blow-off gun • Door/blast interlock • Easily unloaded hopper door • Precision timer • 1/3-hp., DC variable drive (2 to 20 RPM) • 3-phase fan motor • Heavy-duty conveying hose • Lined, tunable reclaimer • 1" piping with general purpose filter, gauge and pressure regulator • Electrical control box • Two, 90-watt interior lights • Easily accessed media hopper • Observation window • Cabinet and dust-collector leveling bolts

Options: • Boron carbide nozzles (recommended with aluminum oxide) • Coated basket • Automatic bag shaker or photohelic-controlled pulse-jet cleaning for cartridge-type dust collectors • Automatic blow-off cycle • Signal light to indicate cycle completion • Non-standard voltages • 50 Hz operation • Basket cover assembly for light parts (BB2-3K only) • Larger 7/16" guns (BB2-3K requires 104 SCFM at 60 psi; BB4-3K requires 156 SCFM at 60 psi) • Smaller 1/4" guns (BB2-3K requires 34 SCFM at 60 psi; BB4-3K requires 51 SCFM at 60 psi) • High-capacity fan for oversized media • Small-parts barrel with 1/8" diameter perforations • Barrel kick flights for more even processing of parts • CDC-6 cartridge-type dust collectors

Media: Empire basket blasters are designed for use with glass bead (180 mesh or larger), aluminum oxide (40 to 200 mesh), steel grit (G-125 to G-200), steel shot (S-70), and nutshells or plastic of any size. Consult Empire for recommendations concerning other abrasives.

Media Reclamation

Basket-blasters reclaimers are tunable, meaning they can be adjusted to prevent and control the loss of fine, medium or coarse media. They also include a removable debris screen to prevent oversized material from clogging the nozzles, an easy-access door for quick media filling and a polyurethane liner that extends reclaimer life.



BEST WARRANTY IN THE INDUSTRY

Three-years limited on parts and labor

Empire Air-Blast Products

- A complete range of cabinets
- Robotic, turntable and in-line automation
- Blast rooms and blast booths
- Portable blasters
- A full line of parts and accessories

NEVER USE SILICA SAND IN ANY EMPIRE EQUIPMENT

Information subject to change without notice.