

MICROBLASTER  
**MICRA 1-2**

 **USER AND MAINTENANCE MANUAL**



## 1. DESCRIPTION

**MICRA 2** is a sandblasting unit designed for microblasting operations in the Dental and Jewellery branch.

The main features of the machine are: the ergonomic layout of the working chamber, the safety of use, and the trouble-free structure of the mechanical installation. **MICRA 2** is equipped with useful accessories and ensures a fast, practical and accurate work. The unit consists of 2 **EASY tanks**, featuring a pressure discharge system and an instant stop of the blasting jet. The unit can thus operate with **two different abrasive media**.

The sandblasting process originates toxic dust which must not be inhaled; for this reason, **it is absolutely forbidden to operate the machine if a proper suction system has not been previously connected to the sandblaster.**

DENTALFARM has developed the so-called W.A.F.I.S. (WATER AIR FILTERING SYSTEM), a patented solution which eliminates airborne dust thanks to the combined action of water and air pressure, in compliance with hygiene and safety regulations. The WAFIS system can be easily connected on the top left side of the machine and starts automatically when the sandblaster switches on.

DENTALFARM ranges also include **PRO-3** and **PRO-3 Shake** suction units, which can be easily connected to any sandblasting machine.

## 2. TECHNICAL REFERENCE REGULATIONS AND TEST PROCEDURES

The appliance is mass-manufactured by DENTALFARM in compliance with technical and safety rules in force, as provided for by the Machinery Directive 2006/42 EEC.

Careful inspection and full routine testing is carried out singularly on each machine which is furtherly processed by an automatic testing installation assuring compliance with the fixed limits

### DEMOLITION AND WASTE DISPOSAL

According to International regulations, this unit has been classified as AEE (electric and electronic device, whose correct operation depends on electric currents and electromagnetic fields) and as a consequence, at the end of its lifetime, it can not be treated as normal waste material but it must be disposed separately, complying with Directive 2002/96/EEC.



### 3. INSTALLATION INSTRUCTIONS



Installation of this machine is quite easy but must be carried out paying utmost attention in order to avoid any mistake which may originate problems, inconveniences and even damages during operation.

1. Place the machine on a proper workbench, which must be stable and strong enough to hold the machine safely. Keep a sufficient distance (10/15 cm) on the right side of the machine for the pipes and the feeding cables, as well as in order to access the shutter and the filter. If a built-in WAFIS system is present, preferably choose a workbench and a position (for instance at the rim of the bench) so that the exhaust pipe can fall perpendicularly into the collection tank.



2. Insert the quick clutch fitting on the male intake (A) located on the right side of the unit and connect the pneumatic feeding pipe (polyethylene or rilsan, with diameter  $\varnothing$  8x6) to the pipe-fitting. It is also possible to use a  $\varnothing$  12x6 elastic feeding pipe, by using the fitting supplied with the unit.
3. Connect the electric feeding cable to the pre-fitted electric socket on the unit (B) and plug into an approved 220v AC - 50Hz network socket with ground connection.
4. Install the preferred suction system; WAFIS, PRO-3 or any other.

The built-in WAFIS should be installed on the top left side of the unit: unscrew the 4 screws fixing the black collection intake and mount the WAFIS, unscrew the cap (C) and replace it by the pipe-fitting delivered in the package, put together with the other portion of pipe and plug the feeding cable into the electric socket (D). PRO-3 suction units can be



connected in two different ways: **on the top left** to extract dust particles only; in this case, insert the piping into the black collection intake; alternatively, **on the rear bottom** of the working chamber: in this case, all the

used abrasive will be extracted. In both cases, remove the protection caps from their holes.

Any other suction system can be connected to the black collection intake by means of flexible piping; the inside manifold fits a  $\varnothing$  30mm pipe, the outside manifold fits a  $\varnothing$  40mm pipe.



5. Adjust the air flow to avoid the machine being under pressure. Slightly turn the mobile section of the adjusting valve when the suction system is on and stop when you notice that the gloves are still slightly inflated.
6. **Microblasting tanks (EASY tanks) are identical in layout, but can feature different components (calibrated dosing system) and external nozzles which vary according to the abrasive mixture they can dispense;** it is therefore necessary to observe the indications written on the identifying labels. Should you need to use an abrasive compound of different grainsize (not listed below), it is possible to request the components and to replace them.

To pour abrasive media into the tank, unscrew the tank cap and fill in the tank till approximately 2/3 of its capacity (observe the maximum level marked on the label); then close the tank.


Strictly observe the following parameters, based on the abrasive grainsize.				
TREATMENT	TANK (dosing system)	RECOMMENDED ABRASIVE	NOZZLE DIAMETER	PRESSURE
Surface roughness on metals for composites	<b>A1072G (coarse)</b>	<b>AP-060</b> Orange label (AL2O3 60 - 250µ)	<b>2,0 mm</b> (RMN046)	4 BAR
Surface roughness on metals for composites	<b>A1072M (medium)</b>	<b>AP-120</b> Pink label (AL2O3 120 - 105µ)	<b>1,2 mm</b> (RMN043)	3/4 BAR
Surface roughness on metals for ceramic or resin	<b>A1072M (medium)</b>	<b>AP-150</b> Green label (AL2O3 150 - 95µ)	<b>0,8 mm</b> (RMN044)	3/5 BAR
Surface roughness on metals for ceramic	<b>A1072M (medium)</b>	<b>AP-180</b> Red label (AL2O3 180 - 80µ)	<b>0,8 mm</b> (RMN044)	3/5 BAR
Sculpture on ceramic	<b>A1072S (fine)</b>	<b>AP-270</b> Yellow label (AL2O3 270 - 50µ)	<b>0,5 mm</b> (RMN045)	3/5 BAR
Satin-finishing on any type of metal	<b>A1072M (medium)</b>	<b>AP-090 MICROBLAST</b> White label	Higher precision <b>0,8mm</b> Higher speed <b>1,2 mm</b>	3/4 BAR 4/5 BAR

A longer nozzle with Ø 0,8 mm size (RMN044L) is available on request to carry out cleaning operations on ceramic prosthesis without metal support.

<p><b><u>⚠ WARNING:</u></b></p>	<p>Very fine abrasives are highly sensitive to moisture and must be stored in a dry place, after the can has been accurately sealed and the antimoisture packet has been duly introduced into the can (if needed, replace them periodically).</p> <p>When filling the abrasive containers, check the condition of the abrasive product; if the moisture rate is too high (bad flowability and presence of clots) it is recommended to heat the abrasive in order to allow it to dry up completely. It is also of utmost importance to check the condition of the compressed air which in no way must contain evidence of moisture or of any polluting agents (oil, grease or rust).</p>
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## 4. INSTRUCTIONS FOR USE

- Press the switch to illuminate the working chamber and feed the operating controls.

 <b><u>ATTENTION:</u></b>	May we remind that the sandblasting process will start only provided the suction system is operating – as a consequence, the filtering system <b>MUST</b> always be installed and <b>OPERATED BEFORE</b> you start to work.
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- Lift the window to introduce the pieces to be treated into the working chamber.
- Turn the selector switch knob to choose the type of blasting procedure you prefer – references marked on the label are herewith specified.

POSITION OF THE POINTER	SELECTED FUNCTION
GREEN	MICROBLASTING FROM THE GREEN TANK
WHITE	MICROBLASTING FROM THE WHITE TANK


- Press the foot control: air enters the selected tank putting it under pressure, it gets mixed with abrasive micrograins and will then be dispensed by the spraying nozzle.
- Adjust the working pressure by means of the pressure adjusting device located next to the pressure gauge: lift the knob and turn it rightwards (to increase) or leftwards (to decrease). To lock the knob, push the knob back down.

The microprojectors are ideally positioned in the middle of the working chamber to facilitate use with both hands. We recommend to put back them in place on their holders at the end of the work.

The window is made of anti-scratch polycarbonate material, resisting to the rebounding abrasive grains. We recommend to use a soft cloth to clean it and to remove the dust from inside and the use of protection screens (code 1000533).

## 5. MAINTENANCE

**Many of the components of any sandblasting machine are subject to wear:** this is caused by the circulation of abrasive media; the instructions for a careful maintenance of the machine as well as the operations to replace the damaged or worn out parts are specified here below.

 <b><u>ATTENTION:</u></b>	Before carrying out any maintenance operation inside the working chamber or technical repair of the connections, remove the feeding cable both from network socket and from the rear of the machine; in such a way, both the electric and pneumatic installation of the unit will be fully disconnected. Should you have any doubts or difficulties, get in touch with our Technical Service to avoid any risks or damages.
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### **Cleaning of the 5my filter**

A 5my filter, mounted on the right side of the sandblaster, prevents fine dust from damaging internal components. Remove the inspection cap every 2-3 months and blow the filter with compressed air to clean it from dust sediment.

### **Replacement of the polycarbonate window**

Although the window is anti-scratch, it can be damaged by an extensive use (or a bad maintenance). Replacement is very simple: locate the screws which fix the window to the hinges and unscrew them.

### **Replacement of the plastic protection screens of the glass window**

Remove the fixing clips, clean accurately the glass and place a new protection screen.

### **Replacement of gloves**

The gloves are made of highly resistant and elastic latex, but are subject to the natural ageing of rubber and to the action of sweat (produced by hands). This cause them to dry up. To replace them, unscrew the flange screws and fit a new pair of gloves into the proper seat.

### **Replacement of the fluorescent lamp**

Move leftwards the plastic screen, then pull the lamp leftwards and take it out of its holder. Re-assemble the screen on the metallic container, paying attention to properly bend and fit the edges. Should this operation be too complicated, it is possible to remove the complete lighting group by unscrewing the two fixing screws placed on the upper part of the chamber.

### **Replacement of nozzles**

Nozzles of the microblasting tanks are also subject to wear and need to be replaced. To do this, unscrew the ring nut and assemble the new nozzle.

### **Replacement of abrasive media**

To replace used abrasive media, pull the machine forward, lift the internal filtering grid, remove the cap from the bottom of the working chamber and let abrasive flow out, collecting it into a proper container.

### **Replacement of parts subject to wear (pipe, pipe-fittings, microprojector body)**

The polyurethan pipe, the connection fitting and the microprojector body where abrasive flows will inevitably wear out and need to be replaced regularly. To replace the microprojector body, follow the same instructions specified for the nozzle; to replace pipes or pipe-fittings, capsize the unit and work under the container. It is also possible to disconnect each tank for easier operation, simply unscrewing the nuts fixing it to the housing.

### **Replacement of tank internal components**

Should it be necessary to replace the tank internal components like joints, air injectors, abrasive outlet pipe, please contact our Technical Service.

### **Removal of a microblasting tank for repair purposes**

The new tank units have been studied to facilitate your task during installation and removal

1. Unscrew the the feeding pipe ring nut and disconnect the pipe
2. Unscrew the plastic ring nut and detach the microprojector pipe
3. Unscrew the two nuts fixing the tank to the holder, and unclutch the tank.

## 6. TROUBLESHOOTING

### Problem: **THE MACHINE DOES NOT START**

Possible cause	Remedy
Lack of tension	Check: - magnetothermic switch - socket supply switch - fuses of the supply board
Lack of distribution in the machine	Check: - connection to network socket - network fuse Should this malfunction repeat, contact our TECHNICAL SERVICE.

### Problem: **NO LIGHTING**

Possible cause	Remedy
Bad electrical connection	Check that the electrical plug is correctly plugged in.
Shutter is damaged	Check connections and operation (some dust could have oxidized contacts so that they seized up). Try to blow with compressed air and replace if needed.

### Problem: **NO AIR IS COMING OUT**

Possible cause	Remedy
Bad pneumatic connection	Check connection to the compressor.
Internal pipes are clogged	Check connections and condition of pipes up to their end (nozzles).
Air filter is clogged	Check and disassemble, if needed, the moisture collection glass and replace the internal filtering element.

### Problem: **INTERNAL AIR LEAKAGE**

Possible cause	Remedy
Condensate discharge on the filtering unit.	The condensate discharge is carried out by the lifting of a ball cock. A sufficient level of pressure must be provided for the valve to close.
Internal pipes are disconnected	Check the state of the piping. Polyethylene pipes might not be perfectly calibrated; try to cut out a small portion from the end of the pipe and insert it into the pipe-fitting; if needed, replace the pipe.

### Problem: **NO ABRASIVE COMING OUT, INTERNAL LEAKAGE.**

Possible cause	Remedy
Worn pipe-fittings or punched microprojector pipe.	The components of the circuit located after the tank - in which the abrasive circulates - are subject to wear. It is recommended to prevent any possible break by replacing these components each 6-12 months, according to the workload.

Problem: **THE BLASTING JET IS UNSTEADY**

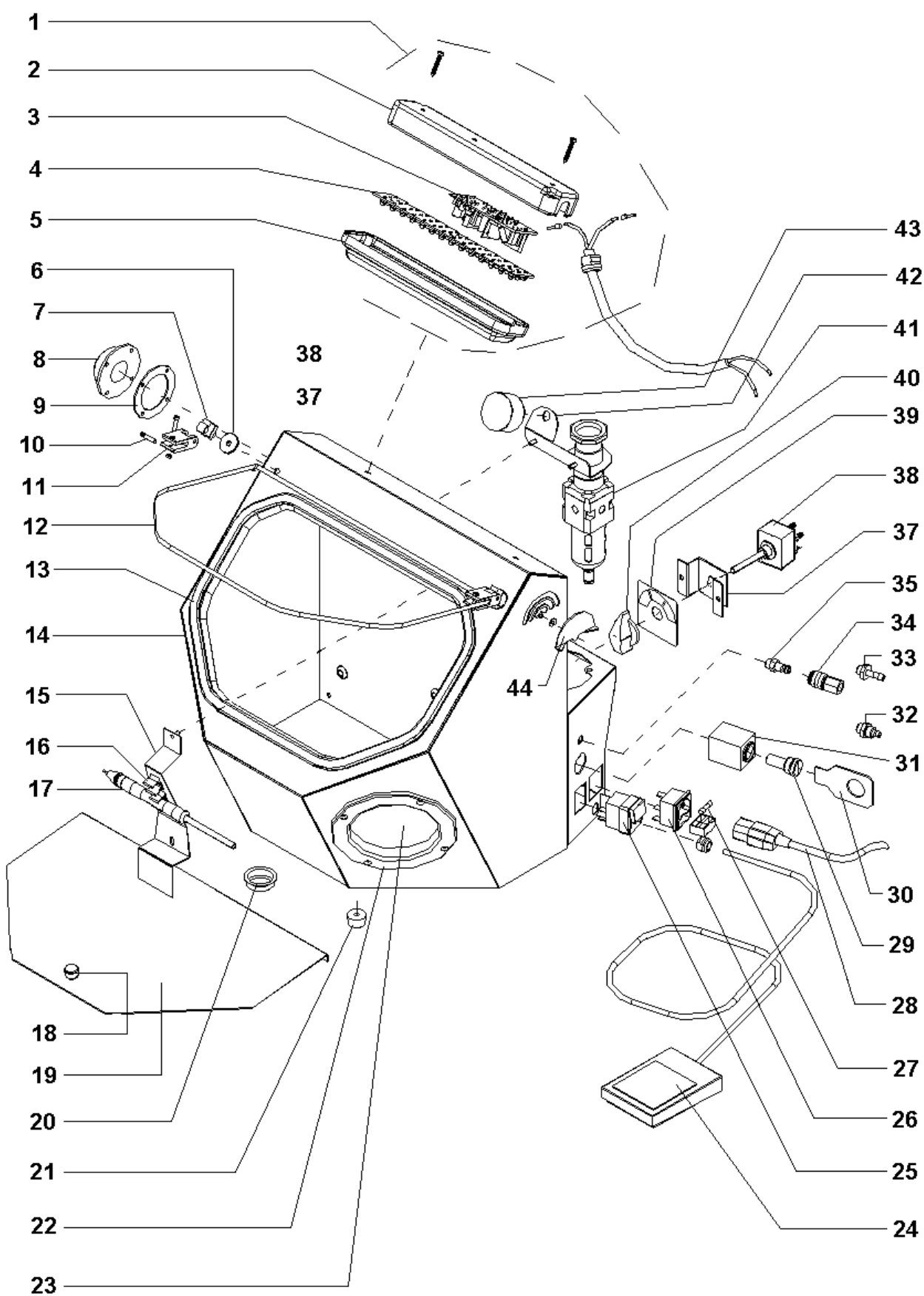
Possible cause	Remedy
Nozzle is clogged or worn out.	Unscrew nozzle fixing nut, clean both the hole and microprojector components (especially the thread) - re-assemble. If necessary, replace the damaged parts.
Microprojector feeding pipe is worn out, bent or clogged	If the pipe is worn out or bent, replace it. If it is clogged, disassemble the nozzle and let air come out.
The abrasive mixture is too rich in aluminium oxide, i.e. loss of sharpness	Abrasive container is overfilled, discharge it. Pipe bending under the containers may collect abrasive at the end of the work, when the valve releases pressure; it is possible to limit this reaction reducing pipe bending.
Damp aluminium oxide causing bad flowing.	Empty the tank, possibly disconnect it from the machine and turn it upside down, blow with clean air in order to dry up all the internal pipings, then heat and dry up the abrasive product and fill in again.
Compressed air filled with condensation or oily particles.	Fine abrasive compounds are particularly sensitive to moisture and, as mechanic pickling agents, they capture polluting agents. Therefore it is important to protect the efficiency of the product installing adequate filtering and drying systems on the air installation.
Grainsize of the aluminium oxide is not compatible with the abrasive metering system inside the container.	Verify compliance with the indications printed on the tank label and with the comparative tables (abrasive grainsize / nozzle diameter / internal dosing system).
The blasting jet is not efficient	Unsufficient pressure. The 5my filter is clogged, unscrew the inspection cap and clean it. The solenoid valve is dirty: get in touch with Dentaform Technical Dept.

Problem: **ABRASIVE TANK IS NOT UNDER PRESSURE**

Possible cause	Remedy
Joints are not perfectly airtight	Check whether cap is correctly tightened. Disconnect the container from the machine, disassemble and clean.

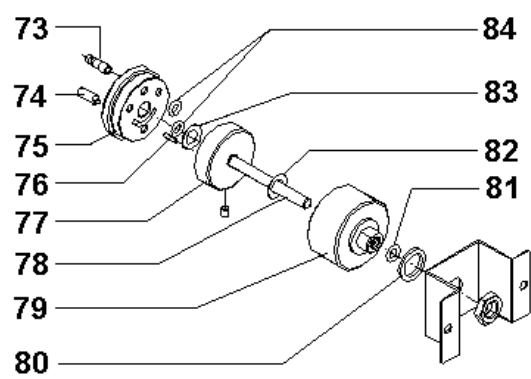
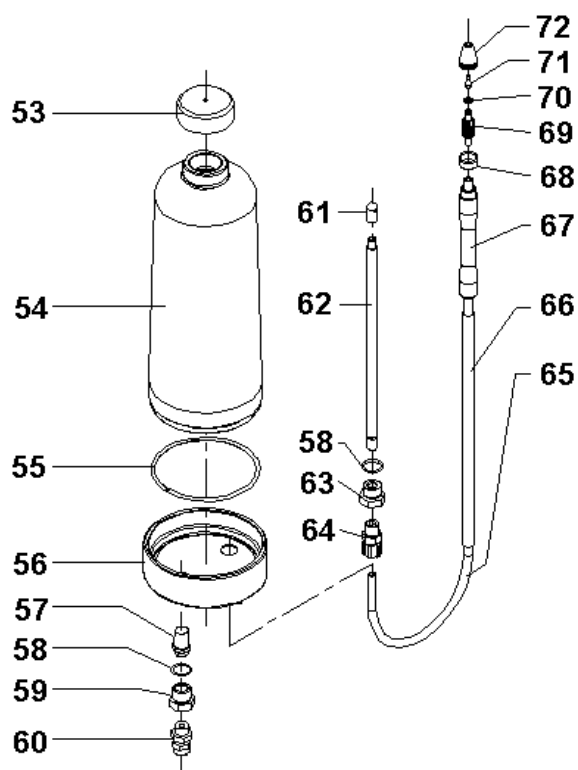
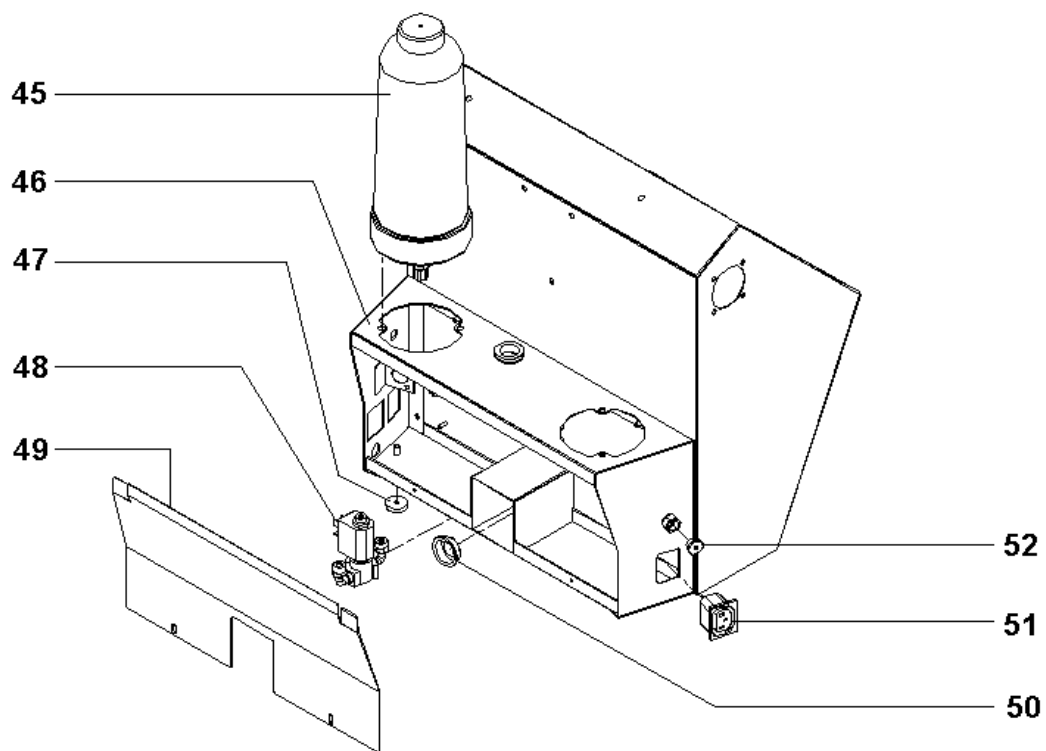
## 7. EXPLODED DRAWING AND SPARE PART LIST MICRA 1-2 table 1

#	CODE	DESCRIPTION
1	<b>1000534</b>	COMPLETE LRD LIGHTING SYSTEM
2	<b>1072037</b>	LIGHTING SYSTEM BASE
3	<b>1072040</b>	ELECTRONIC BALLAST
4	<b>1072041</b>	42 LRD CIRCUIT
5	<b>1072038</b>	LIGHTING SYSTEM COVER
6	<b>1069010</b>	PVC WASHER FOR HINGE
7	<b>1054019A6</b>	HINGE FIXED PART HOLE 6mm
8	<b>RWA007</b>	SUCTION HOSE
9	<b>RWA006</b>	JOINT FOR SUCTION HOSE
10	<b>RMBL028</b>	PIVOT FOR HINGE
11	<b>RCB016A</b>	HINGE MOVABLE PART
12	<b>1073010</b>	MICRA POLYCARBONATE WINDOW
	<b>1000533</b>	CONF. x 6 GLASS PROTECTION SCREEN
	<b>RCB042</b>	PROTECTION SCREEN FIXING CLIPS
13	<b>1064015</b>	GLASS JOINT FOR SANDBLASTERS
14	<b>1073001</b>	MICRA WORKING CHAMBER
15	<b>1073009</b>	MICROPROJECTOR HOLDERS FOR 2 MICROPROJECTORS - MICRA
16	<b>NEA123</b>	CLIP
17	<b>1000605</b>	COMPLETE MICROPROJECTOR (specify color and nozzle)
18	<b>NVT151</b>	MALE KNOB M4x10
19	<b>1073006</b>	ABRASIVE FILTERING GRID
20	<b>NVP030</b>	PLASTIC CAP D.=31
21	<b>NVG049</b>	RUBBER FOOT H=19
22	<b>RCB017</b>	GLOVE FLANGE
23	<b>RMA103</b>	PAIR OF LATEX GLOVES
24	<b>NEC050</b>	ELECTRIC FOOT CONTROL
25	<b>NEC018</b>	PROTECTED BIPOLAR SWITCH
26	<b>NEA046</b>	PLUG AND FUSEHOLDER
27	<b>NEA071</b>	RAPID FUSE 5x20 - 6.3 A
28	<b>NEV013</b>	ELECTRIC CABLE WITH 3x1 PIN/PLUG
29	<b>1072009</b>	CAP WITH 5MY FILTER
30	<b>1072034</b>	KEY FOR 5MY FILTER - BASE/MICRA
31	<b>1072008</b>	FILTER CONTAINER
32	<b>NPR119</b>	STRAIGHT MALE PIPE-FITTING 8x6 1/8
33	<b>NPR220</b>	PIPE-FITTING 7 1/8
34	<b>NPR303</b>	RAPID FEMALE CLUTCH 1/8
35	<b>NPR304</b>	RAPID MALE CLUTCH 1/8
37	<b>1000531</b>	5-WAY SELECTOR SWITCH
38	<b>1069003</b>	SELECTOR SWITCH HOLDER
39	<b>1073008</b>	SELECTOR LABEL
40	<b>NVT141</b>	GRADUATED KNOB
41	<b>NPS029</b>	FILTER + REDUCER 1/8
42	<b>1072026</b>	REDUCER AND MANOMETER ASSEMBLY BASE/MICRA
43	<b>NPS040</b>	0-6 1/8 MANOMETER
44	<b>1072033</b>	CAP FOR SUCTION - BASE/MICRA

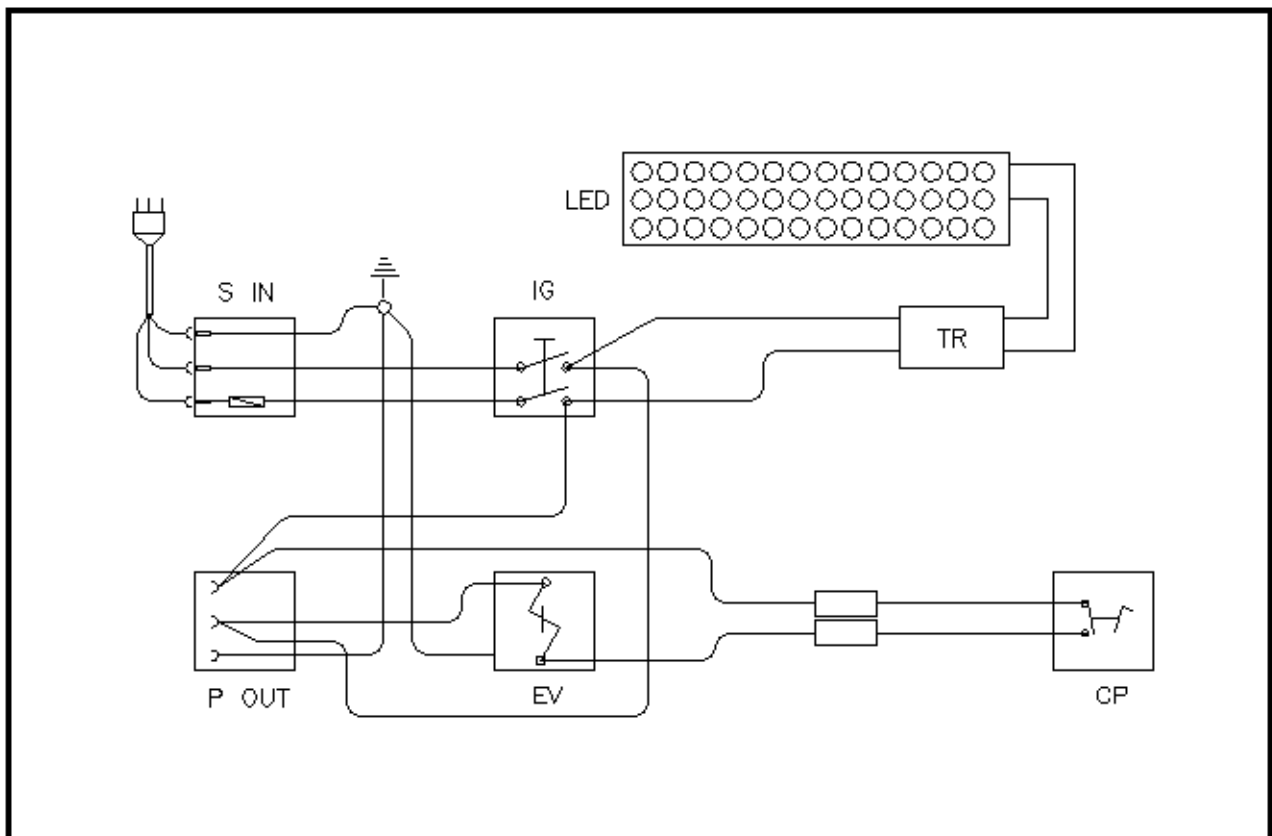


## EXPLODED DRAWING AND SPARE PART LIST MICRA 1-2 - table 2

#	CODE	DESCRIPTION
45	<b>100072N</b>	COMPLETE EASY TANK
46	<b>1073002</b>	TANK SUPPORT
47	<b>NVG048</b>	RUBBER FOOT H=12
48	<b>NES018</b>	3-WAY SOLENOID VALVE 220V
49	<b>1073004</b>	REAR LOCK MICRA 2
50	<b>NVP036</b>	PLASTIC CAP D.=27
51	<b>NEA047</b>	FEMALE SOCKET
52	<b>NPR223</b>	MALE PIPE-FITTING 1/8
53	<b>NVT165</b>	FEMALE CAP G1
54	<b>1072003</b>	COMPLETE ABRASIVE TANK
55	<b>NPOR3300</b>	OR JOINT 3300
56	<b>1072002P</b>	NYLON/GLASS TANK BASE
57	<b>NPV020</b>	SINTERED AIR INJECTOR
58	<b>NPOR2043</b>	OR JOINT 2043
59	<b>1072004</b>	AIR BLOWER PIPE-FITTING
60	<b>NPR111</b>	STRAIGHT MALE PIPE-FITTING 6x4 1/8
61	<b>1072007</b>	TERMINAL CAP ON ABRAISVE PIPE
62	<b>1072006</b>	ABRASIVE OUTLET PIPE
63	<b>1072005</b>	ABRASIVE PIPE ASSEMBLY PIPE-FITTING
64	<b>NPR111P</b>	PLASTIC STRAIGHT PIPE-FITTING M 6x4 1/8
65	<b>NPV042</b>	SOFT POLYURETHAN PIPE 6x4
66	<b>NEV030</b>	SHEATH D.= 6
67	<b>1067005</b>	MICROPROJECTOR ALUMINIUM HANDLE
68	<b>1067022</b>	HANDLE WASHER (SPECIFY COLOR)
69	<b>1067006</b>	MICROPROJECTOR BODY
70	<b>NPOR2012</b>	OR JOINT 2012
71	<b>RMN043</b>	TUNGSTEN CARBIDE NOZZLE D.= 1.2
71	<b>RMN044</b>	TUNGSTEN CARBIDE NOZZLE D.= 0.8
71	<b>RMN045</b>	TUNGSTEN CARBIDE NOZZLE D.= 0.5
71	<b>RMN046</b>	TUNGSTEN CARBIDE NOZZLE D.= 2.0
71	<b>RMN047</b>	TUNGSTEN CARBIDE NOZZLE D.= 1.5
72	<b>1067007</b>	NOZZLE LOCKING RING NUT
73	<b>1049019</b>	PIPE-FITTING
74	<b>1073014</b>	SELECTOR SWITCH LOWER CAP
75	<b>NVT047</b>	HOSE CONNECTOR
76	<b>NVT020</b>	5-WAY SELECTOR CAP
77	<b>1072076</b>	PS RING 8/14/0.2
78	<b>NVT049</b>	STEEL BALL 1/4
79	<b>1073012</b>	SPRING ON SELECTOR BALL
80	<b>NVT034</b>	COMPENSATION RING LMKAS22
81	<b>NPOR2025</b>	5-WAY SELECTOR BODY
82	<b>1073013</b>	PS RING 15/22/0.2
83	<b>NPOR2018</b>	OR JOINT 2025

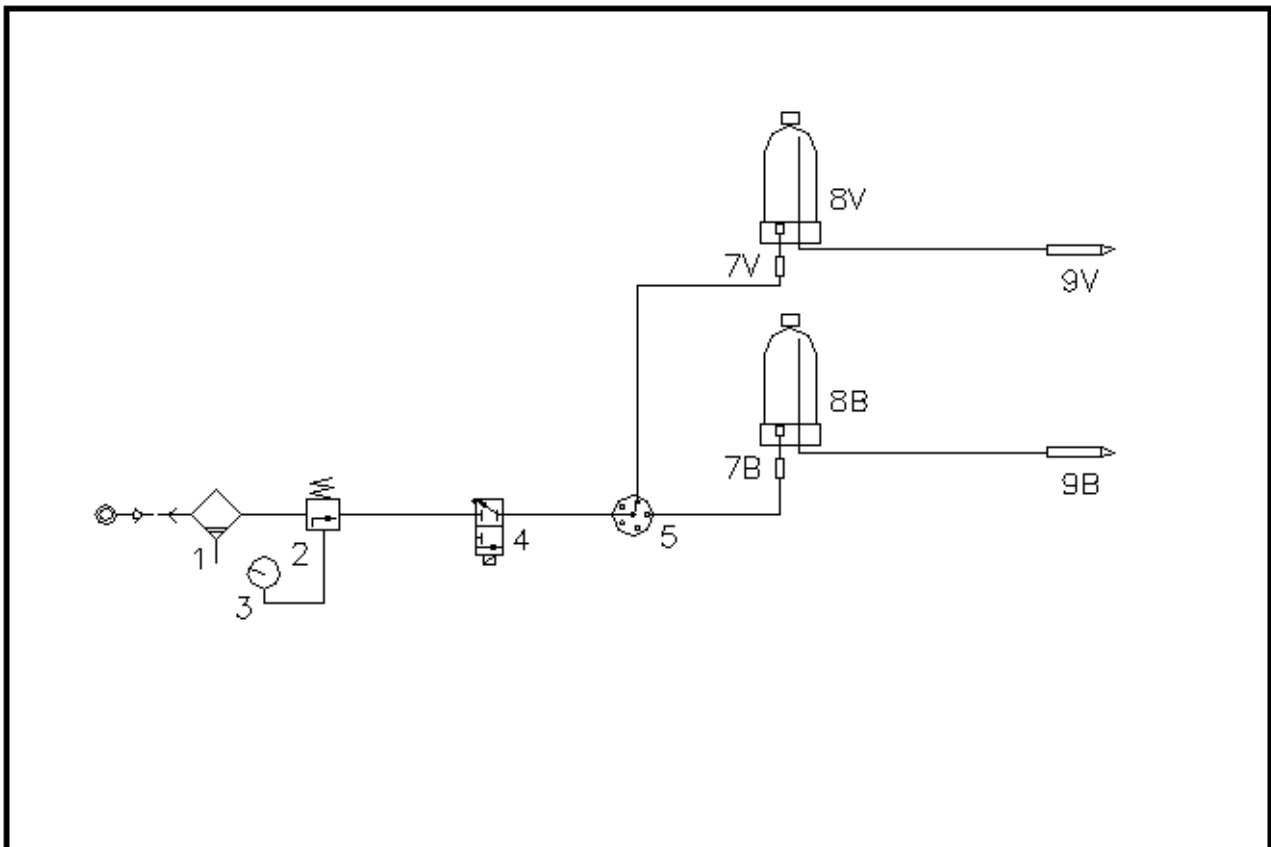


## 8. WIRING DIAGRAM



NO.	DESCRIPTION
<b>S IN</b>	PLUG AND FUSEHOLDER UNIT
<b>IG</b>	MAIN SWITCH
<b>TR</b>	ELECTRONIC BALLAST
<b>LED</b>	LED CIRCUIT
<b>EV</b>	3-WAY-SOLENOID VALVE
<b>CP</b>	ELECTRIC FOOT CONTROL
<b>P OUT</b>	FLUSH-MOUNTED SOCKET for DUST EXTRACTOR

## 9. PNEUMATIC CIRCUIT



NO.	DESCRIPTION
1	AIR FILTER
2	PRESSURE REDUCER
3	PRESSURE GAUGE
4	3-WAY-SOLENOID VALVE – MANUAL BLASTING
5	SELECTOR SWITCH
7	5 MY FILTER
8	MICROBLASTING TANK
9	MICROPROJECTOR

## 10. TECHNICAL DATA

Height	415 mm
Width	410 mm
Depth	315 mm at base – 385 mm overall
Net and Gross weight	11,0 kg – 13,5 kg
Voltage	230 V - 50 Hz (different tensions available on demand)
Absorption	50 W - 1,3 A
Lighting	Energy-saving 42 LED circuit
Dust filtering system	Possibility to add-on the built-in WAFIS system or PRO-3; compatible with traditional extractors


Microblasting pressure	min 1,5 BAR - max 6,0 BAR
Air consumption (Ø0,8mm)	15 l/min at 2 BAR
Air consumption (Ø2,0mm)	120 l/min at 4 BAR
Standard nozzles	2 x Ø 0,8 mm tungsten carbide nozzles
Abrasive grainsize min - max	mesh 270 (50µ) – mesh 60 (250µ)

### **DENTALFARM s.r.l.**

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