

# EXAIR®

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**27**  
CATALOG



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Terms and Conditions ..... 2

**EXAIR Optimization ..... 3**

- Electronic Flow Control ..... 4
- Digital Sound Level Meter ..... 6
- Ultrasonic Leak Detector ..... 7
- Digital Flowmeter ..... 9

**Air Knives ..... 11**

- Super Air Knife ..... 11
- PVDF Super Air Knife ..... 17
- Universal Air Knife Mounting System ..... 20
- NEW** Long Super Air Knife ..... 22
- Standard Air Knife ..... 24
- Full-Flow Air Knife ..... 27

**Air Wipes ..... 29**

- Super Air Wipes ..... 29
- Standard Air Wipes ..... 33

**Air Amplifiers ..... 35**

- Super Air Amplifiers ..... 37
- Adjustable Air Amplifiers ..... 41

**Air Nozzles and Jets ..... 43**

- Air Nozzles ..... 43
- Super Air Nozzles ..... 46
- Air Jets ..... 50
- High Force Air Nozzles ..... 52
- NEW** Large Super Air Nozzles ..... 53
- Super Air Nozzle Clusters ..... 56
- Stay Set Hoses ..... 56

**Atomizing Nozzles ..... 59**

- Internal Mix Narrow Angle Round Atomizing Nozzles ..... 60
- Internal Mix Wide Angle Round ..... 61
- Internal Mix Flat Fan Atomizing Nozzles ..... 62
- NEW** Internal Mix Deflected Flat Fan Atomizing Nozzles ..... 63
- NEW** Internal Mix 360° Hollow Circular Atomizing Nozzles ..... 63
- External Mix Round Atomizing Nozzles ..... 64
- External Mix Narrow Angle Flat Fan ..... 65
- External Mix Wide Angle Flat Fan Nozzles ..... 66
- Siphon Fed Round Atomizing Nozzles ..... 67
- Siphon Fed Flat Fan Atomizing Nozzles ..... 68
- No Drip Internal Mix Narrow Angle Round ..... 70
- No Drip Internal Mix Wide Angle Round ..... 70
- No Drip Internal Mix Flat Fan ..... 70
- NEW** No Drip Internal Mix Deflected Flat Fan ..... 70
- NEW** No Drip Internal Mix 360° Hollow Circular ..... 70
- No Drip External Mix Round ..... 70
- No Drip External Mix Narrow Angle Flat Fan ..... 70
- No Drip External Mix Wide Angle Flat Fan ..... 70
- No Drip Siphon Fed Round ..... 70
- No Drip Siphon Fed Flat Fan ..... 70

**Safety Air Guns ..... 72**

- Chip Shields ..... 73
- Precision Safety Air Guns ..... 74
- NEW** Soft Grip Safety Air Guns ..... 74
- NEW** Heavy Duty Safety Air Guns ..... 76
- Super Blast Safety Air Guns ..... 77

**Static Eliminators ..... 79**

- Super Ion Air Knife ..... 81
- Power Supplies ..... 83
- Standard Ion Air Knife ..... 87
- Ionizing Bars ..... 89
- Super Ion Air Wipes ..... 91
- Ion Air Cannon ..... 93
- Ion Air Gun ..... 95
- Ion Air Jet ..... 97
- Stay Set Ion Air Jet ..... 97
- Ionizing Point ..... 99
- Static Meter, AC Sensor ..... 100

**E-Vac® Vacuum Generators ... 101**

- How to Build an E-Vac System ..... 102
- In-Line ..... 105
- Adjustable ..... 106
- Vacuum Cups ..... 108

**Air Operated Conveyors ..... 112**

- Line Vac ..... 112
- Threaded Line Vac ..... 118
- Heavy Duty Line Vac ..... 120
- Light Duty Line Vac ..... 122

**Industrial Housekeeping ..... 124**

- Reversible Drum Vac ..... 124
- NEW** High Lift Reversible Drum Vac ..... 126
- Chip Trapper ..... 128
- Chip Vac ..... 130
- Heavy Duty Dry Vac ..... 132
- NEW** Heavy Duty HEPA Vac ..... 134
- Vac-u-Gun ..... 136

**Vortex Tubes & Spot Cooling . 138**

- Vortex Tubes ..... 138
- Adjustable Spot Cooler ..... 146
- Mini Cooler ..... 149

**Cold Gun Aircoolant Systems . 150**

**Cabinet Cooler® Systems ..... 154**

- NEMA 12, 4 and 4X ..... 156
- Electronic Temperature Control ..... 159

**Accessories ..... 163**

- Filters ..... 163
- Regulators ..... 164
- Silencing Mufflers ..... 165
- Receiver Tank ..... 166
- Valves, Swivels, Thermostats ..... 167
- Magnetic Bases, Stay Sets, Hoses ..... 168

**Page 3 EXAIR Optimization**  
Minimize Compressed Air Use and Detect Wasteful Leaks

**Page 11 Air Knives**  
Blowoff, Clean, Dry and Cool with Less Noise and Air Consumption

**Page 29 Air Wipes**  
Blowoff, Dry, Clean and Cool Pipe, Cable, Extruded Shapes and Hose

**Page 35 Air Amplifiers**  
Vent, Exhaust, Cool, Dry and Clean - with No Moving Parts

**Page 43 Air Nozzles and Jets**  
Reduce Noise Levels and Air Costs on Blowoff Operations

**Page 59 Atomizing Nozzles**  
All Stainless Steel Construction for Durability and Corrosion Resistance!

**Page 72 Safety Air Guns**  
Safety Air Guns Use Engineered Air Nozzles for High Performance

**Page 79 Static Eliminators**  
Eliminate Static Electricity, Dust and Shock Hazard

**Page 101 E-Vac® Vacuum Generators**  
Vacuums for Lifting, Clamping, Mounting and Placement

**Page 112 Air Operated Conveyors**  
Convey Parts, Materials and Waste - with No Moving Parts

**Page 124 Industrial Housekeeping**  
Reliable Vacuums for Chip Removal, Liquid Transfer and Cleaning

**Page 138 Vortex Tubes and Spot Cooling**  
Cold Air for Industrial Spot Cooling Problems

**Page 150 Cold Gun Aircoolant Systems**  
Cool Machining Operations with Clean, Cold Air

**Page 154 Cabinet Cooler® Systems**  
Cool and Purge NEMA 12, 4 and 4X Electrical Control Panels

**Page 163 Accessories**  
Mufflers, Filters, Regulators, Valves, Swivel Fittings and More

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**Reach:** Per Regulation (EC) No 1907/2006 Title I, Article 3, paragraph 3, the European Union has recently enacted legislation to register chemicals and substances imported into the EU to ensure a high level of protection of human health and the environment.

Per Title II, Article 7, paragraph 1, articles (products) must be registered when a substance is intended to be released under normal or reasonably foreseeable conditions of use and it is present in those articles in quantities totaling over 1 metric ton per producer or importer per year. Registration of EXAIR products is not required since they do not contain substances that are intentionally released.

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Intelligent Compressed Air® products are identified throughout this catalog that can help your plant save tens of thousands of dollars over the course of a single year. *The Best Practices for Compressed Air Systems* manual published by the Compressed Air Challenge® recommends products like the Super Air Knife™, Super Air Amplifier™, and the family of Super Air Nozzles™ for energy conservation. Many of the products shown offer unique ways to solve common industrial problems using compressed air. Compressed Air Challenge is a registered trademark of Compressed Air Challenge, Inc.



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EXAIR products are subject to ongoing development. Specifications are subject to change without notice.

Some products in this catalog are covered by U.S. Patent #5402938, #8153001 and #8268179 and others may be U.S. Patent Pending.

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## Cold Gun Aircoolant System™



Replace messy mist systems - improve dry machining with clean, cold air!

### What Is The Cold Gun Aircoolant System?



A new solution to an old problem. Heat build up on dry machining operations reduces tool life and machining rates. The Cold Gun Aircoolant System produces a stream of **clean, cold air at 50°F (28°C) below supply air temperature. Operation is quiet and there are no moving parts to wear out.** It will remove heat to prolong tool life and increase productivity on machining operations when liquid coolants cannot be used.

The Cold Gun is also an alternative to expensive mist systems. It eliminates the costs associated with the purchase and disposal of cutting fluids and worker related health problems from breathing airborne coolants or slipping on wet floors.

**EXAIR's Cold Gun is non-adjustable to prevent freeze-up during use. Cold airflow and temperature drop are factory set to optimize the gun's cooling capability.**



The Model 5215 Cold Gun keeps the part cool to the touch and prevents discoloration.



Cold air eliminates heat cracking of the carbide tool during sharpening.



The Model 5315 Cold Gun cools a two flute 3/8" carbide cutter on a CNC, increasing tool life by 50%.

### Applications

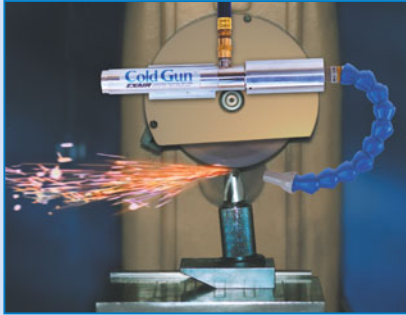
- Tool sharpening
- Drill and cutter grinding
- Routing
- Plunge and form grinding
- Milling
- Surface grinding
- Drilling
- Tire grinding
- Band sawing
- Plastic machining
- Laser cutting
- Chill rolls
- Setting hot melt adhesives

### Advantages

- Improves production rates
- Prevents burning
- Extends tool life - reduces breakage
- Improves tolerance control
- Prevents smearing of metal or plastics
- Finished part is dry
- Eliminates wheel loading
- Low cost
- Compact, lightweight, portable
- No moving parts - maintenance free
- Quiet
- No coolant cost
- No electricity

Cold Gun Air Coolant System

## Applications



Model 5215 Cold Gun System

### Tool Grinding

Cold air eliminates heat cracking of carbide and tool edge burning during grinding and sharpening operations. Increased tool life between regrinds is the result.



Model 5215 Cold Gun System

### Milling & Drilling

Fly cutters up to 460mm in diameter have been cooled with the Cold Gun. Dissipating heat with cold air extends tool life, increases speeds and feeds, and improves finishes.



Model 5315 Cold Gun System

### Chill Roll

Cooling a roll with 20°F (-7°C) air keeps the material on the surface from bunching up, jamming or tearing. The metal surface transfers the cold temperature to the product.



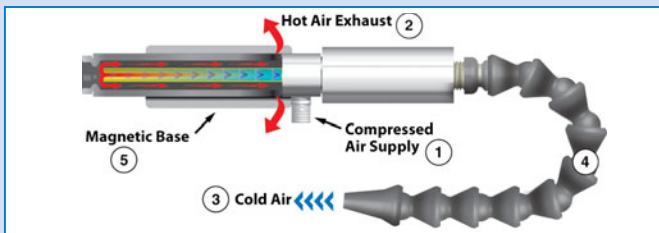
Model 5230 High Power Cold Gun System

### Laser Cutting

Cold air cools a laser cut part so it can be handled seconds later. The High Power Cold Gun has twice the cooling capacity of the standard Cold Gun, cooling the part in less time.

# Cold Gun Aircoolant System

## How The Cold Gun Works

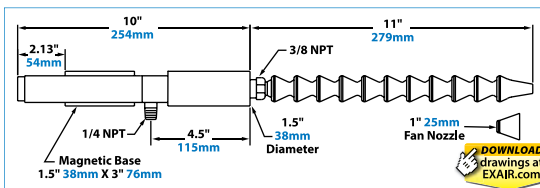


The standard Cold Gun and High Power Cold Gun incorporate a vortex tube to convert an ordinary supply of compressed air (1) into two low pressure streams, one hot and one cold. (For complete information on vortex tube operation, see page 139 of this catalog.) The Cold Gun's hot airstream is muffled and discharged through the **hot air exhaust** (2). The cold air (3) is muffled and discharged through the **flexible hose** (4), which directs it to the point of use. Easy mounting and portability are provided through the use of an attached **magnetic base** (5).

## Specifications

Model #	Pressure Supply		Air Consumption		Sound Level
	PSIG	BAR	SCFM	SLPM	dBA
<b>Cold Gun 5215, 5315</b>	100	6.9	15	425	70
<b>High Power Cold Gun 5230, 5330</b>	100	6.9	30	850	82

## Cold Gun Dimensions



DOWNLOAD drawings at EXAIR.com

## Controlling the Cold Air

The EXAIR Cold Gun gives **instant cold air** when filtered compressed air is supplied to it. Cycling on and off is a good way to save air. **For on and off control**, use a Model 9012 Manual Shutoff Valve. To turn the Cold Gun on with the machine, the Model 9020 Solenoid Valve may be used and wired through the machine control switch. This method is ideal for hand grinders and drill sharpeners.

## The Compressed Air Supply

The Cold Gun is designed to use full line pressure of 80-100 PSIG (5.5-6.9 BAR). Temperature drop and flow are reduced when lower input pressures are applied. The use of clean, filtered air is essential to the operation of the Cold Gun. A filter separator that removes moisture, dirt and other particulates from the compressed air is included with each Cold Gun System. An optional Oil Removal Filter is also available. (See page 163 for details.)

## Need More Cooling?

EXAIR's High Power Cold Gun Aircoolant System™ produces twice the airflow of the standard Cold Gun, doubling the cooling capability. It produces cold air at 50°F (28°C) below the supply air temperature so the air is as cold as possible without freezing up. Two systems are available: the Model 5230 High Power Cold Gun with Single Point Hose Kit and Model 5330 High Power Cold Gun with Dual Point Hose Kit.

## Selecting The Right Model

Cold Gun Aircoolant Systems are available with either a Single Point or Dual Point Hose Kit.



**The Single Point Hose Kit** (included with the Model 5215 Cold Gun and Model 5230 High Power Cold Gun) is recommended for applications where a concentrated airflow is needed such as drilling and grinding operations.

**The Dual Point Hose Kit** (included with the Model 5315 Cold Gun and Model 5330 High Power Cold Gun) is recommended for applications where the heat is generated over a larger surface area such as band sawing, milling, chill rolls and hot melt adhesives.

A Cold Gun System with the Model 5901 Single Point Hose Kit can be easily converted to a "dual point" system with the purchase of the Model 5902 Dual Point Hose Kit.

# Cold Gun Aircoolant System

## Purdue University Study Confirms Benefits Of The EXAIR Cold Gun

Tooling costs a lot of money to replace. That's only part of the problem. As the tools wear out, you can expect:

- Slowed production and downtime to change out the tooling
- Poor tolerances and dimensional accuracy due to increased temperature
- Increased cutting force is required (generates more heat and uses more electricity)

If you could just make the tooling last longer, you'd not only cut the tool cost but could increase profits by reducing scrapped parts and downtime.

A long term study on the effect of refrigerated air on tool wear in wood machining was conducted at the Forestry Products Department of Purdue University by Ms.

Judith Gisip. The project was under the direction of Dr. Rado Gazo (department professor) and Harold Stewart



Purdue's CNC router turns (22) 4'x8' sheets into sawdust.

EXAIR's Cold Gun is mounted under the protective guard.

Cold air from EXAIR's Model 5315 Cold Gun System keeps the tooling cool.

(professor at North Carolina State University with 35 years in wood machining research). Wood is brutal on tooling. In metalworking, most of the heat goes away with the machined chip. Wood is an excellent insulator and doesn't conduct the heat away, which keeps it all there at the tool. Temperatures can exceed 1472°F (800°C)!

The extensive tests at Purdue were conducted in a 70°F climate controlled room. They tested (4) 1/2" (12.7mm) two-flute cutters on a CNC router at 16,000 rpm. (22) sheets of 3/4" thick MDF (medium density fiberboard) were fed one at a time, cutting away 1/4" (6mm) depth of cut on each pass. Power consumption of the CNC was recorded (current draw increases as the tool starts to dull). When finished, the surface of the tools was examined using a scanning electron microscope. Machining with the Cold Gun's 20°F air reduced tool wear by over 21% compared to the results with no cooling.

For complete details of the Purdue study, visit our web site at [www.exair.com/purdue.htm](http://www.exair.com/purdue.htm).

### How Much Can You Save?

- A 1/2" two flute router bit for wood is approximately \$67.
- The 21% reduction in tool wear when using a Cold Gun is  $\$67 \times 0.21 = \mathbf{\$14.07 \text{ savings per bit.}}$
- If you use (1) router bit per working day, the savings is  $\$14.07 \times 5 \text{ working days} = \mathbf{\$70.35 \text{ per week} / \$3,658 \text{ per year}}$  For One Bit!

## Cold Gun Aircoolant Systems



### Model 5215 Cold Gun System (one cold outlet)

includes Cold Gun, Single Point Hose Kit, 3/8" (10mm) Cone Nozzle, 1-1/4" (32mm) Fan Nozzle, Manual Drain Filter Separator.



### Model 5315 Cold Gun System (two cold outlets)

includes Cold Gun, Dual Point Hose Kit, (2) 1/4" (6mm) Cone Nozzles, (2) 1" (25mm) Fan Nozzles, Manual Drain Filter Separator.



### Model 5230 High Power Cold Gun System (one cold outlet)

includes High Power Cold Gun, Single Point Hose Kit, 3/8" (10mm) Cone Nozzle, 1-1/4" (32mm) Fan Nozzle, Automatic Drain Filter Separator.



### Model 5330 High Power Cold Gun System (two cold outlets)

includes High Power Cold Gun, Dual Point Hose Kit, (2) 1/4" (6mm) Cone Nozzles, (2) 1" (25mm) Fan Nozzles, Automatic Drain Filter Separator.

Dual Point Hose Kit is recommended when heat is generated over a larger surface area.

### Accessories and Components

Model #	Description	Model #	Description
5015	Cold Gun Only	9005	Oil Removal Filter, 3/8 NPT, 15-37 SCFM (425-1,048 SLPM)
5030	High Power Cold Gun Only	9012	Manual Shutoff Valve, 1/4 NPT
5901	Single Point Hose Kit (Included with 5215 and 5230)	9020	Solenoid Valve (120V, 50/60Hz), 1/4 NPT, 40 SCFM (1,133 SLPM)
5902	Dual Point Hose Kit (Included with 5315 and 5330)	9021	Solenoid Valve (200-240V, 50/60Hz), 1/4 NPT, 40 SCFM (1,133 SLPM)
9003	Manual Drain Filter Separator, 1/4 NPT, 27 SCFM (765 SLPM)	9031	Solenoid Valve (24VDC), 1/4 NPT, 40 SCFM (1,133 SLPM)