

# TROUBLESHOOTING THREE BLASTCLEANING VARIABLES

## *BLAST-PATTERN, OPERATING MIX, ABRASIVE FLOW*

### **I. BLAST-PATTERN**

1. Inspect wheel parts daily for wear.
  - Impeller - change when segments are worn 1/8".
  - Control Cage - change when beveled edge is worn 1/4".
  - Blades/Vanes - change when worn to 1/2 their thickness.
2. Check blast-pattern (hot spot) regularly.
  - Blast the test plate at normal work height for 20 to 30 seconds.
  - Adjust hot spot approximately 8" in advance of wheel center line.
3. 2% sand and fines in the abrasive operating mix will increase wear on wheel parts 50%.
4. Maintain records of parts replacement by wheel hours so that a preventive maintenance program can be established.

### **II. OPERATING MIX**

1. Add new abrasive each work shift. Keep storage hopper 1/2 to 2/3 full.
2. Screen abrasive operating mix weekly.
3. Add back to machine each work shift abrasive that has leaked out.
4. Inspect air wash separator each work shift.
  - Scalping Screen - holes, flights and blockage.
  - Shed Plate - full abrasive curtain, holes.
  - Dribble Pipe - dribble valves in working order.
  - Usable abrasive in dribble pipe waste.
  - Dust collector pipes - inspect for dust, abrasive build-up and holes.
5. Inspect separator and dust collector baffles for proper settings and wear.

### **III. ABRASIVE FLOW - Low Wheel Amps**

1. Clean out scalp screens each work shift.
2. Inspect wheel parts daily for wear.
3. Inspect abrasive feed control valve for proper abrasive flow. Excessive abrasive will flood wheel and lower wheel amps.
4. Inspect for loose and missing drive belts.
5. Show proper full load amps above each ammeter. Record ammeter reading each work shift.
6. Check ammeter calibration monthly.