OWNER'S MANUAL

SINGLE CHAMBER BLAST MACHINES
ABSC-24524

IMPORTANT WARNING FOR SAFER BLAST CLEANING

1. Use protective equipment: Abrasive-resistant clothing, safety shoes, leather gloves, ear protection, CE-approved air-fed helmet. Air for helmet must be supplied by a breathing air compressor or through a helmet air filter.
2. Check for possible silicosis hazards. Avoid dust.
3. Do not blast with damaged or worn equipment.
4. Point nozzle only at area being cleaned.
5. Use only proper dry and well-screened abrasives specifically intended for blasting.
6. Keep unprotected workers out of the blast area.
7. Before blasting:
   - Check fittings and hose for wear.
   - Safety-wire couplings together.
   - Check helmet filters and air supply.
   - Check pop-up valve for alignment.
   - Test remote controls.
   - Make sure blast machine is adequately grounded.
8. Do not weld on blast machine, this voids approval.
9. Do not substitute Blastrite parts or modified equipment in any way.

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SINGLE CHAMBER BLAST MACHINES
ABSC- 2454

1.0 INTRODUCTION: This manual covers the set-up, maintenance of the following pressure type of blast machines.

BLASTRITE model	CAPACITY	
	ltr.	lbs.
ABSC-2452	200	600

See page 4 for all basic components of the ABSC-Model single chamber blast machines.

2.0 OPERATION SET-UP

2.1 Set-up

The set-up procedure for manual controlled blasting (without the use of a remote control system) is as follows:

a. Make sure that the compressor is located upwind from the blasting area. Start the compressor and bring it up to operating pressure and temperature before beginning the blast cleaning operation.
b. Open the bleed-off and choke valves (handles in parallel position with piping).
c. Close the air inlet valve at the abrasive valve. Closed grit metering valve.
d. Connect the compressed air line to the air inlet valve (minimum 1¼" ID air line for optimum blast cleaning performance).
e. Connect the blast hose quick connect coupling to the machine quick coupling. Check condition and proper placing of the rubber coupling gaskets.
f. Fill the concave head of the machine with abrasive. The abrasive will pass the filling port into the machine.
g. Put on all protective clothing.

2.2 Operation:

To blast clean, the machine tender:

a. Puts pressure to the air line of the blast machine.
b. Closes the bleed-off valve.
c. Opens the air inlet valve, when the blasting operator signals that he is ready. This causes sealing of the filling port by the pop-up valve and the blast machine will pressurize. Only air will come out of the nozzle.
d. Adjusts the abrasive metering valve for proper air/abrasive mixture. **General rule:** use as little abrasive as possible. The abrasive stream coming out of the blast nozzle should hardly discolor the air when seen against whatever light source.
e. Closes the air inlet valve and quickly opens the bleed-off valve to stop blasting.

2.3 Shut-down

When shutting down for the day: empty the blast machine of all abrasive by removing the nozzle and putting the blast hose in a suitable waste container. Close the choke valve and put the handle of the abrasive valve in full open position. Then put pressure to the machine by opening the air inlet valve.

The blast machine should be covered if left out at site, in order to prevent moist abrasive to cause trouble when starting up blasting again.

USE ONLY ABRASIVE SPECIFICALLY MEANT FOR BLASTING, NEVER USE UN-SCREENED OR MOIST ABRASIVES.

3.0 MAINTENANCE

3.1 Replacement of the Pop-up valve

Remove the inspection door assembly in order to get access to the Pop-up valve. Unscrew the Pop-up guide (page 2, item 20) by counter-clockwise turning. Remove both Pop-up valve and guide from the blast machine. Put the new Pop-up valve in the valve guide and then install them inside of the machine.
It is recommended to replace the inspection door gasket at the same time.
Do not forget to tighten the inspection door assembly back onto the machine.

3.2 Replacement of the Pop-up O-ring

Put your fingers between the Pop-up O-ring and the retainer and slowly remove the old O-ring. If necessary, use a screwdriver.
Push the new Pop-up O-ring trough the filling port and fit it into the retainer.
Pull up on the O-ring in order to get it into position.

4.0 TROUBLESHOOTING

4.1 Blockages

If neither abrasives nor air comes out of the blast nozzle, first depressurize the machine and then check if the nozzle is clogged. If only air comes out and no abrasive, fully open the abrasive valve and then quickly open and close the choke valve. If this fails, depressurize the machine, remove the inspection door assembly and check the inside of the machine for foreign objects (paper, etc.).

4.2 Abrasive surge

When starting up, surge of abrasive is normal

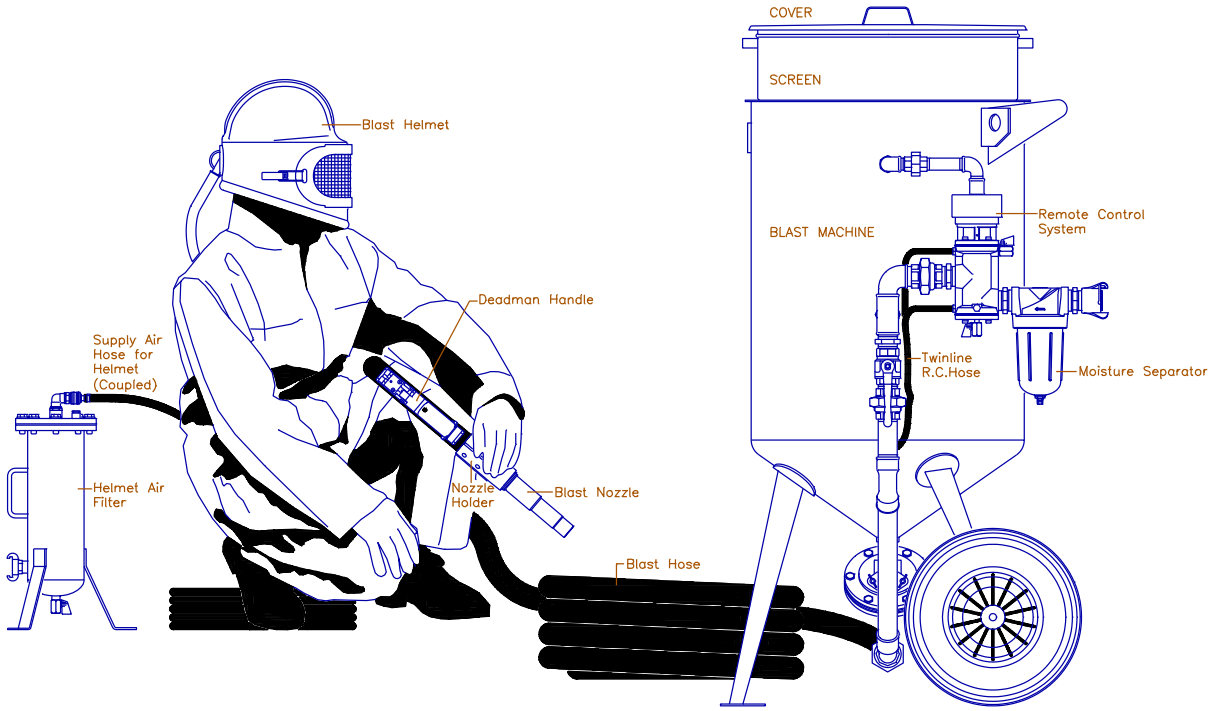
to some extend. However, if the abrasive surge should continue, the flow of abrasive can usually be stabilized by the quick opening and closing of the choke valve.

An intermittent abrasive flow is sometimes caused by an excess of moisture in the blasting system. This problem in practice can be solved by installing a moisture/water separator in the air line, closest to the machine as possible.

4.3 Removal of moist abrasive

In order to remove moist abrasive from the system, the blast hose has to be disconnected and the rubber gasket in the quick coupling on the machine has to be removed. The next step is to close the choke valve and open the abrasive valve. Force out any moist abrasive by pressurizing the machine.

See separate Instruction-Parts List for Remote Control Systems.



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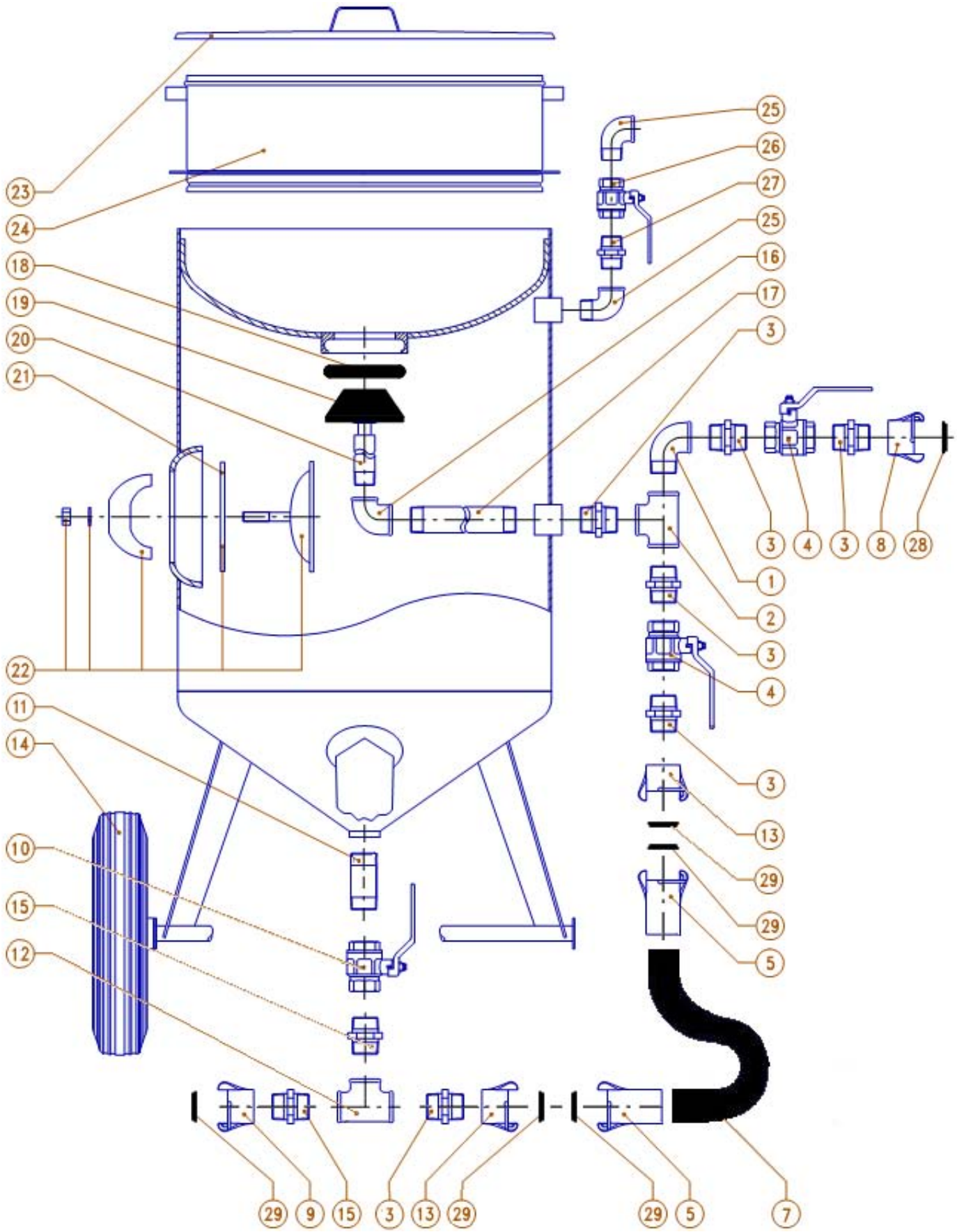

5.0 SPARE PARTS – 2454 (Manual)

	ART.NR.	MODEL	DESCRIPTION				
	8011501	2454 Manual	200 litre Manual Pot complete (excl. Items 23 &24)				
01)	21996		Elbow 1¼”	FM	no.	92	(1)
02)	22116		T-piece 1¼”	FFF	no.	130	(1)
03)	22256		Hex nipple 1¼”	MM	no.	280	(4)
04)	11930	P-10	Air valve 1¼”				(2)
05)	21520	CQN - 2	Nylon Hose Coupling (48 mm OD Hose, 1¼")				(2)
06)							
07)	25140	32x8 (1m)	1¼" Blast Hose (32 mm ID , 48 mm OD				(1)
08)	21630	CFT	Coupling 1¼” incl. gasket				(2)
09)	21631	CFN	Nylon 1¼" thread				(1)
10)			Metering Valve Ball Type 1 ¼”				(1)
11)	10460	P-31	Pipe 1¼” x 100 mm rubber lined				(1)
12)	10441		T-piece 1¼” rubber lined				(1)
13)	21630	CFT	Coupling 1¼” incl. gasket				(2)
14)	10680		Wheel required for (200 L				(2)
15)	10450	P-32	Hex nipple 1¼” rubber lined				(2)
16)	22596		Elbow 1¼” x 1”	FF	no.	90	(1)
17)	10270		Inner pipe 1¼” for 2452 (200 L				(1)
18)	11920	P-5	Pop-up O-ring				(1)
19)	11880	P-2F	Pop-up valve with shaft, flat				(1)
	11881	P-2R	Pop-up valve with shaft, round				(1)
	11890		Pop-up valve only, flat				
	11891		Pop-up valve only, round				
	11900		Washer 21 mm				
	11910		Pipe ½” x 165 mm				
20)	10500		Pipe 1” for 2454 & 2452 (200 L)				(1)
21)	10470		Inspection door gasket				(1)
22)	10480		Inspection door assy				(1)
23)	10590		Cover for 2452 & 2454 (200 L)				(1)
24)	10550		Screen for 2452 & 2454 (200 L)				(1)
25)	21995		Elbow 1”	FM	no.	92	(2)
26)	11130		Air valve 1”				(1)
27)	22255		Hex nipple 1”	MM	no.	280	(1)
28)	21650	CQG	Rubber coupling gasket				(2)
29)	21652	CQG – 2	Rubber coupling gasket				(5)

All (*)-marked items are included in Pot Service Kit(art.nr xxxxx) in quantities shown ( ).

NOTES:

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