



METALTEC STEEL ABRASIVE CO.

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TROUBLE SHOOTING - THREE BLAST CLEANING VARIABLES: BLAST-PATTERN, OPERATING MIX AND ABRASIVE FLOW

I. BLAST-PATTERN

- 1.** Daily inspect wheel parts 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 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 preventative 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.
 - Too much 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.