



# INTERNATIONAL MARKETING, INC. TECHNICAL BULLETIN

**SUBJECT: 2020 Blaster Maintenance Guidelines**

**DATE: December 26, 2002**

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## 2020 BLASTER MAINTENANCE GUIDELINES

### Daily

- Check and clean out screens (inside lower blast cabinet and upper hopper).
- (Opened door) General wear inspection – a flash light, work or trouble light should be used:
  1. Mill rollers
  2. Cast protection plates
  3. General wear plates
  4. POD liners
  5. Door liners and seals
  6. Guide collars
  7. Make sure photo eye and reflector are clean
  8. Make sure cylinder movements are clean
  9. Make sure protection trays are full of shot/grit blast media
- (Closed door) General Operation Inspection
  1. Check amp readings on motors – add any needed media
  2. Check touch pad operation
  3. Report any indicator lights
  4. Perform any indicated maintenance alerts
  5. Note and report any shot leakage
  6. Note and report any unusual sound changes
- Operational Tips
  1. Keep the mix flowing – add back any shot/grit removed from the blaster plus an additional ½ - 1 pound of media per wheel. *\*Media should be added at regular intervals throughout the day to maintain the correct amp reading on the Blast module. Suggested: every five wheels (2.5 lbs.) or every ten wheels (5 lbs.).*

NOTE: Always use the recommended blast media and procedures above. Be careful not to overload and NEVER USE 460/550 shot.
  2. Keep oil, dirt and heavy grease out of the blaster – remove all grease from wheels before blasting.
  3. Remove valve stem and hardware prior to blasting.
  4. Keep area swept up from shot blast media spills.

5. Report any changes in the performance of the machine (lack of cleaning, drop or raise in amp reading, unusual noises, empty protection trays, obvious wear, etc.).
6. Dispose of the dust from the Dust Collector daily.

NOTE: Replace any leaking seals or worn protection plates before they become bigger problems.

### **Weekly**

- Check and clean out screens (inside hopper and upper hopper – *do not remove the elevator hopper screen*).
- Check condition of the working mix in upper hopper to make sure it is clean.
- Check elevator power unit and elevator belt alignment.
- (Opened door) General Wear Inspection – (just like daily) – use silicone caulk in all gapped areas for general protection (allow for 24-hour cure time).
- Replace or reinforce any worn protection plates as needed.
- (Closed door) General Operation Inspection
  1. Check operation control panels for proper function.
  2. Perform any indicated maintenance alerts.
  3. Check for any shot leakage and repair as needed.
  4. Note and report any unusual sound changes.
  5. Check Magnahelic gauge on Dust Collector (note reading).
- Remove all dust, debris and loose shot blast media from machinery, trays and the work area (general housekeeping).

NOTE: Log all maintenance performed with date and hour meter readings.

### **POWDER BOOTH AND APPLICATOR MAINTENANCE GUIDELINES**

Note: The key to a properly maintained system is “clean and adjusted”.

- DO NOT allow powder to pile up in the booth. Remove daily.
- DO NOT allow the gun system to get covered with powder.
- DO NOT spray powder outside the booth or without the booth running.
- DO NOT clean up the gun system outside the booth or without the booth running.
- DO NOT allow the powder to build up on any areas or machinery outside the booth.
- DO NOT operate the gun without the proper settings (refer to operation manual) and without the booth operating.

## **Daily**

1. Make sure gun is kept clean and operating properly.
2. Make sure filters in booth have been “blown down” and relatively clean.
3. Make sure “Block” filters are clean and dry.

NOTE: There should be no moisture on the wheels, in the powder, or going through the gun system.

4. Make sure all ground wires are secure and hooks clean.
5. Clean gun and booth at the end of day or at color changes.
6. Use the vibrator only when spraying with the gun or powder will pack too tight to spray.

NOTE: Pneumatic vibrator only operates when gun is triggered. Electric vibrator must be turned on when spraying and off when not spraying.

- \*\* The operator should not be experiencing electrical shocks while operating the gun system and this should not be checked immediately.
- \*\* The operator should be “bare palmed” or “bare handed” when using applicator gun – NO GLOVES should be worn.
- \*\* The operator should not hold or touch the monorail, trolley/hook, or wheel while applying the powder.

## **OVEN AND POWERED MONORAIL MAINTENANCE GUIDELINES**

- Keep the parabolic reflectors clean and free from dust.
- Replace any “burned out” ceramic generators.
- Keep external baffles clean and dust free.

NOTE: Dirty reflectors and burned out generators will drop the efficiency of the oven, drastically affecting the overall cure cycle.

- Keep the monorail clean and free from loose dirt that could drop on the finished wheels.
- DO NOT lubricate the monorail track.
- Keep trolleys clean and free of steel shot or grit.
- DO NOT store trolleys in areas contaminated by shot blast media and dirt (example: under the blaster tray table).
- DO NOT over lubricate trolleys.

**Questions regarding the above technical bulletin may be directed to:**

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