

STANDARD LINE MACHINES
MODELS 50SP, 100SP, 200SP, 250SP, 300SP, 450SP,
OPERATING INSTRUCTIONS - MANUAL CONTROL

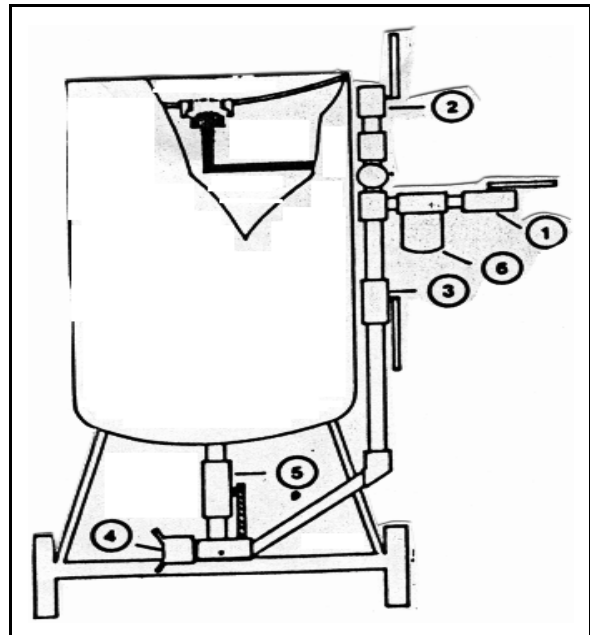
IMPORTANT: CURRENT OSHA REGULATIONS REQUIRE, AND WE RECOMMEND, THAT ALL BLAST CLEANING MACHINES ARE EQUIPPED WITH REMOTE CONTROL SYSTEMS THAT CONTROL OPERATION OF THE MACHINE AT THE NOZZLE. THESE INSTRUCTIONS ARE ONLY TO ASSIST IN UNDERSTANDING THE OPERATION OF THE MACHINES.

INITIAL SETUP

- 1.) Close inlet valve (1) and exhaust valve (2) as shown on diagram below. Be certain choke valve (3) is open as shown below. Choke valve use, a very important part of machine operation, is explained in detail below.
- 2.) Connected air line to inlet valve (1) using non restrictive couplings and air hose with an I.D. at least the size of the machine piping.
- 3.) Set Econoblast mixing valve (5) midway between open and closed. This adjustment is preliminary and will usually have to be reset in operation.
- 4.) Insert ceramic nozzle with desired orifice into the aluminum retaining coupling at the end of the hose.
- 5.) Fill machine with dry, clean abrasive free of dirt and debris. As a general rule we do not recommend pressure blasting with abrasive finer than 100 mesh. DO NOT OVERFILL, doing so may damage the automatic sealing system.

TO OPERATE

- 1.) Direct nozzle end of hose in a safe direction.
- 2.) Turn on air supply from the compressor.
- 3.) Begin blasting by opening the air inlet valve (1).
- 4.) Adjust Econoblast abrasive regulator to desired setting. For most work you should barely see the abrasive as it is discharged from the nozzle.
- 5.) To stop blasting close the inlet valve (1) and open the exhaust valve (2).



DURING OPERATION - USE OF THE CHOKE VALVE

1. If the abrasive flow stops or becomes erratic with the abrasive regulator in the full open position, briefly close the choke valve (3). This will divert full pressure to the tank and will generally free most obstructions if size will permit passage through the abrasive regulator. If not, it will be necessary to open the inspection door on the side of the tank to remove the obstruction. Please note that even a small piece of an abrasive bag has the potential to cause a blockage.

MOISTURE IN THE AIR LINES

Erratic operation, often blamed on the blast machine, is almost always caused by excessive air line moisture saturating the abrasive.

TITAN Standard Line machines are equipped with a moisture separator (6) which should be drained at least each time the machine is refilled with abrasive. If moisture is causing operating problems and the separator does not discharge water when drained, the problem is not with the separator but with the high temperature of the compressed air supply.

In order for the separator to function it is necessary for the compressed air to cool to surrounding temperature levels to condense the moisture from vapor to liquid before reaching the separator. If it does not cool sufficiently the condensation usually takes place inside the blast tank because of the relatively large surface area for cooling.

There are many ways to cool the air in advance of the blast machine; electric and desiccant air dryers, additional air tanks and longer runs of supply air hose and piping. We will be glad to discuss your specific application and offer recommendations.

ADDITIONAL OPERATING SUGGESTIONS

- A. Abrasive particle size should not exceed 1/3 the diameter of the nozzle.
- B. Most blasting is done at 100-110 PSI. The difference between 60-70 PSI and 100 PSI is startling in terms of production. However, many surfaces require lesser pressures and we will again offer our recommendations.
- C. Adjust the abrasive regulator only if the machine is operating or empty of abrasive.
- D. We recommend silica sand, supplied specifically for blast cleaning, for most cleaning applications. Slag abrasives are an alternative where available or where silica sand is not permitted by local ordinance.