

## Routine maintenance checklist

The frequency of maintenance will vary according to workload placed on the machine and work processed. The schedules listed in the following sections are intended for general guidance purposes only. Air Blast machines are ideally used for high throughput or demanding production applications, therefore, depending on the application, the components in the feed system can be subject to high wear rates and may require maintenance at more frequent intervals. The duration between inspections is best established from experience in operating the machine.

Below are the minimum checks, there are more detailed checks listed in the machine's manuals. Wheelabrator Plus offers SMART Care Service Packages which are tailored to your requirements, please contact us for more information.

Enclosure	Daily	Weekly	Monthly
1. Empty the dust container	○		
2. Clean the cabinet, dust collector and the surrounding work area. Ensure the cabinet interior is free from coagulated media and dust.	○		
3. Check the cabinet door for freedom of action and correct latching.	○		
4. Check the viewing window for cracks, etching or damage, replace if necessary. Clean the glass inside and out.	○		
5. Examine the media in use, change if contaminated or broken down.*	○		
6. Check the gauntlets are free from defects and holes	○		
7. Check the cabinet air inlet for obstructions.	○		
8. Ensure that the aerator stone (if fitted) is not choked or cracked. Replace if necessary.	○		
9. At the end of the shift, drain the abrasive from the machine.**	○		
10. Check the blast nozzle for blockage or wear.***		○	
11. Check the media supply hose for wear, particularly at sharp bends and near the feed shaft.		○	
12. Remove the Y-strainer. Clean and inspect in accordance with your OEM manual. Check the capacity of the element for passing air. Unscrew the base nut at the end of the strainer housing and withdraw the element.		○	
13. Check that door and dust container seals are intact and there are no air leaks.			○
14. Check the dust collector filters are free of dust build up in accordance with the procedure manual.			○

## Four monthly inspection & maintenance

Media Feed System	Every 4 Months
1. Check the dump valve cone for signs of wear.	○
2. Check the diffuser block for coagulated media and wear in the bore. If necessary, remove, clean or replace.	○
3. Inspect the inside surfaces of the feed valve body for excessive erosion.	○
4. Inspect the outer surface, bore and orifice of the feed shaft for wear. Compare the shaft with new shaft, and if the orifice is more than approximately 20% oversize, replace the shaft	○

\*Defective media will be signified by unsatisfactory appearance of the workpiece, reduced cleaning speed, erratic media delivery and a dusty cabinet interior.

\*\* This is particularly important in areas subject to high humidity. If the media appears dusty adjust the airwash (if fitted) or replace the media when next charging the machine.

\*\*\* Wear at the nozzle should not exceed 20% over the original bore size.

Wheelabrator Plus offer five levels of emergency breakdown and preventative maintenance packages, contact us to discuss our SMART Care service options.

### Wheelabrator Plus Key facts

- Over 30 globally situated sales and service centres
- Serving customers in over 100 countries
- Over 22,000 product lines in stock
- Over 400 technical experts globally

Contact Wheelabrator Plus for an evaluation of your existing surface preparation equipment, regardless of its manufacturer. Upon assessment, Wheelabrator Plus will follow-up with a detailed report so that you can achieve the best results.

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Wheelabrator Plus  
surface preparation  
services and support

wheelabrator  
plus+ shaping industry

## About Wheelabrator Plus

With over a century of expertise in design and manufacture, Wheelabrator Plus offers the largest aftermarket replacement parts supply, service and technical support for the surface preparation industry globally. With the capability of maintaining and upgrading surface preparation equipment from both Wheelabrator and non-Wheelabrator brands within the industry, Wheelabrator Plus continually strives to contribute in helping to profitably meet or even exceed your customers' requirements and deliver the highest quality of both replacement parts and service, in the shortest time frame and at the most competitive prices.

Wheelabrator Plus services include:

- Servicing and inspection
- Equipment modernisation and upgrades
- Operation and Maintenance incorporating:
  - Training
  - Replacement parts
  - Equipment relocation

Machine downtime is undesirable, but not unavoidable with proactive servicing and inspection. Wheelabrator Plus understands the work pressures of your internal resources and is well prepared with a team of service technicians that are available at short notice. We have the largest inventory of surface preparation spare parts in the world, this allows us to meet your requirements quickly.

Our Equipment Modernisation Programme has been designed to enable you to completely upgrade your current blasting equipment, giving you all the advantages of a new machine at a lower cost. By utilising the latest technical developments including the use of long life technology to improve productivity and save costs, we can effectively enable you to reduce the cost of each part you produce.

There are many benefits to having your current equipment upgraded rather than buying a new machine:

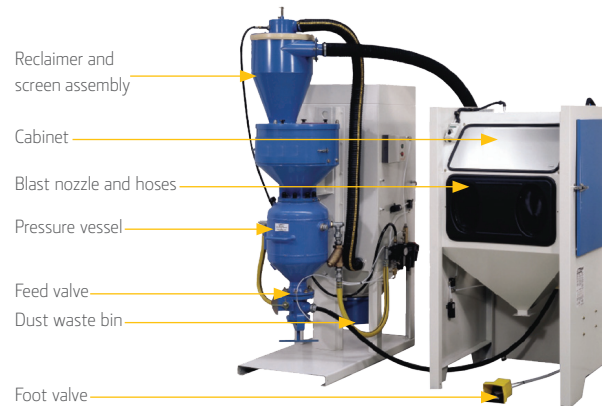
- Lower cost
- Faster payback on investment
- Additional return on the initial investment of original equipment
- Quicker turnaround
- Easier to implement
- Less disruption to production
- Added value to overall process
- More environmentally responsible as you "recycle", rather than replace your existing machine

## Feed assembly setting and clearing

To ensure that the media feed is even and efficient, pressure fed and suction feed cabinets have aeration fitted to the bottom of the feed valve assemblies when light abrasive is used.

It is therefore important to ensure that the feed assembly settings and clearing of media is carried out correctly.

- When changing media ensure that the base plate gasket is clean and seals completely otherwise the blasting performance will be significantly negatively impacted.
- The best media feed rate is generally obtained when the feed is set too rich which will give a slightly pulsing feed and then back the feed off until the blast stream is lean and even.
- Should a blockage occur it can usually be cleared by simply rotating the control shaft a couple of times on pressure-fed machines before returning it to the previous setting.



## Reclaimer assembly setting and clearing

The reclaimer is a high efficiency adjustable design enabling close control of dust and broken down media.

Correct set up and maintenance of the reclaimer and screen assembly ensures a closely controlled media charge and therefore more consistent surface finish.

- Adjustment is via the T bar at the top of the reclaimer. To increase carry over adjust upwards in 12mm steps. To reduce carry over move downwards in 12mm steps. The ideal setting is when the carry over has a small amount of good media. At this stage the waste can be discarded and an equivalent amount of new media can be used for replenishment.
- Screen size and type are specified to suit the media. It is very important that if you are changing a machine from one type of media to another or from one size to another you must check that the correct size is fitted.
- **WARNING:** It is very important that you don't put ferrous media in your machine if a magnetic separator is fitted.

## Dust collector

- It is important that the dust waste bin is cleared regularly otherwise it may overflow. This would make emptying the bin difficult and messy, and could affect efficiency if the waste reaches the filters.
- After removing the media from the dust bin, charge the machine with the same amount of new media, do not use media discarded from the dust container.
- Care should be taken when reseating the filter element(s).



## Blasting technique

- Start on the component at an area closest to you and track the nozzle back and forth in an even flowing motion similar to a painting motion.
- When the desired result is achieved continue the movement back and forth and begin stripping the area. This technique maintains the best possible visibility of the area to be cleaned.
- Use the specified pressure or the lowest possible pressure possible to achieve the desired result. This will ensure no damage and low media usage rates.
- Try and direct the blast so that it ricochets away from the window to preserve the life of the window.
- After blasting blow off the components with the supplied blow off gun before opening the door.

### Contact us

Contact Wheelabrator Plus for any information or support you require to increase your performance.

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