



SPEEDO MARINE (PTE) LTD

11, Tuas Link 2, Singapore 638559 Tel : (65) 68631998 Fax : (65) 68631667
Website : www.speedo.com.sg Email : enquiry@speedo.com.sg

MANUAL

BLAST POT 600LBS

P/N: 0001-600/CN

P/N: 0001-600/C

P/N: 0001-600G/C



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BLASTING POT 600 LBS MODEL : PBM-600

1.0 FOR SAFER & MORE PROTECTIVE BLAST CLEANING

1.1 Use Protective Equipment

Abrasive resistant clothing, safety shoes, leather glove, ear protection, approved air-fed helmet. Air for helmet must supplied by a breathing air compressor monitored for carbob monoxide (CO) and filtered.

1.2 Start-up Preparation

- Check helmet reapirotor filter and lenses.
- Blast machine must be grounded to avoid shock.
- Inspect fittings and hose for damage and wear.
- Wire quick coupling together.
- Check abrasive-trap screen for damage and wear.
- Check pop-up valve for alignment.
- Inspect and test remote control.

1.3 Warning

- Check for possible silicosis hazards. Avoid dust.
- Do not blast with damaged or worn equipment.
- Use only abrasive approved for safe blasting.
- Keep blast nozzle controlled & aimed at work.
- Keep unprotected workers out of the blast area.
- Do not weld on blast machine.
- Do not modify the equipment.



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2.0 Start up Operation

- Pot-man pressurizes the airline to the blast machine.
- Pot-man close the outlet valve.
- When the blaster signals he is ready, Pot-man opens the inlet air valve. This causes the pop-up valve to seal off the filling port. The machine will pressurize but only air will come out of the machine.
- Pot-man adjusts the metering valve for the proper air abrasive mixture. A general rule, use as little abrasive as possible. The stream of abrasive coming out of the nozzle should barely discolor the air when seen against the light or other light sources.
- To stop blasting, Pot-man closes the inlet valve and quickly opens the outlet valve. The blast machine will immediately depressurize.
(Note: Prior to activating the blast machine, the blaster should have complete control of the blasehose nozzle)

3.0 Shut Down and Storage

- Always clean out abrasive remaining in the blast machine when shutting down at the end of the day. This will eliminate trouble from moist abrasive when starting new day's blasting operation.
- To empty abrasive from machine, remove blast nozzle and put the hose into a suitable container.
- Close the choke-valve and adjust abrasive-metering valve to fully open.
- Pressurize the machine by opening the inlet valve. Make sure the hose is secured properly in the container, air with abrasive will hit the container when the pot is almost empty. Take precaution to make sure no one is standing near. Use safety equipment when carrying out this operation.
- Once the abrasive is expelled, simultaneously close the inlet valve and open the outlet valve.
- Shut off the air compressor.
- The machine should be covered if left out at night.



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4.0 Preventive Maintenance

4.1 Use Protective Equipment

Review all appropriate operation manual prior to installing accessories items on the equipment. Inspect all components of the blast machine frequently and replace worn or damaged parts with original items only.

4.2 Replacement of Pop-Up Valve

To gain access to the pop-up valve, remove the inspection door assembly. Using small pipe wrench, unscrew the pop-up valve by turning it anti-clockwise. Remove the pop-up valve from the machine and install the new pop-up valve back into original position. Put new gasket on the inspection door assembly before bolting the door back onto the machine.

4.3 Replacement of Pop-Up Valve Seat Gasket

Remove the old gasket by inserting your fingers between the gasket and retainer and slowly working it loose. Use a screwdriver if necessary. Push the new gasket all the way through the pot and then fit into the groove in the retainer. For the last few inches, pull up the gasket and allow it to “pop” into position.



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5.0 System Malfunction

5.1 Blockages – No abrasive discharge from nozzle.

If neither abrasive nor air comes out from the nozzle, depressurize the machine and check the nozzle, abrasive control valve and blast hose for blockages. If only air but no abrasive comes out, adjust metering valve to fully open and open & close the choke valve rapidly. If this fails, depressurize the machine, open the inspection plate and check for foreign objects (paper, stone, etc...)

5.2 Abrasive Surge – Abrasive flow from nozzle is spitting or irregular

A certain flow of surge is normal at start-up. Should the flow of abrasive continue to surge, quick closing and opening of the choke-valve will usually stabilize the flow. Intermittent flow is sometimes due to excessive moisture in the system. If this is the problem, install a moisture separator in the airline as close to the machine as possible.

5.3 Blasting Machine Fail to Pressurize_

Review the set up procedure covered in this manual. Inspect remote control, bi-line hose for leaks and kinks. Check the volume of air-supplied to the blast machine. An insufficient air supply will not seal gasket adequately enough to pressurize the blast machine.

5.4 Removing Damp Abrasives_

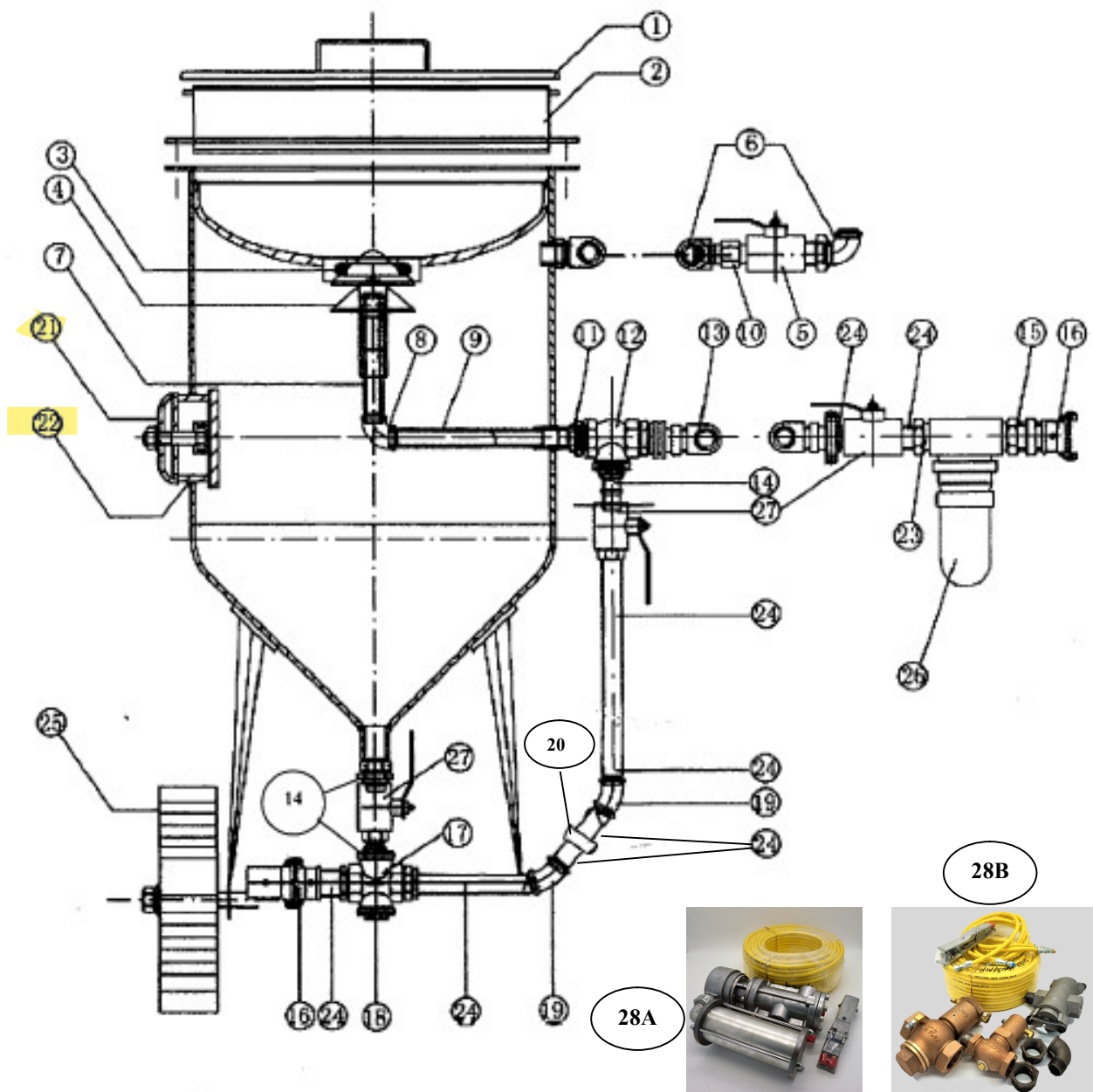
To remove damp abrasive from the machine, shut down air supply, disconnect the blast hose, and release the air in blast pot. Remove the cover and manually clear the damp abrasives in the blast pot. When the damp abrasive has been removed, reconnect the blast hose and blast nozzle then the machine can be started under normal procedure.



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MODEL 600LBS BLAST POT





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BLASTING POT 600 LBS PART LIST

No.	Part No.	Description	Quantity
	STANDARD		
3	0083-003	Pop-Up Valve Seat Rubber O-Ring	1
4	0083-002	Pop-Up Valve & Shaft 1-1/2"	1
5	0643-006	Full Ball Valve Chrome 1" C/W Steel Handle	1
6	0623-576/G	Elbow 1" M X F (Galvd)	2
7	0083-007/8	1" X 8" Pipe	1
8	0623-556/G	Elbow 90 Deg 1" F (Galvd)	1
9	0083-007/11	1" X 11" Pipe	1
10	0623-006/G	Nipple 1" (Galvd)	1
11	0623-076/G	Reducing Nipple 1-1/4" X 1" (Galvd)	1
12	0623-307/G	Tee 1-1/4" Female (Galvd)	1
13	0623-577/G	Elbow 1-1/4" M X F (Galvd)	1
14	0623-007/G	Nipple 1-1/4" (Galvd)	3
16	0633-007/D	Threaded Coupling 1-1/4" (Ductile)	2
17	0623-357/G	Cross Tee 1-1/4" F (Galvd)	1
18	0623-857/G	Plug 1-1/4" (Galvd)	1
19	0623-507/G	Elbow 45 Deg 1-1/4" F (Galvd)	2
20	0623-807/G	Union 1-1/4" (Galvd)	1
21	0013-000/6	Inspection Cover (2 Pcs/Set)	1 SET
22	0083-052	Window Gasket	1
24	DC	Pipe 1-1/4", (5" = 5pc) (6.5", 9.5" = 1 Pc Each)	
25	0673-039	Wheel 16"	2
27	0643-007	Full Ball Valve Chrome 1-1/4" C/W Steel Handle	3
	OPTIONAL		
1	0012-024	Machine Cover 24"	1
2	0012-124	Recessed Screen 24"	1
15	0623-087/G	Reducing Nipple 1-1/2" X 1-1/4" (Galvd)	1
23	0623-787	Bush 1-1/2" X 1-1/4"	1
26	0022-008/P	Moisture Separator 1-1/2", Manual Drain (Parker)	1
28A	0132-003/IP	1-1/4" Remote Control Pvo (Rcv 1.25) C/W 20m Bi-Line Hose & Bi-Line Switch	1
28B	0132-003/MP	1-1/4" Remote Control System C/W 20m Bi-Line Hose & Bi-Line Switch (Marco)	1



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BLASTING POT 600 LBS SPECIFICATIONS

Model	0001-600/CN	0001-600/C	0001-600G/C
Machine's Diameter	0.610 m (24 in)	0.610 m (24 in)	0.610 m (24 in)
Machine's Height	1.430 m (56 in)	1.430 m (56 in)	1.430 m (56 in)
Machine's Weight	200 Kg (440 lbs)	200 Kg (440 lbs)	200 Kg (440 lbs)
Abrasive Capacity	272 Kg (600 lbs)	272 Kg (600 lbs)	272 Kg (600 lbs)
No. of Chamber	1	1	1
No. of Outlet	1	1	1
Wheel Diameter	406 mm (16 in)	406 mm (16 in)	406 mm (16 in)
Shell Thickness	6 mm	6 mm	6 mm
Material	Q345B	SA-516 GR.70 / SA-516 GR.485	SA-516 GR.70 / SA-516 GR.485
Safe Working Pressure	860 KN/sq.m (125 psi)	1034.2 KN/sq.m (150 psi)	1034.2 KN/sq.m (150 psi)
Hydrostatic Test Pressure	1300 KN/sq.m (188 psi)	1300 KN/sq.m (188 psi)	1300 KN/sq.m (188 psi)



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