

TUMBLE BLASTER PROCEDURE

CAPACITY

- Parts may not exceed 14" length. Longer parts will damage the internal components of the Blaster.
- The Tumble Blaster may be loaded to a point where the work does not roll out over the front of the apron Conveyor when the door is open, and does not hit against the door when it is closed. The work should tumble freely without any danger of it climbing up into the wheel assembly or against the end liners.

A. SAFETY

1. Never reach into the Tumble Blaster while the blast wheel is turning. Shot is ejected at 240' per second.
2. Remove small parts from the mill with a shovel.
3. Shot that accumulates on the floor is extremely slippery; regularly sweep the floor surrounding the Tumble Blaster to ensure a safe work area.
4. It is suggested to wear a dust mask, while loading and unloading.
5. Do not load parts, which have been painted.
6. Do not load parts that are wet. The moisture will gum up the machine.

B. START UP SEQUENCE

1. Load parts on mill belt.
2. Close front parts loading door.
3.
 - a) Start the elevator: This transfers the shot from the collection hopper to the separator. It also starts the dust collector: the shaker cycle runs automatically.
 - b) Check the magnehelic gauge reading. If it reads 4" or higher- stop the elevator and restart it. If the gauge still reads 4 or higher call maintenance immediately. Set the timer for parts to be blasted for 3-5 minutes.
 - c) Start mill forward: This rotates the mill belt, allowing all surfaces of the part to be exposed to the shot, by tumbling the parts.
 - d) Start the wheel: The wheel is what sprays the shot into the mill area.
 - e) Pull shot handle down ↓ : This allows shot to enter the wheel area.

Allow parts to be blasted for 3 - 5 minutes.

C. SHUT DOWN SEQUENCE

1. Push shot handle up↑ : Shot will be stopped from entering the wheel area for manual operation. Allow shot to clear from the wheel before stopping the wheel. (32002 only North prep)
2. Stop the wheel: This stops shot from entering the blast or mill area.
3. **Caution:** The parts loading door should never be opened when the wheel is turning. Doing so can cause serious personal injury.
4. Stop the mill: Stopping the mill stops the rotation of the mill belt, which stops the tumbling of the parts.
5. Allow the elevator and fan to run while unloading the Tumblast. The mill belt can be run in reverse to aid in unloading parts.
6. Stop the elevator and fan.

D. DUST COLLECTOR:

Note: Before emptying the hopper, the Tumblast must be turned off and “locked out”

- a) Empty hoppers into pails; be sure to close hopper gates correctly. Seal the pails before moving them to door #9 for North prep and door #24 for East prep. Dump the contents of the pails into the large Loraas bin.