Doc 77

Euroblast Suction Feed Range

Operating & Maintenance Instructions

Machine	
Serial No.	
Customer	
A/C No.	

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1. Introduction

This manual should be regarded as part of the product and must be retained for the life of the machine. The manual must be passed to any subsequent owners of the machine.

Any amendments should be attached to the original manual. Machine identification and serial number can be found on the identification plate fixed to the machine body.

1.1 Safety recommendations

Users of Guyson equipment are advised to make sure they have identified any hazards associated with their specific blasting processes, including:

Use of compressed air
Fire/explosion risks, e.g. Aluminium dust
Suitable procedures for dealing with fire hazards
Production of carcinogenic or toxic dusts from media or component surface removal
Any other known hazards

Users are responsible for ensuring that they have implemented any current regulatory requirements, e.g. COSHH, to deal with any potential risks and/or hazards associated with their processes.

ATEX ZONE DESIGNATION

The ATEX Directives 2014/34/EU (product requirements) and 99/92/EC (user requirements) are implemented by the Equipment and Protective Systems intended for use in potentially explosive Atmospheres Regulations 1996 (EPS and the Dangerous Substances and Explosive Atmosphere Regulations 2002 (DSEAR) respectively.

We are able to provide equipment that is suitable for use in a hazardous area, and/or equipment that is suitable for use when a hazardous area is created within a system, but it is the end users' responsibility to classify the area in which the equipment is to be used and/or the explosivity of any internal atmosphere created within the system. This is defined in Section 2, Article 3 to 9 of the 99/92/EC Directive (ATEX 137).

Unless we have been advised otherwise, we have to assume that the equipment will be used in an area that is not classified as potentially explosive, and uses a process which will not create an explosive atmosphere within the equipment.

1.2 Electrical specification

Electrical wiring on Guyson equipment conforms to:

BSEN 60204-1:2006
IEC 60204-1:2005

1.3 Blast media

Type	Guyson reference	Material	Application
Abrasive	Saftigrit brown	Brown alumina	Cleaning, removing corrosion and other surface deposits, roughening, preparing surfaces, etching and decorating.
	Saftigrit white	White alumina	
	Saftigrit pink	Pink alumina	
	Saftigrain	Reclaimed alumina	
	Sinterball	Sintered alumina	Different qualities are available for all applications.
	Silicon carbide	Silicon carbide	
Glass	Honite	Glass bead	Cleaning, peening, sheen surface cleaning
	Glass grit	Glass granules	Mild cutting version of above.
Metallic	Saftimetal	Angular iron grit	Removing corrosion, surface preparation for bonding.
	Turbogrit	Carbon steel grit	
	Turbobead	Carbon steel shot	Cleaning, deburring and peening.
	Flexgrain	Soft iron shot	Cleaning without dimensional change.
	Turbonox	Stainless steel shot	Cleaning, deburring and finishing.
Plastic	Guyblast	Urea - US type 2	Cleaning without dimensional change mould and die cleaning, light deburring and deflashing, paint removal.
	Guystrip	Melamine - US type 3	
	Flashgrit	Acrylic - US type 5	
	Flashgrain	Polycarbonate	Deburring and deflashing
	Flashbead	Polystyrene	Very fine deburring and deflashing
	Thermoflash	Polyamide nylon	Deburring and deflashing
Natural	Loygrain	Corn cob	Removal of corrosion and carbon
	Walnut shell	Walnut shell	
Ceramic	Zirblast	Fused zirconia	Cleaning, peening, deburring and scale removal
Expendables	Iron silicate	Copper slag	Site blasting, removing corrosion and paint prior to recoating

A data sheet is available for each of the media listed in the table, giving more specific details of the product, applications and mesh sizes. Contact Guyson International Ltd for further information and advice on which blast media will suit your application. Test and evaluation facilities are available if required.

2. Data sheets

2.1 Blast cabinets

	Euroblast cabinet model number						
	2	**4**	**6**	**7**	**8**	**9**	**10**
Overall dimensions							
Height (mm)	1600	1655	1825	1825	1825	2265	2125
Width (mm)	680	815	1070	1500	1070	1220	1500
Depth (mm)	500	560	760	915	1070	1220	1500
Blast chamber dimensions							
Height (mm)	500	715	880	880	880	1325	1145
Width (mm)	660	800	1050	1480	1050	1200	1480
Depth (mm)	480	540	740	900	1050	1200	1480
Turntable diameter (mm)	N/A	400	600	750	750	900	900
Evenly distributed maximum load (kg)							
Floor	200	400	350	650	500	500	750
Turntable	N/A	200	450	450	500	500	500
Average noise levels at 1 Metre							
with dust collector {dB(A)}	<80	<80	<80	<80	<80	<80	<80
with dust collector and cyclone {dB(A)}	<80	<80	<80	<80	<80	<80	<80
Floor height (mm)	960	810	845	845	845	805	845
Armhole height (mm)	1070	1040	1075	1075	1075	1045 + 1510	1075
Maximum air pressure	90 psi or 6 bar						
Maximum air supply	77.4 m^3/hr or 42 CFM						
Cabinet lighting **Electric supply** **LED link light** **Fuse rating**	 Single phase, 230 V, 50 Hz 7 W 2 A						
Operator protection required	Hand and lower arm by gloves or gauntlets (supplied)						

2.2 Cyclones

	Cyclone & Dust collector combination				
	HE with C400 D/C	**75/16 with 41D/C**	**75/16 with C400 or C800 D/C**	**CY600/12 with C800 D/C**	**CY600/16 with C800 D/C**
Inlet diameter (mm)	100	100	100	100	100
Outlet diameter (mm	150	100	150	150	150
Airflow (m^3/min)		8.0	12.0		
Height (mm)	1915	*	*	2776	3145
Base diameter (mm)	700 x 860	*	*	750	750
Body diameter (mm)	400	400	400	300	400

*Dependant on whether cyclone is free standing or cabinet mounted

2.3 Dust collectors

	Dust collector model number			
	41	**C400**	**C600**	**C800**
Inlet diameter (mm)	100	150	150	150
Extraction outlet	Open exhaust			
Maximum inlet static pressure (mm Wg)	150	165	165	230
Maximum inlet static pressure (Pa)	1470	1620	1620	2255
Measured airflow (with open inlet/outlet) (m^3/min)	10	11	11	33
Airflow adjustable?	Yes			
Number of primary filters	4	1	1	2
Type of primary filter	B	A	A	A
Filtration area	1.8 m^2 17.5 ft^2	10 m^2 97 ft^2	10 m^2 97 ft^2	20 m^2 194 ft^2
Air flow rating (with a filter velocity of 1.5 m/min)	162 m^3/hr 95 CFM	900 m^3/hr 530 CFM	900 m^3/hr 530 CFM	1800 m^3/hr 1059 CFM
Filter cleaning system	C	D	D	E
Air consumption (litres per pulse)	N/A	7	7	7
Maximum compressed air supply pressure	N/A	50 psi 3.5 bar	50 psi 3.5 bar	50 psi 3.5 bar

where:

A	Cartridge Filter - Polyester Element
B	Fabric filter - Polyester needlefelt - Scrim reinforced
C	Manual shaking system
D	Manual Pulse Air Cleaning System
E	Auto Pulse Air Cleaning System

2.4 Air consumption tables

2.4.1 Air flow measured in m³/hr at different pressures measured in bar

Air-jet bore (mm)	Guyson gun type	Blast pressure (bar)				
		2	3	4	5	6
2.0	400	4.8	7.2	9.0	11.4	13.8
2.4	400	6.6	10.2	13.8	17.1	20.4
2.8	400	10.2	15.0	19.2	25.2	29.4
3.3	400	15.6	22.8	28.2	35.4	40.8
3.2	900	11.4	16.5	21.6	27.0	31.8
4.0	900	19.2	27.3	35.4	43.2	51.6
4.8	900	30.6	42.0	53.4	66.0	77.4

2.4.2 Air flow measured in CFM at different pressures measured in psi

Air-jet bore (mm)	Guyson gun type	Blast pressure (psi)					
		30	40	50	60	70	80
2.0	400	3	4	4.5	5.5	6.5	7.5
2.4	400	4	5	7	8	9	11
2.8	400	6	8	10	12	14	16
3.3	400	10	12	15	17	20	22
3.2	900	7	9	11	14	16	17
4.0	900	12	15	18	21	24	27
4.8	900	18	22	27	32	37	42

3. Installation

The system may comprise of the following units:

Blast Cabinet/Cyclone/Dust Collector

Flexible extraction hoses, sealing bands and hose clamps are supplied to connect these together.

Remove packing materials and check inside blast cabinet for loose items.

3.1 Location

The equipment must be located on a clean, dry surface.

Locate the cabinet in the required position and orientation; always allow sufficient room around the units to fully open doors and to give access for operation and maintenance.

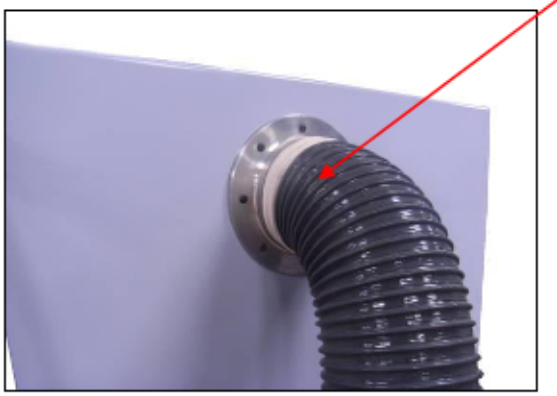
Care should be taken to ensure all parts of the system are level

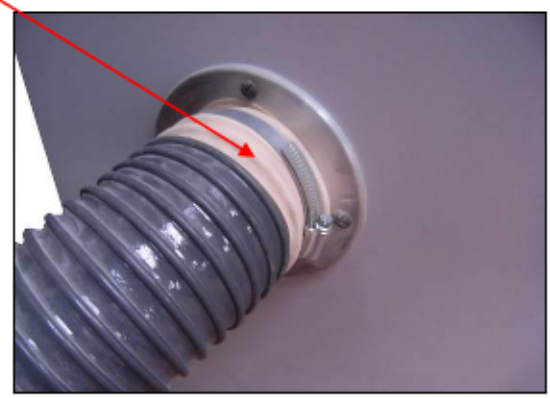
3.2 Assembly

Hoses with media flowing through them should only have smooth flowing curves in them.

If your system only comprises of a blast cabinet and dust collector then:

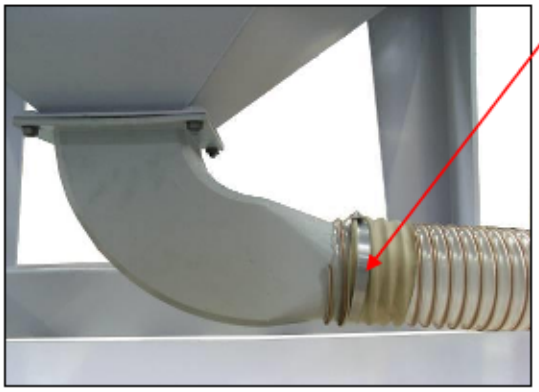
Connect the flexible extraction hose from the cabinet outlet to the dust collector inlet using the sealing bands and hose clamps supplied.

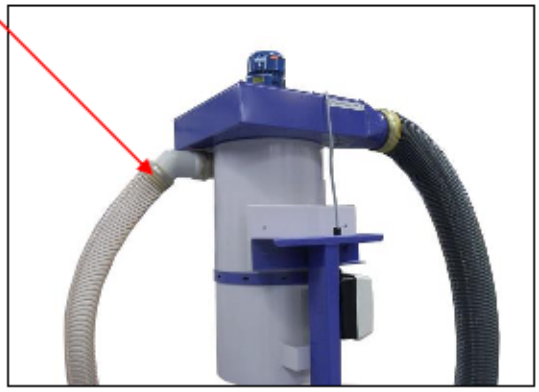




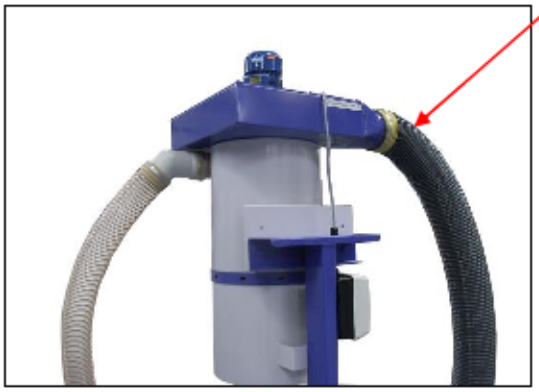
If your system comprises of a blast cabinet, cyclone and dust collector then the cyclone needs to be connected between the blast cabinet and dust collector:

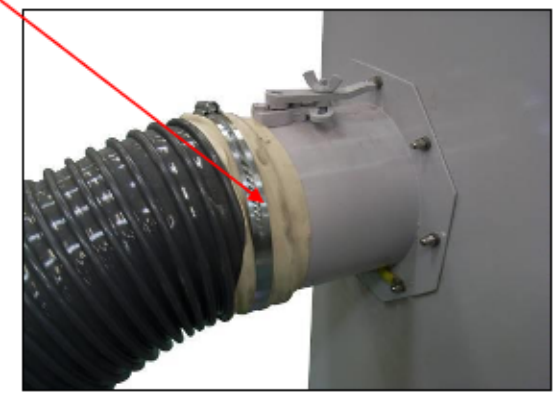
Connect the flexible extraction hose from the cabinet outlet to the cyclone inlet using the sealing bands and hose clamps supplied.





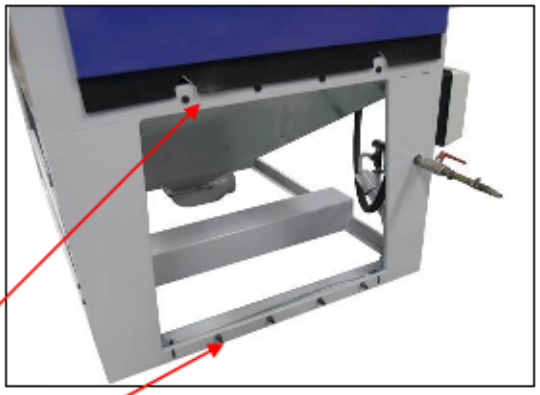
Connect the flexible extraction hose from the cyclone outlet to the dust collector inlet using the sealing bands and hose clamps supplied.

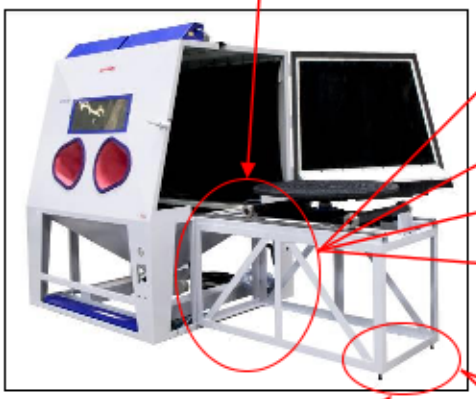


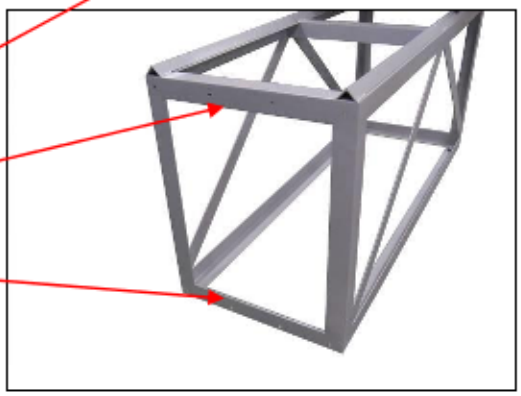


If the cabinet is a side loader version then:

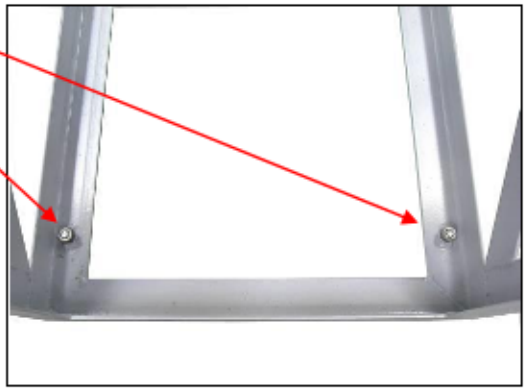
Connect the outer frame to the cabinet using the fasteners supplied.







Ensure the outer support is level using the adjustable feet

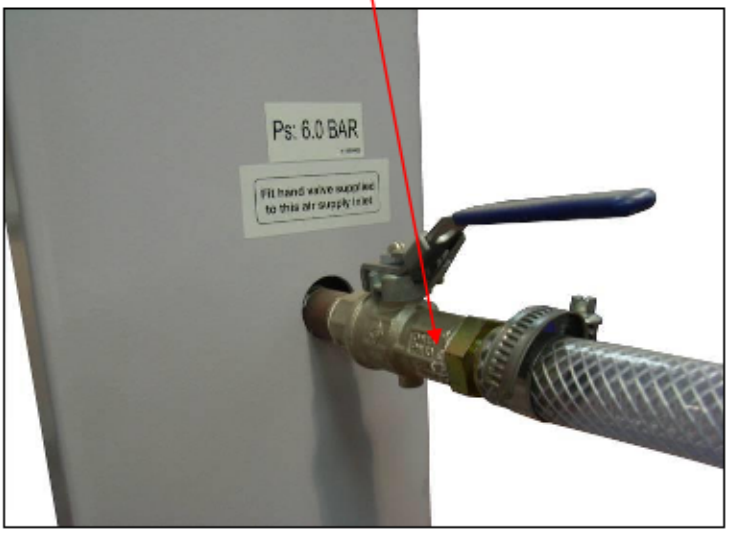


3.2.1 Compressed air connections

The air supply should be from a manual shut-off valve that will exhaust down-stream air and be clean, dry and oil-free.

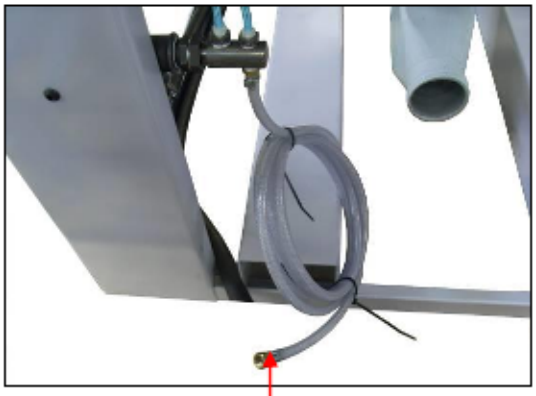
The machine requires a compressed air supply at a maximum of 6.0 bar (90 psi) at the filter inlet and pipework of adequate diameter to provide the flow rate required (see air consumption tables). The minimum recommended bore for the compressed air line is 1" and it connects to a 1/2" BSP thread.

Connect the main compressed air supply to the pneumatic isolator valve.

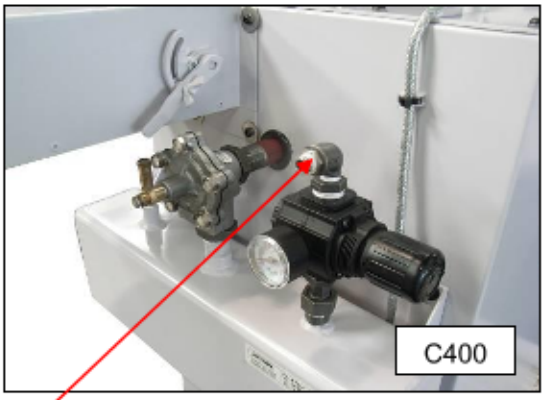


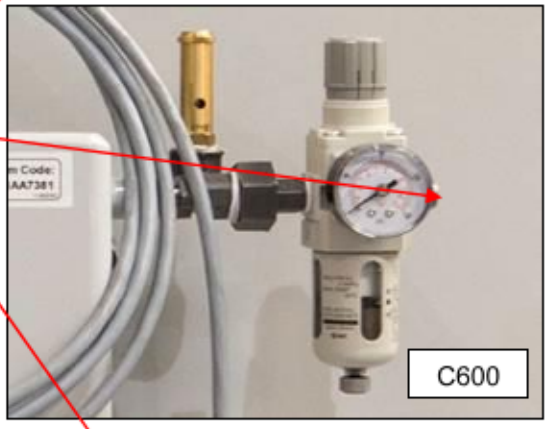
Take care that any jointing material (e.g. PTFE tape) does not enter the pipework.

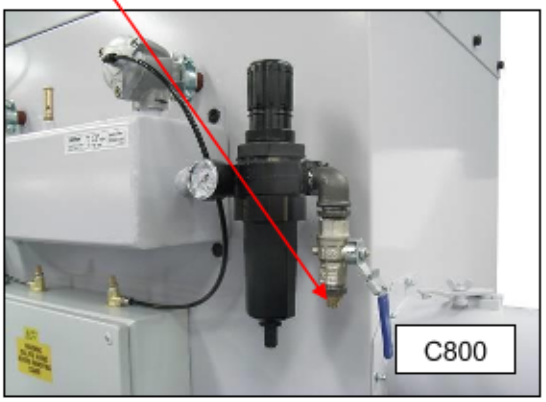
The C400, C600 and C800 dust collectors will require a compressed air supply. The regulator should be set to a max of 50 psi.



Connect the air supply from the back right leg of the blast cabinet to the dust collector.







3.2.2 Electrical connections

Electrical installations should only be carried out by qualified electricians

Please see "Electrical Installation of Dust Collectors and Cyclones" in the appendix

Power supplies should be taken to the starter boxes situated on the side of the dust collector and cyclone.

The electrical supply to the lighting on the cabinet is via an IEC lead.

4. Testing installation

4.1 Testing installation procedure

After completing all the connections the cabinet operation should be checked.

Do not add media at this stage

Do not open the air supply at this stage

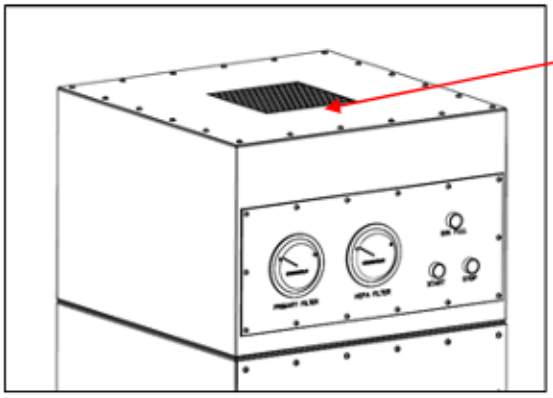
- Switch on main electrical power supply
- Switch on cabinet light
- Start the dust collector:
    - The direction of the impellor motor should be checked visually against the arrow on the motor. If rotation is in the wrong direction, then on a 3 phase motor two of the input phase lines should be changed over. Guyson International should be contacted for more info if it is a single phase motor.

      NOTE: Air will flow from the outlet even if the fan rotation is wrong, but only at a low level, so rotation must be checked visually.

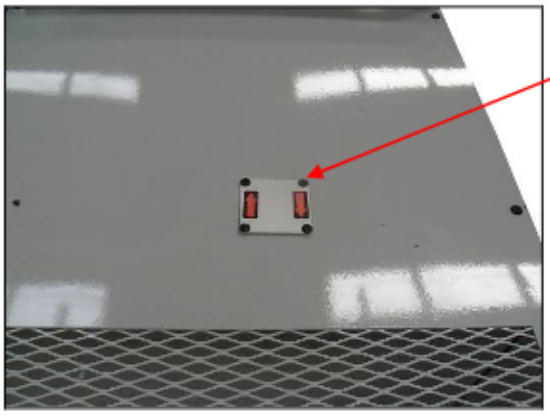
      The best way to do this task is by starting then stopping the dust collector and watch the fan as it slows down.

On a 41 dust collector the motor is inside. The front cover must be removed to see the top of the motor.

On a C400 dust collector the motor is on the outside and can be easily checked.



The C600 motor can be viewed through the mesh screening on the top of the unit.



On a C800 dust collector the motor is inside. There is a viewing hatch on top of the dust collector that can be opened to see the top of the motor.

- Start the cyclone:
    - The direction of the impellor motor should be checked visually against the arrow on the motor. If rotation is in the wrong direction, then on a 3 phase motor two of the input phase lines should be changed over. Guyson International should be contacted for more info if it is a single phase motor.

      NOTE: Air will flow from the outlet even if the fan rotation is wrong, but only at a low level, so rotation must be checked visually.

      The best way to do this task is by starting then stopping the dust collector and watch the fan as it slows down.

On a 75/16 and CY600 cyclone the motors are on the outside and can be easily checked.

- Turn on the air supply by opening the main air valve

- Set pressure regulator to required blast pressure
- Check all in-line connections for leaks and possible blockages
- Insert both arms through the armhole entries
- Depress the foot pedal
- Check for steady air blast from blast nozzle and for possible leaks
- Release foot pedal and remove arms from entries
- Add media to machine

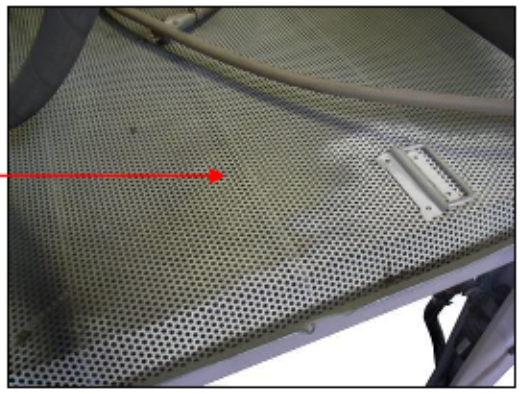
4.2 Media levels

If a cyclone is fitted to the system then media should be added to this. If not then it should be added to the cabinet hopper. ¼ - ¾ of a 25kg bag of media should suffice.

NOTE: If a HE cyclone is fitted, media should be added to the cabinet hopper.

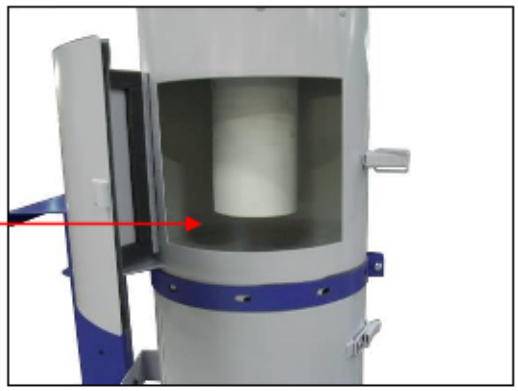
4.2.1 Adding media to hopper

- Turn off the dust collector
- Open the cabinet door
- Pour media into the hopper
- Close the door
- Turn the dust collector on

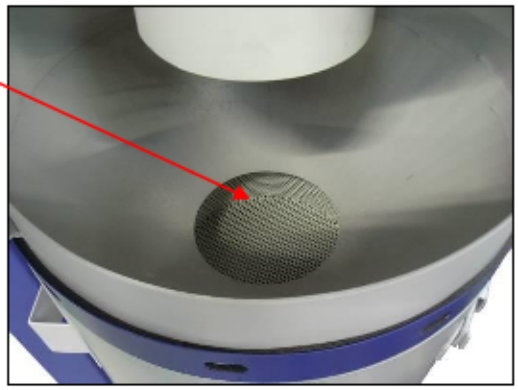


4.2.2 Adding media to 75/16 cyclone

- Turn off the dust collector
- Turn off the cyclone
- Open the upper cyclone door
- Pour media into the cyclone
- Close the door
- Turn the dust collector on
- Turn the cyclone on

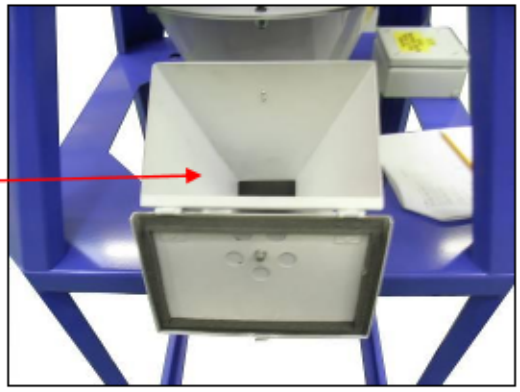


The upper door should always be used so the media can pass through the sieve before it gets to the mixer box.



4.2.3 Adding media to CY600 cyclone

- Turn off the dust collector
- Turn off the cyclone
- Open the filler chute flap
- Pour media into the cyclone
- Close the filler chute flap
- Turn the dust collector on
- Turn the cyclone on



5. Machine settings

5.1 Blast settings

The blast settings should be set in the order they appear in the following sections.

5.1.1 Blasting pressure

Air pressure controls the speed at which the blast media leaves the nozzle. Blasting speed increases at higher pressures and shortens operation time. Never use a higher blast pressure than necessary to achieve the finish required.

- Higher pressure air is less economical
- It may distort or damage components
- Greater media breakdown means higher media consumption
- Noise increases

Adjust the blast gun pressure using the control knob on the main air inlet filter. The gauge shows the set pressure.

5.1.2 Media pick-up tubes

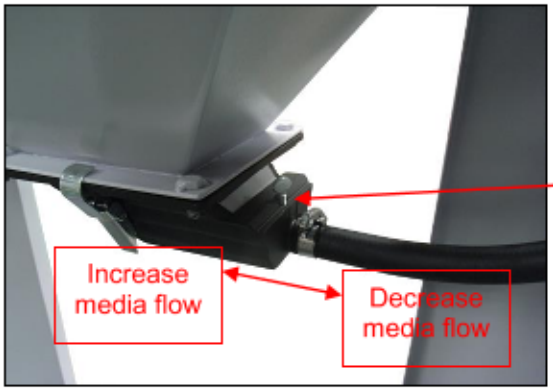
The setting of the pick-up tube in the media box has a significant effect on the blasting performance. Adjustment varies with the media density, with denser media requiring more air to circulate it.

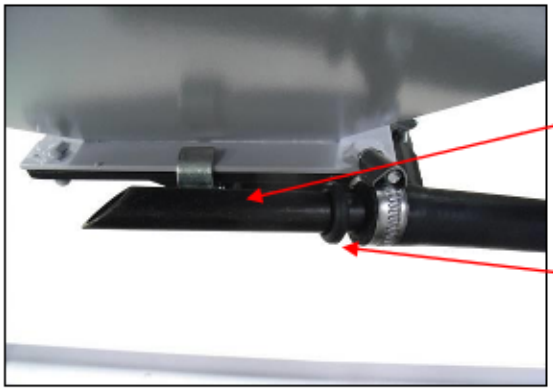
The greater the flow of media from the mixer box to the blast gun, the higher the rate of wear on media hose, blast nozzle.

- Check that there is a supply of free-flowing, dry media to the mixer box
- With compressed air flowing through the blast gun gradually move the pick-up tube into the mixer box with the chamfer facing upwards while a colleague watches the media flow from the nozzle.

  The pick-up tube is in the right position when you are just able to see the media stream leaving the nozzle. If the media stream is intermittent then the pick-up tube has been pushed too far in.

  - Moving the pick-up tube out decreases media flow
  - Moving the pick-up tube in increases media flow
- Lock the pick-up tube in place with the retaining screw
- Further adjustment should not be needed whilst using the same media





5.1.3 Stand-off distance

This is the distance of the gun nozzle from the component. The stand-off distance should not normally be reduced below 50 mm as media from the nozzle will be deflected or slowed down by media ricocheting from the surface being blasted.

The impact of the media can be affected by the stand-off distance and the air pressure. The type of media will influence this but a larger blast area may be achieved by increasing both the stand-off distance and the blast air pressure.

5.1.4 Angle of blasting

The optimum angle for blasting for surface finishing is between 90 and 60 degrees to the horizontal. Shallower angles can cause surface damage or compromise material properties. Shallower angles than this can be used for deposit removal where the surface finish is not critical and with softer media.

Blast guns should be angled to minimise interference between the outputs from different guns. This will avoid disrupting the speed and direction of media between nozzle and component.

Always position guns pointing away from any cabinet openings; this minimises the risk of media being blasted out of the cabinet.

5.2 Extraction settings

5.2.1 Dust collector

The air-flow must be sufficient to create a slight negative pressure inside the cabinet to prevent dust from blowing out. The airspeed must also be high enough to carry the blast media and dust out of the cabinet and up the extraction hose to the inlet of the cyclone. This varies with the size and weight of blast media.

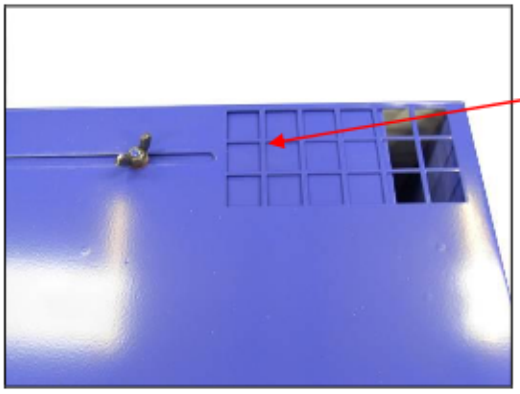
The suction in the dust collector should be such that a minimum amount of media is transferred into the dust collection system.

This is altered with the damper/blast gate on the dust collector outlet/inlet:

- Opening the damper/blast gate increases the suction
- Closing the damper/blast gate reduces the suction.

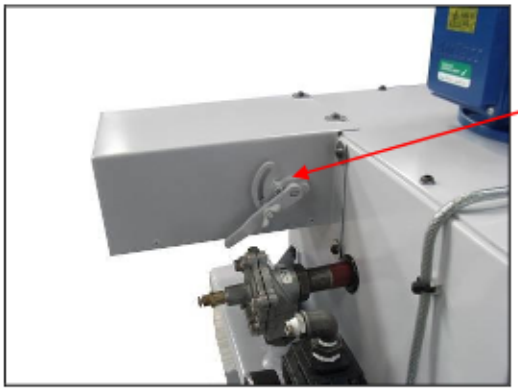
When setting the dampers/blast gates always keep the extraction air-flow to the minimum needed to avoid pressurisation of the cabinet during blasting. Over time the filters in the dust collector will become clogged with dust, and an increased air-flow may be necessary between filter changes and maintenance. In systems with a cyclone the extraction should be set so that a minimum amount of media is transferred into the dust collection system.

Always check the waste bin for good media when adjusting any settings.



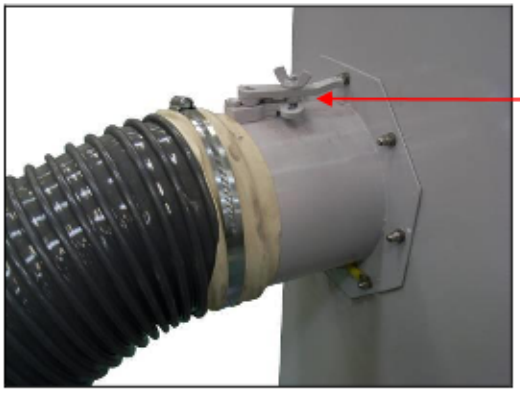
41 Dust collector

Air flow is controlled by the slide damper on the exhaust outlet on the dust collector.



C400 Dust collector

Air flow is controlled by the slide damper on the exhaust outlet on the dust collector.



C400, C600 and C800 Dust collector

Air flow is controlled by the blast gate on the inlet to the dust collector.

A blast gate will be fitted to the C400 if a cyclone is being used.

The dust collector must be started before and stopped after the cyclone unit (if fitted) in order to clear the system of dust after the blasting operation.

The dust collector should be checked to see how much reusable media has been transferred and the settings adjusted accordingly.

Never try to extract reusable media for reuse in the machine.

On a C800 it is essential that a plastic bin liner (Y1CA0047) is used. It provides a simple and clean means of removing and disposing of the dust, but its use requires balancing the pressure either side of the bag to prevent it being drawn up into the hopper. This is achieved by the use of the bin balance pipe so that the same negative pressure is applied to the outside of the bag as the inside.

If a bin liner is not used then dust will be drawn up through the bin balance pipe into the clean side of the dust collector.

5.2.2 Cyclone

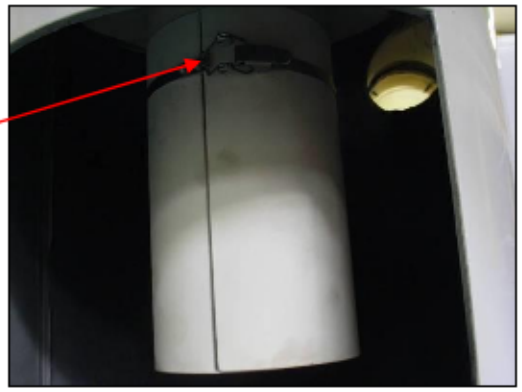
If after adjusting the dust collector damper good media is still being drawn into the dust collector, it may be necessary to adjust the cyclone vortex as well.

To test the position of vortex; first clean the dust collector waste bin. Operate the blast process for 10 minutes and then look inside the dust collector waste bin. A large quantity of usable blast media in the waste bin indicates the vortex needs adjusting to reduce carry over. The absence of any dust at all indicates the vortex needs adjustment to separate the dust which may be retained within the media hopper.

A short vortex will usually draw more dust out of the cyclone than a long vortex. Each process may need a different vortex setting, with best results being achieved by trial.

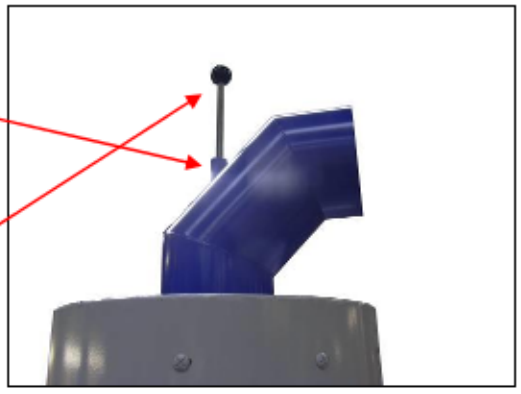
To adjust the length of the vortex in a motorized cyclone:

- Switch off the cyclone then the dust collector
- Open the access panel
- Slacken the tensioning clip around the vortex sleeve
- Slide the sleeve up or down as required
- Replace and secure the tensioning clip and close the access panel



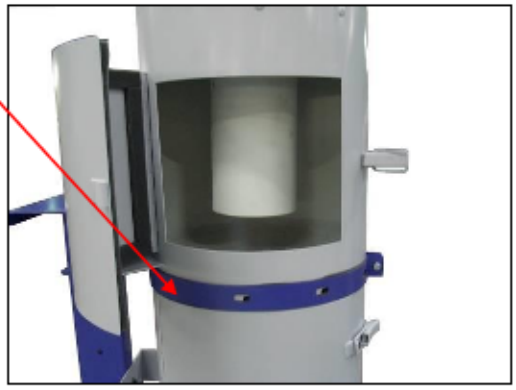
To adjust the length of the vortex on a non-motorized cyclone:

- Switch off the cyclone then the dust collector
- Open the access panel
- Release the thumb-screw securing the vortex adjusting rod at the top of the cyclone exit elbow.
- By means of the knob attached to the adjusting rod, slide the rod up or down as required to decrease or increase respectively the length of the vortex.
- Secure the thumb-screw when the adjusting rod is in the desired position.
- Close the access panel



NOTE: The position of the vortex can be viewed by opening the top access door during the adjustment procedure.

As a further aid to the separation of good media from dust and fines there is an adjustable airflow separation control disc mounted on the top of the filler chute flap on a CY600 or an air-flow separation control band around the body of the 75/16 cyclone.



This disc/band has slots cut in it which coincide with holes in the filler chute flap/cyclone body itself. When all the holes are lined up, air is permitted to enter the cyclone increasing the amount of air available for extraction to the dust collector. In turn this reduces the velocity of the exhaust air and permits media to fall out of the airstream more easily. This is particularly beneficial with light media (such as plastics) where the individual granules do not have sufficient mass to drop out of a moving airstream.

Where it is not necessary or not required to increase the velocity of the exhaust airstream the separator disc/band should be rotated so that the holes in the disc/band do not line up with the holes in the filler chute flap/cyclone body; this will inhibit the entry of any extra air by this route and hence leave the characteristics of the air-flow unchanged.

It must be remembered that the air-flow separation disc/band is adjustable to give all permutations between fully open and fully closed; this provides the operator with a wide range of adjustment to suit individual situations. However, it is also important to remember that there is no firm rule concerning the use of this disc/band and the best results will be achieved by trial and error.

Once the cyclone has been set for a particular application, it should not require adjustment. Any loss of visibility or a failure to remove sufficient dust may be caused by blocked breather pads or choked dust collector filters.

To maximize operation, each different blasting operation will need the settings checking for best blasting performance.

6. Operation

6.1 Operating procedure

- Perform daily maintenance tasks (see section 7.1)
- Switch on main electrical power supply
- Switch on cabinet light
- Start the dust collector
- Start the cyclone
- Turn on the air supply by opening the main air valve
- Ensure any component is grease-free and dry before blasting
- Open the cabinet door
- Place component in cabinet
- Position the blast gun and airwash so that they will be easily reached when using the gauntlets/gloves and sleeves
- Close the cabinet door securely
- Insert both arms through the armhole entries

GAUNTLETS/GLOVES MUST BE USED IN CONJUNCTION WITH THE ARMHOLE SLEEVES

- Depress the foot pedal, media will exit from the gun nozzle
- Move the nozzle jet across the component surface at a suitable distance, refer to blast nozzle settings section
- The component should be blasted evenly
- When the blasting is complete, release the foot pedal
- The door can now be opened, and the component can be removed for inspection
- Further blasting may be necessary, or an adjustment to one or more of the machine or blast settings
- The air line may be used to clean dust from the component surface

7. Maintenance

Blast machines are subject to wear. The rate of wear is determined by:

- The speed of media passing over the component surface
- The proportion of media to air exiting the blast nozzle
- The angle of contact with component surface
- Component material
- Media coarseness and type used

The wear can be minimised by regular maintenance and monitoring settings particularly those effecting localised wear.

The frequency of any maintenance and the replacement of parts are determined by the amount of use, type of media used and the operating conditions. Maintenance intervals will be determined by experience of machine-use over time. The following schedule is recommended for an initial trial period until wear patterns are established.

ENSURE ALL AIR SUPPLIES ARE TURNED OFF AND THE SYSTEM IS FULLY EXHAUSTED BEFORE PERFORMING ANY MAINTENANCE

THE DUST COLLECTOR SHOULD BE FULLY ISOLATED BEFORE PERFORMING ANY MAINTENANCE. A LOCK-OUT AND TAG PROCEDURE SHOULD BE IN PLACE TO PREVENT THE MACHINE FROM BEING STARTED PRIOR TO THE COMPLETION OF MAINTENANCE.

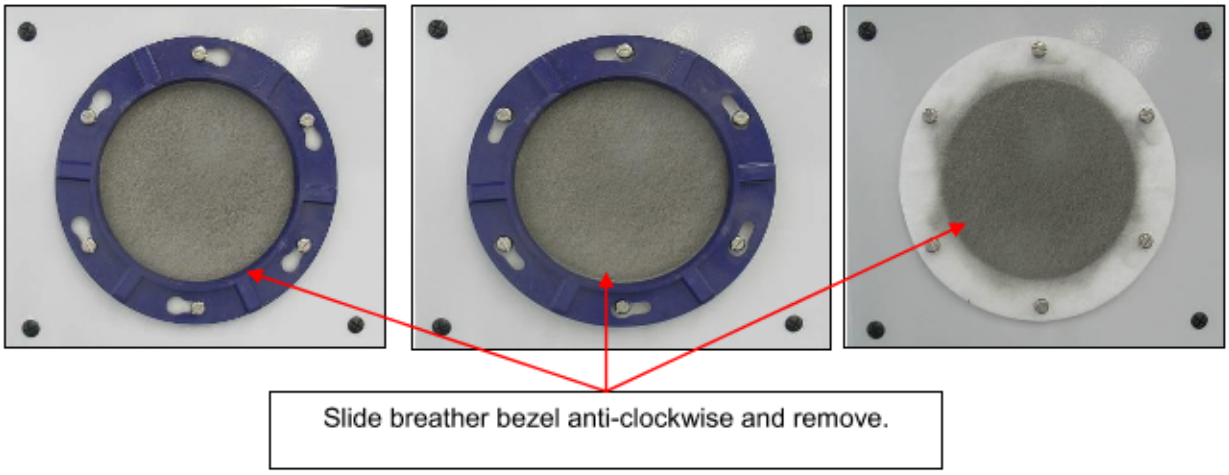
PPE: GUYSON RECOMMENDS THAT AS A MINIMUM, OPERATIVES SHOULD USE A DUST MASK AND SAFETY GLASSES WHEN PERFORMING MAINTENANCE OF ANY SORT.
REFERENCE SHOULD BE MADE TO THE MATERIAL SAFETY DATA SHEET OF THE MEDIA BEING USED FOR ANY SPECIFIC PPE REQUIRED.

7.1 Daily

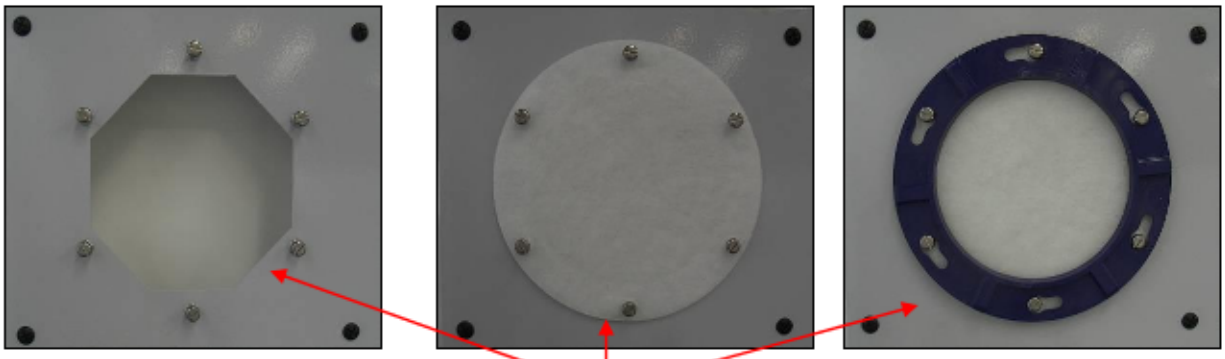
- Inspect breathers pads (see section 7.1.1)
- Inspect the viewing window, anti-frost sheet and illumination window (see section 7.1.2)
- Inspect all hoses for wear and damage (see section 7.1.3)
- Inspect pick up tube(s) and mixer box for wear and damage (see section 7.1.4)
- Inspect blast nozzles for uneven wear and bore size (maximum oversize is plus 20%) (see section 7.1.5)
- Inspect door seals for wear (see section 7.1.6)
- Inspect hopper for signs of overspray wear (see section 7.1.7)
- Empty dust collector bin and check contents for quality of media, ensure good media is not being wasted (see section 7.1.8)
- Top up media as required (see section 7.1.9)
- Clean the filters every four working hours (see section 7.1.10)
- Check compressed air filter (see section 7.1.11)
- Check earthing bonds are secure (see section 7.1.12)

7.1.1 Breather pads

The breather pads should be checked to see that they are not blocked. If they are they can cause an excessive negative pressure in the cabinet and affect the media stream from the gun. See below for how to change them if necessary.



Slide breather bezel anti-clockwise and remove.



Remove and replace the breather pad **(Y1AB0001)**. Return the breather bezel to the locked position.

7.1.2 Viewing and illumination window

Check that the view of the component to be blasted is not impaired by a scratched anti frost sheet **(P2PF0013*)** or glass **(P2GL0009*)**. Replace if necessary.

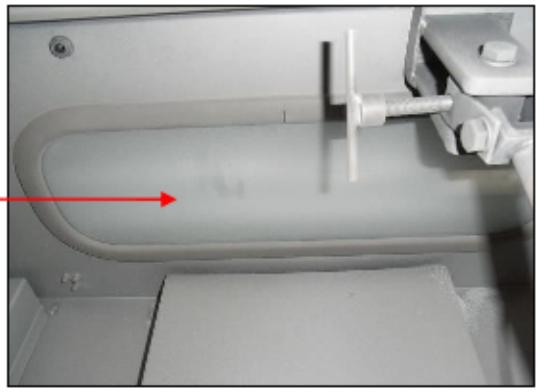
The window gasket should also be inspected and replaced when worn **(R5SL0009)**.

* The Euroblast 2 SF cabinet has a different sized window fitted:

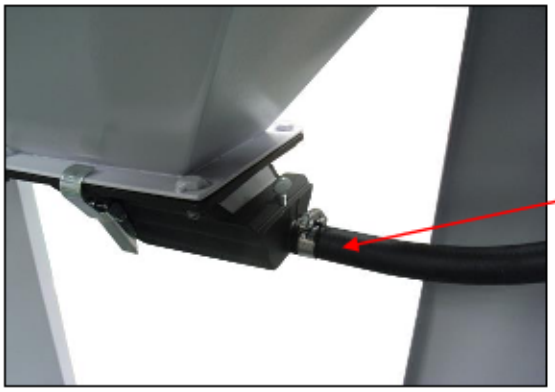
Item code	Description
P2PF0014	Euro 2 Antifrost sheet
P2GL0010	Euro 2 Glass

Check there is enough light entering the cabinet to work by. If not the illumination window **(P2GL0012)** may be scratched. Replace if necessary.

The rubber gasket **(R5SL0000)** and the gasket filler strip **(R5SL0002)** should also be inspected and replaced if necessary.



7.1.3 Hoses

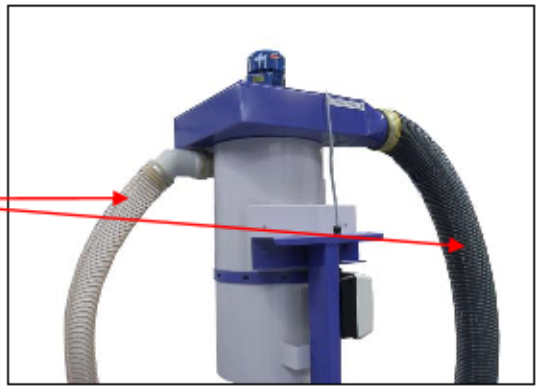


Check the media supply hoses **(R6TB0018*)** for signs of wear and damage. Internal wear can be determined by feeling the rigidity of the tubing along its length. Any internal wear will result in the hose feeling soft where the hose wall is thinner. The first section to wear out is usually next to the pick up tube.

*The Euroblast 2 has a different size media hose **(R6TB0014)**

Item code	Description
R6TB0014	Media hose - 10mm
R6TB0018	Media hose - 16mm

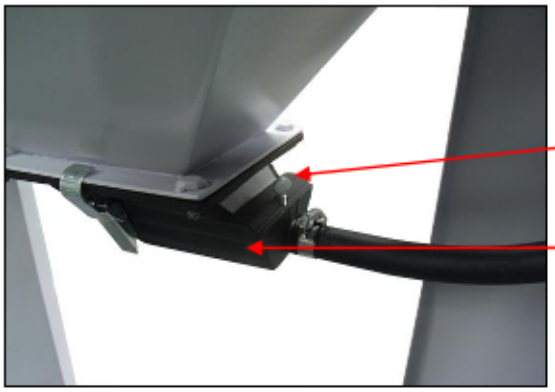
Check the extraction hoses for holes or breaks as these will affect the rate of extraction from the cabinet.

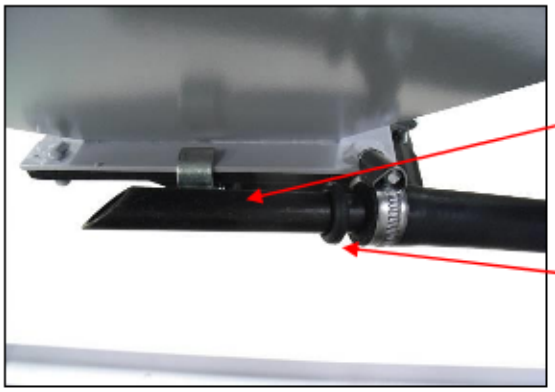


Item code	Description
R6TB0030	Flexible exhaust ducting - standard - 100 mm bore (m)
R6TB0032	Flexible exhaust ducting - polyurethane - 100 mm (m)
P2HS0000	Hose sleeve - 100mm
P1HC0004	Hose clip - 100mm
Y2AB0013	Hose flange - 100mm
R6TB0034	Flexible exhaust ducting - standard - 150 mm bore (m)
R6TB0036	Flexible exhaust ducting - polyurethane - 150 mm bore (m)
P2HS0001	Hose sleeve - 150mm
P1HC0006	Hose clip - 150mm
Y2AB0014	Hose flange - 150mm

7.1.4 Pick up tubes and mixer box

Unscrew the retaining screw so the mixer box and the pick up tube can be inspected for wear and replaced when necessary. Refer to section 5.1.2 for setting up the new mixer box and/or pick-up tube.

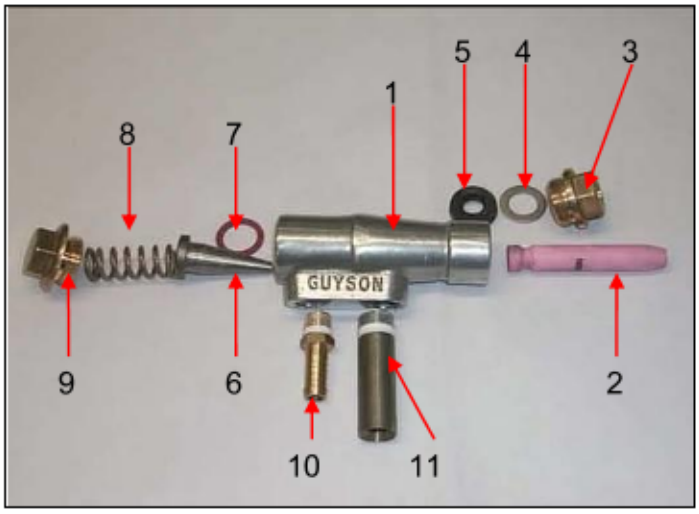




Item code	Description
E1AA4060	16mm pick up tube
E1AA3673	10mm pick up tube

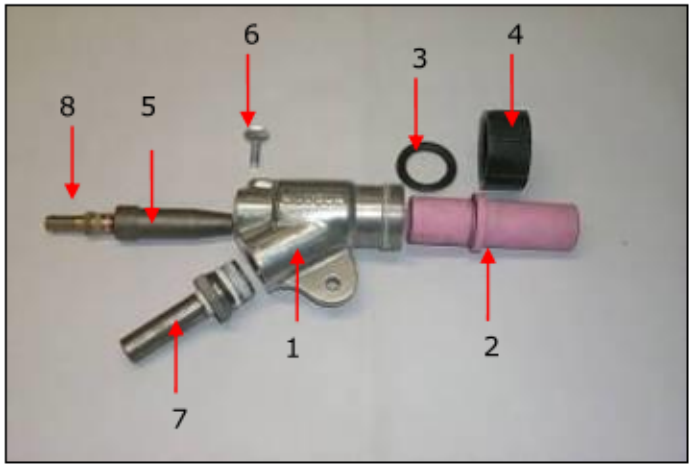
7.1.5 Blast nozzles

400 Blast gun



Pos	Item code	Description
1		400 Gun body
2	D2BA0001	6.4mm Ceramic nozzle
	D2BA0002	8.0mm Ceramic nozzle
	D2BA0004	6.4mm Tungsten nozzle
	D2BA0005	8.0mm Tungsten nozzle
3	D2AA0007	Nozzle locknut
4	P1WS0038	Nozzle washer
5	P2GT0012	Nozzle grommet
	D1AA0000	2.0mm Airjet
	D1AA0001	2.4mm Airjet
6	D1AA0002	2.8mm Airjet
	D1AA0003	3.3mm Airjet
7	P1WS0037	Airjet gasket
8	P2SG0000	Airjet coil spring
9	D2AA0008	Top nut
10	P4CG0001	¼" Hosetail x 10mm
11	P4CG0002	Media entry 3/8" x 16mm
	P4CG0006	Media entry 3/8" x 10mm

900 Blast gun



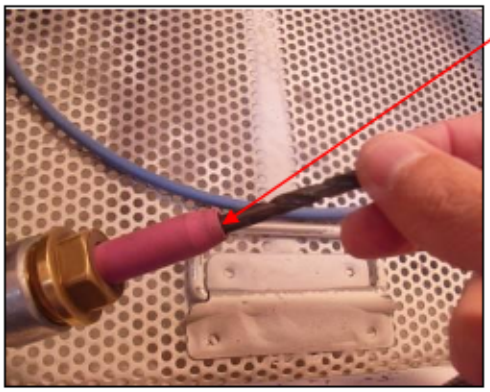
Pos	Item code	Description
1		900 Gun body
2	D2BA0006	9.5mm Ceramic nozzle
	D2BA0007	12.7mm Ceramic nozzle
	D2BA0009	9.5mm Boron nozzle
	D2BA0010	12.7mm Boron nozzle
3	P1WS0039	Nozzle washer
4	D2AA0009	Nozzle locknut
	D1AA0004	3.2mm Airjet
	D1AA0005	4.0mm Airjet
5	D1AA0006	4.8mm Airjet
	D1AA0007	6.4mm Airjet
	D1AA0012	3.2mm Tungsten sleeved airjet
	D1AA0011	4.0mm Tungsten sleeved airjet
	D1AA0008	4.8mm Tungsten sleeved airjet
6	P1TH0189	Thumbscrew
7	P4CG0009	Media entry 16mm Hose
8	P4CG0001	¼" BSP Hosetail x 10mm

Blast nozzle

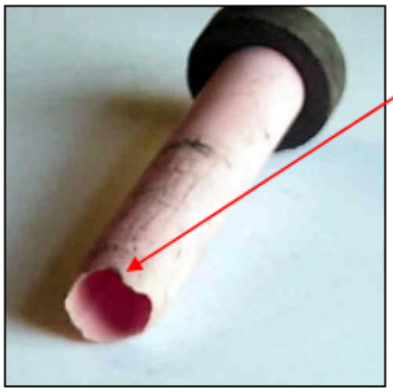
Inspect the blast nozzle for wear. When the bore size has increased by 20% (6mm bore @ 20% = 7.2mm) then the nozzle needs to be replaced. The effective bore of a nozzle can be quickly checked by use of a twist drill bit.

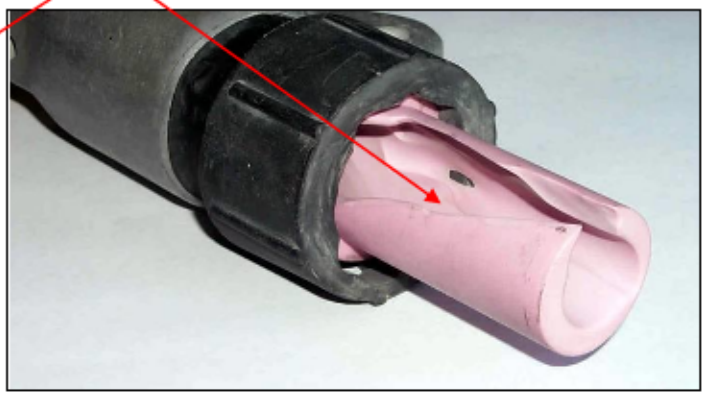
The nozzle should be withdrawn from the gun body after 8 hours blasting and rotated by 5° to avoid uneven wear.

CAUTION: CUSTOMER WEAR LIMITS ON SHOT PEENING APPLICATIONS MAY NEED TO BE 10% WEAR LIMIT MAXIMUM



The pictures below show extremely worn nozzles. Your nozzle should not be allowed to reach this state as it will decrease its blasting effectiveness and may also damage the blast gun.





Airjet

The airjet should be withdrawn from the gun body after 8 hours blasting to establish the wear pattern on its outer surface. When wear has become noticeable, the fitting should be rotated to the next unworn section. When wear has occurred around the whole circumference, the airjet should be replaced.

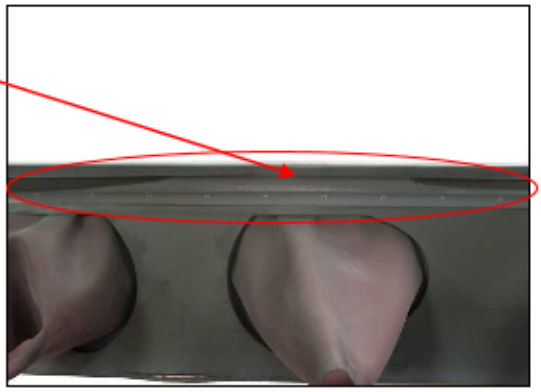
Media entry

The media entry connection should be withdrawn from the gun body and inspected for wear on a regular basis.

7.1.6 Door seals

If the door gasket strips are worn then:

- this allows noise to escape from the cabinet more easily
- media may be able to exit the cabinet



Item code	Description
R5SL0024	16mm wide x 5m roll
R5SL0027	25mm wide x 5m roll
R5SL0026	38mm wide x 5m roll

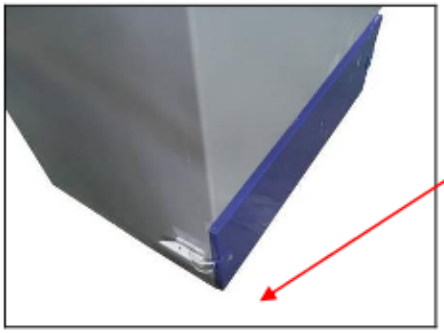
7.1.7 Overspray

Care should be taken not to wear away the insides of the cabinet. If certain areas are getting increased wear then Guyson International can supply rubber curtains and linings.

7.1.8 Empty waste bin

The dust collector bins should be emptied twice daily. They should also be checked for good media. If this is present then the dust collector/cyclone settings will need adjusting.

CARE SHOULD BE TAKEN WHEN HANDLING THE WASTE BINS AS THEY MAY BE HEAVY

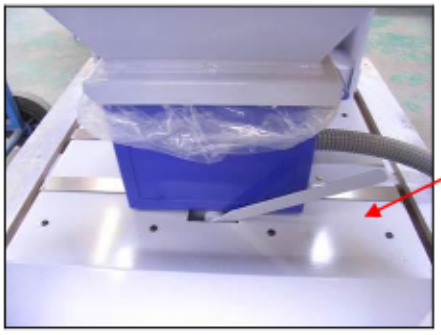


41 Dust collector

This bin is held in by clips on both sides of the dust collector. Release these to remove the bin from the dust collector.

C400 Dust collector

This bin is compressed against the filter chamber of the dust collector by a lifter cam. To lower the bin, use the handle on the side. Then slide the bin out.



C600 and C800 Dust collector

This bin is compressed against the filter chamber of the dust collector by a lifter cam. To lower the bin; use the lever on the side. Then slide the bin out.
It is essential that a plastic bin liner (Y1CA0047) is used.
If a bin liner is not used then dust will be drawn up into the clean side of the dust collector.

HE Cyclone waste bin

This bin is compressed against the filter chamber of the dust collector by a lifter cam. To lower the bin; use the lever on the side. Then slide the bin out. The bin is also raised so a suitable lifting mechanism can be used to move the bin.

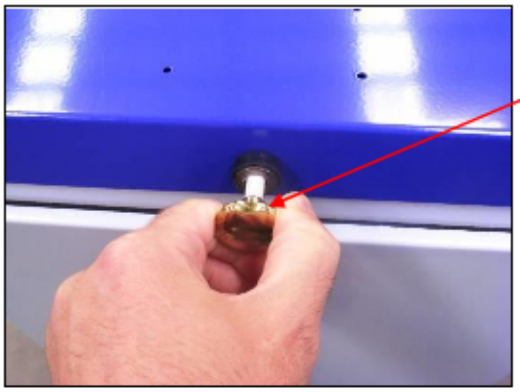
7.1.9 Topping up media

Top up the media levels as required as media is consumed. This can be roughly gauged from the waste bin on the dust collector. Regular additions of small quantities of media maintain an even particle size and assist in producing consistent results.

7.1.10 Filter cleaning

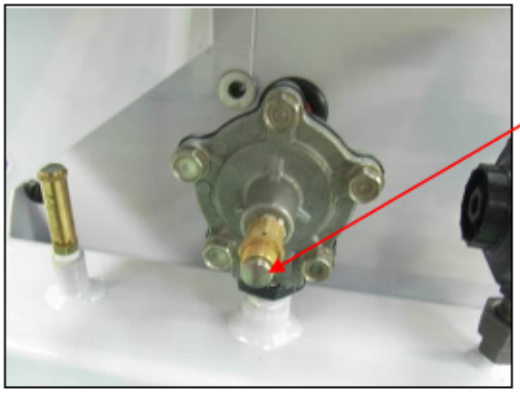
Filter cleaning must be carried out on a regular basis. Initially this should be carried out every four hours, until a working pattern is reached. The table below shows the different cleaning mechanisms on the various dust collector models:

THE MOTOR SHOULD BE SWITCHED OFF WHEN USING THE CLEANING MECHANISM ON THE 41, C400 AND C600 DUST COLLECTORS



41 Dust collector

The filter cleaning system is manual. Pull and push the knob back and forth to shake the filter clean.



C400 and C600 Dust collector

The filter cleaning system is manual. Push the button to release the compressed air from the pressure vessel to knock the dust from the filter.

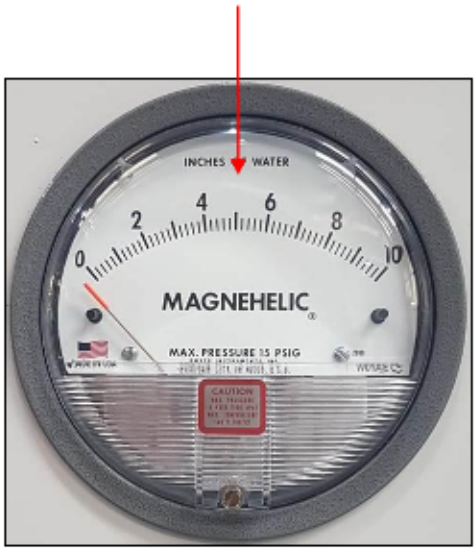
C800 Dust collector

This has an automatic filter cleaning system. A controller automatically releases compressed air from the pressure vessel to knock the dust from the filters.

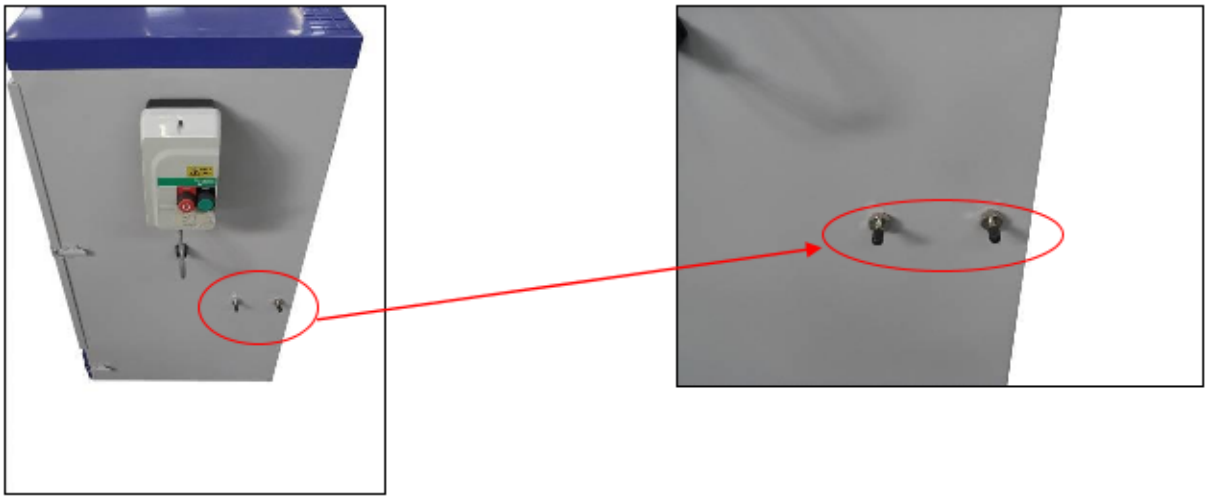
The release interval is set to 30 secs in the factory.

See appendix for controller manual.

C400, C600 and C800 dust collectors are fitted as standard with differential pressure gauges. These measure the differential pressure across the main filter(s). When the pressure difference reaches 5" Water Gauge then a filter change will be necessary. The HEPA 14 filter (where fitted) has a separate gauge. When this reaches 2.5" Water Gauge then a filter change will become necessary. See sections 7.1.10.4 and 7.1.10.5 for details.

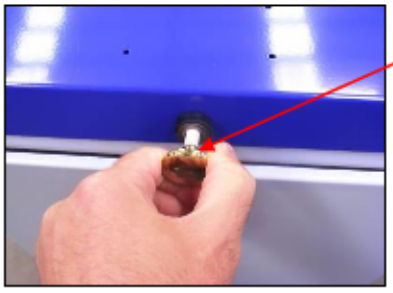


The 41 dust collector does not come fitted with differential pressure gauges as standard. Hosetails are fitted as standard allowing an aftermarket differential pressure gauge (**E1AA1836**) to be used.



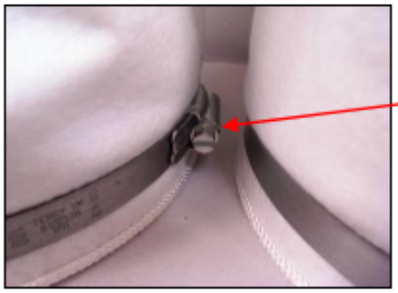
On a 41 dust collector, after approximately five hundred hours use the dust will have worked its way into the body of the filters and cleaning with the cleaning mechanism will no longer clean sufficiently to allow enough air through. This will be evident by poor visibility in the cabinet and/or failure to extract the dust even with the dust collector damper fully open. A filter change will be necessary at this point.

7.1.10.1 Replacing the filter sleeves on a 41



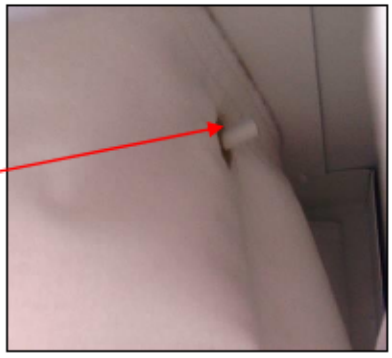
Shake filters and allow dust to settle.

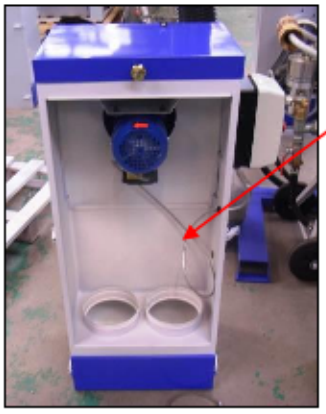
Remove front panel by unhooking latches.



Remove large worm-drive clip from base of each filter sleeve.

Unhook top of each filter from retainer clip.



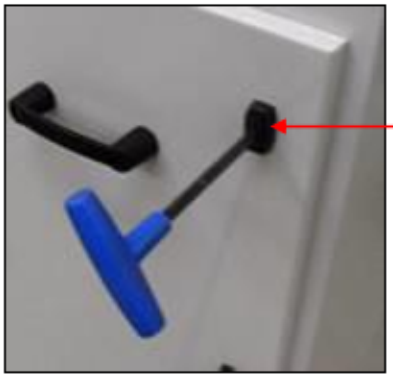


Carefully remove filter from dust collector.

Replace with new filter sleeve **(Y1CA0000)** by hooking top of filter onto retainer clip first then pass worm drive clip over the base of the sleeve and secure to base of dust collector. Re-fit front cover.

7.1.10.2 Replacing the filter cartridge on a C400

- Press the filter cleaning push button and turn off the air supply.



Turn anti-clockwise to unlock

Remove front cover

For filter removal turn lifter cam 180° to the left

The cam is now unlocked and the filter cartridge can be removed

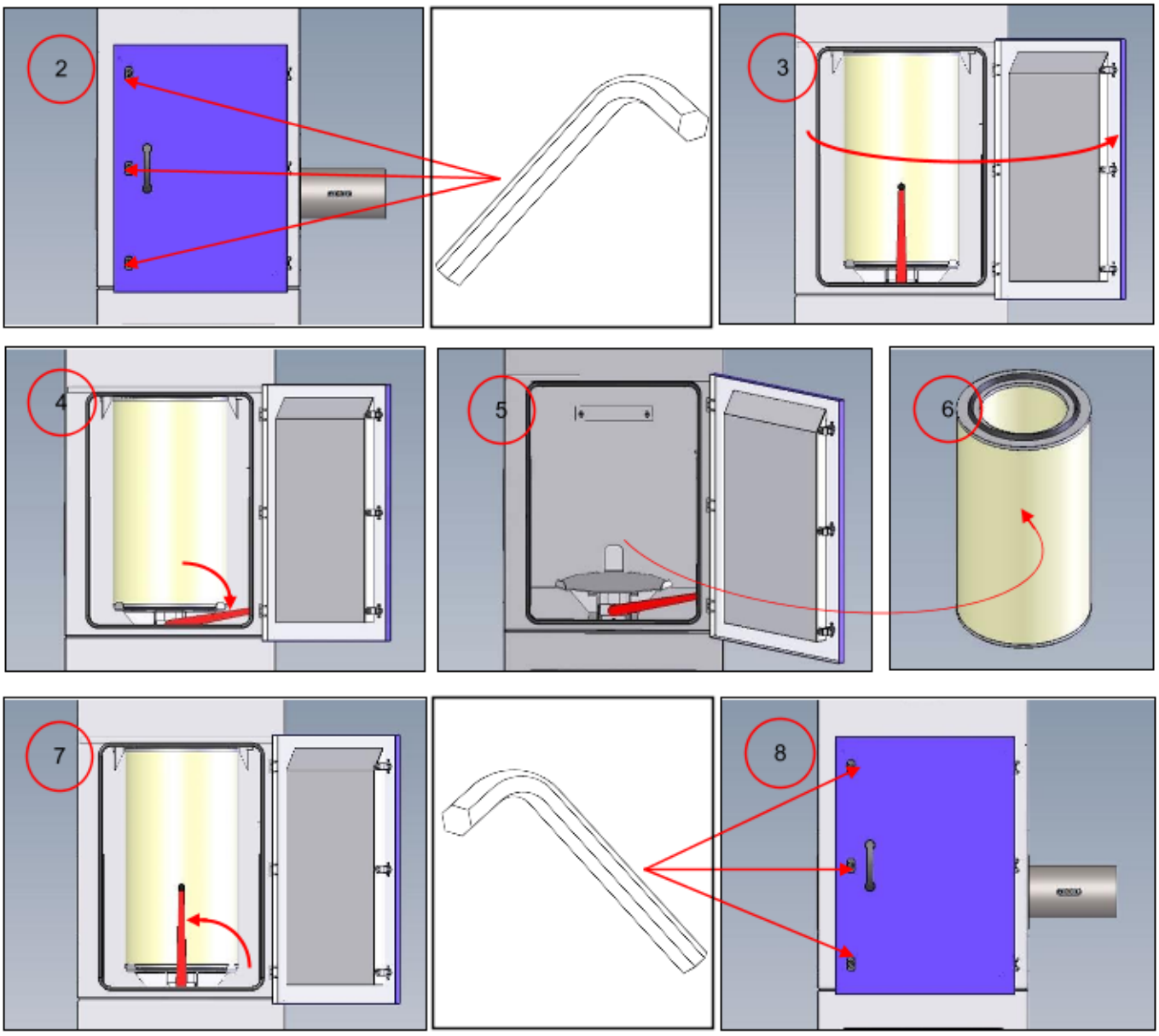
Replace with new filter cartridge **(Y1CA0049)**

Turn lifter cam 180° to the right to lock cartridge

Replace front cover

ENSURE THE FILTER IS CORRECTLY POSITIONED SO THAT DUST CANNOT BYPASS IT TO THE EXHAUST

7.1.10.3 Replacing the filter cartridge on a C600



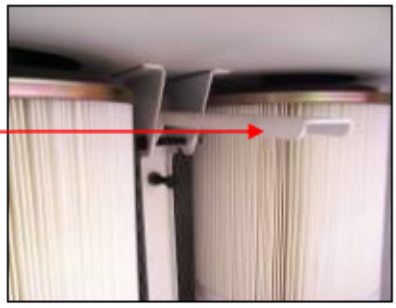
Press the filter cleaning push button and turn off the air supply

1. Turn anti-clockwise to unlock
2. Open door.
3. For filter removal turn lifter cam 90° to the right
4. The cam is now unlocked and the filter cartridge can be removed
5. Replace with new filter cartridge **(Y1CA0049)**
6. Turn lifter cam 90° to the left to lock cartridge
7. Close door and lock

7.1.10.4 Replacing the filter cartridges on a C800

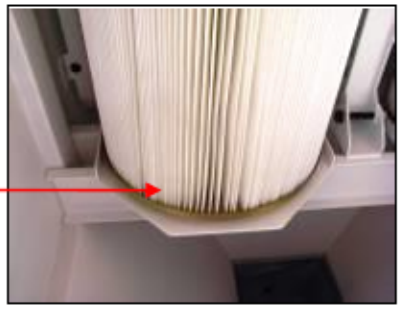
Unlock and open door

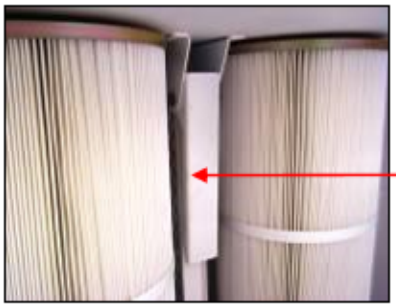
Lift filter handle to its unlocked position



Remove filter cartridges and clean inside the dust collector

Fit new filter cartridge (**Y1CA0049**) ensuring cartridge sits to the rear of the bottom plate





Ensure filters are sitting evenly on the top plate

Lower lifting handle to its locked position

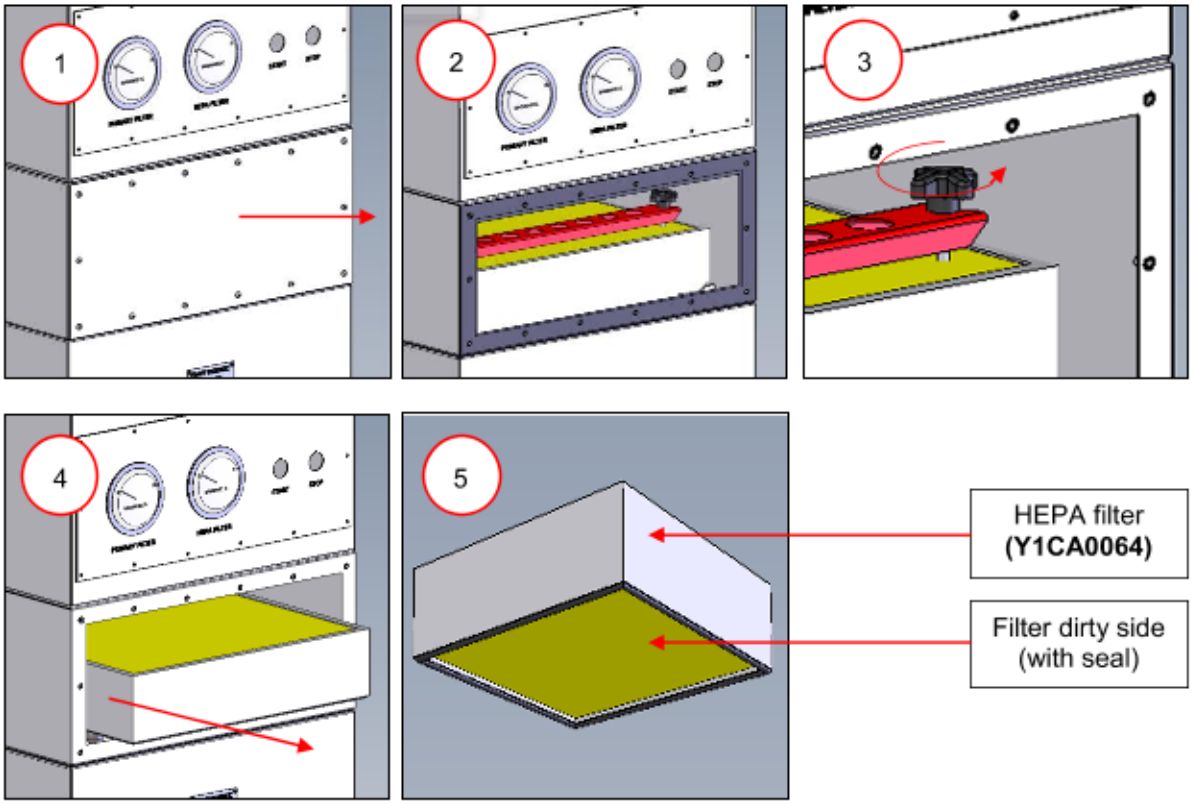
Close door and lock

ENSURE THE FILTERS ARE CORRECTLY POSITIONED SO THAT DUST CANNOT BYPASS THEM TO THE EXHAUST

7.1.10.5 Replacing the HEPA14 Filter Cartridge, C600 Dust Collector

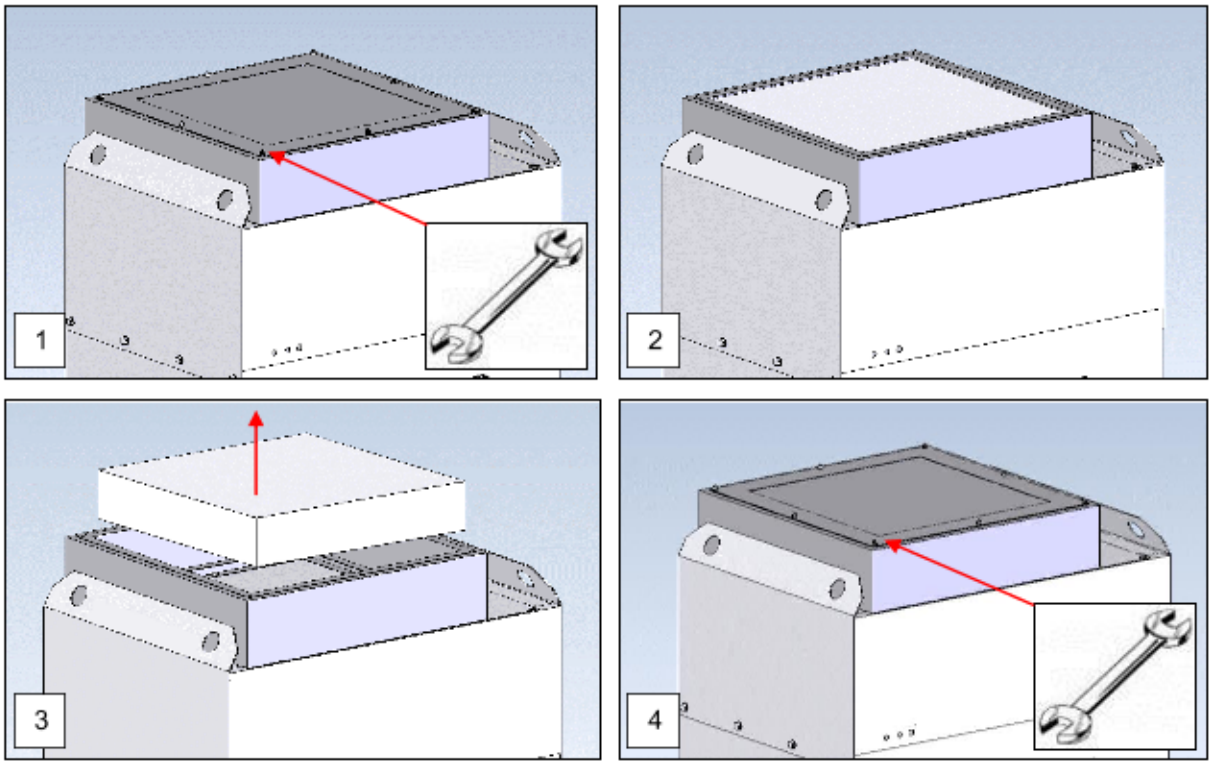
A secondary HEPA14 filter has been added to ensure maximum air filtration, minimising the amount of air born particles exhausted by the system. The health of this filter is checked by using the Magnehelic manometer gauge fitted to the side of the machine. This measures the differential pressure across the main filters. When the pressure difference reaches 2.5" Water Gauge then a filter change will be necessary.

1. Undo the screws from the filter door and remove
2. Check gasket for signs of damage
3. Remove the clamp bars by unscrewing the retaining knobs either side
4. The filter can now be lifted and removed
5. The HEPA14 filter is fitted with a continuous airtight seal on one side. Ensure the filter is fitted with the seal side on the dirty side of the airflow (facing down).



7.1.10.6 Replacing the HEPA14 Filter Cartridge, C800 Dust Collector

A secondary HEPA filter has been added to ensure maximum air filtration, minimising the amount of air born particles exhausted by the system. The health of this filter is checked by using the magnehelic manometer gauge fitted to the side of the machine. This measures the differential pressure across the main filters. When the pressure difference reaches 2.5" Water Gauge then a filter change will be necessary.



1. Undo the M6 Hex Screws from the filter lid and remove.

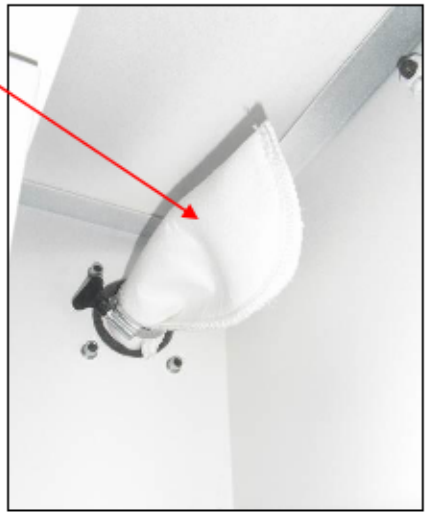
2. Replace with a new HEPA filter **(Y1CA0064)** ensuring that the air flow arrow on the filter match those on the inner frame.

3. Carefully lift the HEPA panel filter from the frame and remove.

4. Replace the filter lid and tighten the M6 Hex screws.

7.1.10.7 Bin Balance Breather Sock

When changing the filter cartridges on a dust collector fitted with a bin balance pipe, check that the filter sock is in place and not full of media. The filter sock is attached to the end of the bin balance pipe and is there to prevent dust from being drawn into the clean side of the dust collector.



If a plastic bin liner has not been used then dust will be drawn up the bin balance pipe into the sock.

It is essential therefore that a plastic bin liner is always used.

Check that the sock is firmly attached and not full of dust. The sock prevents dust from contaminating the clean side, as dust will be drawn out of the dust collector bin if a plastic bin liner is not used.

7.1.10.8 Autopulse, C400 and C600

Filter cleaning must be carried out on a regular basis. Initially this should be carried out every four hours. This can be done by setting the DLUX pulse timer correctly. The pulse timer has two settings, the first being how long you want the machine to be pulsed for (discharge time), the other being the frequency in which you want the machine to be pulsed (interval time). The ON and OFF time on the DLUX timer can be programmed anywhere between 10 milliseconds and 99 hours.

To set these, follow the below instructions:

ON = Discharge Time

OFF = Interval Time

To change the ON time (discharge time), simply press the right 'on/arrow up' button and 'on' will appear briefly on the display. You can now press the 'off/arrow down' button to decrease the time or the right 'on/arrow up' button to increase the time. Once the desired ON time is set, simply don't press any buttons and the display will flash, indicating that the new time is being saved. Once saved, the unit will operate with the new time setting.

To change the OFF time press the left 'off/arrow down' button and 'off' will appear briefly on the display. You can now press the left 'off/down arrow' for decreasing the time or the right 'on/arrow up' for increasing the time. Once the desired OFF time is set, simply don't press any buttons and the display will flash, indicating that the new time is being saved. Once the new time is saved, the unit will start operating with the new settings.

The TEST button allows you to check the valve function.

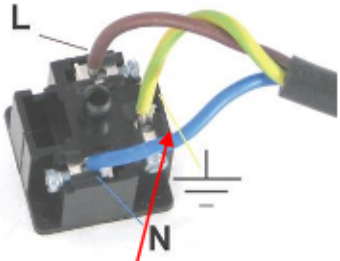
Replacing the AutoPulse Timer:

NOTE: Before any installation or replacement occurs, depressurise the system.

Having removed the old timer, follow the below instructions to install the new one.

Place the flat gasket over the coil connection pins.

Mount the timer on to the coil as shown above.



Connect your power cable to the connector as shown above.

Place the connector gasket on the connector, plug the connector on the timer as shown below and tighten the screw

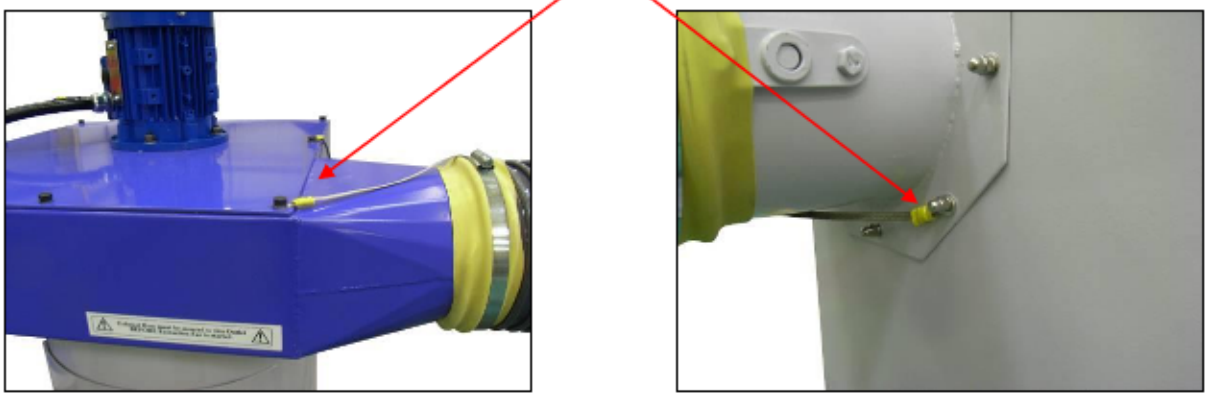
You are now ready to start using the DLUX timer again. Restore normal system pressure and proceed to use the machine.

7.1.11 Compressed air filter

The compressed air filter is self draining. If the media is dry and not clumping together then the compressed air filter is working correctly. If the media is clumping together then there is a problem with the compressed air filter or your air supply. Guyson International should be contacted for more information.

7.1.12 Earthing bonds

Check that the earthing wires between the separate units of the system are secure.



7.2 Weekly

- Inspect hopper elbow and wear plates for wear (see section 7.2.1)
- Inspect cyclone interior and wear plates for wear (see section 7.2.2)
- Inspect sleeves/gauntlets for wear (see section 7.2.3)
- Inspect side loader turntable trolley (see section 7.2.4)
- Ensure turntable is free to rotate (see section 7.2.5)

7.2.1 Hopper elbow

Hopper elbows will either be made of PU or Mild Steel. If they are Mild Steel they will either have a PU or Mild Steel Wear plate fitted depending on the specification ordered. The wear plate should be inspected and replaced when worn thin. If the elbow is made of PU and has worn through then a new hopper elbow will be required.

7.2.1.1 Replacing the wear plate

- Turn dust collector on
- Turn cyclone on
- Run machine for 10 minutes to clear pipes
- Turn cyclone off
- Turn dust collector off
- Detach hopper elbow
- Replace wear plate
- Reattach hopper elbow

Item code	Description
E1AA0097	90° Ø100 PU Hopper elbow
E1AA3176	Wear plate side loader hopper elbow

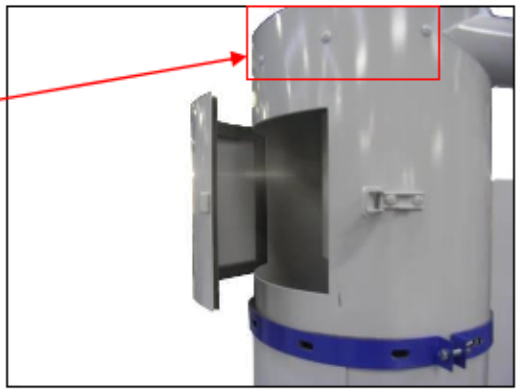
If your elbow is not one of those listed in the table above then please contact Guyson International for more information.

7.2.2 Cyclone

Cyclones will either have a PU lining or a wear plate fitted depending on the specification ordered. The wear plate should be inspected and replaced when worn thin. The PU lining cannot be relined and a new cyclone body will be required when it has been worn away.

7.2.2.1 Replacing the wear plate

- Open the top door
- Remove the 3 bolts while holding on to the wear plate to stop it falling off
- Replace wear plate and secure it in position with the 3 bolts

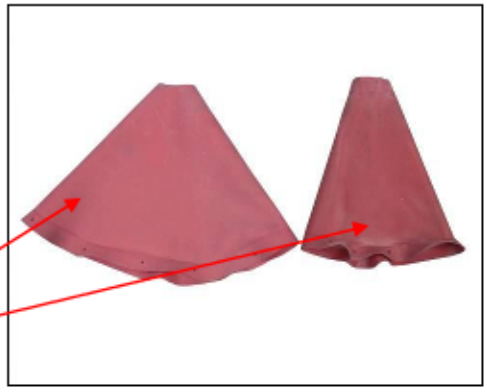


Item code	Description
E1AA2454	75/16 Body wear plate
E1AA2711	CY600/12 Body wear plate
E1AA2713	CY600/12 Entry wear plate
E1AA1611	CY600/16 Body wear plate
E1AA1613	CY600/16 Entry wear plate

7.2.3 Sleeves/Gauntlets

If the sleeves or gauntlets have holes in them or have split then:

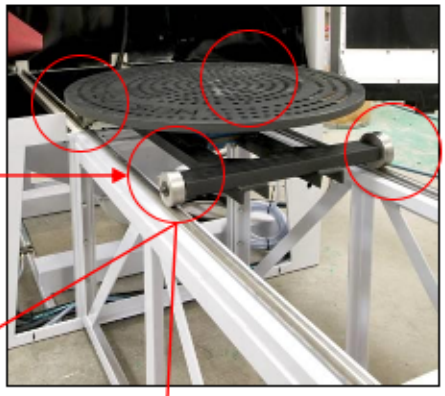
- this allows noise to escape the cabinet more easily
- media may be able to exit the cabinet

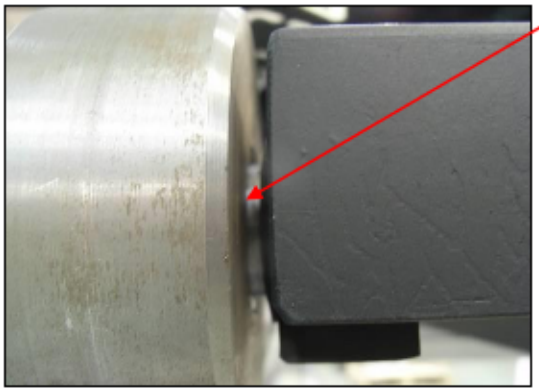


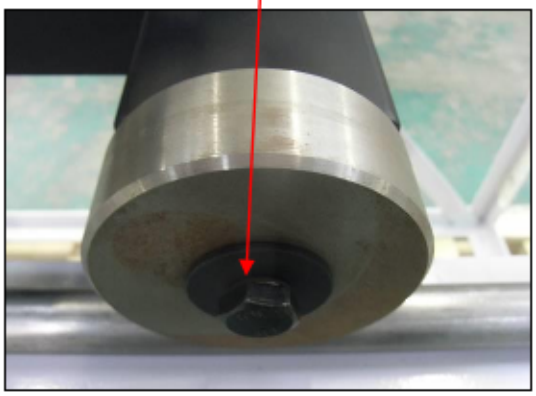
Item code	Description
Y1AA0024	Armhole sleeve large
Y1AA0011	Armhole sleeve 3 corner
Y1AA0017	Gauntlets

7.2.4 Side loader turntable trolley

The turntable trolley should be checked to see that its 4 wheels are running smoothly and freely. If not then the wheels/spacers/washers may have worn and need replacing.



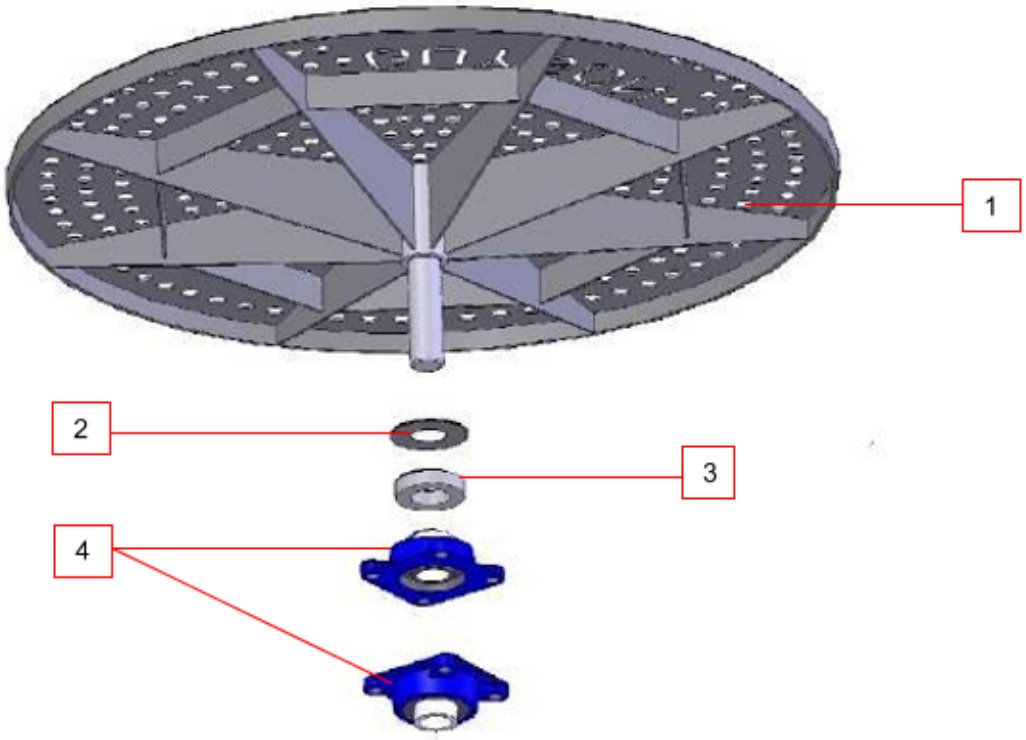




Item code	Description
E1AA0298	Euro 6/7/8/9 Vee wheel
E1AA0299	Euro 6/7/8 Flat wheel
E1AA0301	Euro 6/7/8 Spacer
P1WS0010	Euro 6/7/8 Washer
P1PN0010	Euro 6/7/8 Split pin
E1AA0308	Euro 9 Flat wheel
E1AA0309	Euro 9 Inner washer
E1AA0310	Euro 9 Outer washer
E1AB5909	Euro 10 Outer PTFE washer
E1AB5910	Euro 10 Outer MS washer
P5BE0006	Euro 10 Sealed bearing
E1AB4167	Euro 10 Flat wheel
E1AB4166	Euro 10 Vee wheel
E1AB5911	Euro 10 Inner PTFE washer
E1AB5912	Euro 10 Outer MS wheel

7.2.5 Turntable rotation

The turntable should be checked to see that it is able to rotate freely. If it will not rotate freely or is completely jammed check the bearings and replace if necessary.



Pos.	Description	Item Number
1	Turn table, various sizes and finishes available	Call for options
2	Washer, Euro 6/7/8/9/10, sideloader and non-sideloader	E1AA0104
3	Felt seal, Euro 6/7/8/9/10, sideloader and non-sideloader	P5SE0019
4	Flange bearing, Euro 6/7/8/9/10, sideloader and non-sideloader	P5BE0017

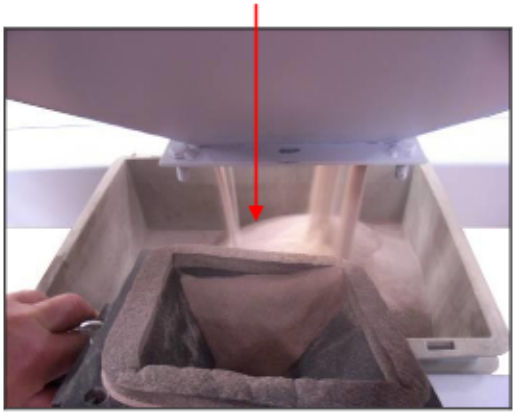
7.3 Monthly

- Drain old media and discard (see section 7.3.1) and refill system with new media (see section 4.2).

7.3.1 Emptying media

To empty machine:

- Turn on the dust collector
- Turn on the cyclone
- Use an air line to clean inside cabinet
- Once clean leave dust extraction on for 10 minutes to clear pipes of residual media
- Switch off cyclone
- Switch off dust collector
- When motor has stopped remove pick-up tube from mixer box
- Place container under mixer box, unclip and remove mixer box and collect media



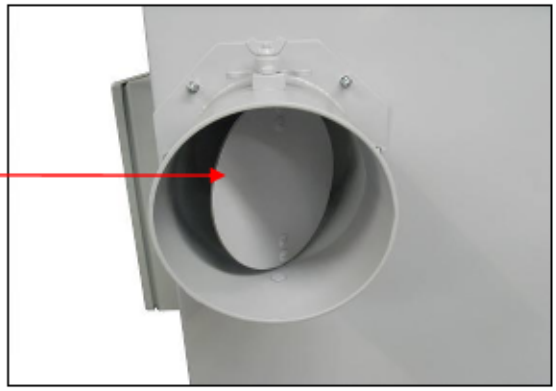
TAKE CARE TO AVOID TRAPPING FINGERS; THE MIXER BOX COULD BE VERY HEAVY

7.4 Quarterly

- Inspect blast gates for internal wear (see section 7.4.1)

7.4.1 Blast gates

Inspect for excessive wear. If this wear is so excessive that you cannot set the blast gate correctly then it will need replacing. Contact Guyson International for more information.



8. FAQ's

Static Electricity

Cabinet, media and component

Un-insulated earth braid wrapped round the media hose and/or connected to the component and then earthed to the cabinet and extraction equipment provides a drain path.

Static build-up on extraction hose

Un-insulated earth braid wrapped round the extraction hose and earthed to the cabinet and extraction equipment provides a drain path.

If you experience any problems with static electricity please contact our Service Department

FAULT-FINDING CHECKS SHOULD ONLY BE CARRIED OUT BY A FULLY QUALIFIED ENGINEER

IF REQUIRED THE BLAST CABINET AND ALL ITS ANCILLARY EQUIPMENT SHOULD BE FULLY ISOLATED BEFORE PERFORMING ANY FAULT FINDING CHECKS

IF REQUIRED ENSURE ALL AIR SUPPLIES ARE TURNED OFF AND THE SYSTEM IS FULLY EXHAUSTED BEFORE PERFORMING ANY MAINTENANCE

Questions for suction-feed machines		
Fault	**No air from blast gun when in cycle**	**Action**
Possible cause	Bore of air-jet in blast gun blocked	Unblock and clean
	Nozzle blocked	Unblock and clean
Fault	**Moisture coming from blast gun nozzle**	**Action**
Possible cause	Fault with customer air supply	Customer to check and correct
Fault	**Air pressure from blast nozzle drops**	**Action**
Possible cause	Compressor fault/not to specification	Customer to check air supply and correct
	Incorrect mains supply pipe diameter	Refer to Data sheets, change pipe
	Worn air-jets or nozzle	Replace

	Faulty air valve	Replace
Fault	**No media flow from blast gun**	**Action**
Possible cause	Pick-up-tube incorrectly set in mixer box	Refer to Setting Media Pick-up-tube
	Damp media causing poor flow to mixer box	Replace media and check air supply and compressed air filter
	No suction at pick-up-tube	Check for hose blockage/ gun wear
	Blocked media supply hose to blast gun	Unblock
	No media in hopper	Refill
	Blocked nozzle	Unblock
Fault	**Erratic media flow from gun nozzle**	**Action**
Possible cause	Incorrect pick-up-tube setting	Refer to Setting Media Pick-up-tube
	Incorrect air-pressure setting	Refer to Set-up information
	Worn pick-up-tube/air-jet/gun nozzle	Replace as necessary
	Hole in gun body	Replace as necessary
	Air supply causing moisture in media	Customer to check air supply
Questions for machines with Cyclones / Dust collectors		
Fault	**Incorrect media separation**	**Action**
Possible cause	Cyclone vortex incorrectly set	Refer to Cyclone set-up
	Breather filters blocked	Replace
	Cyclone door seals worn/bin seals faulty	Replace as necessary
Fault	**Poor visibility/dust emissions**	**Action**
Possible cause	Lack of negative pressure in extraction system	Check dust collector filters and damper settings
	Damaged hoses on dust collector	Replace
	Breather filters blocked	Replace
	Poor media quality	Replace all media
If problems are ongoing please conduct a full maintenance service of the equipment or contact Customer Services to book a Guyson Service Engineer visit		

9. Spares and servicing

A maintenance and service agreement for this system is available as an optional extra, for further details please refer to contact details below.

When ordering spares or accessories please quote the following information:

Customer Account Number
Machine Serial Number
Product code of item required

If an item need replacing that is not listed in the maintenance section and cannot be identified from the assembly drawings in the appendix of this manual then please contact Guyson International on the details below for further help.

Guyson International Limited
Snaygill Industrial Estate
Keighley Road
Skipton
North Yorkshire
BD23 2QR

Tel: 01756 799911
Fax: 01756 790213
E-mail: info@guyson.co.uk
Website: www.guyson.co.uk

9.1 Spare parts identification

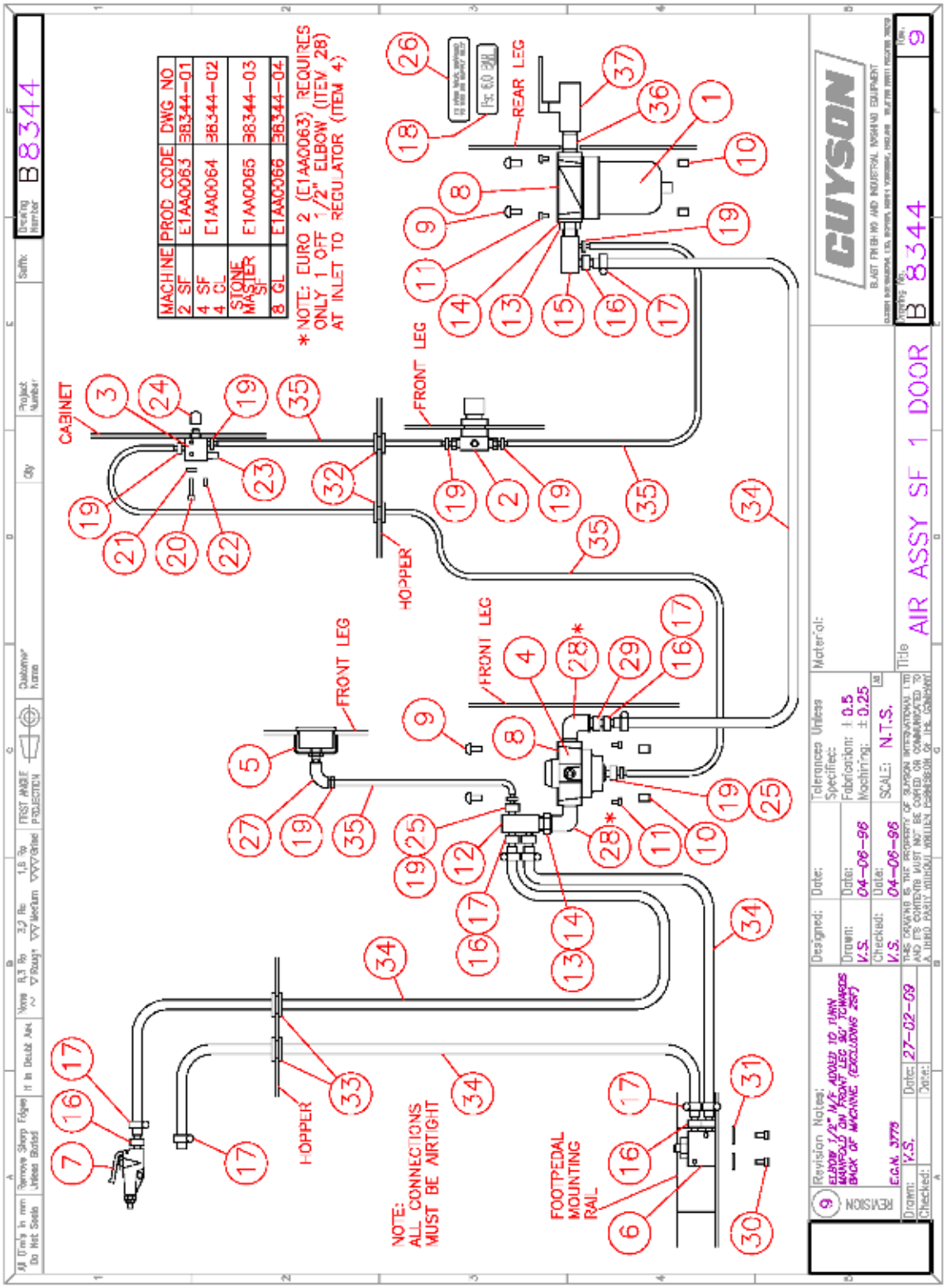
Description	2	4	6	7	8	9	10	Item code
Breather pads	✓	✓	✓	✓	✓	✓	✓	Y1AB0001
Antifrost sheet		✓	✓	✓	✓	✓	✓	P2PF0013
Euro 2 Antifrost sheet	✓							P2PF0014
Viewing window glass		✓	✓	✓	✓	✓	✓	P2GL0009
Euro 2 viewing window glass								P2GL0010
Viewing window gasket strip	✓	✓	✓	✓	✓	✓	✓	R5SL0009
Illumination window	✓	✓	✓	✓	✓	✓	✓	P2GL0012
Illumination window rubber gasket	✓	✓	✓	✓	✓	✓	✓	R5SL0000
Illumination window gasket filler strip	✓	✓	✓	✓	✓	✓	✓	R5SL0002
Media hose - 10mm	✓							R6TB0014
Media hose - 16mm		✓	✓	✓	✓	✓	✓	R6TB0018
Media pick up tube - 10mm hose	✓							E1AA3673
Media pick up tube - 16mm hose		✓	✓	✓	✓	✓	✓	E1AA4060
Mixer box	✓	✓	✓	✓	✓	✓	✓	E1AA2452
400 Gun Media entry - 10mm	✓							P4CG0006
400 Gun Media entry - 16mm / 900 Gun Media entry - 16mm		✓	✓	✓	✓	✓	✓	P4CG0006/ P4CG0009
Flexible exhaust ducting - standard - 100 mm bore (m)	*	*	*	*	*	*	*	R6TB0030
Flexible exhaust ducting - polyurethane - 100 mm (m)	*	*	*	*	*	*	*	R6TB0032
Hose sleeve - 100mm	*	*	*	*	*	*	*	P2HS0000
Hose clips - 100mm	*	*	*	*	*	*	*	P1HC0004
Hose flanges - 100mm	*	*	*	*	*	*	*	Y2AB0013
Flexible exhaust ducting - standard - 150 mm bore (m)	*	*	*	*	*	*	*	R6TB0034
Flexible exhaust ducting - polyurethane - 150 mm (m)	*	*	*	*	*	*	*	R6TB0036
Hose sleeve - 150mm	*	*	*	*	*	*	*	P2HS0001
Hose clips - 150mm	*	*	*	*	*	*	*	P1HC0006
Hose flanges - 150mm	*	*	*	*	*	*	*	Y2AB0014
90° Ø100 PU Hopper Elbow	*	*	*	*	*	*	*	E1AA0097
Wear Plate Side Loader Hopper Elbow	*	*	*	*	*	*	*	E1AA3176
Armhole sleeve 3 corner	✓	✓	✓	✓	✓	✓	✓	Y1AA0011
Gauntlets	✓	✓	✓	✓	✓	✓	✓	Y1AA0017
Armhole sleeve large	*	*	*	*	*	*	*	Y1AA0024
Floor - Euro 2	✓							E1AA0433
Floor - Euro 4		✓						E1AA0971
Floor - Euro 6			✓					E1AA0896
Floor - Euro 7				✓				E1AA0898
Floor - Euro 8					✓			E1AA0901
Floor - Euro 9						✓		E1AA0905
Floor - Euro 10							✓	E1AA0633

✓ = Standard options fitted to the specified Euroblast
*** = Optional equipment**

10. Appendices

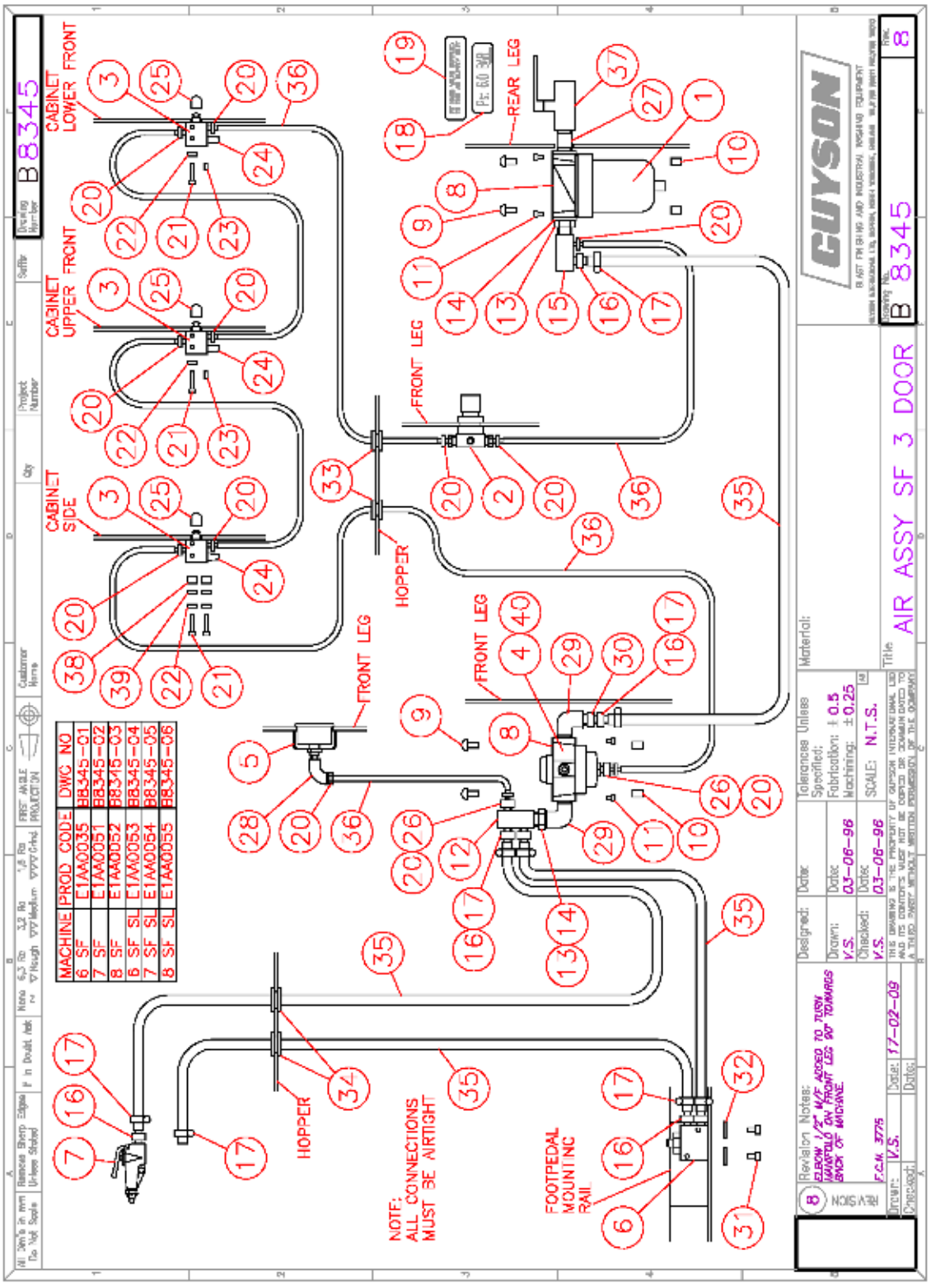
10.1 Mechanical drawings and parts lists

10.1.1 Air assembly for Euroblast 2 SF & 4 SF



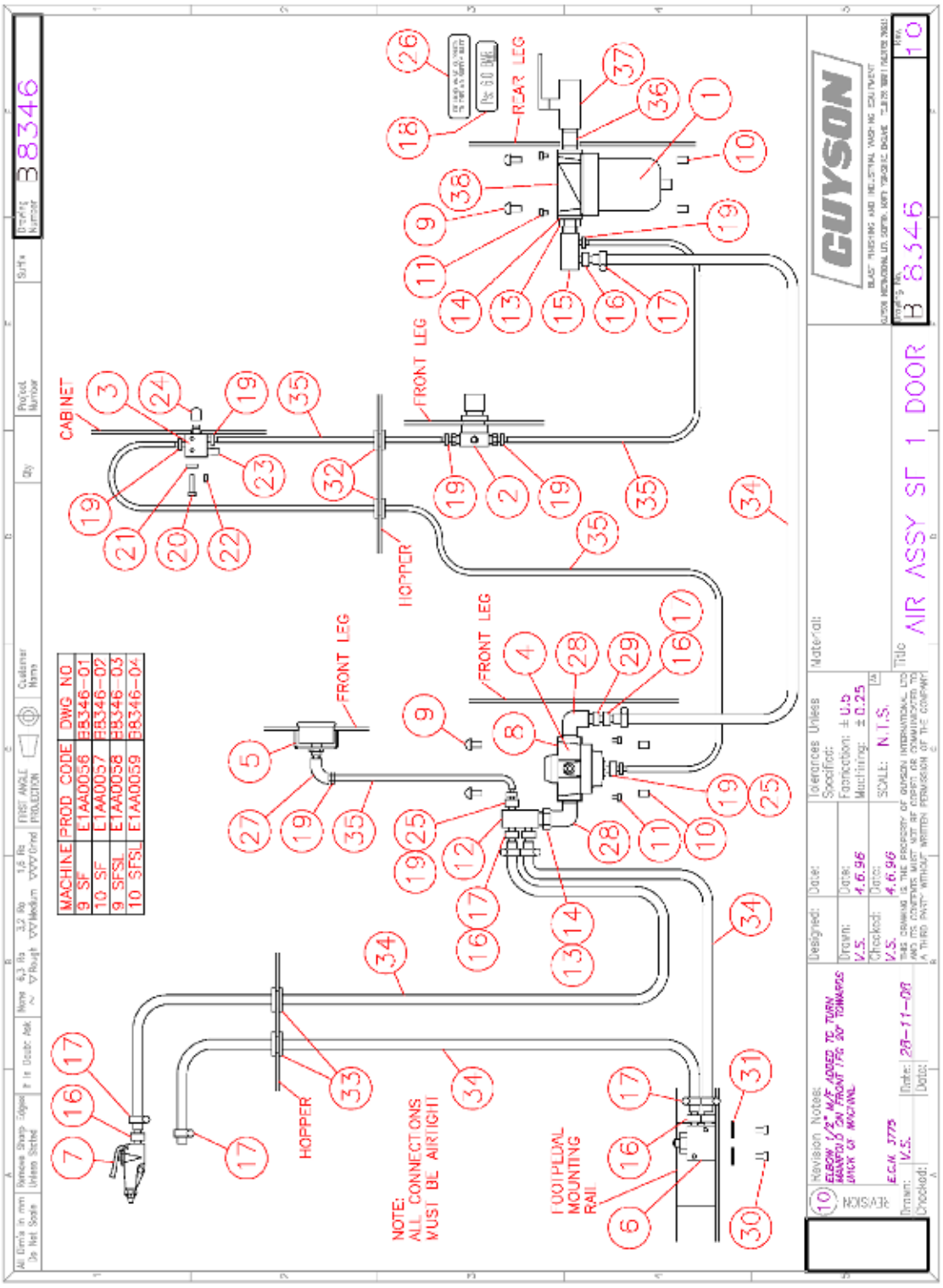
Pos.	Item number	Description
1	P4AP0027	Filter 1/2" BSP Autodrain
2	P4AP0030	Regulator 1/8" BSP Pilot Reg
3	P4VL0033	Plunger Valve 3/2" 1/8" NPT
4	P4AP0028	Regulator 1/2" BSP P/Operated
5	P4SD0000	Press Gauge Panel 0-10 Bar
6	P4VL0059	Plunger 2/2 Valve 1/4" BSP
7	P4VL0072	Valve Trigger Gun (2006ga44)
8	E1AA0032	Mounting Bracket
9	P1TH0184	Hex.Skt. Button Screw M8 x 16
10	P1TH0228	Nutsert M8
11	P1TH0093	Hex.Skt.Cap Screw M5 x 10
12	D1MC0000	Manifold A3201 (3 Outlets)
13	P4MN0179	Locknut 1/2" BSP (Manifold)
14	P1WS0036	Washer Dowty 1/2"
15	D1MC0001	Manifold A15249
16	P4CG0001	Hosetail 1/4" BSP x 10mm Hose
17	P1HC0000	Hose Clip 10mm
18	Y1BB0422	Label, "Ps: 6.0 Bar"
19	P4TF0132	Hosetail Barb 1/8" - 1/8" NPT
20	P1TH0025	Hex. Set Screw M5 x 25
21	P1WS0012	Spring Washer M5
22	E1AA0031	Valve Locating Pin
23	P4SL0002	Silencer 1/8" NPT
24	P2GT0013	PVC Black End Cap
25	P4MN0151	Bush Red. 1/4" x 1/8" BSP
26	Y1BB0056	Label "Fit Hand Valve ...."
27	P4MN0000	Elbow Fem. 1/8" BSP
28	P4MN0019	Elbow M/F 1/2" BSP
29	P4MN0155	Bush Red. 1/2" x 1/4" BSP
30	P1TH0030	Hex. Set Screw M6 x 12
31	P1WS0003	Plain Washer M6
32	P2GT0009	Grommet 5.6 x 8mm
33	P2GT0000	Grommet 10mm PVC Hose
34	R6TB0003	Hose 10mm X 16 OD Braided PVC
35	R6TB0046	Tube 1/8" Id Blue PU
36	P4MN0089	Nipple Barrel 1/2" BSP
37	P4VL0114	Ball Valve 1/2" BSP Venting

10.1.2 Air assembly for Euroblast 6 SF, 7 SF, 8 SF, 6 SF SL, 7 SF SL & 8 SF SL



Pos.	Item number	Description
1	P4AP0027	Filter 1/2" BSP Autodrain
2	P4AP0030	Regulator 1/8" BSP Pilot Reg
3	P4VL0033	Plunger Valve 3/2" 1/8" NPT
4	P4AP0028	Regulator 1/2" BSP P/Operated
5	P4SD0000	Press Gauge Panel 0-10 Bar
6	P4VL0059	Plunger 2/2 Valve 1/4" BSP
7	P4VL0072	Valve Trigger Gun (2006ga44)
8	E1AA0032	Mounting Bracket
9	P1TH0184	Hex.Skt. Button Screw M8 x 16
10	P1TH0228	Nutsert M8
11	P1TH0093	Hex.Skt.Cap Screw M5 x 10
12	D1MC0000	Manifold A3201 (3 Outlets)
13	P4MN0179	Locknut 1/2" BSP (Manifold)
14	P1WS0036	Washer Dowty 1/2"
15	D1MC0001	Manifold A15249
16	P4CG0001	Hosetail 1/4" BSP x 10mm Hose
17	P1HC0000	Hose Clip 10mm
18	Y1BB0422	Label, "Ps: 6.0 Bar"
19	Y1BB0056	Label "Fit Hand Valve ...."
20	P4TF0132	Hosetail Barb 1/8" - 1/8" NPT
21	P1TH0025	Hex. Set Screw M5 x 25
22	P1WS0012	Spring Washer M5
23	E1AA0031	Valve Locating Pin
24	P4SL0002	Silencer 1/8" NPT
25	P2GT0013	PVC Black End Cap
26	P4MN0151	Bush Red 1/4" x 1/8" BSP
27	P4MN0089	Nipple Barrel 1/2" BSP
28	P4MN0000	Elbow Fem. 1/8" BSP
29	P4MN0019	Elbow M/F 1/2" BSP
30	P4MN0155	Bush Red. 1/2" x 1/4" BSP
31	P1TH0030	Hex. Set Screw M6 x 12
32	P1WS0003	Plain Washer M6
33	P2GT0009	Grommet 5.6 x 8mm
34	P2GT0000	Grommet 10mm PVC Hose
35	R6TB0003	Hose 10mm x 16 OD Braided PVC
36	R6TB0046	Tube 1/8" Id Blue PU
37	P4VL0114	Ball Valve 1/2" BSP Venting
38	P1TH0213	Hex. Nut M5 Nyloc
39	P1WS0002	Plain Washer M5
40	P4MN0134	Plug Solid 1/4" BSP

10.1.3 Air assembly for Euroblast 9 SF, 10 SF, 9 SF SL & 10 SF SL



Pos.	Item number	Description
1	P4AP0027	Filter 1/2" BSP Autodrain
2	P4AP0030	Regulator 1/8" BSP Pilot Reg
3	P4VL0033	Plunger Valve 3/2" 1/8" NPT
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5	P4SD0000	Press Gauge Panel 0-10 Bar
6	P4VL0059	Plunger 2/2 Valve 1/4" BSP
7	P4VL0072	Valve Trigger Gun (2006ga44)
8	E1AA0032	Mounting Bracket
9	P1TH0184	Hex.Skt. Button Screw M8 x 16
10	P1TH0228	Nutsert M8
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12	D1MC0000	Manifold A3201 (3 Outlets)
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14	P1WS0036	Washer Dowty 1/2"
15	D1MC0001	Manifold A15249
16	P4CG0001	Hosetail 1/4" BSPx10mm Hose
17	P1HC0000	Hose Clip 10mm
18	Y1BB0422	Label, "Ps: 6.0 Bar"
19	P4TF0132	Hosetail Barb 1/8" - 1/8" NPT
20	P1TH0025	Hex. Set Screw M5 x 25
21	P1WS0012	Spring Washer M5
22	E1AA0031	Valve Locating Pin
23	P4SL0002	Silencer 1/8" NPT
24	P2GT0013	PVC Black End Cap
25	P4MN0151	Bush Red. 1/4" x 1/8" BSP
26	Y1BB0056	Label "Fit Hand Valve ...."
27	P4MN0000	Elbow Fem. 1/8" BSP
28	P4MN0019	Elbow M/F 1/2" BSP
29	P4MN0155	Bush Red. 1/2" X 1/4" BSP
30	P1TH0030	Hex. Set Screw M6 x 12
31	P1WS0003	Plain Washer M6
32	P2GT0009	Grommet 5.6 x 8mm
33	P2GT0000	Grommet 10mm PVC Hose
34	R6TB0003	Hose 10mm x 16 OD Braided PVC
35	R6TB0046	Tube 1/8" Id Blue PU
36	P4MN0089	Nipple Barrel 1/2" BSP
37	P4VL0114	Ball Valve 1/2" BSP Venting
38	E1AA0675	Mounting Bracket

10.2 Electrical schematics and parts lists

The following references are used on the electrical drawing package.
Where numbering is added, this is to distinguish between like components.
Where a component consists of several units performing different functions, separate part numbers are given.

Reference	Description	Example
A	Assemblies/sub-assemblies	Speed controller, PLC
B	Transducers	Pressure, Vacuum, Reed, Proximity and Limit switches
E	Misc. equipment	Machine lighting
F	Protection devices	Fuses, Overloads, RCDs
H	Signalling devices	Visual and Audio indicators
KA	Relays	Control, Signal, Interface relays
KM	Main contactors	Motor contactors
KT	Timers	Process, Interface, Delay timers
M	Motors	All electrical motors
P	Test devices, meters	Hourmeter, Counter, Ammeter, Voltmeter
Q	Mechanical connecting devices for power circuits	Isolators, Circuit breakers
R	Resistors	Potentiometers, Resistors
S	Mechanical connecting devices for control circuits	Selector switches, Pushbuttons
T	Transformers	Voltage: Lighting, Controls, Power, Sensors
U	Converters (electrical)	Rectifiers, Encoders, Filters
X	Terminal connectors	Plugs/Sockets, Terminals
Y	Electrically actuated devices	Solenoid valves, Motor brakes, Door locks

Note:

These reference letters should be distinguished from lower case letters used to identify terminal connections

10.2.1 Electrical installation of dust collectors and cyclones

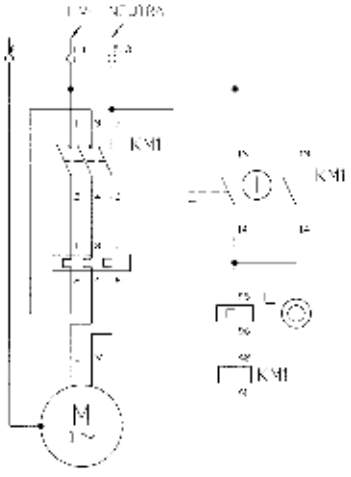
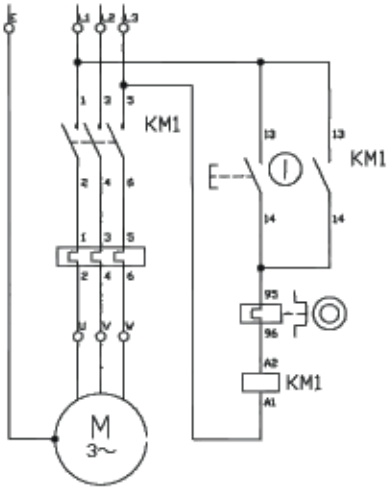
Guyson dust collectors and motorised cyclones (whether for single or three phase supplies), when supplied to complement blast cabinets, are fitted with starters. These should be wired from the customer's switched fused isolator.

The starter needs to be wired up by a suitably qualified electrician; electrical schematics for the single and three phase systems are attached.

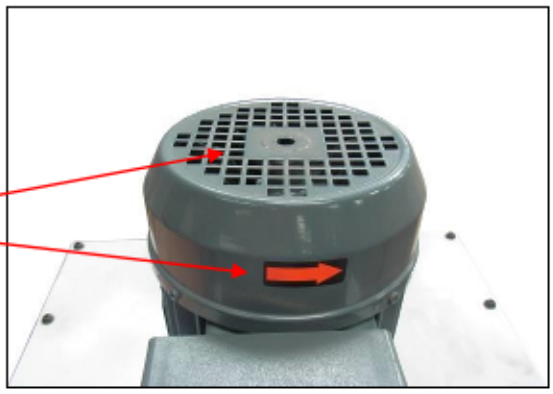
The supply required can be discovered from reading this chart:

Model	Phase	Voltage	Cycle (Hz)	Power (kW)	Full load current (A)*
21/41	1	230	50	0.37	3
C400	1	230	50	0.75	5
C800	1	230	50	1.5	6.8
75/16	1	230	50	0.55	4.7
CY600	1	230	50	1.5	6.8
41	3	400	50	0.37	1.4
C400	3	400	50	0.75	1.8
C800	3	400	50	1.5	3.6
75/16	3	400	50	0.55	1.5
CY600	3	400	50	1.5	3.6
CY900	3	400	50	1.5	3.6

* Fuses should be sized to comply with full load current. When sizing fuses, smallest fuse rating should be used to suit motor and starting characteristics.

Single phase supply	Three phase supply
	

On both single and three phase motors it is essential to check that the direction of rotation matches the arrow attached to the motor housing. This is best done visually. If the motor is rotating in the wrong direction, it will be necessary to switch off the machine, isolate the electric supply and reverse the position of L1 and L2 on single phase machines or any TWO of the feed wires (L1, L2 or L3) on three phase machines.

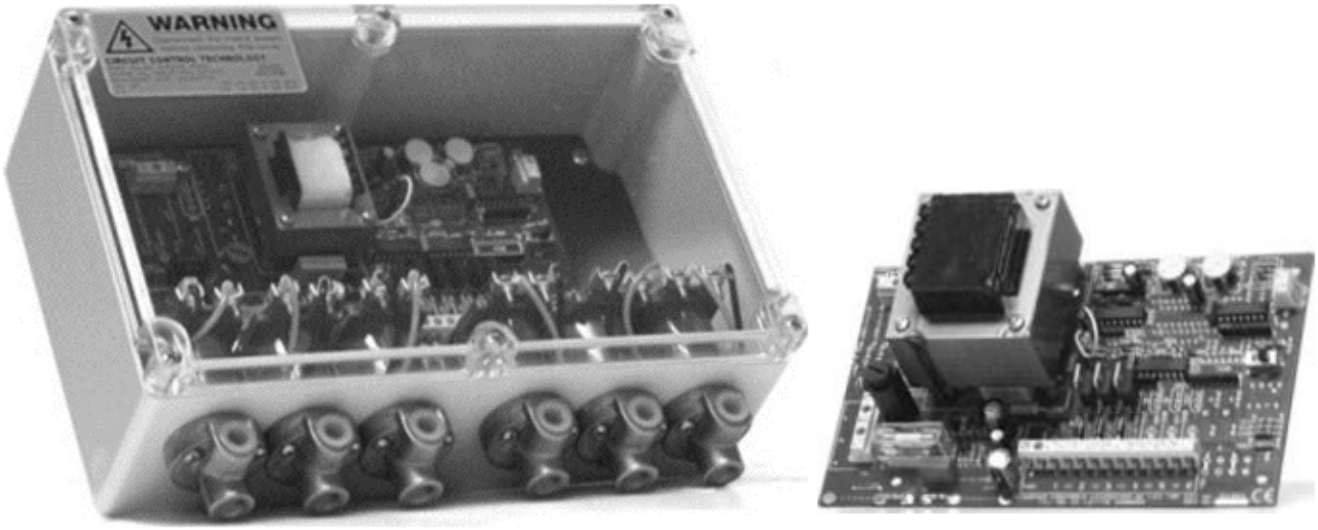


If a problem occurs with installation then Guyson International should be contacted to provide support.

If the yellow indicator is visible where the arrow points to, the blue reset button needs to be pressed. If the Dust Collector is still not functional, readjust the trip setting up slightly.
If the problem persists, contact Guyson International.

10.3 Proprietary manuals

Product Data Sheet ZX393 1-6 Way Sequence Controller



FEATURES

- *The **ZX393 Sequence Controller pcb** is the pulsing heart of our range of tried and tested Reverse Jet Stations. Aimed primarily at Dust Extraction and Air Flow applications, this sequencer has an electronic control system and responds to a simple volt-free open circuit. The unit is fully versatile for input voltage, output voltage, number of ways, pulse length and time between pulses.*
  You select the number of ways by ordering 2, 4 or 6 way units. Each unit has an on-board selector to pulse any number of ways you like up to the nominal. In other words a 2 way unit can pulse 2 ways; a 4 way unit does 1, 2, 3 or 4 ways and a 6 way unit covers all the options up to 6 ways.
  Input and output voltages are available from 12Vdc to 24Vdc, or 110Vac to 240Vac - see the table on page 2 for a breakdown. This table also details the options available on the various models - options like Fan Rundown, Multiple Cycling of Outputs, Delay before Pulsing, Fast Clean Control, Enhanced Wattage Output (can fire 2 valves on a single pulse)and top entry terminals.
  Pulse Duration and Pulse Interval are adjustable as standard on all models.
  *The **ZX393** is offered as a naked PCB ASSEMBLY or housed in a robust, IP65 rated, plastic enclosure as a SEQUENCE CONTROLLER or complete with pilot valves (and pipe fittings if required)- also in an IP65 plastic enclosure - as a REVERSE JET STATION.*

CIRCUIT CONTROL TECHNOLOGY
dust filter controls
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Gorse Hill Industrial Estate
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E-mail: sales@dustfiltercontrols.co.uk

Contents

CCT REV.C/01.03.2012

Models and Options

The following is a table of models (-G...) available in the ZX393 Sequence Controller PCB.
The features incorporated with each model are shown as well as a reference drawing number.

MODEL	INPUT VOLTAGE	OUTPUT VOLTAGE	FEATURES	REFERENCE DRAWING
-G4	110 / 220 / 240 Vac	110Vac	Pressure Switch Control (PSC)	ZX393G4600
-G49	110 / 220 / 240 Vac	110Vac	Pressure Switch Control (PSC) Fan Run Down (FRD) Fast Clean Control (FCC) Cycles of Board (PSC)	ZX393G49600
-G9	12Vdc	12Vdc	Pressure Switch Control (PSC)	ZX393G9600
-G10	24Vdc	24Vdc	Pressure Switch Control (PSC)	ZX393G10600
-G1419	110Vac	110Vac	Pressure Switch Control (PSC) Fan Run Down (FRD) Fast Clean Control (FCC) Cycles of Board (PSC)	ZX393G1419600
-G15	110 / 220 / 240 Vac	24Vdc	Pressure Switch Control (PSC) Enhanced Wattage Output	ZX393G15600
-G159	110 / 220 / 240 Vac	24Vdc	Pressure Switch Control (PSC) Fan Run Down (FRD) Fast Clean Control (FCC) Cycles of Board (PSC) Enhanced Wattage Output	ZX393G159600
-G31	110 / 220 / 240 Vac	24Vac	Pressure Switch Control (PSC) Enhanced Wattage Output	ZX393G31600
-G319	110 / 220 / 240 Vac	24Vac	Pressure Switch Control (PSC) Fan Run Down (FRD) Fast Clean Control (FCC) Cycles of Board (PSC) Enhanced Wattage Output	ZX393G319600
-G33	24Vac	24Vac	Pressure Switch Control (PSC)	ZX393G33600
-G339	24Vac	24Vac	Pressure Switch Control (PSC) Fan Run Down (FRD) Fast Clean Control (FCC) Cycles of Board (PSC)	ZX393G339600

Top entry terminals are available on each model - simply add "2" at the end of the -G number.

Drawing references shown are all for 6 way boards. 2 way and 4 way boards are also available and the drawing reference is the same except that the number "6" - third from the right hand end - becomes "2" for a 2 way and "4" for a 4 way.

To order by part number, start by stating the number of ways (outputs) required followed by "W", then "ZX393" followed by the "-G..." number, e.g. a "4W ZX393-G92" is a 4 way ZX393 pcb with 12Vdc in, 12Vdc out, pressure switch control only and top entry terminals.

CIRCUIT CONTROL TECHNOLOGY
dust filter controls

Set-up Procedure

The following is a flow chart of the set-up procedure for the ZX393 Sequence Controller PCB.
The options available at each stage are explained in an easy to follow format.

STAGE 1

Power Supply

Wire an isolated power supply into appropriately marked terminals at lower-left hand area of the board.
DO NOT SWITCH ON
Double check that supply is correct for model ("G"no.) and wired into correct terminals.
On 240/220/110Vac input models ensure that the LINK adjacent to the power terminals is in the sockets appropriate to the incoming voltage. For safety reasons this link is factory set for 240V.

STAGE 2

Pressure Switch Control (PSC)

This unit pulses when there is an open circuit across terminals PS1 and PS2. Connect the volt-free N/C contacts of a pressure switch across these terminals to cause the board to pulse whenever pressure opens the contacts! Of course it doesn't have to be a pressure switch, you can use any volt-free contacts to automate pulsing. Switching SW1 (PSC) to the "OFF" position will override (open circuit) the PS1/PS2 terminals and pulse the board - use this facility for testing and commissioning.
The normal operating position for this switch is the "DLY" setting.This allows a short time delay after PS1/PS2 goes open circuit before pulsing starts so that short term transient pressure signals do not precipitate premature pulsing.

STAGE 3 - applicable to some models only

Fast Clean Control (FCC)

The FCC switch (SW2) controls the fast clean facility available on some models - see the table on page 2. This facility only comes into effect during Fan Rundown.
Set the swtch to "OFF"for no fast clean.
Set the switch to "FC1" to reduce the time interval between pulses by approximately 10%
Set the switch to "FC2" to reduce the time interval between pulses by approximately 20%.
This facility is of limited usefulness when applied to low numbers of valves e.g. on small installations.

STAGE 4 - applicable to some models only

Fan Rundown Control (FRDC)

The FRDC switch (SW3) controls the Fan Rundown or "Afterclean" facility available on some models - see table on page 2. This functions by recognising a change of mode from open to closed circuit across terminals FR1/FR2. Connecting a N/C Volt-Free auxiliary of the Fan contactor to these terminals achieves this.
Set SW3 to "OFF" for no afterdeaning.
Set SW3 to "DLY" to introduce a delay of about 1 minute between the Fan being switched off and aftercleaning commencing. This allows the Fan and any free particles in the system to stabilise.
Set SW3 to "O.DLY" for aftercleaning to start immediately upon the Fan being switched off.
N.B. Aftercleaning does not require a Pressure Switch "HIGH" signal (open circuit at PS1/PS2) for the board to pulse.

STAGE 5 - applicable to some models only

Cycles of Board

This facility is available only on certain models - see table on page 2. It runs the pulsing of the board for up to 9 complete cycles every time cycling is initiated, whether by Pressure Switch or Fan Rundown.
Set the PSC switch (SW1) to "CYC" and select the number of cycles you require by pushing the "PROG" flying lead on the board onto the appropriately marked terminal pin in the adjacent row. When cycling is complete, a red "STOP" LED lights up to indicate the board has returned to stand-by.

STAGE 6

Number of Ways

Sets the number of outlets to be pulsedin one cleaning cycle. Simply push the "SET" flying lead on the PCB onto the appropriately marked pin in the row adjacent to it! e.g."2" for 2 ways, "3" for 3 ways etc.

STAGE 7

Moment of Truth

This is the time tou find out if you've got the power supply connected correctly. For your own peace of mind and personal safety - check it again.
Set the PSC switch (SW1) to "OFF" and TURN THE POWER ON!!
After a short interval No.1 output will pulse, then No.2, No.3 and so on. Red LED's adjacent to each output will flash in turn to indicate which one is pulsing.

STAGE 8

Set Interval and Duration

The "INTERVAL" potentiometer (RV1) controls the time delay between successive output pulses.
This is adjustable over a range of approximately 4 to 60 seconds (turn clockwise to increase).

The "DURATION" potentiometer (RV2) controls the length or "time on" of each pulse.
This is adjustable over a range of approximately 40 to 300 milliseconds (turn clockwise to increase).

LEAVE IT SAFE

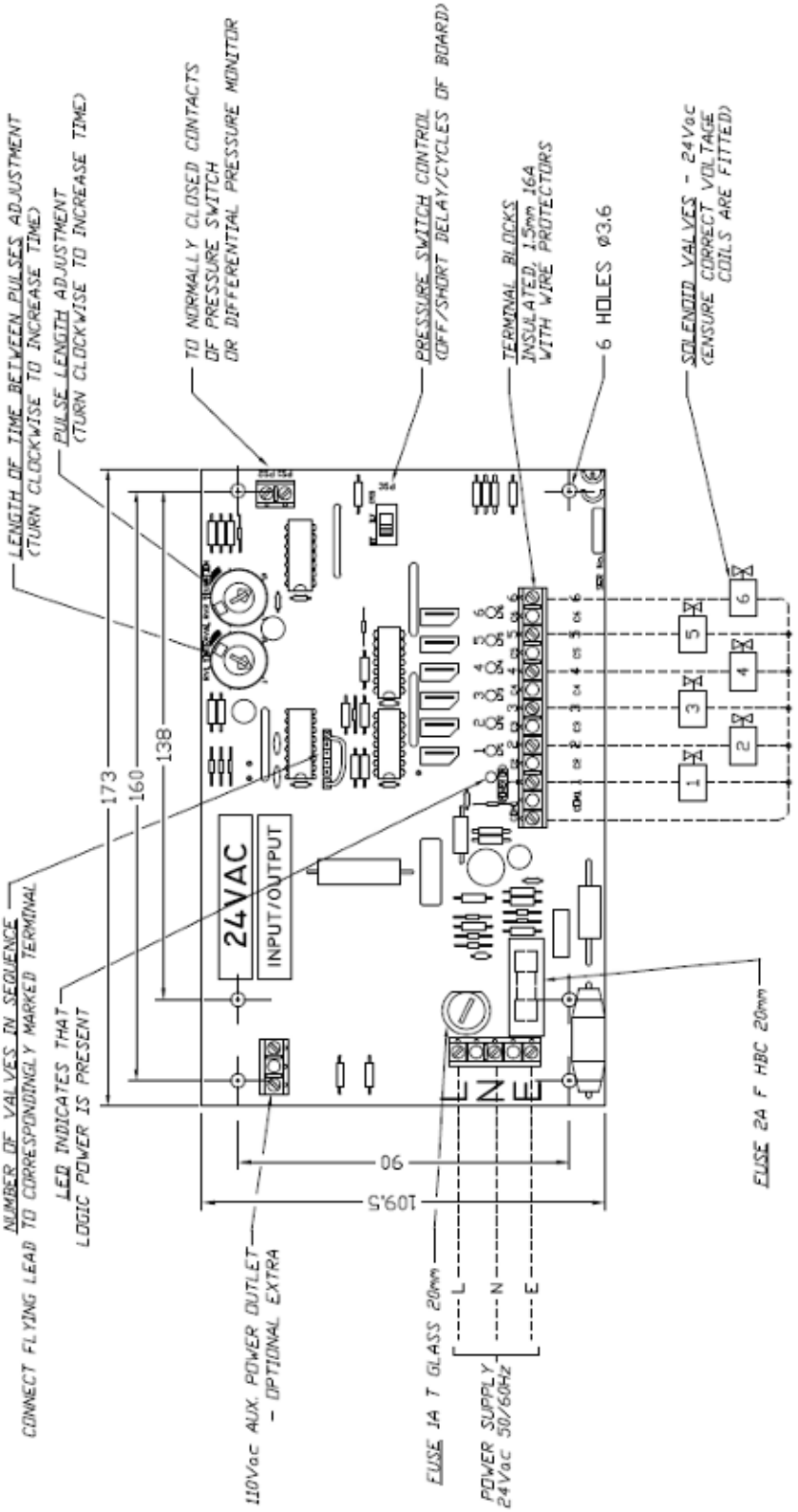
Turn off the power - Set PSC switch to "DLY".

CIRCUIT CONTROL TECHNOLOGY
dust filter controls

Technical Specifications

UNIT:	Part Number ZX393
INPUT SUPPLY/ POWER CONSUMPTION:	Volts:-refer to table on page 2. Amps:- less than 500mA
INPUT FUSE:	Depending on Model Number.
OUTPUT FUSE:	Depending on Model Number.
MAINS FAILURE:	In the event of power interruption, the unit will operate to specification when the supply voltage is re-instated..
START UP SEQUENCE:	The unit is arranged so that pulsing will start as soon as an open circuit has been established across terminals PS1/PS2 for a few seconds, unless another option has been selected (see "Power Supply" on page 3).
INDICATION:	Red LED indicates "Power On", others light up to show which output is pulsing during cycling. Some models also have "STOP" LED also (see "Cycles of Board on page 3).
AMBIENT TEMPERATURE AT BOARD SURFACE:	-10 to +45 deg.C.
STORAGE TEMPERATURE:	-20 to + 70 deg.C.
SEQUENCE CONTROLLER:	The ZX393 is also available enclosed within an IP65 rated plastic .box. Just add "/E0" to the Part Number immediately after the model (-G...) number. Non-standard enclosures are also possible, or we can mount your ZX393 integrally with other equipments (e.g. Pressure Switch) on request. Please consult Circuit Control's sales department for more information.
REVERSE JET STATION:	The ZX393 can be used to drive any normally configured pilot valve, and we offer a variety of commercially available solenoid valves as standard in our Rev. Jet Stations - with or without rapid-fit or compression pipe fittings. Please consult Circuit Control's sales department for availability of specific combinations of board, box and valves to suit your requirements.
EXTERNAL SIGNALS:	The ZX393 conforms to current regulations regarding proper operation within zones of electrical interference. Nevertheless we recommend that connections to external equipments are kept as short as possible, made with screened cable earthed at one end and/or via an interposing relay.
MAINS (ac) SUPPLIES:	To ensure the reliable operation and longevity of your ZX393, any mains supply should not be a branch off a line carrying power to equipment containing rectifiers and/or thyristors (e.g. welders, variable speed drives, battery chargers etc.). Keep supply cables away from other power carrying conductors. A free-standing mains filter is available if needed.

Wiring diagram



General arrangement