



Operating Instructions

Model

GPXP1018LP

Ride-On Shot Blasting System

INTRODUCTION

This manual has been prepared to assist the operator and maintenance personnel in understanding the machine so that it may be operated in the safest and most efficient manner and maintained in the best condition. Therefore, it is necessary that all personnel responsible for the operation and maintenance of the machine read and understand the manual.

Before attempting to operate, service or maintain the machine, the personnel should thoroughly familiarize themselves with the physical make-up of the machine. They should be familiar with the major components of the machine and have a general understanding of overall operations.

The operating and maintenance personnel must obey all the warnings and safety precautions posted on the machine and stated throughout this manual. Serious injury to personnel or severe damage to the equipment may result if the warnings and precautions are not followed.

You will be notified of any changes that occur after this manual is printed. We will send you manual revisions that should be inserted in the manual in accordance with instructions that will be forwarded with them.

Receipt of Machine

Examine the shipment carefully for possible damage that might have occurred while in transit. If any damage is noted, notify the transportation carrier immediately and advise Blastrac.

FORWARD

Blastrac is pleased that you have selected the Model GPX-10-18 Blast Cleaning Machine for you surface preparation requirements. This environmental, closed-cycle, surface preparation machine has been designed and built for abrasive blast cleaning of horizontal surfaces.

This manual has been prepared to assist the operator and the maintenance personnel in understanding the machine so that it may be operated in the most efficient manner and maintained in the best condition. Therefore, it is necessary that all personnel responsible for the operation and maintenance of the machine read the manual thoroughly. By following the instructions in this manual, the GPX-10-18 system can be easily and effectively operated, serviced and maintained by personnel assisted by a brief period of familiarization and training from a Blastrac technician.

Before attempting to operate, service or maintain the machine, the personnel should thoroughly familiarize themselves with the physical makeup of the machine, be familiar with the major systems of the machine, and have an understanding of its operation.

The operating and maintenance personnel must obey all the warnings and safety precautions posted on the side of the machine and stated throughout this manual. Serious injury to personnel or severe damage to the equipment may result if the warnings and precautions are not followed, or through careless handling of this equipment.

Initial operation and maintenance must be done cautiously. Extreme care should be taken when activating any control devices until the response of the machine and its various components are clearly understood.

If you have any questions or problems in regard to the operation or capabilities of this Blastrac machine, please contact:

Blastrac
13201 North Santa Fe
Oklahoma City, OK 73114
405/478-3440
800/256-3440

or your nearest Service Center.

BLASTRAC®/SAWTEC®
WARRANTY POLICY

This document is to be used as a guide in determining warranty policies and procedures for BLASTRAC/SAWTEC products. It is to be used in determining whether a warranty is justified and also as a procedural guide in completing a BLASTRAC/SAWTEC Warranty Claim form.

Warranty Responsibility:

The distributor or the end user **must** prepare a Machine Warranty Information Card when the machine is delivered. Failure to comply will make any and all warranties on this equipment null and void. Credit for warranty repairs will be given only after receipt of the WARRANTY CLAIM FORM, properly completed with all the required details. Submittal details are described later in this document.

Warranty Policy:

1. Blastrac warrants its products against defects in material and workmanship under normal and proper use for a period of **1 year** from the date of delivery as noted on the returned warranty registration card; in the case of Rental Fleet Machines, date of assignment to Rental Fleet. Such warranty is extended only to the buyer who purchases the equipment directly from Blastrac or its authorized distributor. This warranty does not include expendable parts such as, but not limited to, blades, blast wheel, wear plats, liners and seals. **If the warranty card is not returned within 30 days of delivery date, the warranty period is limited to 6 months from the date of delivery as noted on the warranty registration card.**
2. The obligation under this warranty is strictly limited to the replacement or repair, at Blastrac's option, of machines and does not include the cost of transportation, loss of operating time, or normal maintenance services.
3. This warranty does not apply to failure occurring as a result of abuse, misuse, negligence, corrosion, erosion, normal wear and tear, alterations or modifications made to the machine without express written consent of Blastrac.
4. Warranty request must be submitted in writing within thirty (30) days after failure.
5. Written authorization to return merchandise under warranty must first be obtained from Blastrac.

Warranty Policy (Continued)

6. Blastrac reserves the right to inspect and make the final decision on any merchandise returned under warranty.
7. Blastrac offers no warranty with respect to accessories, including but not limited to, engines, motors, batteries, tires and any other parts not manufactured by us but which the original manufacturer warrants.
8. Blastrac reserves the right to make product changes or improvements without prior notice and without imposing any obligation upon itself to install the same on its products previously sold.
9. The above warranty conditions can only be altered by Blastrac. Blastrac must confirm alterations in writing for each specific transaction.
10. Blastrac reserves the right to establish specific warranty terms for used or demo machines on an individual transaction basis. Invoices covering such merchandise will clearly state the provisions of the applicable warranty for each specific transaction.
11. WE DO NOT AUTHORIZE ANY PERSON, REPRESENTATIVE OR SERVICE OR SALES OUTFIT TO MAKE ANY OTHER WARRANTY OR TO ASSUME FOR US ANY LIABILITY IN CONNECTION WITH THE SALE OF OUR PRODUCTS OTHER THAN THOSE CONTAINED HEREIN.
12. UNDER NO CIRCUMSTANCES SHALL BLASTRAC BE LIABLE TO CUSTOMER OR ANY OTHER PERSON FOR ANY DIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES RESULTING FROM THE USE OF THE PRODUCT OR ARISING OUT OF ANY BREACH OF ANY WARRANTY OR FOR ANY SPECIAL OR CONSEQUENTIAL DAMAGES OF ANY CHARACTER, INCLUDING WITHOUT LIMITATIONS, DAMAGES FOR ANY LOSS OF GOODWILL, WORK STOPPAGE, OR ANY AND ALL OTHER COMMERCIAL DAMAGES OR LOSSES.
13. BLASTRAC MAKES NO OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE WITH RESPECT TO THE BLASTRAC PRODUCTS SOLD PURSUANT THERETO.

Blastrac®/Sawtec® Warranty Registration Card

NOTICE!

TO THE DELIVERING DISTRIBUTOR OR END USER

To ensure the proper warranty coverage is extended to the owner of this machine, fill out the attached card **COMPLETELY** and **ACCURATELY** and return to Blastrac.

The warranty period will start on the delivery date entered below.

The distributor or the end user must prepare a machine warranty information card when the machine is delivered. Return of warranty card will extend the warranty period to **1 year** from the date entered below. **Failure to comply will make any and all warranties on the equipment void after 6 months.**

USER'S REFERENCE INFORMATION

Delivery Date _____	Machine Model No. _____
Delivering Distributor's Name and Address _____	Machine Serial No. _____
_____	Modifications _____
_____	_____
_____	_____

SIGNATURE OF DELIVERING DISTRIBUTOR'S REPRESENTATIVE _____

.....
CUT HERE

WARRANTY REGISTRATION CARD

IMPORTANT! To ensure that your Blastrac/Sawtec machine is covered under warranty, please fill in the following information and mail or fax it to Blastrac, 6215 Aluma Valley Drive, Oklahoma City, OK 73121, Fax No. 405-478-8608.

(Please print)

Company _____
Address _____

City, State, and Zip code _____
Telephone Number _____
Contact Person _____
Date of Purchase _____ Date Received _____
Machine Model No. _____
Distributor Name _____
End User Name _____
End User E-mail _____

Change of Owner or New Address Registration Card



If you are not the owner of record as shown on the manual copy of the warranty registration card, do not operate this machine before contacting Blastrac/Sawtec at 800-256-3440 ext. 3185. Verify the following before operating the equipment:

1. You have the most recent operations and maintenance manual.
2. Any safety related updates have been incorporated in your equipment.
3. You have had training by an authorized Blastrac/Sawtec representative or arrange for the training.
4. Blastrac/Sawtec has a record of your new ownership registration for any future contact that may be necessary on safety related matters.

USER'S REFERENCE INFORMATION

Date _____	Machine Model No. _____
Previous Owner's Name and Address _____	Machine Serial No. _____
_____	Modifications _____
_____	_____
_____	_____
_____	_____

.....CUT HERE.....

CHANGE OF OWNER OR NEW ADDRESS REGISTRATION CARD

IMPORTANT! To ensure that your Blastrac/Sawtec machine owner's record is up to date, fill in the following information and mail or fax it to Blastrac, 6215 Aluma Valley Drive, Oklahoma City, OK 73121, Fax No. 405-478-8608.

(Please print)

Company _____
Address _____

City, State, and Zip code _____
Telephone Number _____
Contact Person _____
Date of Purchase _____ Date Received _____
Machine Model No. _____
Distributor or Previous Owner Name _____

Table of Contents

Safety Precautions	1
1.1 Safety Instructions	2
Operator Responsibilities	3
2.1 Operator Responsibilities	4
Operator Procedures	5
3.1 Operator Awareness	6
3.2 Operation Sequence	7
3.3 Operation Adjustments	8
Removal and Installation of Parts	9
4.1 Blade Removal and Installation	10
4.2 Pinch Bar Removal and Installation	11
4.3 Blast Wheel Removal	12, 13
4.4 Blast Wheel Installation	13
4.5 Top Liner Removal and Installation	13, 14
4.6 Dust Collector – General	14
4.7 Flapper Removal and Installation	15
4.8 Cam Disk Removal and Installation	15, 16
4.9 Cam Disk Adjustment	16
4.10 Timing Cam Disks	16, 17
Maintenance	18
5.1 Maintenance Check List	19
5.2 Maintenance Log	20
Specifications	21
6.1 Specifications	22
Hazardous Materials Safety Warning	23
7.1 Hazardous Materials Safety Warning	24

Section 1

1.1 Safety Instructions

1.1 Safety Instructions

Note: Please read these instructions carefully and completely prior to operating this equipment.

1. All personnel in the vicinity of this machine must wear safety goggles and adequate ear protection while it is in operation.
2. Never perform maintenance on the machine while it is running.
3. When operating machine, keep hands away from all moving parts.
4. Do not wear loose fitting clothing or attempt to remove V-belt covers.
5. Do not stand to side of blast housing while machine is in operation due to the possibility of blade failure.
6. If an emergency should occur while machine is in operation, push the top of the throttle assembly down and turn ignition switch to the off position.
7. Do not operate this equipment on wet surface or in the vicinity of flammable liquids.
8. When repairing underside of machine, always use jack stands.
9. Before transporting machine, be sure dust is cleaned out of the dust collector. The extra weight will cause stress on the axles and may cause them to break.
10. In this manual, we have provided an operation/maintenance checklist. These items **must** be checked before each operation for the safety of the operator as well as the machine.

BEFORE STARTING MACHINE, BE SURE ALL V-BELTS ARE IN GOOD CONDITION!

Section 2

2.1 Operator Responsibilities

2.1 Operator Responsibilities

1. The operator shall provide personnel who have been trained by a Blastrac Technician for the operation and maintenance of Blastrac equipment.
2. The operator shall provide the necessary blasting media in accordance with the recommendations of a Blastrac technician so that the machine will operate at maximum efficiency.
3. The operator shall be responsible for the observance of all safety precautions expressed in this manual.
4. The operator shall perform all maintenance and basic repair functions as stated and described in this manual.
5. The operator shall maintain an inventory of “wear parts” as outlined in this manual.
6. The operator shall dispose of all dust collector refuse.
7. The operator shall provide the following tools & accessories:

Hammer
Wrench Set
5/16” Allen Wrench
Buckets

Screwdrivers
VOM (meter)
Magnetic Broom

Section 3

- 3.1 Operator Awareness
- 3.2 Operation Sequence
- 3.3 Operation Adjustments

3.1 Operator Awareness

The GPX 10-18 machine is designed to blast a concrete surface and reclaim all shot and dust. The machine can very easily destroy the concrete surface if not operated properly. The absence of Operator Awareness will create down time and can prove to be very costly. Read the following precautions carefully prior to operation.

1. When the shot valve is open, the machine is throwing shot! Therefore, you must **be sure the shot valve is closed prior to starting** as well as any time the machine comes to a stop.
2. **The speed of travel controls the depth of your cut.** You should run a test pattern to be sure you are not gouging the floor.
3. Due to variances in concrete, it is necessary to check the pattern every 10 feet as the concrete or coated surface may be softer in different areas.
4. The maintenance checklist is provided for blasting efficiency. This list should be completed after each day of blasting. You will save time and money by maintaining you shot blast machine.
5. **The dust collector must be dumped approximately every two hours. If the dust collector gets too full, you will lose all of your suction.** This will result in loss of all shot from the hopper. Check the dust collector after the first 30 minutes. Determine how long you can operate before dumping. All concrete surfaces are different.
6. The gap between the Blades and the Pinch Bar is very important. If you gap exceeds 1/8", you will begin to trail shot and eventually lose the whole load.
7. The Porta-Shot Blast machine is equipped with blast seals. These seals provide a seal for the suction required and they contain shot that would otherwise be thrown from the machine. If the seals are worn out, you will lose you seal and shot will fly out from the worn areas.

3.2 Operator Sequence

Refer to **Figure 1** for the location of switches and control identified in this procedure.

1. Complete the Operation/Maintenance check list.
2. Place the transmission control lever in the neutral (center) position.
3. Turn ignition switch to ON and start machine.
4. Pull throttle to the wide-open position. Tach should read between 3630 rpm to 3680 rpm.
5. Push the transmission lever forward to go forward and backward for reverse.

ALWAYS BLAST IN FORWARD DIRECTION

6. Adjust the height of the seals using the Housing Lift switch. Lower seals until they contact the surface. Then lower them an additional $\frac{1}{4}$ inch.
7. Start machine moving forward and slowly open the shot valve. The slower the machine travels while the blast wheel is engaged, the deeper the cut.
8. When coming to a stopping point, shut off the shot valve about 5 feet before stopping. (This will allow you to clear the housing of shot keeping you from blasting a hole when you come to a complete stop.) This distance will vary depending on the speed of travel (fast – more than 5 feet, slow – less than 5 feet).

3.3 Operation Adjustments

The GPX-10-18 is equipped with a few fine tune adjustments to make blasting easier.

1. **FRONT END LIFT:** This is used primarily for loading and unloading the machine. This feature may also be used to adjust your seals while operating machine, opposed to stopping machine and doing it manually.
2. **VACUUM ADJUST PLATE:** This plate is used to adjust the amount of vacuum pulled through the blast housing. It can be used to fine tune air flow to the specific application.
3. **PINCH BAR:** The pinch bar clearance must be checked before each operation. For best blasting results, rotate the pinch bar to allow 1/8" clearance for all applications.

IMPORTANT: AFTER ADJUSTING THE PINCH BAR TO BLADE GAP, ALWAYS SPIN BLAST WHEEL TO VERIFY CLEARANCE ON ALL BLADES.

Section 4

- 4.1 Blade Removal and Installation
- 4.2 Pinch Bar Removal and Installation
- 4.3 Blast Wheel Removal
- 4.4 Blast Wheel Installation
- 4.5 Top Liner Removal and Installation
- 4.6 Dust Collector – General
- 4.7 Flapper Removal and Installation
- 4.8 Cam Disk Removal and Installation
- 4.9 Cam Disk Adjustment
- 4.10 Timing Cam Disks

4.1 Blade Removal and Installation

Refer to **Figure 2** for the location of parts and equipment identified in this procedure.

Caution: All electric power must be disconnected and all rotation parts completely Stopped before attempting any maintenance procedure. Always observe Zero Motion Status before attempting any adjustments or maintenance.

Refer to Figure (4) for the location of parts and equipment identified in this procedure.

1. Remove the inspection plate below the blast wheel.
2. Rotate the blast wheel to bring the blade that is to be removed into reach.
3. Remove the two (2) cap screws and retainer plate at the end of the blade.
4. Blow dust and shot out of the threaded hole in the end of the blade.
5. Use a slide hammer to pull the blade out of the blast head.

NOTE: Slide hammer is provided with all machines containing a pinch bar.

6. Clean dust and shot out of the slot for the blast head for proper installation of the blades.
7. Insert the new blade and replace the retainer plate and cap screws.
8. Inspect gap between blade and Pinch Bar for rotation or replacement of Pinch Bar.
9. Install inspection plate.

4.2 Pinch Bar Removal and Installation

Refer to **Figure 3** for the location of parts and equipment identified in this procedure.

Caution: All power must be disconnected and all rotation parts completely stopped before attempting any maintenance procedure. Always observe Zero Motion Status before attempting any adjustments or maintenance.

1. Remove the Pinch Bar retaining lug.
2. Insert a slide hammer into the threaded hole in the end of the Pinch Bar.

NOTE: Slide hammer is provided with all Pinch Bar machines.

3. Withdraw the Pinch Bar from the blast head.
4. Insert the new Pinch Bar and tap into place with a hammer.
5. Reinstall the Pinch Bar lug bolt.

Caution: All power must be disconnected and all rotation parts completely stopped before attempting any maintenance procedure. Always observe Zero Motion Status before attempting any adjustments or maintenance.

1. Remove the Pinch Bar retaining lug.
2. Rotate the Pinch Bar clockwise one notch if it does not exceed 1/8 inch from blast wheel blades.
3. If Pinch Bar gap is larger than 1/8 inch, the Pinch Bar should be rotated two (2) notches clockwise.
4. Rotate Pinch Bar with a large adjustable wrench.
5. Reinstall the Pinch Bar lug bolt.

4.3 Blast Wheel Removal

Refer to **Figure 4** for the location of parts and equipment identified in this procedure.

1. **Belts:**

- a) Remove the seat for better access to the work area.
- b) Remove the lower portion of the belt guard and take the six belts off the blast wheel sheave using a flathead screwdriver.

2. **Taper Lock and Sheave Assembly:**

- a) Remove the two set screws from the taper lock.
- b) Install one set screw in the hole, which did not originally have a set screw.
- c) Tighten the set screw until you hear the taper lock “pop”. If the taper lock does not pop, tap the outside of it lightly with a hammer.
- d) Slide the taper lock off the shaft. If the assembly does not slide off the shaft easily, insert a screwdriver in the slot and pull off.

Note: Be careful not to pry open too far as the taper lock can split in half.

3. **Bearing Collar:**

- a) Remove the two Allen head set screws on each of the two bearing collars.
- b) Remove the bearing collars.

4. **Blast Wheel Bearing:**

- a) Remove the two bolts holding the outside bearing.
- b) Pry the outside bearing off of the shaft.

5. **Inspection Plate:**

- a) Remove the two bolts, which connect the inspection plate to the housing.
- b) Remove the inspection plate.

4.3 Cont'd

Removal and Installation of Parts

6. Cover Plate:

- a) Remove the four nuts, which connect the cover plate to the housing.
- b) Remove the cover plate.

7. Blast Wheel:

1. Remove the blast wheel drum by pulling the drum shaft through the inside bearing.

Note: If the drum shaft is resistant to come through the bearing, you may use a block of wood and a hammer to force it through.

4.4 Blast Wheel Installation

Refer to **Figure 4** for the location of parts and equipment identified in this procedure.

1. Reverse steps 1-7 under Blast Wheel removal
2. Locate the counter sink holes in the outside of the blast wheel shaft
3. The set screws on the outside blast wheel bearing should be set in these holes. This will align the blast wheel from side to side.
4. Before you tighten the blast wheel bearings, you must align the blades with the Pinch Bar. Refer to operation adjustments for proper setting.
5. When the blast wheel is aligned with the Pinch Bar, you can tighten the inside blast wheel bearing.

4.5 Top Liner Removal and Installation

Refer to **Figure 5** for the location of parts and equipment identified in this procedure.

Before attempting to remove the Top Liner, you must complete steps 1-7 under Blast Wheel Removal. If the Top Liner has completed more than 100 hours of

4.5 Cont'd

Removal and Installation of Parts

blasting, it will have expanded. To remove the expanded Top Liner, you may weld a turn buckle across the inside to return the liner to its natural position. If the liner is worn out, it will be much easier to cut it in half with a torch and then remove it.

1. Remove the two bolts located at the top of the blast housing. These bolts are accessible from the outside of the housing.
2. Loosen the one nut located at the bottom of the liner. This nut is protected by a piece of manganese that may also be used for a handle.
3. You must now rotate the liner at least 3 inches to the right to clear the mounting arms and remove the liner.
4. To install the Top Liner, reverse steps 1-3.

4.6 Dust Collector – General

This unit is equipped with an auto pulse dust collector that provides suction to separate the dust from the shot. There are two blowers on the dust collector; one provides suction for the separation and the other provides positive pressure to clean filters while you blast. The dust collector is equipped with six cam discs that are operated by a Delco wiper motor (cam motor). The cam has six flappers. One flapper will drop every two seconds. When a flapper drops, positive air flow is forced through that chamber and blows the dust from the filter. There are six cartridge filters. One filter is being cleaned while the other five are in operation. Refer to Figure 3 and 4 for the location of parts and equipment identified in this procedure.

Filters:

1. Open the back door of the dust collector.
2. Loosen wing nuts and remove the filters.

Note: Be careful not to damage filters when installing.

4.7 Flapper Removal and Installation

Removal:

1. Remove the bolts from the top of the air chamber cover.

Removal and Installation of Parts

2. Remove the cover.
3. Remove the two bolts that hold the hinge to the air chamber
4. Remove the Flapper.

Installation:

1. Reverse steps 1-4 of the removal procedure.

Note: The flappers are connected to hinges that are bolted in and the flappers should
move up and down freely.

4.8 Cam Disk Removal and Installation

Refer to **Figure 8** for the location of parts and equipment identified in this procedure.

The Cam Disks will rarely need any attention. The disks are made of a high grade plastic and may never need to be changed. However, there are a few items that need maintenance or adjustment.

1. Follow steps 1-2 under Flapper replacement.
2. After the air box is removed, you must remove the cam chamber cover by loosening the four bolts.
3. Remove the chain from the cam motor sprocket to free the shaft (not shown).
4. Loosen the set screws on each flange bearing.
5. Loosen the set screw on each cam disc.
6. Pull the cam shaft through to the cam disc you wish to remove.

4.8 Cont'd

7. After the shaft has been pulled through the disc, you can then remove it.
8. To install cam disks, reverse steps 1-7 under Cam Disc Removal (do not tighten the set screws yet).

4.9 Cam Disk Adjustment

1. To adjust the cam discs, the air box must be removed. Complete steps 1-2 under Flapper removal.
2. Remove cam cover plate.
3. Loosen the four nuts on each cam. The holes are slotted $\frac{1}{4}$ " for adjustment.
4. Refer to Cam Disc Timing to adjust the discs.
5. If the disks are too far out of adjustment, you will have to loosen the set screw and turn the cam.

4.10 Timing Cam Disks

Cam Disk sequence is 1-6 starting from the cam motor side.

- Line a straight edge across the cam discs four inches from the edge on each side.
- **No 1 Cam Disc:** The short side of the opening should be 90 degrees up or directly in line with the straight edge.
- **No. 2 Cam Disc:** The long side of the opening should show $\frac{3}{8}$ " past the straight edge while No. 1 is in position.
- **No. 3 Cam Disc:** Turn the cam so that the short side of the opening on No. 2 Cam Disc is in line with the straight edge. Now adjust No. 3 so that the long side of the opening shows $\frac{3}{8}$ " past the straight edge.

4.10 Cont'd

- **No. 4 Cam Disc:** Turn the cam so that the short side of the opening on No. 3 Cam Disc is in line with the straight edge. Now adjust No. 4 so that the long side of the opening shows $\frac{3}{8}$ " past the straight edge.

Removal and Installation of Parts

- **No. 5 Cam Disc:** Turn the cam so that the short side of the opening on No. 4 Cam Disc is in line with the straight edge. Now adjust No. 5 so that the long side of the opening shows 3/8" past the straight edge.
- **No. 6 Cam Disc:** Turn the cam so that the short side of the opening on No. 5 Cam Disc is in line with the straight edge. Now adjust No. 6 so that the long side of the opening shows 3/8" past the straight edge.

Section 5

- 5.1 Maintenance Check List
- 5.2 Maintenance Log

5.1 Maintenance Check List

Operation/Maintenance Check List: The items on this check list **must** be checked before each operation to achieve maximum blasting efficiency and for the safety of the operator as well as the machine.

_____ Blast wheel	Check for balance and excessive wear
_____ Blades	Check for excessive wear
_____ Top liner & Lower liner	Check for excessive wear
_____ Pinch bar	Check clearance and for uneven wear
_____ Gap	To adjust the gap, see operation adjustments
_____ Blast wheel bearings	Check set screws and grease
_____ Shot valve	Check for leaks
_____ Filters	Make sure filters are not clogged or ripped
_____ Flappers	Make sure all flappers open and close
_____ Engine oil	Check level and change when dirty.
_____ Air cleaner	Change when dirty
_____ Transmission oil	Check for leaks and change when dirty
_____ Axle seals	Check for leaks
_____ Blast seals	Check for excessive wear
_____ Blower bearings	Check set screws and grease
_____ Steering assembly	Check chain tension
_____ Belts	Check quality and tension
_____ Idler assembly	Check bearings
_____ Dust collector latches	Make sure latch is firmly secured to door
_____ Cam motor	Make sure motor is on when blasting

5.2 Maintenance Log

maintenance

log

Liners – Inspect for wear	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Blastwheel - Inspect for wear	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Filters – Inspect – clean or replace	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Blades- Inspect for wear	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Shot valve – Inspect	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Seals – Inspect for wear	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Bearings – Inspect set screws and grease	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Check oil levels -	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Pinch bar – Inspect for wear, Rotate ¼ turn every 8 hours	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Belts – Check quality and tension	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Flappers – Check all open, no obstructions	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>
Propane system – check valves for leaks	Checked	<input type="checkbox"/>	OK	<input type="checkbox"/>	Change	<input type="checkbox"/>

Visit us on the web @ www.blastrac.com

Section 6

6.1 Specifications

6.1 Specifications

The GPX-10-18 Porta-Shot Blast machine is powered by a CH-25 Kohler liquid propane engine. The 25HP machine is capable of cutting up to 1/8" of concrete in one pass. It is driven by a Peerless hydraulic system, controlled by lever arm action.

The GPX-10-18 has a 10" blast pattern using Nelco's patented blast wheel which reduces hot spots and groves. The blast wheel is a paddle wheel design that is pulley driven at a maximum speed of 5400 RPM continuously. Shot feeds through the shot valve to the blast wheel. The shot and debris rebound to the dust separator and the dust is removed to the dust collector. Clean shot falls back into the hopper for reuse. The machine recycles shot continuously until the machine is shut off. The auto pulse dust collector cleans the six cartridge filters while the machine is running. This machine is capable of cutting up to 1200 square feet per hour, while achieving a brush blast.

Specifications:

Drive Motor.....	25 HP Kohler
Propane System.....	Liquid
Motor RPM.....	3600 at max idle
Blasting Width.....	10"
Charging System.....	12 volt
Dust Collector.....	600 cfm suction/1400 cfm pulse pressure
Transmission.....	Eaton Mod. 700-002 CCW
Transaxle.....	Peerless Mod. ET-12677
Dimensions.....	L: 78.5" W: 32" H: 48"
Weight.....	1550 lbs

Section 7

7.1 Hazardous Materials Safety Warning

7.1 Hazardous Materials Safety Warning

Some floor or deck surfaces may be coated with or contaminated by **hazardous material**. Typical examples of hazardous materials include tile mastic which is likely to contain **asbestos**, stained areas near electrical equipment which may contain **PCB's**, old paint, which may contain **lead**, stained or surface contaminated floor areas in chemical or other industrial facilities that may contain **pesticides**, **cleaning fluids**, **solvents**, or other **harmful chemicals**.

During the normal operation of shot blasting equipment, surface material is removed and dust is created. When the surface material is contaminated, the dust may contain hazardous material.

It is very probable that dust will be released during the normal operation of U. S. Filter/Blastrac equipment. If this dust contains hazardous material, there is a danger that exposure to this dust may pose a health risk.

Before using U. S. Filter/Blastrac equipment on any surface, the area must be inspected for possible contamination.

U. S. Filter/Blastrac does not warrant its equipment to be suitable for, or approved for, removing hazardous materials.

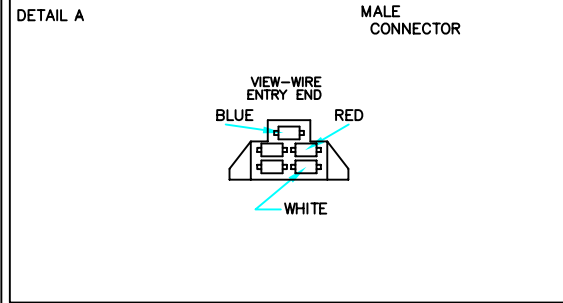
Before beginning any project involving the removal of hazardous materials, it is the responsibility of the contractor to ensure that the work site and equipment to be used have been inspected and the proposed work has been approved by the proper authorities. It is also the responsibility of the contractor to notify workers of any potential health risks and ensure that workers are properly protected from exposure to hazardous materials and from the long term effects of such exposure.

U. S. Filter/Blastrac Portable Shot Blast Cleaning Systems are not designed for use to remove, clean, profile, or alter any surface coated with or otherwise contaminated by hazardous material. U. S. Filter/Blastrac expressly disclaims any liability for injury, illness, death, or damage that might occur or result from such use.

NOTES

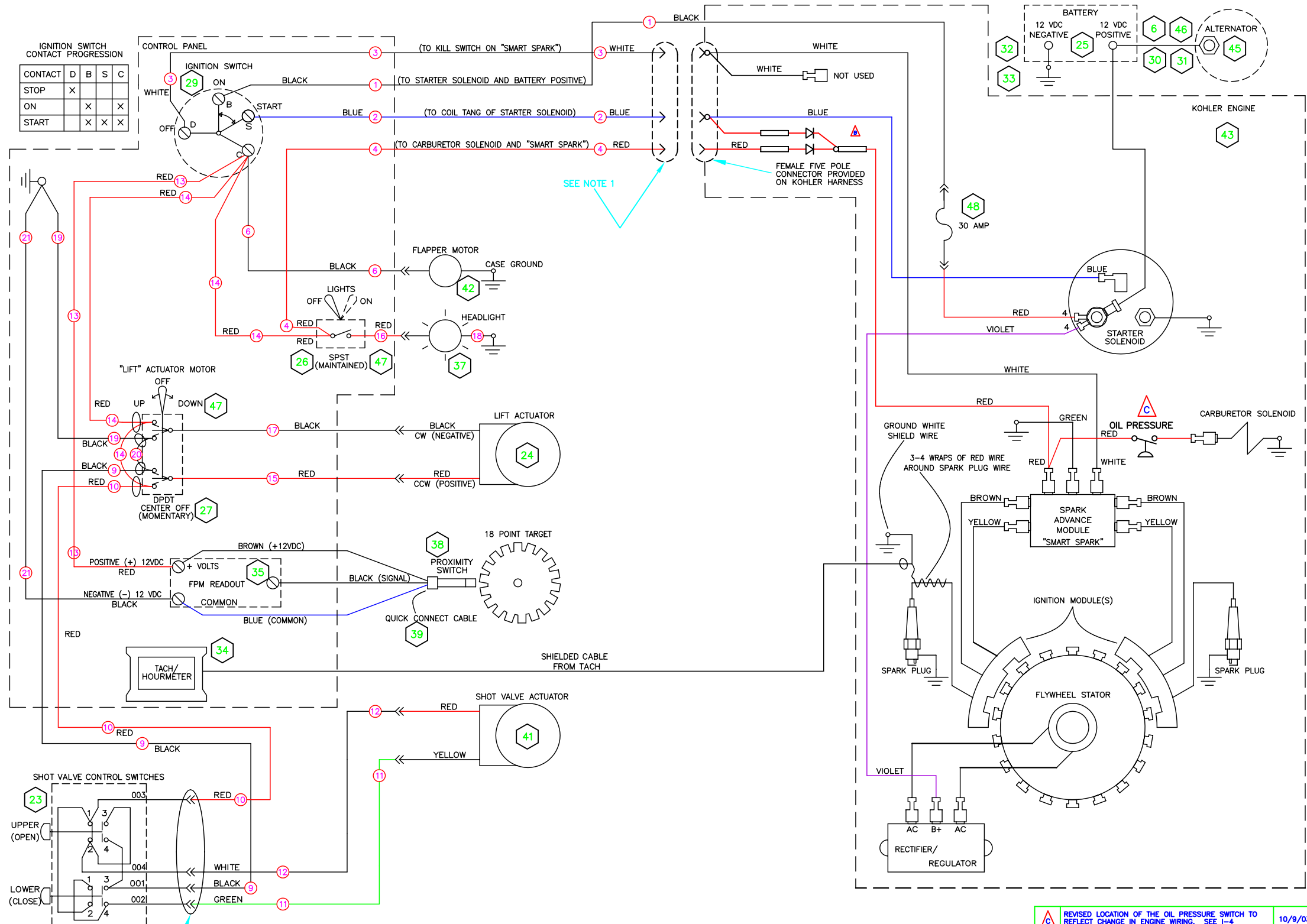
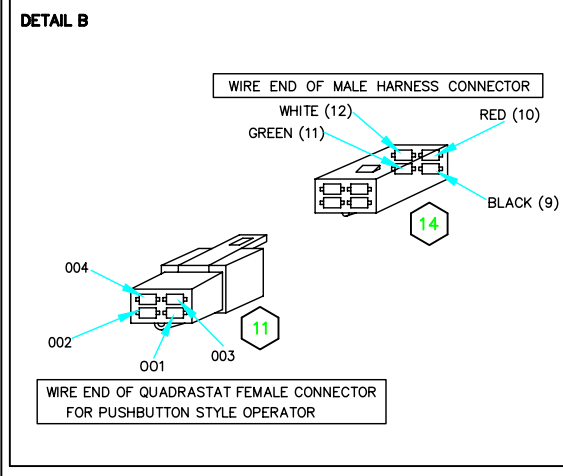
NOTE 1 - 5 CIRCUIT CONNECTOR REPLACEMENT HOUSING (ITEM 15) AND 3 EACH MALE LOCKING SPADE TERMINALS (ITEM 14).
WHEN REPLACING DEVICES OR CONNECTION ELEMENTS PAY CLOSE ATTENTION TO POLARITY OF DEVICE AS INDICATED ON THIS SCHEMATIC.

REFERENCE DETAIL A IMMEDIATELY BELOW



NOTE 2: 4 CIRCUIT CONNECTOR REPLACEMENT FEMALE HOUSING (ITEM 11) AND FEMALE LOCKING SPADE TERMINALS (ITEM 12).
REPLACEMENT MALE HOUSING (ITEM 13) AND MALE LOCKING SPADE TERMINALS (ITEM 14).
WHEN REPLACING DEVICES OR CONNECTION ELEMENTS PAY CLOSE ATTENTION TO POLARITY OF DEVICE AS INDICATED ON THIS SCHEMATIC.

REFERENCE DETAIL B IMMEDIATELY BELOW



Ⓜ DENOTES HARNESS WIRE NUMBER

Ⓜ DENOTES HARNESS WIRE NUMBER

REV	DESCRIPTION	DATE	BY
1	REVISED LOCATION OF THE OIL PRESSURE SWITCH TO REFLECT CHANGE IN ENGINE WIRING. SEE I-4	10/9/03	ML
2	UPDATED SCHEMATIC TO REFLECT CHANGE TO LP ENGINE AND PROVIDE DETAIL OF MOTOR HARNESS. ADDED NOTES WITH DETAILS OF MULTI-POLE CONNECTOR ASSEMBLIES.	10/2/03	OS
3	APPLIED WIRE NUMBERS TO HARNESS WIRING. IDENTIFIED SAME ON SCHEMATIC BY NUMBER WITHIN CIRCLE.	5/25/00	OS

REVISION

THIS DRAWING AND THE DESIGN SHOWN THEREIN IS THE PROPERTY OF BLASTRAC AND USE OR COPIES THEREOF CANNOT BE MADE WITHOUT WRITTEN CONSENT.

FIRST USED	REF. NO.	PART NO.
-	220-0287	P001181

TOLERANCE
UNLESS SPECIFIED

BLASTRAC
6215 ALUMA VALLEY DRIVE
OKLAHOMA CITY, OK 73121
U.S.A.

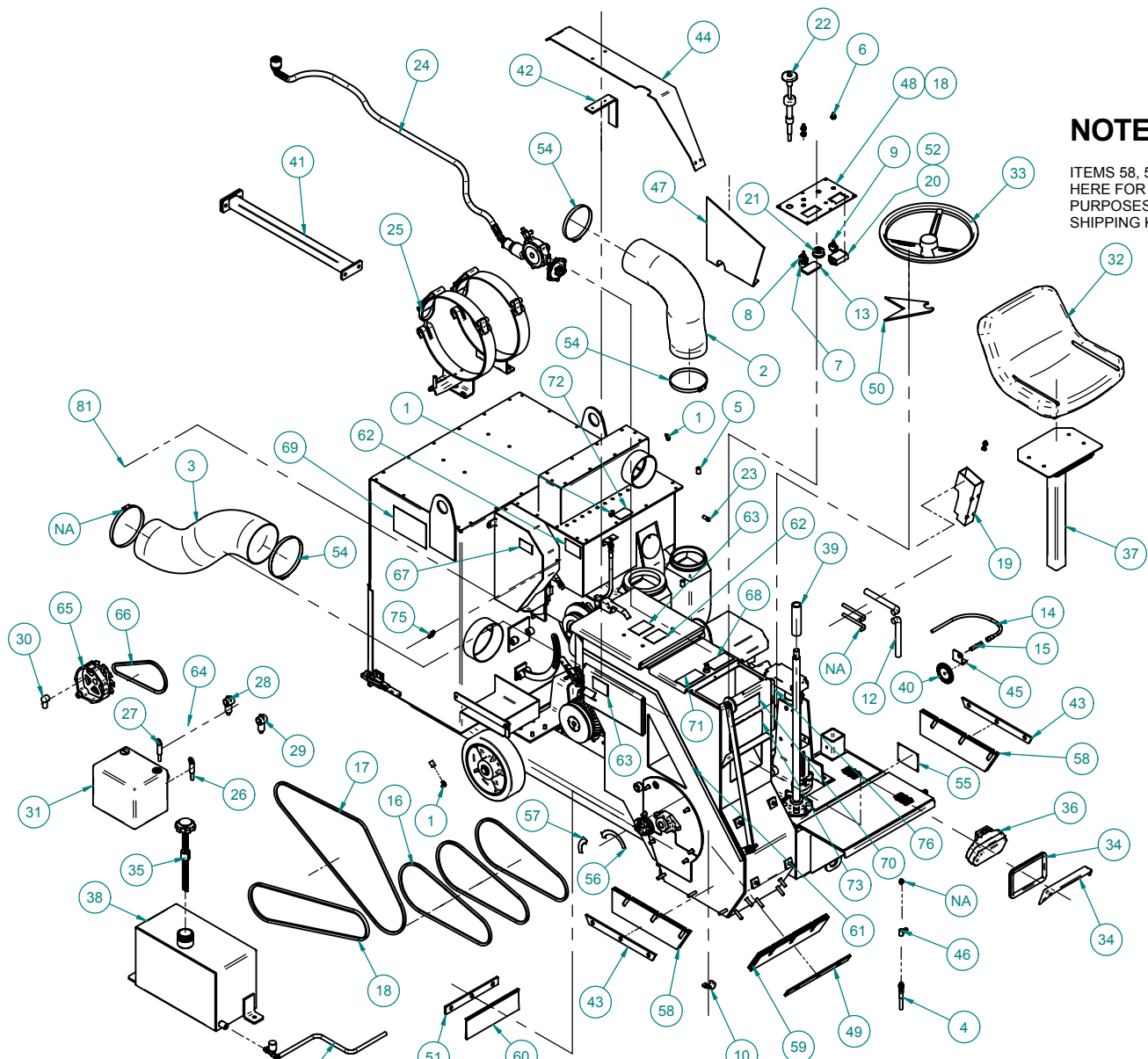
GPX 1018 BLAST UNIT
WIRING HARNESS SCHEMATIC

ANGLES	± 1'
FRACTIONS	± 1/16
2 PL DEC	± .06
3 PL DEC	± .005

SCALE: NTS
DATE: 7/30/99
DRWN: OS
SHT: 1 OF 1

220-0287

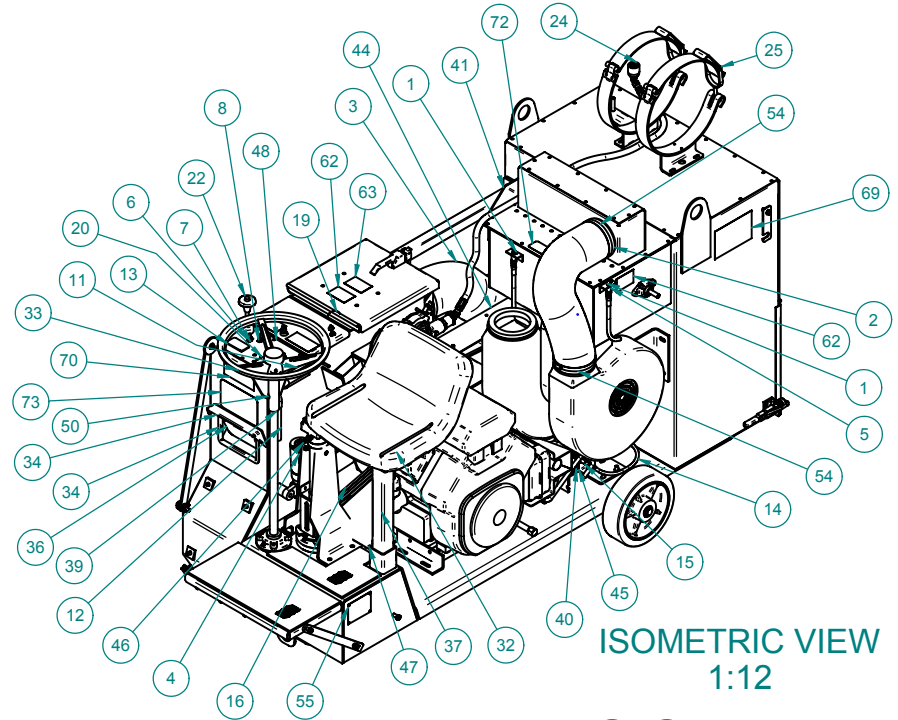
ITEM NUMBER	BLASTRAC PART NUMBER	DESCRIPTION	QUANTITY
1	SHOP STOCK	TERMINAL, RING, 16-14 AWG (BLUE), 6 STUD, INSULATED	3
2	SHOP STOCK	RING TERMINAL, 16-14 AWG, 10 STUD, INSULATED	21
3	SHOP STOCK	TERMINAL, RING, 16-14 AWG (BLUE), 1/4 STUD, INSULATED	2
4	SHOP STOCK	RING TERMINAL, 16-14 AWG, 5/16 STUD, INSULATED	2
5	SHOP STOCK	RING TERMINAL, 16-14 AWG, 3/8 STUD, INSULATED	1
6	SHOP STOCK	RING TERMINAL, 12-10 AWG, 1/4 STUD, INSULATED	2
7	SHOP STOCK	RING TERMINAL, 12-10 AWG, 5/16 STUD, INSULATED	1
8	SHOP STOCK	BULLET CONNECTOR, MALE, 16-14 AWG, INSULATED	9
9	SHOP STOCK	BULLET CONNECTOR, FEMALE, 16-14 AWG, INSULATED	9
10	SHOP STOCK	SPADE TERMINAL, FEMALE, 16-14 AWG, .25, TOTALLY INSULATED	1
11	P003069	TERMINAL, HOUSING, 4 POLE FOR FEMALE TERMINALS, PACKARD PN 38007THF4	1
12	P003068	TERMINAL, HOUSING, 4 POLE FOR MALE TERMINALS, PACKARD PN 38006THM4	1
13	P003066	TERMINAL, HOUSING, 5 POLE FOR MALE TERMINALS	1
14	P003067	TERMINAL, SPADE, LOCKING, .25", FEMALE, 16-14AWG	4
15	P003065	TERMINAL, SPADE, LOCKING .25", MALE, 16-14AWG	7
16		NYLON GROMMET, .5" MOUNTING HOLE, 3/8" ID, HEAD DIA.-37/64, OAH-13/32"	2
17	P003063	FUSE BLOCK, 30 AMP W/ 8" LEADS	1
18	SHOP STOCK	TERMINAL, BUTT CONNECTOR, 16-14 AWG (BLUE), INSULATED	1
19	SHOP STOCK	TERMINAL, FORK, 16-14 AWG, 6 STUD, INSULATED	2
23	6910001	FORWARD/REVERSE CONTROLLER W/ INTERGRATED SHOT FEED - OPEN/CLOSE SWITCHES	1
24	6300064	1500 LB. ACTUATOR, FOR LIFT UP/DOWN	1
25	7530022	BATTERY	1
26	5100002	SPST, ON/OFF, MAINTAINED, LIGHT SWITCH, 6 A/125 VAC	1
27	5100006	DPDT, CENTER OFF, MOMENTARY, LIFT - UP/DOWN, 20 A/277 VAC	1
28			
29	7150007	IGNITION SWITCH	1
30	7530010	46" POSITIVE BATTERY CABLE (RED) W/ 14" WHITE PIGTAIL	1
31	7530013	TERMINAL INSULATOR, BATTERY CABLE, RED	1
32	7530011	14" NEGATIVE BATTERY CABLE (Black)	1
33	7530012	TERMINAL INSULATOR, BATTERY CABLE,	1
34	7100007	TACH/HOUR METER	1
35	5730005	FOOT PER MINUTE (FPM) METER	1
36	8900001	PANEL OVERLAY	1
37	8000025	HEADLIGHT (PN CONTAINS TWO HEADLIGHTS)	1
38	P002245	PROXIMITY SENSOR, NON-SHIELDED, 4 MM SENSING DISTANCE, DC	1
39	5730007	CORDSET, EUROFAST	1
40	5600009	WIRING HARNESS ASSY	1
41	6300065	500LB. ACTUATOR 12V	1
42	5910001	WIPER MOTOR FOR FLAPPER	1
43	10180002	MOTOR KIT	1
44	5200016	3/8" X 1/2", 90 DEGREE GREENFIELD CONNECTOR FOR 1/2" ID LOOM	2
45	7530019	ALTERNATOR	1
46	7530018	TERMINAL INSULATOR, RED (USED ON ALTERNATOR)	1
47	5100001	WEATHER-PROOF BOOT FOR TOGGLE SWITCHES	2
48	P003064	FUSE, 30 AMP	1



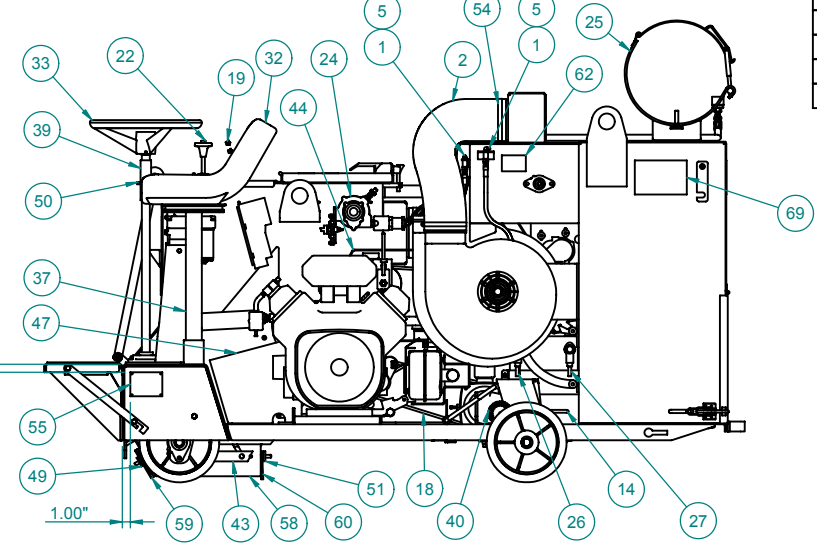
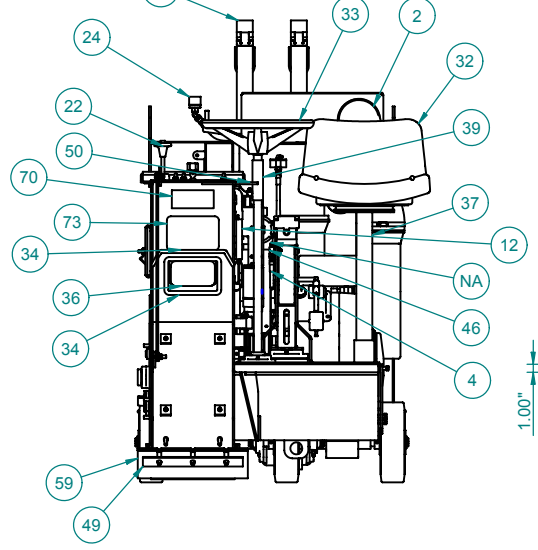
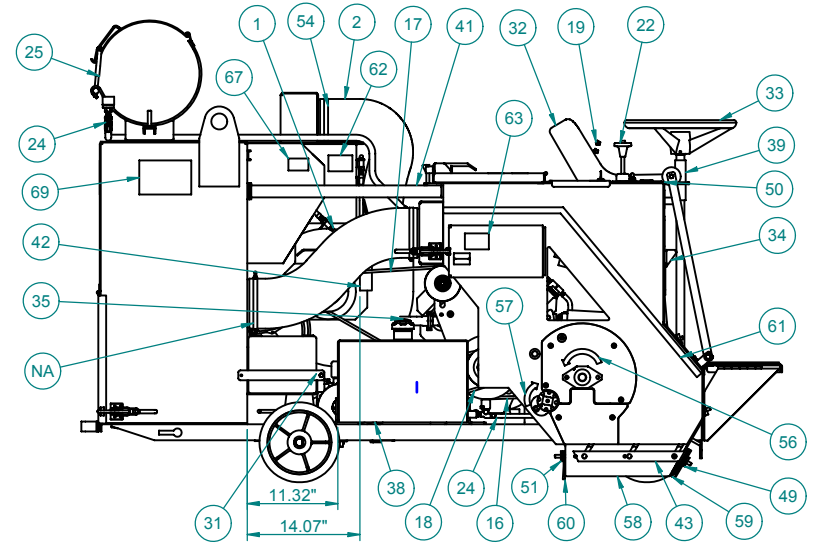
EXPLODED ISOMETRIC VIEW
1:12

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION	WIDTH	LENGTH	ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION	WIDTH	LENGTH
51	1	08300063	220-0080	RETAINER/REAR SEAL	--	--	1	3	02230003	--	FITTING/GREASE ZERK 1/8"NPT 90 DEG.	--	--
52	2	08300121	220-0138	SPACER/TINY TACH	--	--	2	1	04510004	--	HOSE/DUCT NEOPRENE 5"ID	--	28.00
53	1	08900001	--	OVERLAY/INSTRUMENT PANEL	--	--	3	1	04510005	--	HOSE/DUCT NEOPRENE 6"	--	24.00
54	4	176038	--	CLAMP/HOSE ADJUST S.S. 3"-6"	--	--	4	1	04540001	--	HOSE/GREASE 1/4"NPT SWIVEL X 3/16"NR703 X 1/4"NPT X 20"OAL	--	--
55	1	P000818	--	PLATE/SERIAL NUMBER - USF/BLASTRAC	3.00	4.00	5	3	04900022	--	COUPLING/PIPE 1/8" NPT	--	--
56	1	P000921	--	DECAL/WHEEL ROTATION	--	--	6	3	05100001	--	RUBBER BOOT/SWITCH	--	--
57	1	P000922	--	DECAL/PINCH BAR ROTATION	--	--	7	1	05100002	--	SWITCH/ 1 POLE 1 THRW (HEAD LIGHT)	--	--
58	2	SL023506	220-0256	SEAL-KIT/SIDE	--	--	8	1	05100003	--	SWITCH/ 1 POLE 2 THRW (FUEL)	--	--
59	1	SL023507	220-0257	SEAL-KIT/FRONT	--	--	9	1	05100006	--	SWITCH/ 2 POLE 2 THRW (MACHINE LIFT)	--	--
60	1	WP163711	220-0282	SEAL/DRAW-BRUSH	--	10.50	10	1	05200001	--	CLAMP/CONDUIT 1/2"	--	--
61	1	P000923	--	STRIPE/WHITE REFLECTIVE	--	36.00	11	1	05310004	--	WIRE-LOOM/ 1/4"	--	168.00
62	3	P000984	--	SIGN/CAUTION - DO NOT WORK	--	--	12	1	05600009	--	WIRING HARNESS ASSEMBLY	--	--
63	2	P000985	--	SIGN/CAUTION - DO NOT OPEN	--	--	13	1	05730005	--	READOUT/DIGITAL (FOOT PER MINUTE)	--	--
65	1	07530019	--	ALTERNATOR #321 39	--	--	14	1	05730007	--	CABLE/PROXIMITY SENSOR	--	--
66	1	06100002	--	V-BELT 3VX-280	--	--	15	1	05730008	--	PROXIMITY SENSOR	--	--
67	1	494044	--	DECAL/WARNING - DO NOT OPERATE	--	--	16	3	06100006	--	V-BELT/ 3VX-425	--	--
68	1	680181	--	DECAL/WARNING - DUST	--	--	17	1	06100015	--	V-BELT/ 3VX-710	--	--
69	3	P000008	--	DECAL/IDENTITY - USF/BLASTRAC	--	--	18	1	06120005	--	BELT/ACCULINK A25	--	53.00
70	1	P000009	--	DECAL/IDENTITY - GPX10-18	--	--	19	1	06910001	--	TRANSMISSION LEVER/COMPLETE	--	--
71	1	P001419	--	DECAL/CAUTION - EYE AND EAR	--	--	20	1	07100007	--	TACHOMETER/TINY TACH	--	--
72	1	P001420	--	DECAL/MADE IN USA - SMALL	--	--	21	1	07150007	--	SWITCH/IGNITION	--	--
73	1	P001421	--	DECAL/MADE IN USA - LARGE	--	--	22	1	07300001	--	CABLE/THROTTLE - VERNIER STYLE W/RELEASE	--	--
75	1	06520001	--	LINK/MASTER ASA#35	--	--	23	1	07300003	--	PLAIN FITTING KIT/CONTROL CABLE 3/8"DIA. BODY	--	0.75
76	1	05310003	--	WIRE-LOOM 5/8"	--	16.00	24	1	07500002	--	KIT/PROPANE - KOHLER 25HP	--	--
81	1	06500001	--	CHAIN/ ROLLER ASA #35	--	--	25	1	07510005	--	BRACKET/PROPANE TANK	--	--
							26	1	07530010	--	CABLE/BATTERY - POSITIVE (46" RED) W/ LEAD (14" WHITE)	--	46.00
							27	1	07530011	--	CABLE/BATTERY - NEGATIVE (12" BLACK)	--	12.00
							28	1	07530012	--	COVER/BATTERY TERMINAL (BLACK)	--	--
							29	1	07530013	--	COVER/BATTERY TERMINAL (RED)	--	--
							30	1	07530018	--	COVER/ALTERNATOR TERMINAL (RED)	--	--
							31	1	07530022	--	BATTERY/12V WILLARD	--	--
							32	1	08000001	--	SEAT/COMMANDER MODEL #350	--	--
							33	1	08000002	--	STEERING WHEEL	--	--
							34	1	08000005	--	EDGING/DOOR 1/8"ID	--	32.00
							35	1	08000006	--	CAP/GAS - BLACK PLASTIC VENTED	--	--
							36	1	08000025	--	HEADLIGHT/ 12V RECTANGULAR W/CLEAR LENS	--	--
							37	1	08300001	220-0018	SEAT SUPPORT ASSEMBLY	--	--
							38	1	08300004	220-0021	TANK/GAS	--	--
							39	1	08300023	220-0046	BUSHING/FRONT STEERING SHAFT	--	--
							40	1	08300028	220-0045	WHEEL/SPEED SENSOR PICKUP	--	--
							41	1	08300033	220-0050	BRACE/STIFFENER	--	--
							42	1	08300034	220-0051	BRACKET/REAR BELT-GUARD MOUNTING	--	--
							43	2	08300035	220-0052	RETAINER/SIDE SEAL	--	--
							44	1	08300036	220-0053	GUARD/REAR BELT	--	--
							45	1	08300037	220-0054	BRACKET/SPEED PICKUP SENSOR	--	--
							46	1	08300038	220-0055	ADAPTER/GREASE FITTING 1/8"NPT	--	--
							47	1	08300050	220-0067	GUARD/BELT - FRONT	--	--
							48	1	08300055	220-0072	PANEL/INSTRUMENT	--	--
							49	1	08300059	220-0076	RETAINER/FRONT SEAL	--	--
							50	1	08300062	220-0079	BRACKET/STEERING COLUMN	--	--

NOTE:
ITEMS 58, 59 & 60 ARE SHOWN HERE FOR REPLACEMENT PURPOSES ONLY. SEE SHIPPING KIT.

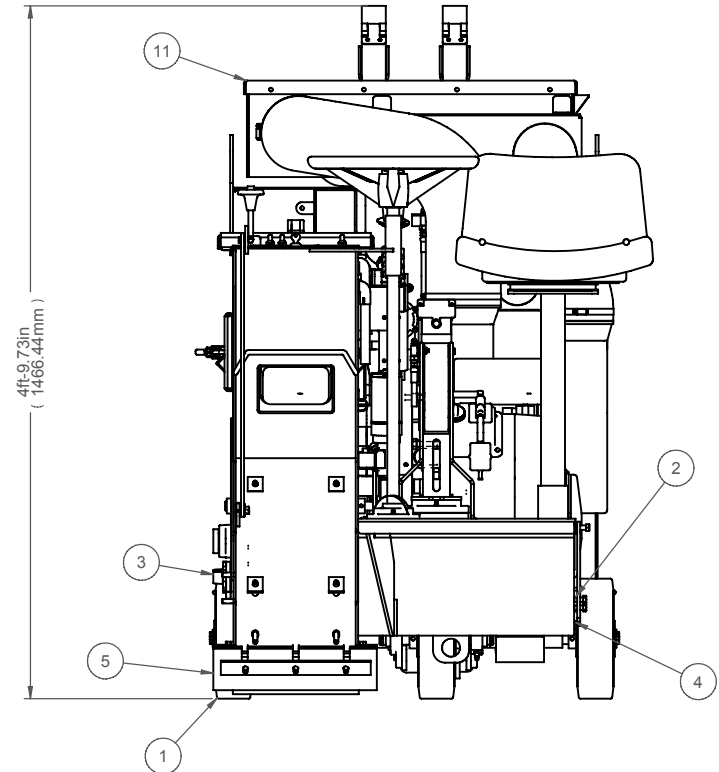
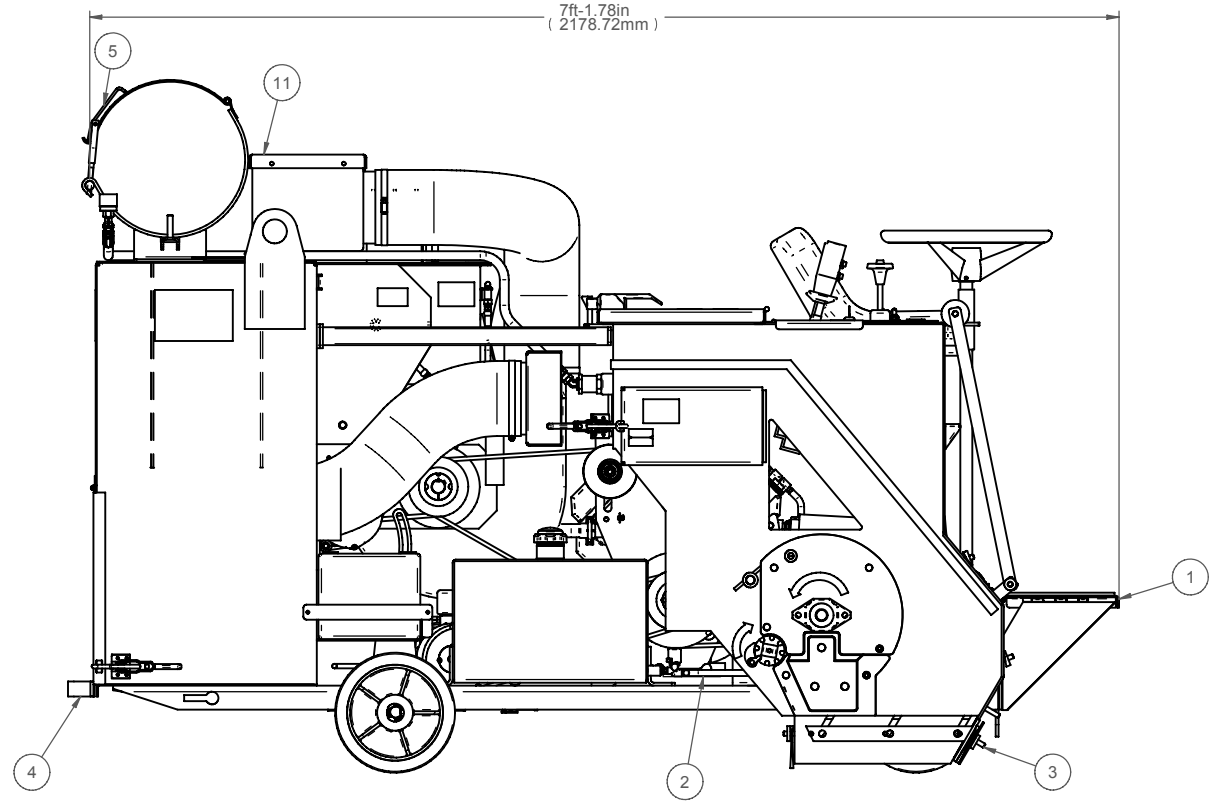
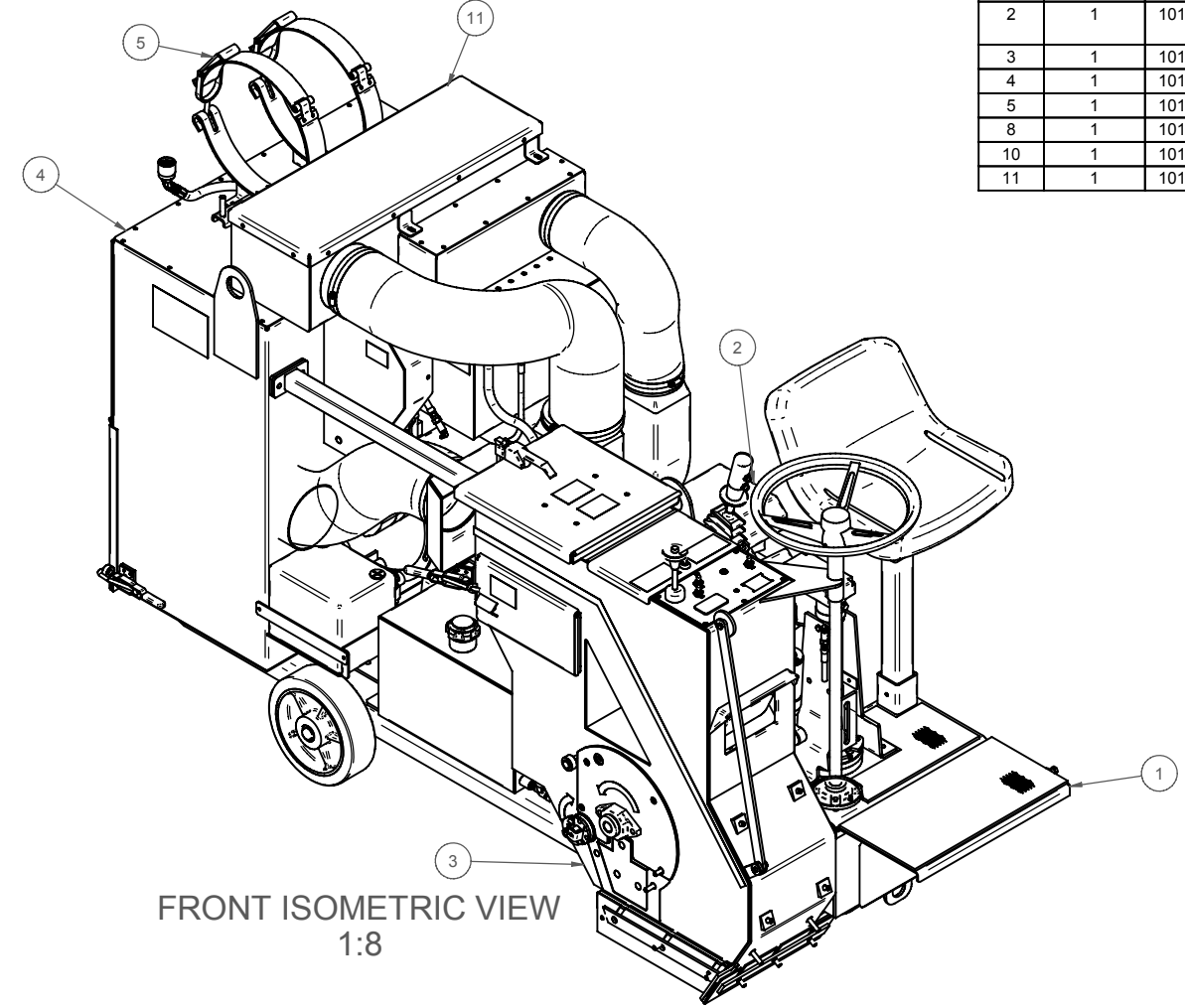
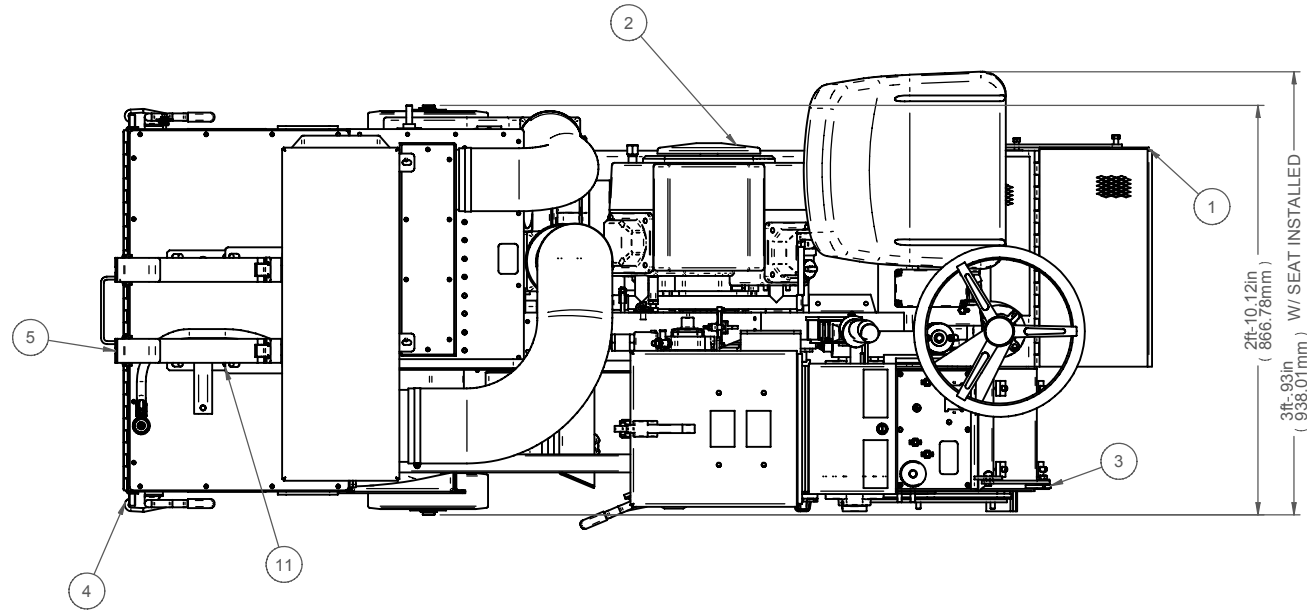


ISOMETRIC VIEW
1:12

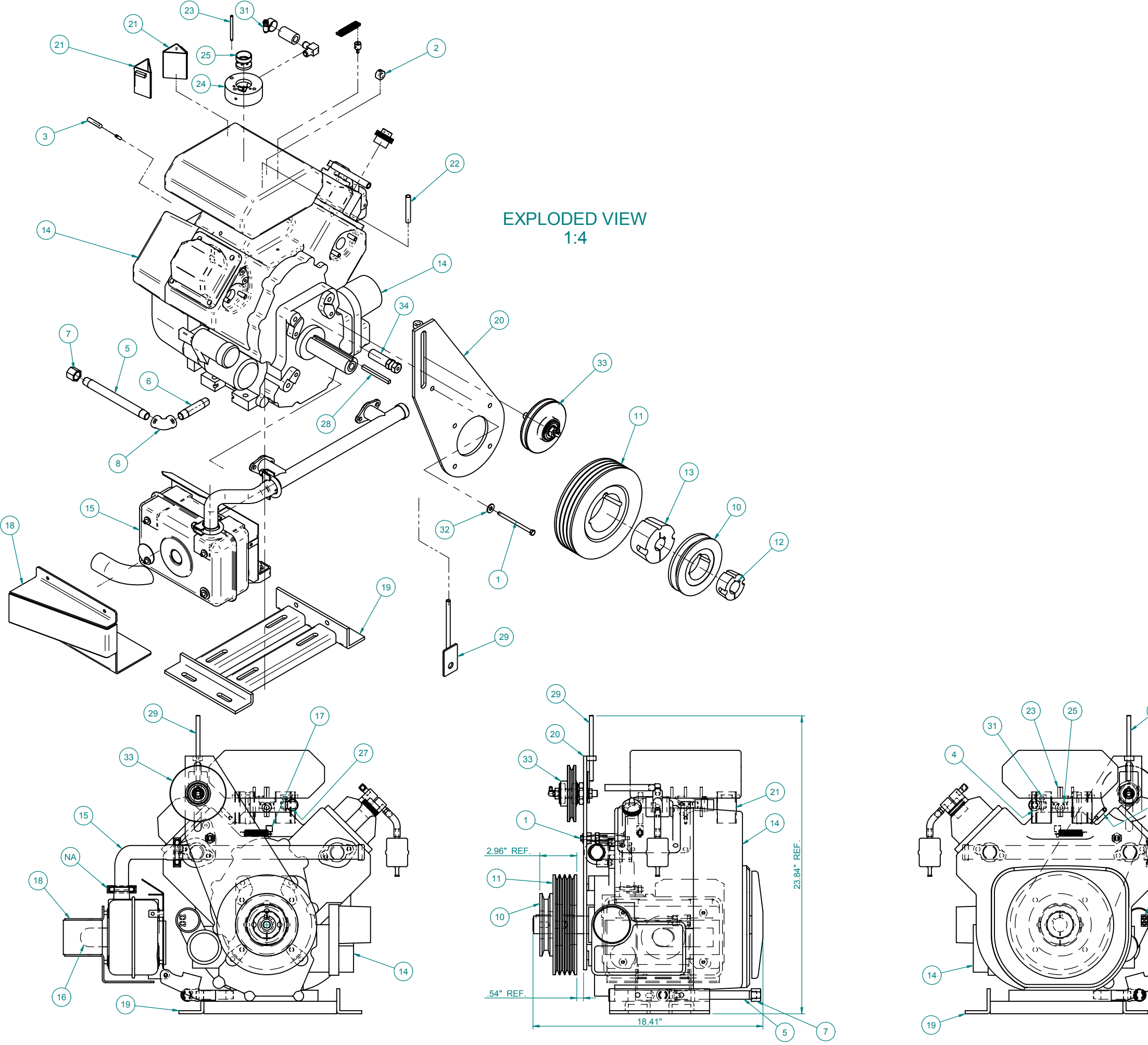


B	ITEM 1 QTY WAS (4); ITEM #62 QTY WAS (2); ITEM #63 QTY WAS (3);	3/30/00	SCS
	WAS (3); ADDED ITEMS #67 THRU #81;		
	REFERENCE NCR00-0040, NCR00-0105, & NCR00-0106		
A	ITEM 54 CATALOG NUMBER WAS 452394 - NCR00-0040;	2/20/00	SCS
	ADDED ITEMS 65 & 66 FROM 10180004 - NCR00-0030		
REV	ZONE	DESCRIPTION	DATE BY
REVISION			
THIS DRAWING AND THE DESIGN SHOWN THEREIN IS THE PROPERTY OF U.S. FILTER WHEELABRATOR AND USE OR COPIES THEREOF CANNOT BE MADE WITHOUT WRITTEN CONSENT.			
NEXT ASSY	GPX10-18	REF. NO.	PART NO. 10180005
TOLERANCE UNLESS SPECIFIED		U.S. FILTER BLASTRAC	
ANGLES ± .500°		6215 ALUMA VALLEY DRIVE OKLAHOMA CITY, OK 73121 U.S.A.	
1 PL DEC ± .060		FINAL ASSEMBLY COMPONENTS	
2 PL DEC ± .010		GPX10-18 BLAST UNIT	
3 PL DEC ± .005		SCALE 1:12	DRWN SCS
		DATE 10/13/99	SHT 1 OF 1
		220-0271	

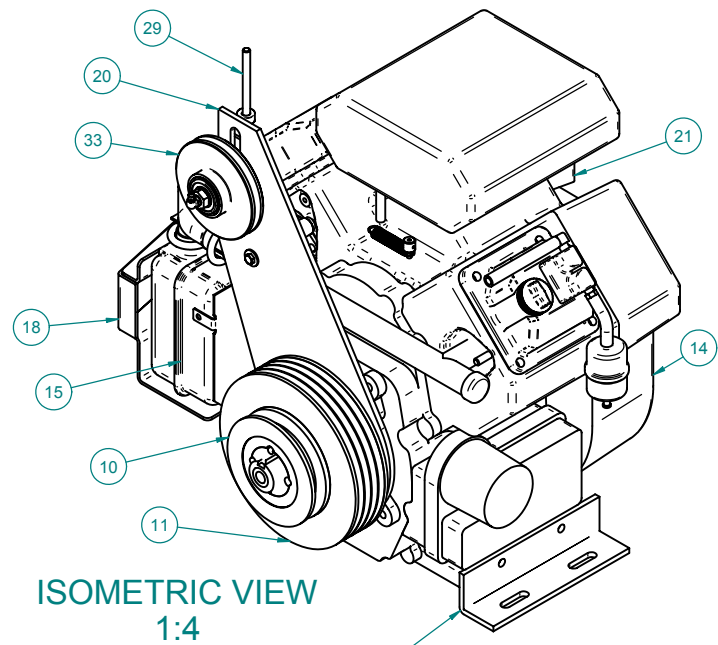
ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1	1	10180001	220-0017	DECK ASSEMBLY
2	1	10180002	220-0273	ENGINE ASSEMBLY - KOHLER 25 HP
3	1	10180003	220-0270	BLASTHEAD ASSEMBLY - 10"
4	1	10180004	220-0258	DUST COLLECTOR ASSEMBLY
5	1	10180005	220-0271	FINAL ASSEMBLY COMPONENTS
8	1	10180008	--	PAINT AND SHIPPING KIT
10	1	10180010	--	DUST BIN KIT
11	1	10180011	--	SILENCER BOX KIT



REV	ZONE	DESCRIPTION	DATE	BY
REVISION				
<small>THIS DRAWING AND THE DESIGN SHOWN THEREIN IS THE PROPERTY OF U.S. FILTER WHEELABRATOR AND USE OR COPIES THEREOF CANNOT BE MADE WITHOUT WRITTEN CONSENT.</small>				
NEXT ASSY	--	REF. DWG. GPX10-18	PART NO.	GPXP1018
TOLERANCE UNLESS SPECIFIED		U.S. FILTER		
ANGLES ± .500°		BLASTRAC		
1 PL DEC ± .060		6215 ALUMA VALLEY DRIVE		
2 PL DEC ± .010		OKLAHOMA CITY, OK 73121		
3 PL DEC ± .005		U.S.A.		
GENERAL ASSEMBLY		GPX10-18 BLAST UNIT		
SCALE	1:8	DRWN	SCS	220-0283
DATE	10/18/99	SHT	1 OF 1	



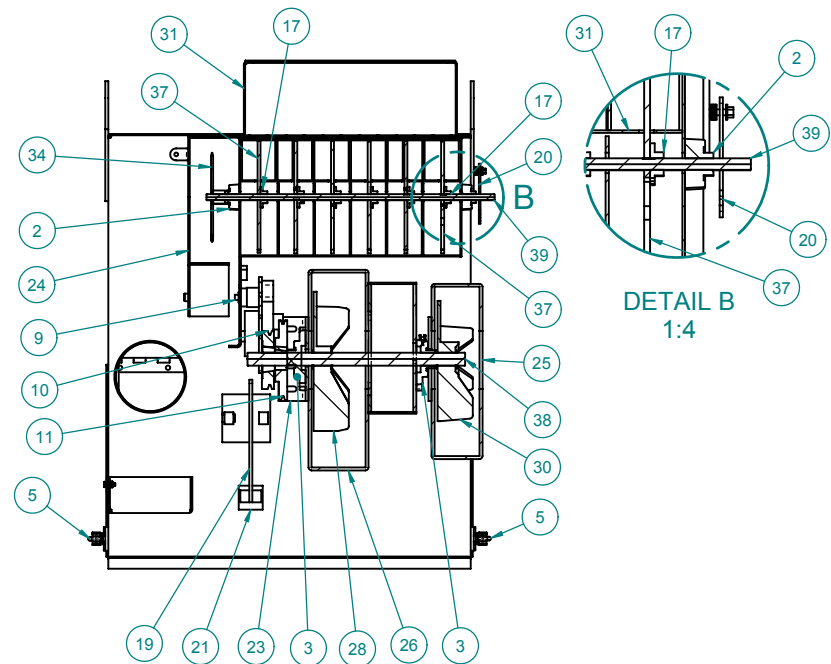
EXPLODED VIEW
1:4



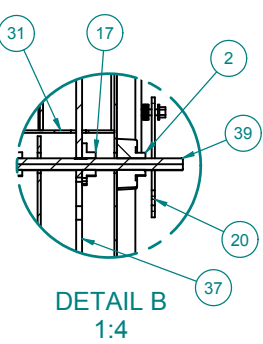
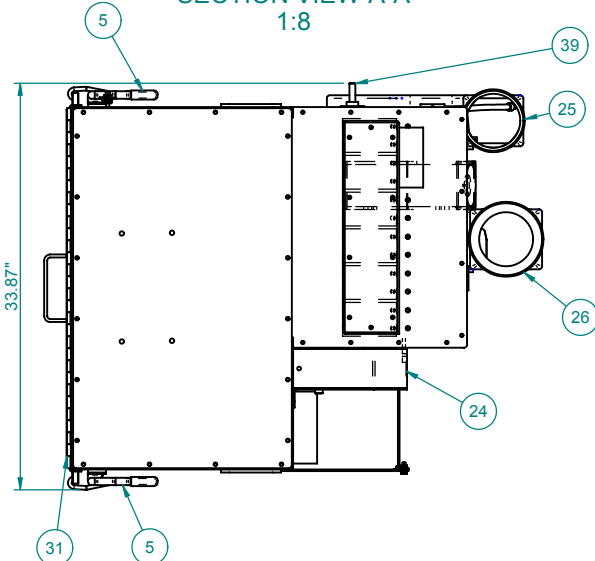
ISOMETRIC VIEW
1:4

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION	WIDTH	LENGTH
1	1	--	--	SCREW/M6 HEX HEAD	--	3.75
2	1	02200005	--	COLLAR/SHAFT 3/8"	--	--
3	1	04500011	--	HOSE/VACUUM 5/32" DIA.	--	26.00"
4	1	04500012	--	HOSE/PROPANE 1/2" DIA	--	22.00"
5	1	04970014	--	NIPPLE/PIPE 3/8" X 7"	--	7.00
6	1	04970015	--	NIPPLE/PIPE 3/8" X 3"	--	3.00
7	1	04980002	--	CAP/PIPE HEX 3/8"	--	--
8	1	04980079	--	ELBOW/PIPE 3/8" X 90DEG.	--	--
9	1	05110004	--	FUSE BLOCK/ 12V x 30 AMP	--	--
10	1	06150001	--	SHEAVE/MOTOR 1A 4.6"DIA	--	--
11	1	06150045	--	SHEAVE/MOTOR 8.0' 4GR 3V T/L	--	--
12	1	06300025	--	BUSHING/1610 x 1.125" DIA. T/L	--	--
13	1	06300052	--	BUSHING/2517 x 1.125"DIA T/L	--	--
14	1	07100001	--	ENGINE KOHLER 25 HP	--	--
15	1	07100002	--	MUFFLER/ASSEMBLY	--	--
16	1	07100030	220-0280	MUFFLER-TIP	--	--
17	1	07100031	--	FITTING/THROTTLE CABLE 25HP	--	--
18	1	07100035	220-0269	GUARD/MUFFLER - CH25	--	--
19	1	07100036	220-0275	BRACKET/MOTOR MOUNTING	--	--
20	1	07100037	220.0274	BRACKET/IDLER PULLEY 25 HP	--	--
21	2	07100038	220-0281	BREATHER-TUBE/KOHLER CH25	--	--
22	1	07100042	--	EXTENSION/ PROPANE HOSE TO CARB.	--	--
23	3	07100043	--	ALL THREAD/CARB VENTURI 25HP	--	2.25"
24	1	07510007	220-0278	VENTURI BLOCK	--	--
25	1	07510008	220-0279	VENTURI	--	--
26	1	07520020	--	NIPPLE/VACUUM BRASS	--	--
27	1	07520028	--	ELBOW/BARBED 90 DEG 1/4-28 NPT	--	--
28	1	08300076	220-0093	STEP SUPPORT STOP	--	--
29	1	08300198	220-0276	BRACKET/IDLER PULLEY ADJUSTMENT	--	--
30	1	08600001	--	SPRING/CHOKE TRIGGER	--	3.00"
31	1	2051120	--	CLAMP/HOSE ADJUST. SS	--	--
32	1	500102	--	WASHER/FLAT 1/4"	--	--
33	1	P000882	220-0223	IDLER ASSEMBLY	--	--
34	1	P001179	220-0285	SPACER/ADJUSTABLE - IDLER BRACKET	--	--

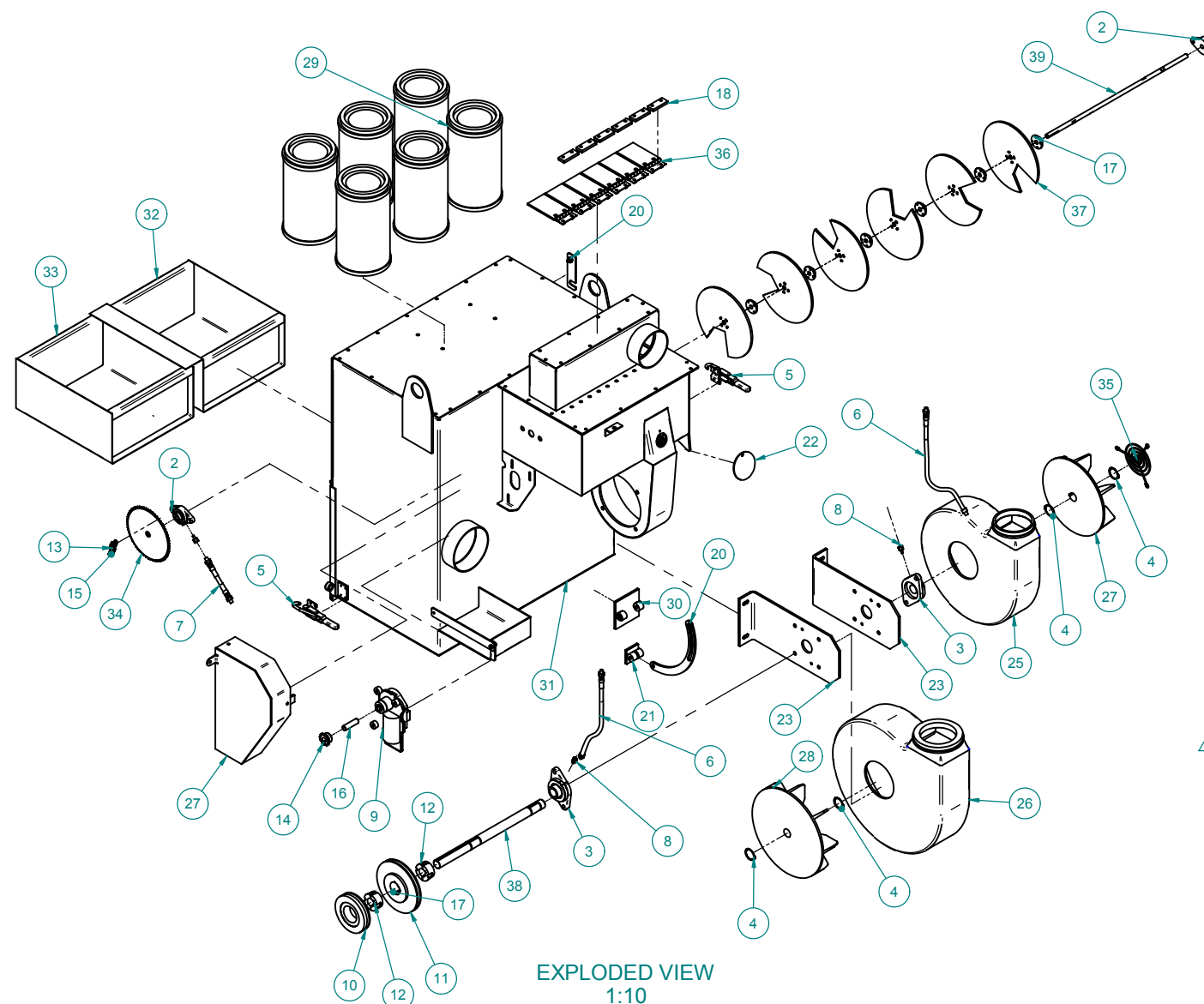
B	ITEM 34 WAS P000978	1/24/00	SCS
A	ITEM 28 WAS 07100044	11/5/99	SCS
REV	ZONE	DESCRIPTION	DATE BY
REVISION			
THIS DRAWING AND THE DESIGN SHOWN THEREIN IS THE PROPERTY OF U.S. FILTER WHEELABRATOR AND USE OR COPIES THEREOF CANNOT BE MADE WITHOUT WRITTEN CONSENT.			
NEXT ASSY	REF. DRWG	PART NO.	10180002
TOLERANCE UNLESS SPECIFIED	U.S. FILTER BLASTRAC		
ANGLES ± .500°	6215 ALUMA VALLEY DRIVE OKLAHOMA CITY, OK 73121 U.S.A.		
1 PL DEC ± .060	KIT/MOTOR KOHLER 25HP		
2 PL DEC ± .010	GPX10-18 BLAST UNIT		
3 PL DEC ± .005	SCALE	DRWN TLH	DATE 9/13/99
	SHT 1 OF 1	REV	220-0273



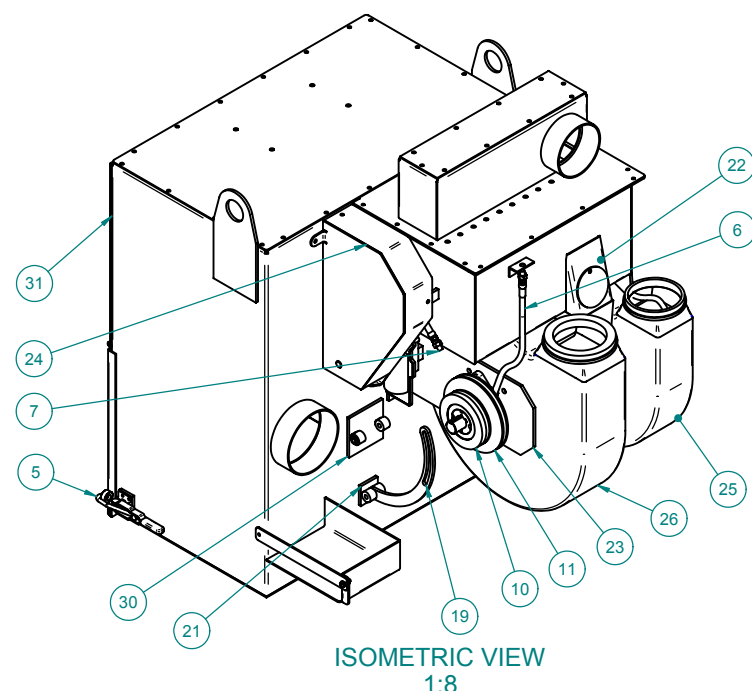
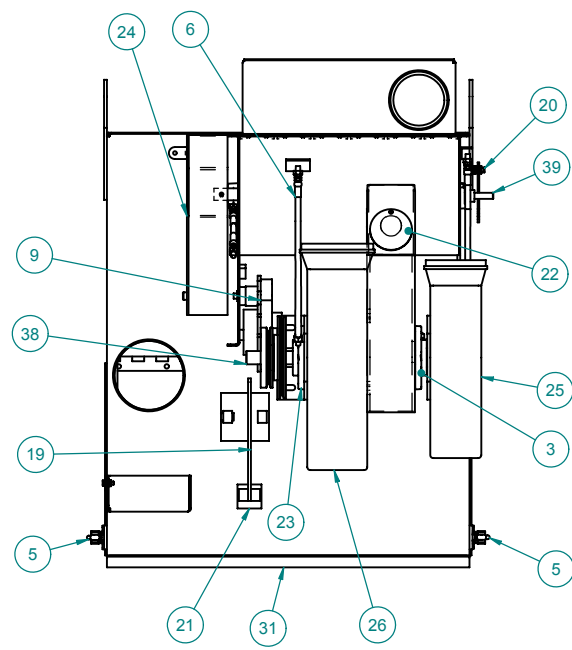
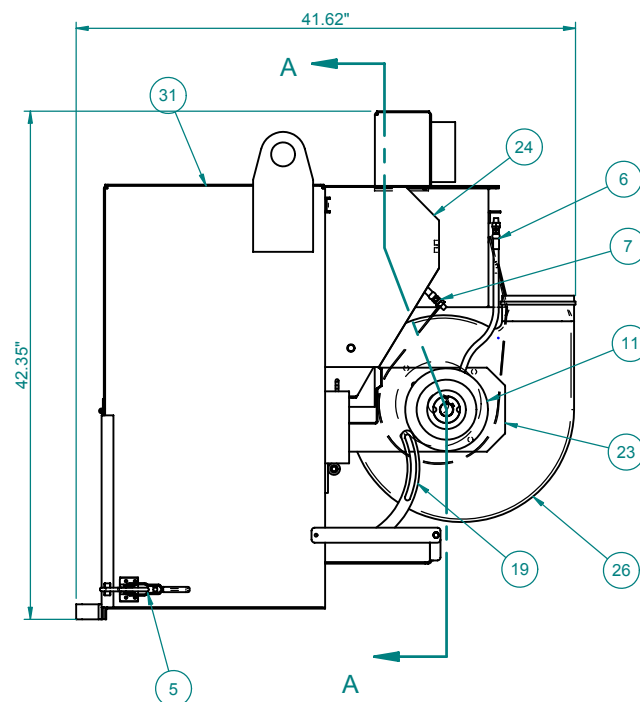
SECTION VIEW A-A
1:8



DETAIL B
1:4



EXPLODED VIEW
1:10

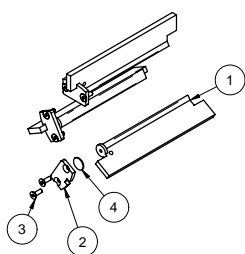
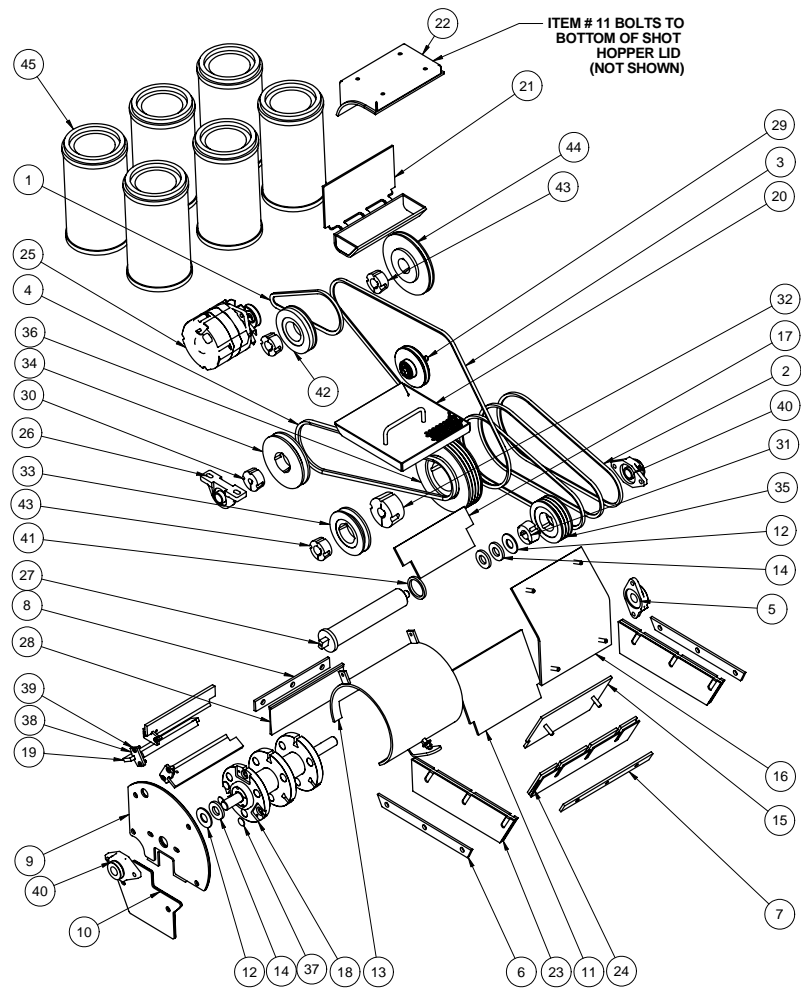


ISOMETRIC VIEW
1:8

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1*	1	01930004	--	SPONGE/ OPEN CELL 1/4" X 1"
2	2	02110001	--	BRG/FG2 DODGE BALL SC 1/2"B
3	2	02110003	--	BRG/ 2 BOLT FLANGE 1-1/8"
4	4	03400001	--	RETAINER-RING 1-1/8 X 0.093"THK #SHR-112
5	2	03600003	--	CLAMP/DE-STA-CO #351
6	2	04540001	--	HOSE/GREASE 1/4"NPT SWIVEL X 3/16"NR703 X 1/4"NPT X 20"OAL
7	1	04540003	--	HOSE/GREASE 1/4"NPT SWIVEL X 3/16"NR703 X 1/4"NPT X 5-1/2"OAL
8	3	04900021	--	ADAPTER/BEARING GREASE FITTING X 1/8"NPT
9	1	05910001	--	MOTOR/ WIPER
10	1	06150003	--	SHEAVE 1GR3V 5.0-1610 T/L
11	1	06150007	--	SHEAVE 1GR3V 6.9-1610 X 1-1/8" T/L
12	2	06300025	--	BUSHING/1610 x 1.125" DIA. T/L
13	1	06500001	--	CHAIN/ ROLLER ASA #35
14	1	06510007	--	SPROCKET 35BS12 X 5/8"
15*	1	06520001	--	LINK/MASTER ASA#35
16	1	08300017	220-0034	ADAPTER/WIPER MOTOR
17	6	08300082	220-0099	CAM DISK HUB
18	6	08300083	220-0100	SPACER/ FLAPPER
19	1	08300085	220-0102	BRACKET/ ARM ALTERNATOR
20	1	08300086	220-0103	LATCH/ DUST COLLECTOR DOOR
21	1	08300088	220-0105	BRACKET/ ALTENATOR ADJUSTING ARM
22	1	08300089	220-0106	PLATE / DAMPER
23	2	08300092	220-0109	BRACKET/ BLOWER HOUSING
24	1	08300169	220-0232	GUARD/ WIPER MOTOR CHAIN
25	1	09100001	--	PB-10 CCW HOUSING
26	1	09100002	--	PB-12 CCW HOUSING
27	1	09200001	--	BLOWER-WHEEL #PB-10 CAST-ALUMINUM 10.375"DIA. X 2.75" WIDE W/ 1.125"B & STDKWY (2) SET SCREWS 120 DEG APART (1) OVER KWY
28	1	09200003	--	BLOWER/ WHEEL PB-14
29	6	09420001	--	ELEMENT/FILTER
30	1	10250002	220-0230	BRACKET/ ALTERNATOR MOUNTING
31	1	P000881	220-0222	DUST COLLECTOR WELDMENT
32	1	P000883	220-0224	DUST TRAY - LH
33	1	P000884	220-0225	DUST TRAY - RH
34	1	P000909	220-0235	SPROCKET ADAPTER/ CAM BOX
35	1	P001022	--	SCREEN/ INLET FOR PB-10
36	1	WP213701	220-0227	FLAPPER KIT (SET OF 6)
37	6	WP223702	220-0229	CAM DISK
38	1	WP233705	220-0272	SHAFT/BLOWER
39	1	WP253703	220-0253	SHAFT/ CAM

A	REVISED ASSEMBLY AND BOM; REMOVED ALT - 07530019 & 2/7/00	SCS																					
	BELT - 06100002; ADDED DUST TRAYS - P000883 & P000884																						
REV	ZONE	DESCRIPTION																					
		DATE																					
		BY																					
REVISION																							
THIS DRAWING AND THE DESIGN SHOWN THEREIN IS THE PROPERTY OF U.S. FILTER WHEELABRATOR AND USE OR COPIES THEREOF CANNOT BE MADE WITHOUT WRITTEN CONSENT.																							
NEXT ASSY	GPXP1018	PART NO. 10180004																					
<table border="1"> <tr> <td>TOLERANCE UNLESS SPECIFIED</td> <td>U.S. FILTER BLASTRAC</td> <td>6215 ALUMA VALLEY DRIVE OKLAHOMA CITY, OK 73121 U.S.A.</td> </tr> <tr> <td colspan="3" style="text-align: center;">DUST COLLECTOR ASSEMBLY</td> </tr> <tr> <td colspan="3" style="text-align: center;">GPX 10-18</td> </tr> <tr> <td>ANGLES ± .500°</td> <td>SCALE 1:8</td> <td>DRWN MJP</td> </tr> <tr> <td>1 PL DEC ± .060</td> <td>DATE 11/2/99</td> <td>SHT 1 OF 1</td> </tr> <tr> <td>2 PL DEC ± .010</td> <td></td> <td></td> </tr> <tr> <td>3 PL DEC ± .005</td> <td></td> <td></td> </tr> </table>			TOLERANCE UNLESS SPECIFIED	U.S. FILTER BLASTRAC	6215 ALUMA VALLEY DRIVE OKLAHOMA CITY, OK 73121 U.S.A.	DUST COLLECTOR ASSEMBLY			GPX 10-18			ANGLES ± .500°	SCALE 1:8	DRWN MJP	1 PL DEC ± .060	DATE 11/2/99	SHT 1 OF 1	2 PL DEC ± .010			3 PL DEC ± .005		
TOLERANCE UNLESS SPECIFIED	U.S. FILTER BLASTRAC	6215 ALUMA VALLEY DRIVE OKLAHOMA CITY, OK 73121 U.S.A.																					
DUST COLLECTOR ASSEMBLY																							
GPX 10-18																							
ANGLES ± .500°	SCALE 1:8	DRWN MJP																					
1 PL DEC ± .060	DATE 11/2/99	SHT 1 OF 1																					
2 PL DEC ± .010																							
3 PL DEC ± .005																							
220-0258																							

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION	ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1	1	06100002	--	V-BELT 3VX-280	25	1	07530019	--	ALTERNATOR 12 V #321 39
2	3	06100006	--	V-BELT/ 3VX-425	26	1	02100002	--	BRG/PB2 DODGE SC 1.000"B
3	1	06100015	--	V-BELT/ 3VX-710	27	1	WP033710	220-0261	PINCH BAR
4	1	06120005	--	BELT/ACCULINK A25	28	1	WP163711	220-0282	SEAL/Drag-BRUSH
5	2	02110002	--	BRG/FG2 DODGE BALL SC 1.000"B	29	1	P000882	220-0223	IDLER ASSEMBLY
6	2	08300035	220-0052	RETAINER/SIDE SEAL	30	1	06300030	--	BUSHING/ TAPERLOCK #1610 X 17MM
7	1	08300059	220-0076	RETAINER/Front SEAL	31	1	06300024	--	BUSHING/TAPERLOCK 1610 X 1.00 / DODGE #117159
8	1	08300063	220-0080	RETAINER/REAR SEAL	32	1	06300052	--	BUSHING/2517 x 1.125"DIA T/L
9	1	P000525	220-0014	COVER-PLATE/BLAST HOUSING	33	1	06150001	--	SHEAVE/MOTOR 1A 4.6"DIA
10	1	P000526	220-0015	INSPECTION COVER/BLAST HOUSING	34	1	06150002	--	SHEAVE/ 1A5.2B5.6-1610 X 17MM T/L
11	1	WP103713	220-0210	LINER/GPX10-18 PINCH BAR BLAST HOUSING LOWER BACK WALL	35	1	06150031	--	SHEAVE/TAPERLOCK 3/3V4.75-1610 DODGE #112205
12	2	08300170	220-0266	SEAL/SHAFT - 1.00" BEARING	36	1	06150045	--	SHEAVE/MOTOR 8.00" 4 GR 3V T/L
13	1	WP113721	220-0238	LINER/TOP CURVED SLL	37	3	08300172	220-0189	SEAL/BLADE KEEPER
14	2	20000001	220-0267	PROTECTOR RING	38	3	WP123714	--	RETAINER/BLADE
15	1	WP043710	220-0254	LINER/LOWER FRONT - SLL	39	6	03110010	--	SCREW/CAP FLAT HEX SOCKET 1/4"-20UNC
16	1	WP043703	220-0255	LINER/UPPER FRONT SLL	40	2	P001083	--	BRG/FG2 DODGE DL 1.000"B 205 D-LOK
17	1	WP103710	220-0260	LINER/PINCH BAR SLL	41	1	08300173	220-0190	SEAL/PINCH BAR
18	1	WP123716	220-0007	BLASTWHEEL/DOVETAIL	42	1	06150003	--	SHEAVE 1GR3V 5.0-1610 T/L
19	1	WP013714	220-0002	BLADE-SET/DOVETAIL 10"	43	2	06300025	--	BUSHING/1610 x 1.125" DIA. T/L
20	1	08300107	220-0124	SCREEN/SHOT HOPPER	44	1	06150007	--	SHEAVE 1GR3V 6.9-1610 X 1-1/8" T/L
21	1	08300100	220-0117	TRAY/SHOT	45	6	09420001	--	ELEMENT/FILTER
22	1	08300131	220-0148	HALF-PIPE WELDMENT					
23	2	SL023506	220-0256	SEAL-KIT/SIDE					
24	1	SL023507	220-0257	SEAL-KIT/Front					



ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1	1	WP013714	220-0002	BLADE-SET/DOVETAIL 10"
2	3	WP123714	--	RETAINER/BLADE
3	6	03110010	--	SCREW/CAP FLAT HEX SOCKET 1/4"-20UNC
4	3	08300172	220-0189	SEAL/BLADE KEEPER

ITEMS #20, #37, #38, AND #39 IN THE ABOVE ASSEMBLY ARE INCLUDED IN THE BLADE KIT. WHEN ORDERING REPLACEMENTS FOR THESE PARTS USE PART NUMBER WKIT1018.

WKIT1018 - BLADE KIT