



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 your 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.

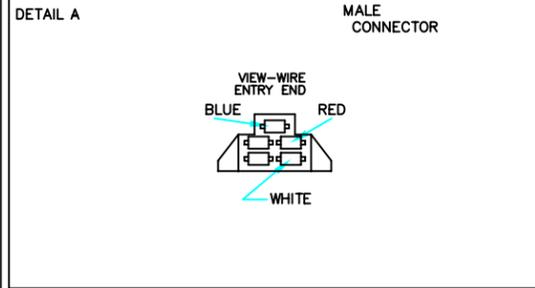
Before beginning any project involving the removal of hazardous materials, it is the responsibility of the contractor to ensure that the work site and equipment to be used have been inspected and the proposed work has been approved by the proper authorities. It is also the responsibility of the contractor 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

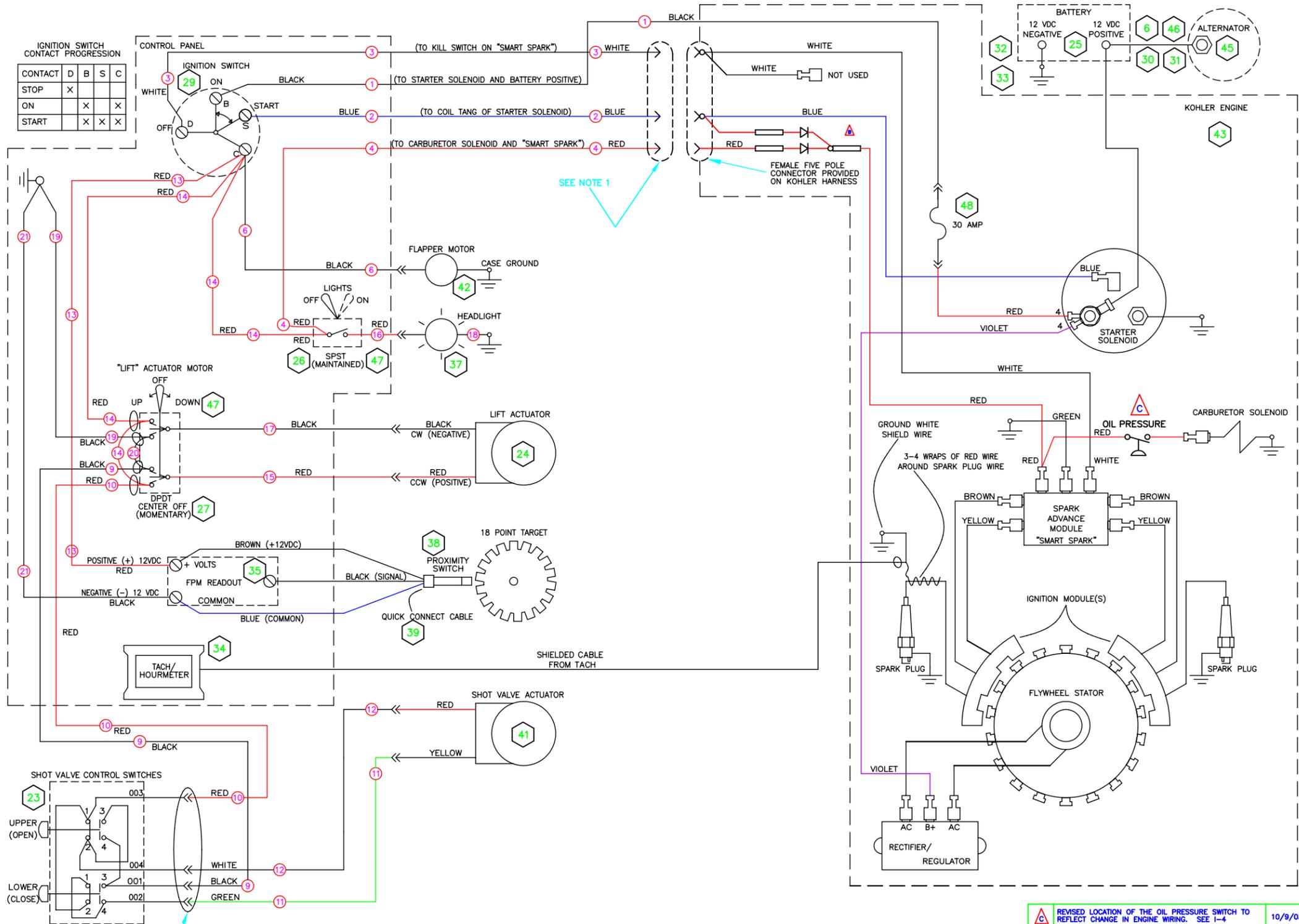
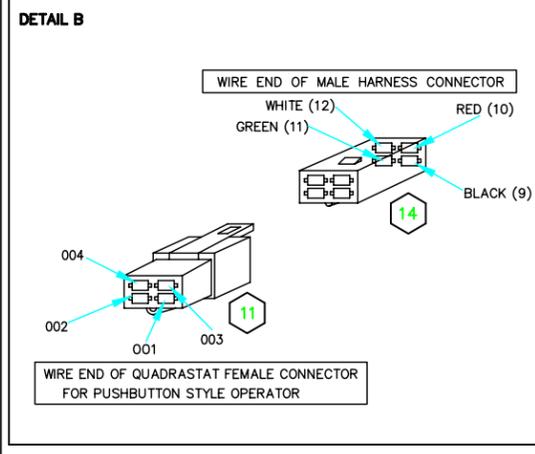
NOTE 1 - 5 CIRCUIT CONNECTOR REPLACEMENT HOUSING (ITEM 15) AND 3 EACH MALE LOCKING SPADE TERMINALS (ITEM 14).
WHEN REPLACING DEVICES OR CONNECTION ELEMENTS PAY CLOSE ATTENTION TO POLARITY OF DEVICE AS INDICATED ON THIS SCHEMATIC.

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



IGNITION SWITCH CONTACT PROGRESSION

| | | | | |
|---------|---|---|---|---|
| CONTACT | D | B | S | C |
| STOP | X | | | |
| ON | | X | | X |
| START | | X | X | X |

Ⓜ 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.

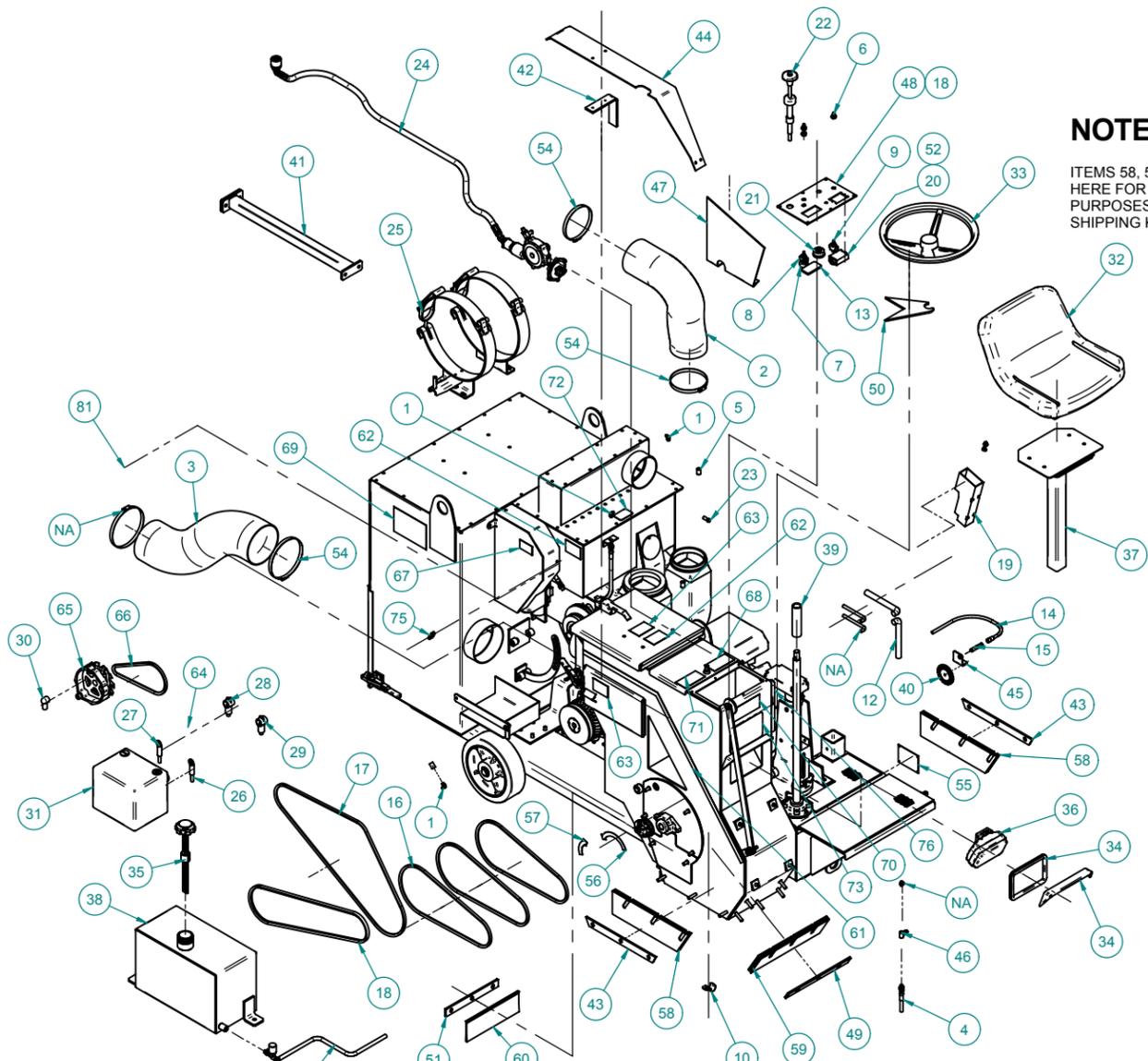
GPX 1018 BLAST UNIT
WIRING HARNESS SCHEMATIC

| | |
|-----------|--------|
| 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

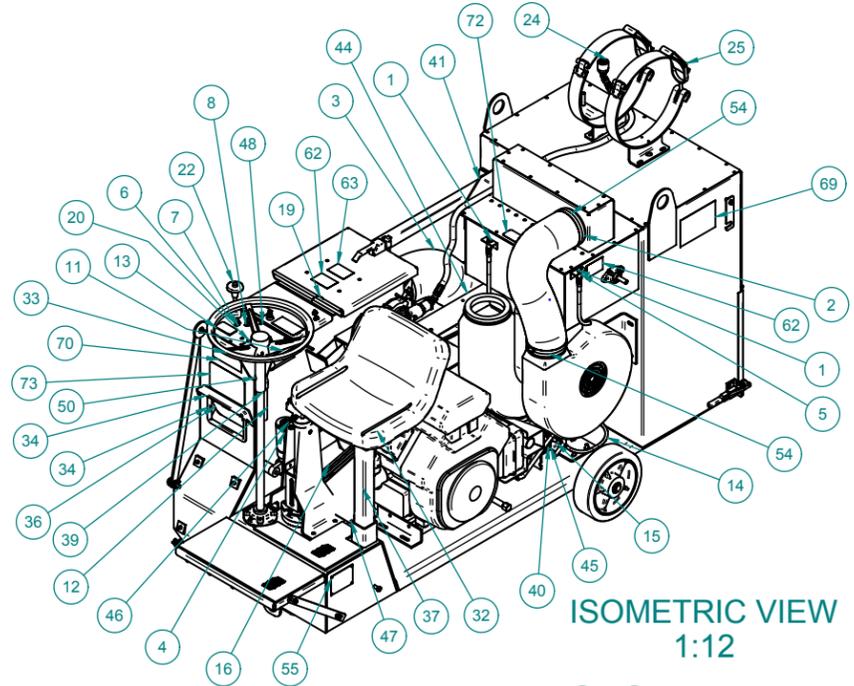
| ITEM NUMBER | BLASTRAC PART NUMBER | DESCRIPTION | QUANTITY |
|-------------|----------------------|---------------------------------------------------------------------------|----------|
| 1 | SHOP STOCK | TERMINAL, RING, 16-14 AWG (BLUE), 6 STUD, INSULATED | 3 |
| 2 | SHOP STOCK | RING TERMINAL, 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 |



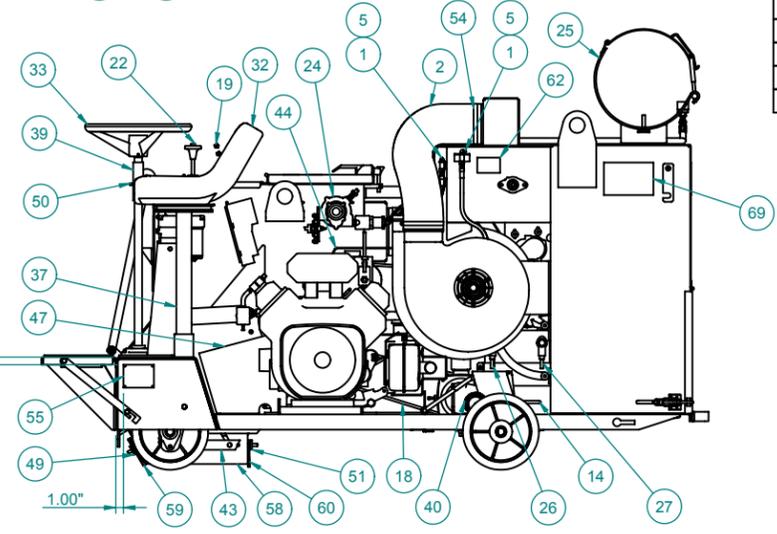
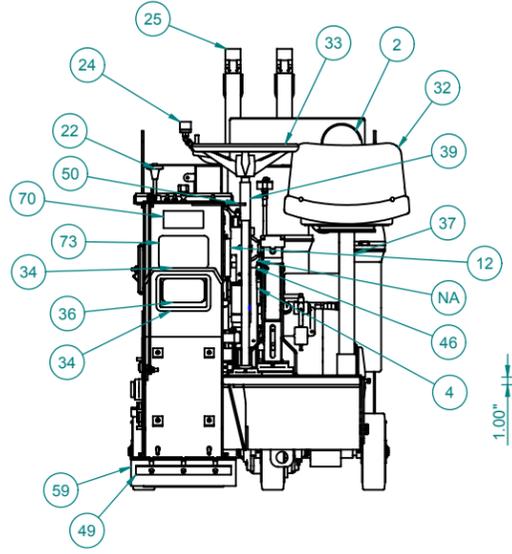
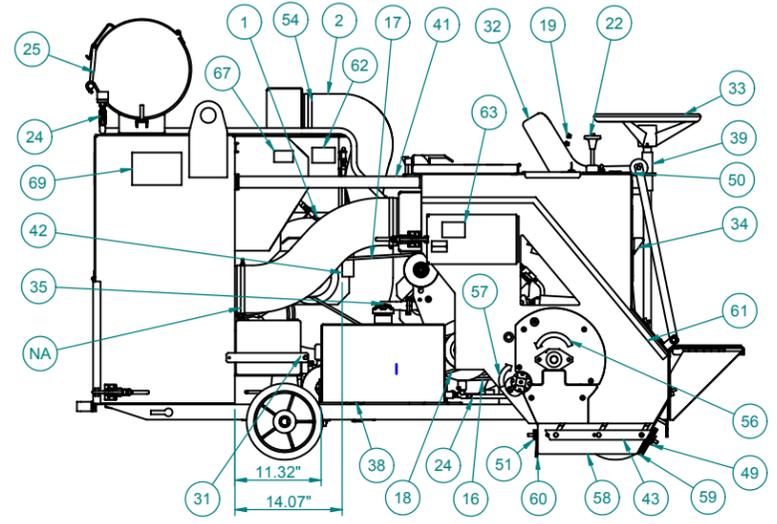
EXPLODED ISOMETRIC VIEW
1:12

| 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



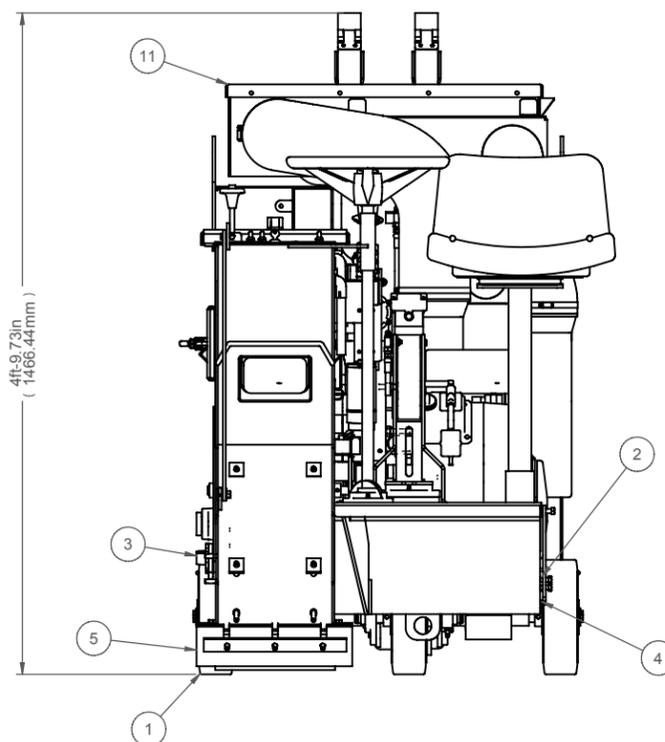
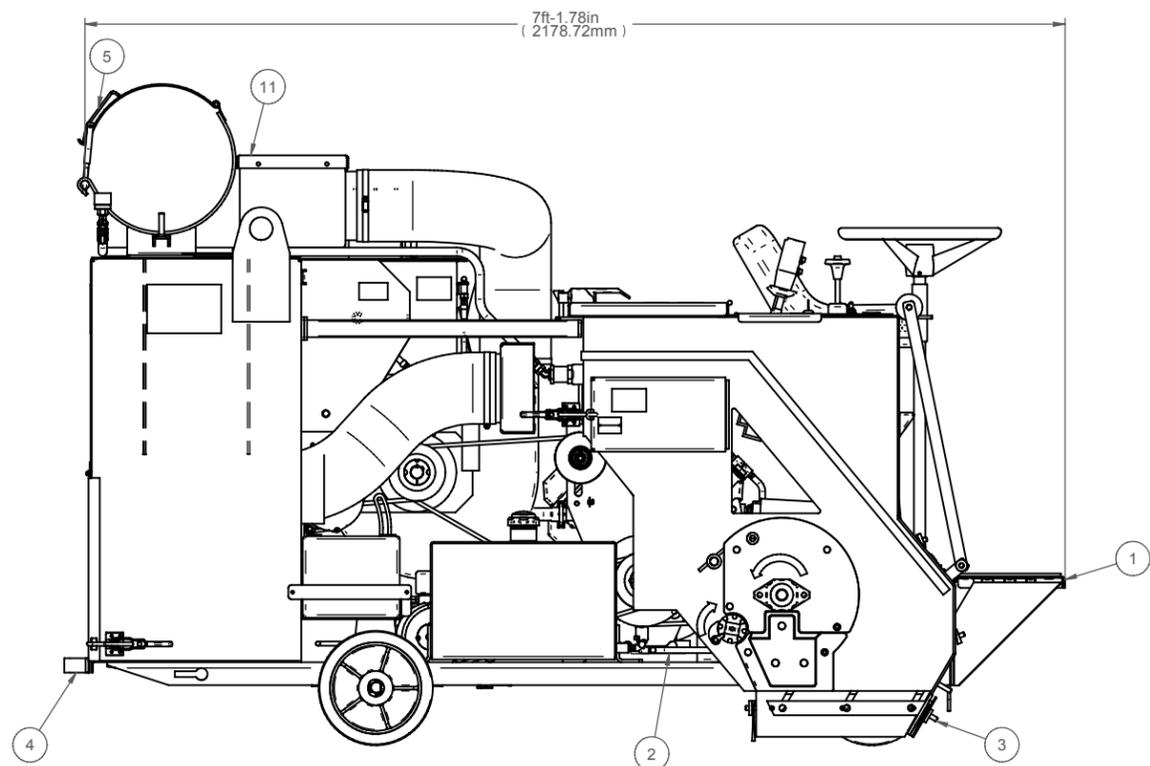
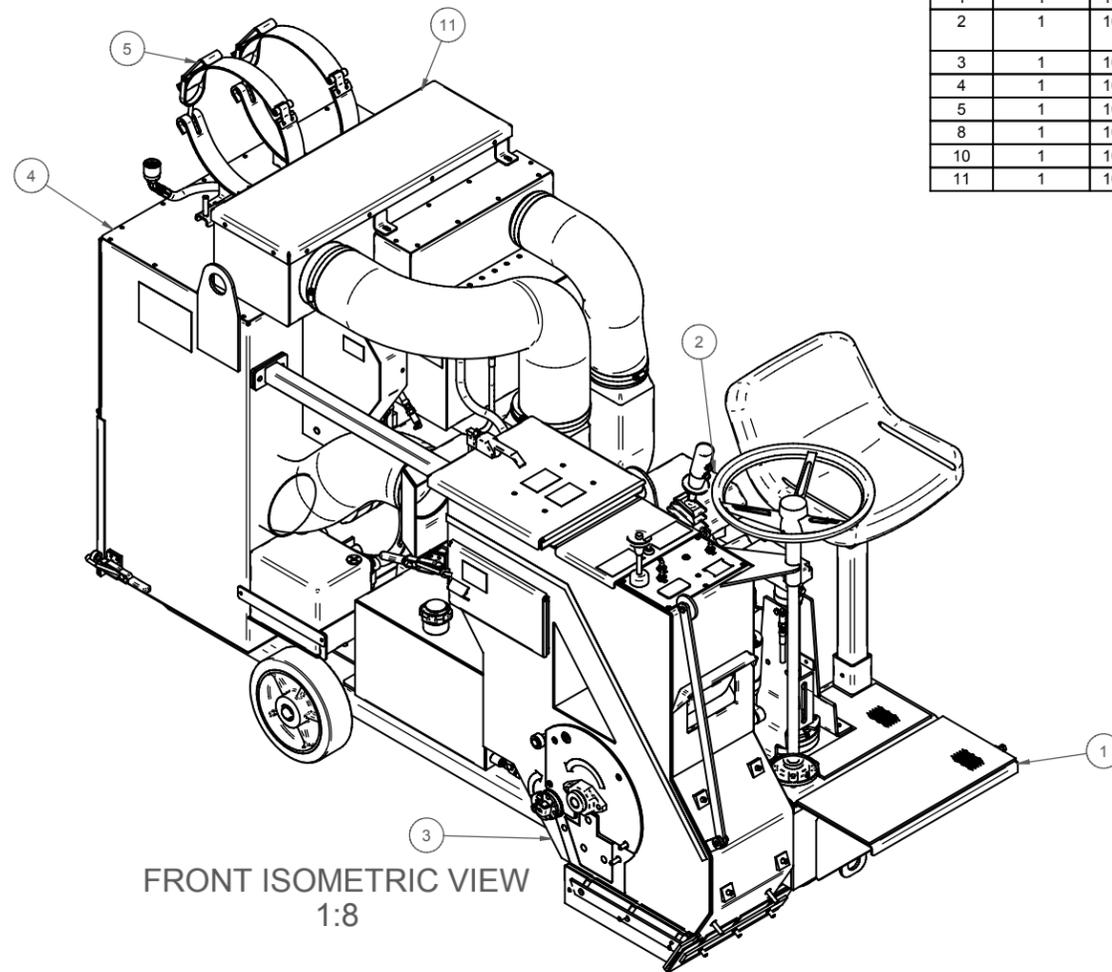
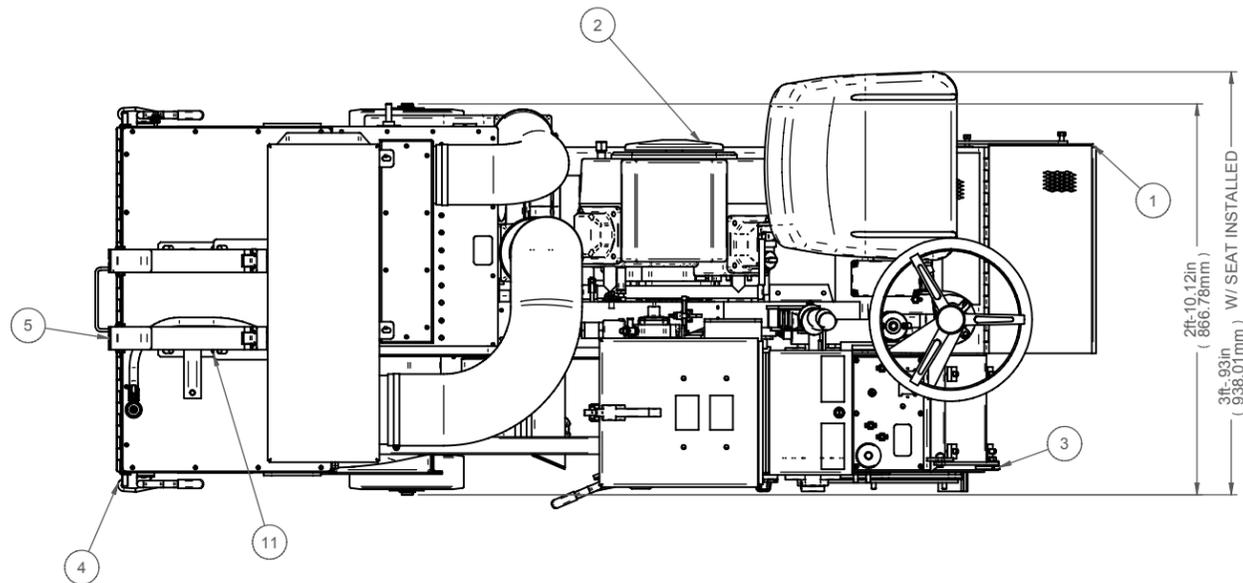
| | | | |
|-----|-----------------------------------------------------------------|-------------|---------|
| B | ITEM 1 QTY WAS (4); ITEM #62 QTY WAS (2); ITEM #63 QTY WAS (3); | 3/30/00 | SCS |
| | WAS (3); ADDED ITEMS #67 THRU #81; | | |
| | REFERENCE NCR00-0040, NCR00-0105, & NCR00-0106 | | |
| A | 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

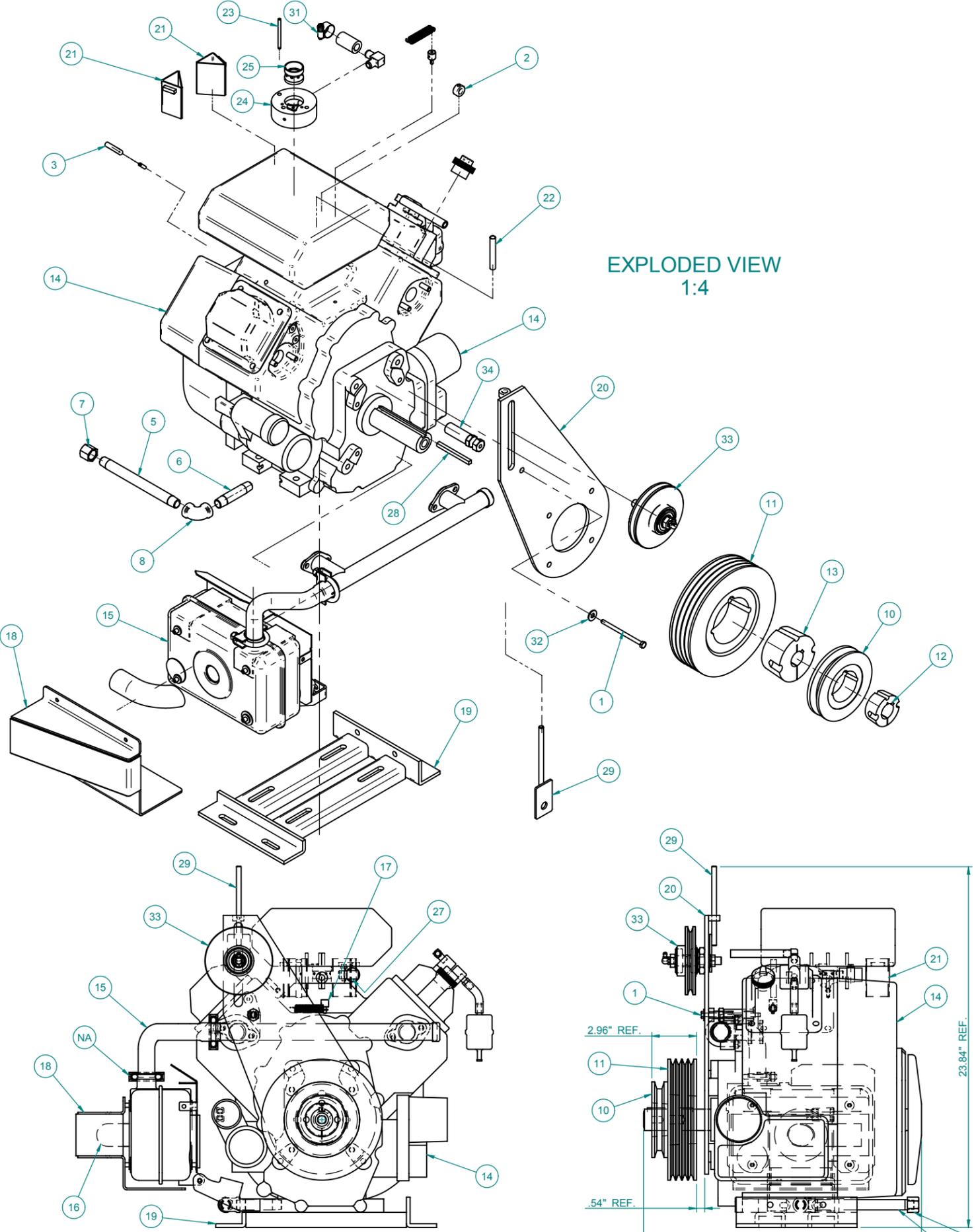
THIS DRAWING AND THE DESIGN SHOWN THEREIN IS THE PROPERTY OF U.S. FILTER WHEELABRATOR AND USE OR COPIES THEREOF CANNOT BE MADE WITHOUT WRITTEN CONSENT.

| | | | | | |
|-----------------------------------|----------|---------------------------|----------|--------------------------------------------------------------|----------|
| NEXT ASSY | GPX10-18 | REF. NO. | -- | PART NO. | 10180005 |
| TOLERANCE UNLESS SPECIFIED | | U.S. FILTER | | 6215 ALUMA VALLEY DRIVE OKLAHOMA CITY, OK 73121 U.S.A. | |
| ANGLES ± 500° | | FINAL ASSEMBLY COMPONENTS | | | |
| 1 PL DEC ± .060 | | GPX10-18 BLAST UNIT | | | |
| 2 PL DEC ± .010 | | SCALE | 1:12 | DRWN | SCS |
| 3 PL DEC ± .005 | | 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 |

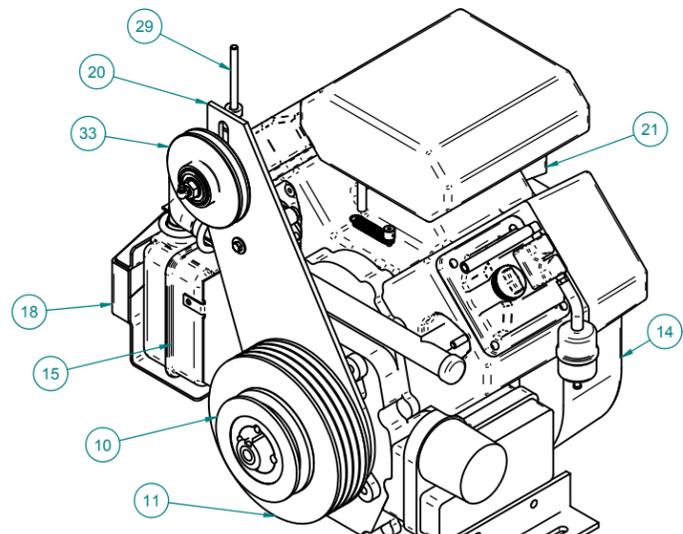


| REV | ZONE | DESCRIPTION | DATE | BY |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|-------------------------|----------|-----------------|
| REVISION | | | | |
| <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° | | 6215 ALUMA VALLEY DRIVE | | |
| 1 PL DEC ± .060 | | OKLAHOMA CITY, OK 73121 | | |
| 2 PL DEC ± .010 | | U.S.A. | | |
| 3 PL DEC ± .005 | | BLASTRAC | | |
| GENERAL ASSEMBLY | | | | |
| GPX10-18 BLAST UNIT | | | | |
| SCALE | 1:8 | DRWN | SCS | 220-0283 |
| DATE | 10/18/99 | SHT | 1 OF 1 | |

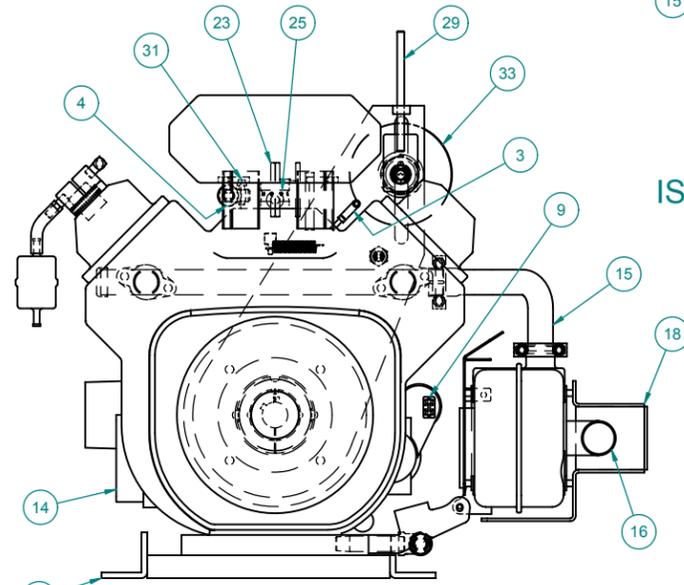


EXPLODED VIEW
1:4

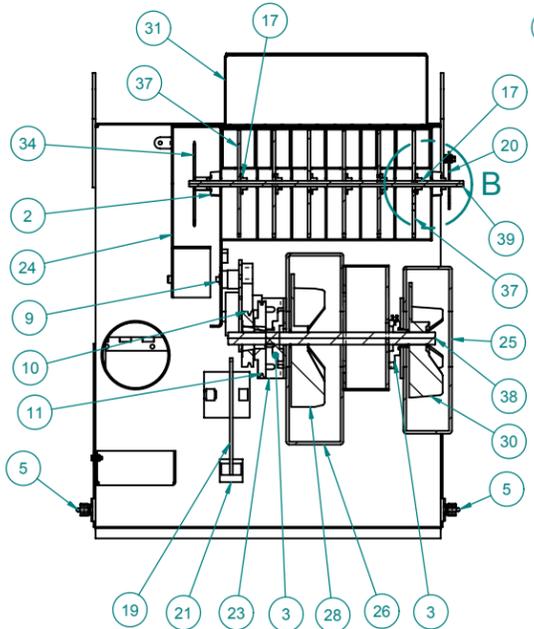
| ITEM | QUANTITY | CATALOG NUMBER | DRAWING NUMBER | DESCRIPTION | WIDTH | LENGTH |
|------|----------|----------------|----------------|-----------------------------------|-------|--------|
| 1 | 1 | -- | -- | SCREW/M6 HEX HEAD | -- | 3.75 |
| 2 | 1 | 02200005 | -- | COLLAR/SHAFT 3/8" | -- | -- |
| 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 | -- | -- |



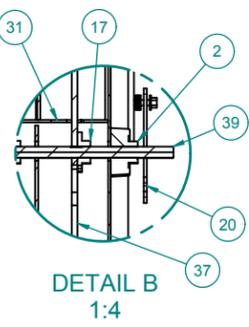
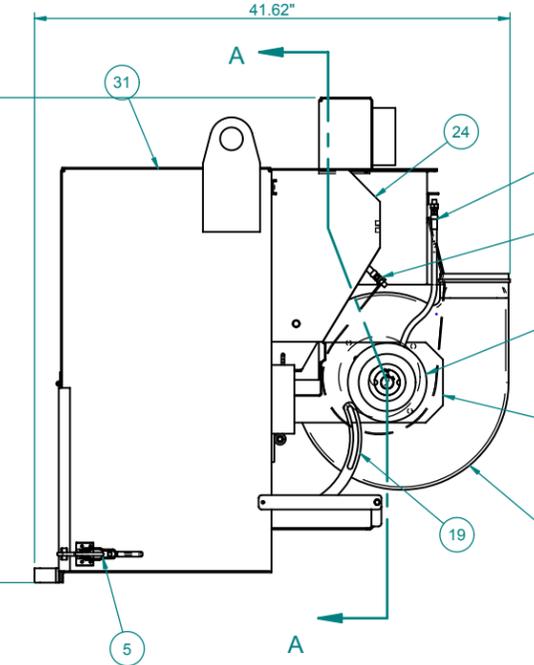
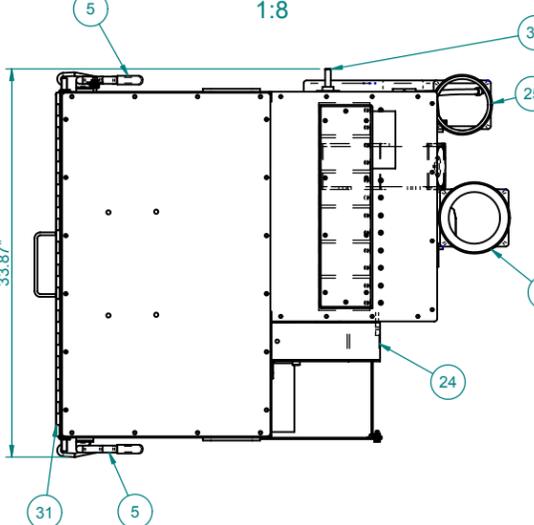
ISOMETRIC VIEW
1:4



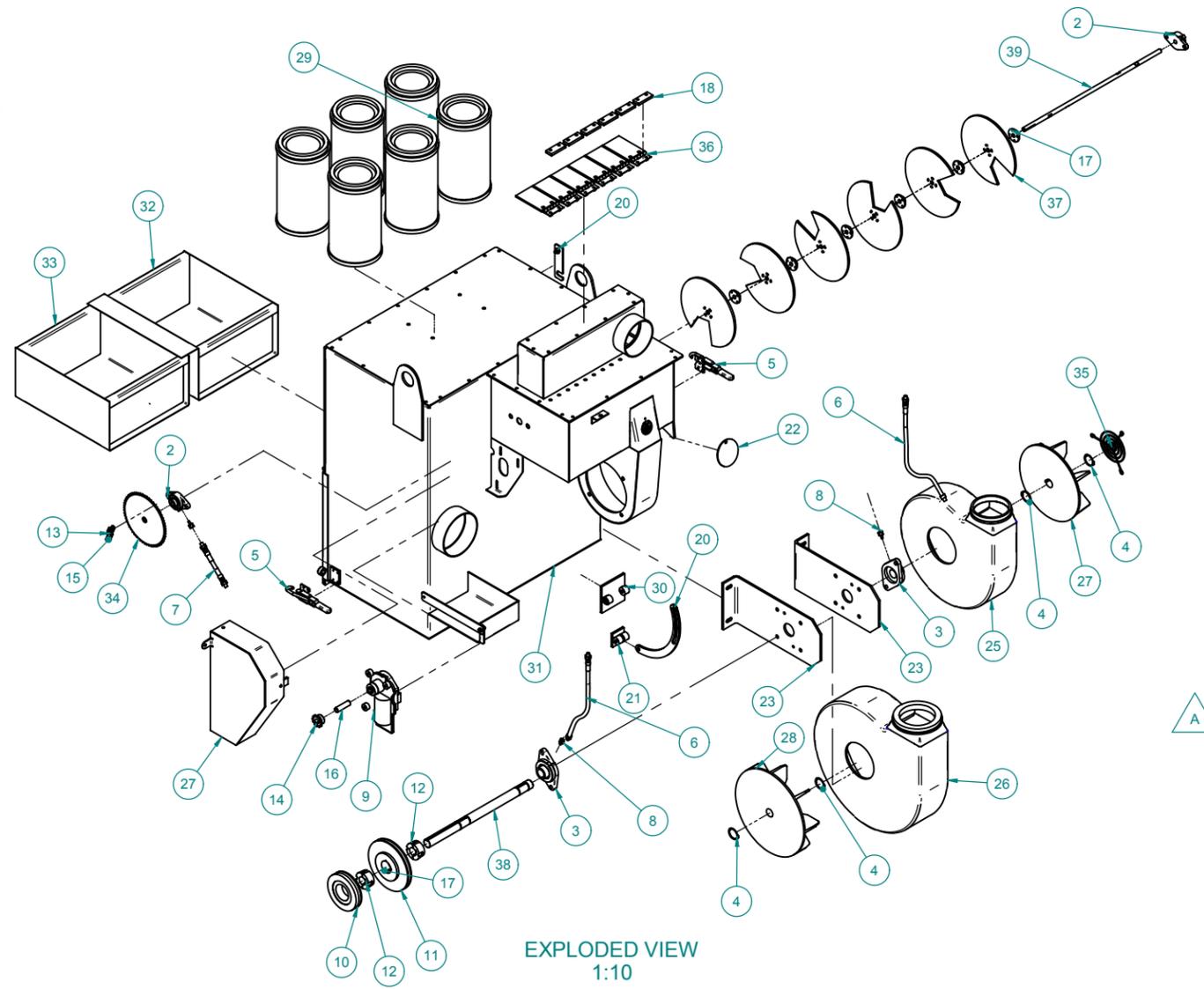
| | | | |
|---------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|-----------------------------|-----------------|
| B | ITEM 34 WAS P000978 | 1/24/00 | SCS |
| A | ITEM 28 WAS 07100044 | 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 | |
| 1 PL DEC ± .060 | | OKLAHOMA CITY, OK 73121 | |
| 2 PL DEC ± .010 | | U.S.A. | |
| 3 PL DEC ± .005 | | KIT/MOTOR KOHLER 25HP | |
| SCALE | | DRWN | TLH |
| DATE 9/13/99 | | SHT 1 OF 1 | 220-0273 |



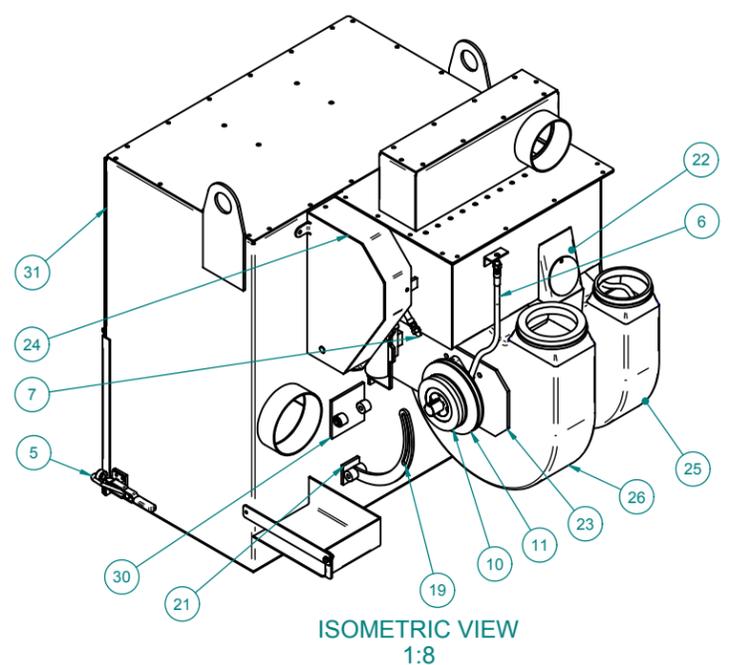
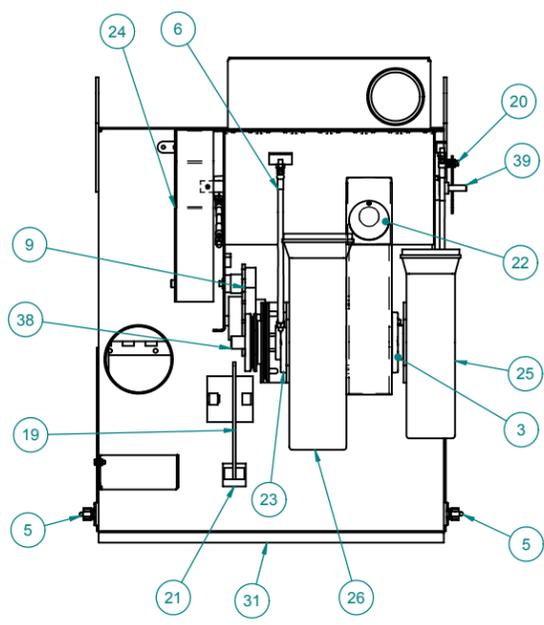
SECTION VIEW A-A
1:8



DETAIL B
1:4



EXPLODED VIEW
1:10

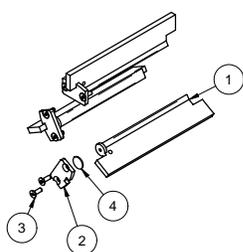
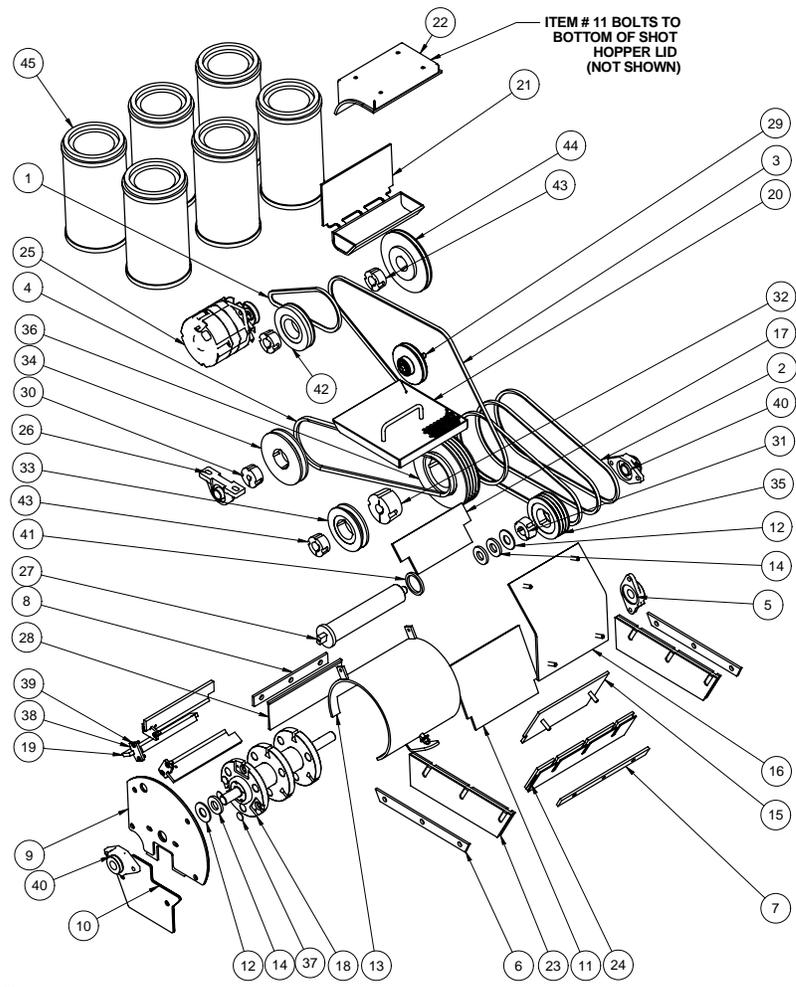


ISOMETRIC VIEW
1:8

| 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 | | | | | | | | | | | | | | | | | | | | | |
| 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 colspan="2" style="text-align: right;">220-0258</td> </tr> <tr> <td>3 PL DEC ± .005</td> <td colspan="2"></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 | 220-0258 | | 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 | 220-0258 | | | | | | | | | | | | | | | | | | | | | | |
| 3 PL DEC ± .005 | | | | | | | | | | | | | | | | | | | | | | | |

| 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