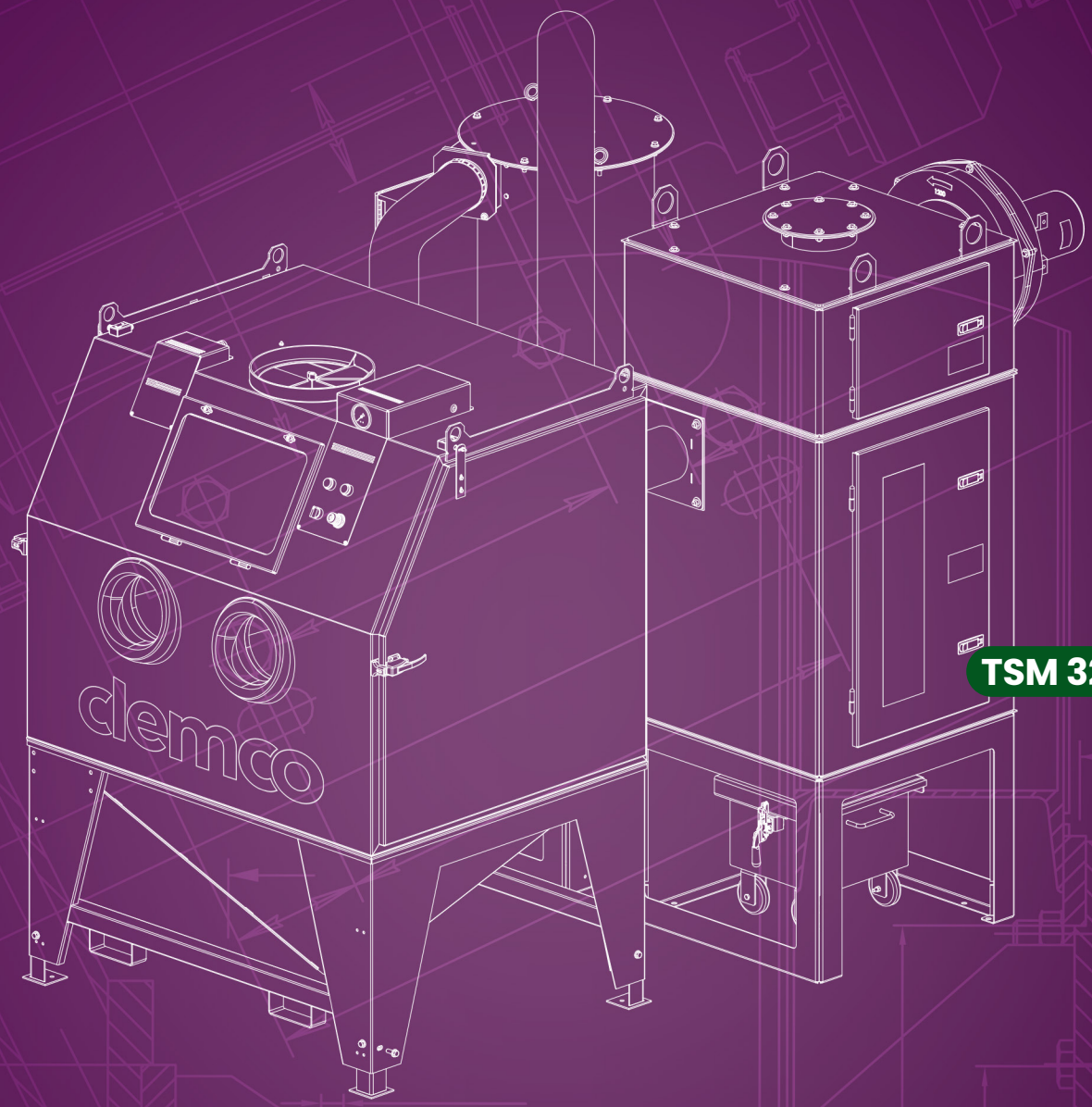
TROUBLESHOOTING MANUAL



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Industrial Cabinet Series Blast Systems

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NOTICE

Notice to purchasers and users of our products and this informational material

Clemco proudly provides products for the abrasive blast industry and is confident that industry professionals will use their knowledge and expertise for the safe and efficient use of these products.

The products described in this material and the information relating to these products are intended for knowledgeable, experienced users. It is the responsibility of the user to insure that proper training of operators has been performed and a safe work environment is provided.

No representation is intended or made as to: the suitability of the products described here for any purpose or application, or to the efficiency, production rate, or useful life of these products. All estimates regarding production rates or finishes are the responsibility of the user and must be derived solely from the user's experience and expertise, not from information contained in this material.

It is possible that the products described in this material may be combined with other products by the user for purposes determined solely by the user. No representations are intended or made as to the suitability of, or engineering balance of, or compliance with regulations or standard practice of any such combination of products or components the user may employ.

This equipment is only one component of a cabinet blasting operation. Other products, such as air compressors, air filters and receivers, abrasives, equipment for ventilating, dehumidifying, or other equipment, even if offered by Clemco, may have been manufactured or supplied by others. The information Clemco provides is intended to support the products Clemco manufactures. Users must contact each manufacturer and supplier of products used in the blast operation for warnings, information, training, and instruction relating to the proper and safe use of their equipment.

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Safety Alerts Key

This is the safety alert symbol. It is used to alert you to potential physical injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

NOTICE

Notice indicates information that is considered important, but not hazard-related, if not avoided, could result in property damage.

CAUTION

Caution indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

WARNING

DANGER

Warning and Danger, indicates a hazardous situation that, if not avoided, will result in death or serious injury.

1.0 | INTRODUCTION

1.1 | Scope of Manual

1.1.1 | These instructions cover troubleshooting for the Series Blast Cabinet Systems, pressure and suction. Topics that are exclusive to either a pressure or suction system, are noted in the description as “Pressure Systems” or “Suction Systems”. If one of these designations does not appear, the topic applies to all systems.

1.1.2 | The instructions contain important information required for safe operation of the cabinet. Before using this equipment, all personnel associated with the blast cabinet’s operation must read this entire manual, and all accessory manuals to become familiar with their operation, parts and terminology.

2.0 | TROUBLESHOOTING

⚠ WARNING

To avoid serious injury, observe the following when troubleshooting:
- **Turn OFF the compressed-air supply, bleed the supply line, lockout, and tagout the air supply.**
- **If checking the controls requires air, always enlist the aid of another person to:**
- **Hold the blast gun securely.**
- **Operate the foot pedal.**
- **Never bypass the foot pedal or wedge it in the operating position.**
- **Never bypass the door interlock system.**
- **Follow all OSHA regulations, including lockout and tagout procedures.**

2.1 | Poor visibility

2.1.1 | Dirty filter cartridge. Empty the dustbin. Pulse cartridge several times. Adjust pulse pressure and timing as needed. Inspect cartridge and replace when necessary.

2.1.2 | Exhauster motor not operating. Check voltage to motor and motor wiring.

2.1.3 | Check rotation of exhauster motor; the motor should rotate as indicated by the arrow on the housing. If it does not rotate in the proper direction, lockout and tagout electrical power and switch motor leads, as shown on the motor plate.

2.1.4 | Using friable media that rapidly breaks down, or using media that is too fine or worn out. Check condition of media.

2.1.5 | Outlet damper closed too far restricting air movement through the cabinet. Adjust static pressure.

2.1.6 | Inlet damper closed too far restricting air movement into the cabinet. Adjust damper.

2.1.7 | Reclaimer door open. Check door.

2.1.8 | Hole worn in flex hose between cabinet hopper and reclaimer inlet, or reclaimer outlet and dust collector inlet. Replace hose.

2.1.9 | Obstruction in flex hose between the cabinet hopper and reclaimer inlet. Inspect hose for blockage.

2.1.10 | Paddle wheel worn. Check wheel for wear.

2.2 | Abnormally high media consumption

2.2.1 | Door on reclaimer open or worn door gasket. Air entering the reclaimer around the door will cause media carryover to the dust collector. Inspect door gasket. DO NOT operate unless all doors are closed.

2.2.2 | Outlet damper open too far. Adjust static pressure.

2.2.3 | Media may be too fine or worn out. Check condition of media.

2.2.4 | Blast pressure too high for the media, causing media to break down. Check blast pressure and adjust as needed.

2.2.5 | Hole worn in reclaimer, or leak in reclaimer seams. Check entire reclaimer for negative-pressure leaks.

2.2.6 | When using media finer than 180-mesh, the inlet baffle of the reclaimer may need to be removed.

2.2.7 | Pressure Systems - Outlet valve not sealing. Inspect blast machine outlet valve for wear.

2.2.8 | Metering valve requires adjustment. Adjust metering valve.

2.3 | Reduction in blast cleaning rate

2.3.1 | Low media level reducing media flow. Check media level and replenish or replace as needed.

2.3.2 | Media-air mixture out of adjustment. Adjust metering valve.

2.3.3 | Reduced air pressure. This may be caused by the pressure regulator set too low, a malfunctioning regulator, a dirty filter element in the air filter, partially-closed air valve, leaking air line, or other air tools in use. Inspect all items.

2.3.4 | Blockage in media hose or gun. Blockage may occur because of:

- A damaged or missing reclaimer screen. Inspect screen.
- Heavy media flow. Adjust media flow.

2.3.5 | Pressure Systems – Air leaking through blast machine outlet valve, reducing blast pressure. Inspect blast machine outlet valve for wear.

2.3.6 | Suction Systems – Worn gun parts such as nozzle or air jet. Inspect and replace all worn parts.

2.3.7 | Suction Systems – Worn media hose. Check hose for leaks and soft spots. Replace if worn or damaged.

2.3.8 | Suction Systems – Air jet in gun out of adjustment. Check adjustment.

2.3.9 | Moist media. Frequent bridging or blockage in the metering valve can be caused by moisture. Refer to **Section 2.5**.

2.4 | Plugged nozzle

2.4.1 | A damaged or missing reclaimer screen will allow large particles to pass and block the nozzle. Replace or reinstall the screen, as necessary.

2.4.2 | Media mixture too rich. Adjust media-air mixture.

2.5 | Media bridging

2.5.1 | Frequent bridging or blockage in the media metering valve can be caused by damp media. Media becomes damp from blasting parts that are slightly oily, from moisture in the compressed air, or from absorption from ambient air.

2.5.2 | To avoid contaminating media from the workpiece, all parts put into the cabinet should be clean and dry. If parts are oily or greasy, degrease and dry them prior to blasting.

2.5.3 | Moist compressed air may be due to a faulty compressor that overheats, or pumps oil or moisture into the air line, too long of an air line permitting moisture to condense on the inside, or from high humidity. Drain the air filter and receiver tank regularly. Ongoing problems with moist air may require the installation of an air dryer or after cooler in the air-supply line.

2.5.4 | Absorption. Some media types tend to absorb moisture from the air, especially fine-mesh media in areas of high humidity. Empty the media and store it in an airtight container when cabinet is not in use.

2.5.5 | A vibrator mounted on the reclaimer mounting bolt may help to prevent bridging of fine-mesh media. **NOTE:** To avoid the possibility of compacting media, a vibrator should be set up to start when the foot pedal is pressed and stop when the pedal is released.

2.6 | Media surge

2.6.1 | Pressure Systems – A small amount of surge is normal at startup.

2.6.2 | Heavy media flow. Adjust media-air mixture.

2.6.3 | Pressure Systems – Empty the blast machine, depressurize the blast machine, and inspect the internal parts of the metering valve for wear. Refer to the metering valve manual.

2.7 | Blockage in media hose – Suction Systems

2.7.1 | Media obstructions. Usually caused when the media mixture is too rich, adjust media-air mixture.

2.7.2 | Wet or damp media. See **Section 2.5**.

2.8 | Poor suction in media hose - Suction Systems

2.8.1 | Inadequate air supply. Refer to Start Up Guide, make sure cfm and air hose requirements are met.

2.8.2 | Air jet needs adjustment. Check adjustment.

2.8.3 | Nozzle is worn. Replace nozzle if the orifice diameter is worn 1/16” or more from original size.

2.8.4 | Blockage in media hose or nozzle. Refer to **Sections 2.4** and **2.7**.

2.8.5 | Air jet and nozzle combination may be wrong. Refer to Start Up Guide.

2.8.6 | Air jet sleeve extends past end of air jet. Cut the sleeve to align with the air jet.

2.8.7 | Air jet worn: Inspect end of air jet and replace when wear reaches the orifice.

2.8.8 | Blast pressure too high; adjust pressure.

2.8.9 | Nozzle inserted backward. The wider tapered end of the nozzle inserts into the gun toward the air jet.

2.9 | Air only (no media) from nozzle – Suction Systems

2.9.1 | Low media level in reclaimer. Check media level and replenish as needed.

2.9.2 | Check for blockage in media hose; refer to **Section 2.7**.

2.9.3 | Poor suction in media hose; refer to **Section 2.8**.

2.9.4 | Make sure the air hose and media hose are not reversed on the BNP gun; the green air hose attaches to the back of the gun and the clear media hose attaches to the bottom of the gun's grip.

2.10 | Air only (no media) from nozzle – Pressure Systems

2.10.1 | Make sure the machine contains media.

2.10.2 | Make sure the metering valve is open and media flow is adjusted.

12.10.3 | Make sure the blast machine is pressurized.

2.10.4 | Make sure the media metering valve opens when foot pedal is pressed. Refer to the metering valve manual.

2.10.5 | Check for minor blockage in the media metering valve by fully opening the metering valve and closing the choke valve. Activate the foot pedal to blow out obstructions. If this procedure fails, depressurize the machine, remove the metering valve inspection plate, and check for foreign objects.

2.10.6 | Outlet valve not sealing. Inspect outlet valve.

2.11 | Blow-back through media hose – Suction Systems

2.11.1 | Blockage in nozzle. Remove the nozzle and check for blockage.

2.11.2 | Air jet may be too large for nozzle. Refer to the Start Up Guide.

2.12 | Blasting does not begin when the foot pedal is pressed – Suction Systems

2.12.1 | Pressure regulator may be set to low or OFF. Adjust blast pressure.

2.12.2 | Make sure the air compressor is operating and air-supply valves are open.

2.12.3 | Check the nozzle to see if it is plugged. Refer to **Section 2.4**.

2.12.4 | Cabinet door interlocks not engaging. Check adjustment. **NOTE:** The green start-button light will alight if either of the two door interlocks are not engaged.

2.12.5 | Blocked or leaking control lines. Check all urethane tubing for blockage or leaks.

2.12.6 | Foot pedal or other electrical malfunction.

2.13 | Blasting does not begin when the foot pedal is pressed – Pressure Systems

2.13.1 | Depressurize the blast machine and, after the pop-up valve has dropped, remove the nozzle to see if it is plugged.

2.13.2 | Make sure the blast machine pressurizes when the foot pedal is pressed. If it does not, refer to **Section 2.14**.

2.13.3 | Make sure the media metering valve and the choke valve are open.

2.14 | Blasting continues after releasing foot pedal

2.14.1 | Foot pedal or other electrical malfunction.

2.14.2 | Inlet regulator stuck open. Inspect inlet regulator.

2.15 | Blast machine does not pressurize – Pressure Systems

2.15.1 | Make sure the compressor is operating and air supply valve is open.

2.15.2 | Make sure the blast pressure regulator is not set too low or OFF; minimum pressure is 40 psi.

2.15.3 | Inadequate air supply. Refer to **Start Up Guide** cfm chart.

2.15.4 | Inspect the diaphragm in the outlet valve for wear.

2.15.5 | Inspect the pop up valve and seal for wear or misalignment.

2.15.6 | Cabinet door interlocks not engaging. Check adjustment

2.15.7 | Electrical malfunction. Refer to **Section 3.4**.

2.16 | Blast machine does not depressurize or depressurizes too slowly – Pressure Systems

2.16.1 | Blockage in the blast solenoid muffler. Air should exhaust from the muffler when the foot pedal is released. If air does not exhaust, remove the muffler, and try again. If air exhausts now, the muffler is blocked. If air still does not exhaust, the solenoid may be faulty. Refer to **Section 3.4**.

2.16.2 | Foot pedal not working. Refer to **Section 3.5**.

2.16.3 | Inspect brass control line filter attached to diaphragm outlet valve for media blockage. If media is present, inspect outlet valve diaphragm for damage.

2.16.4 | Check the outlet muffler, located inside the cabinet, for blockage.

2.16.5 | Inlet regulator stuck open. Inspect inlet regulator. While foot pedal is UP, pull the gray line off the top of the inlet regulator. Air should not come from the gray line and the regulator should shut off. If the regulator remains open, it is stuck open. Inspect the regulator.

2.17 | Squeal from diaphragm outlet valve when foot pedal is pressed – Pressure Systems

2.17.2 | Blockage in the blast solenoid muffler. Remove the muffler and operate the foot pedal. If doing so stops the squealing, install a new muffler.

2.17.3 | If the squeal continues, check for blockage in the 1/4" control line filter.

2.18 | Media buildup in cabinet hopper; media does not convey to reclaimer

NOTE: Do not pour media directly into the cabinet hopper, as overfilling may occur. Overfilling will result in media carryover to the dust collector and possible blockage in the conveying hose.

2.18.1 | Exhauster motor rotating backwards. The motor should rotate as indicated by the arrow on the exhauster housing. If it does not rotate in the proper direction, lockout and tagout electrical power and switch the motor leads, as shown on the motor plate. Refer to the system's wiring schematic stowed in the electrical-control panel.

2.18.2 | Dust-collector damper closed too far, restricting air movement through cabinet. Adjust static pressure.

2.18.3 | Dust-collector filter cartridge clogged. Adjust pulse pressure or refer to dust collector component manual for filter replacement.

2.18.4 | Hole worn in flex hose between cabinet hopper and reclaimer inlet or between the reclaimer outlet and dust-collector inlet. Inspect hoses and replace them as needed.

2.18.5 | Reclaimer door open. DO NOT operate unless door is closed.

2.18.6 | Obstruction in flex hose. Remove hoses and check for blockage.

2.19 | Static shocks

2.19.1 | Cabinet and/or operator not grounded. Abrasive blasting generates static electricity. The cabinet must be earth-grounded to prevent static buildup. If shocks persist, the operator may be building up static. Attach a small ground wire, such as a wrist strap, from the operator to the cabinet.

2.19.2 | Gloves wearing thin. Inspect gloves and replace them as needed.

2.19.3 | Avoid holding parts and blasting off the grate. Static will build in the part if not dissipated through the metal cabinet. If blasting parts off the grate cannot be avoided, attach a ground wire between the cabinet and the part.

2.20 | Dust or media leaking from cabinet

⚠ WARNING

Shut down the cabinet and dust collector immediately if dust discharges from the cabinet or collector. Prolonged breathing of abrasive dust and blasting byproduct dust can result in serious lung disease or death. Short-term ingestion of toxic dust such as lead, poses an immediate danger to health. Identify all materials to be removed by blasting and obtain a safety data sheet (SDS) for the blast media.

2.20.1 | Refer to **Section 2.13**.

2.21 | Dust leaking from dust collector

2.21.1 | Cartridge not seasoned; season cartridge per dust collector manual.

2.21.2 | Damaged or loose cartridge. Inspect filter cartridge and tighten or replace as needed.

2.21.3 | Faulty seal on the dust collector door/opening. Inspect seal and replace if damaged.

2.22 | Dust collector does not pulse

2.22.1 | Refer to dust collector manual.

2.23 | Dust-Collector Pulse is Steady Stream of Air Instead of Quick Pulse

2.23.1 | Refer to dust collector manual.

2.24 | Dust-collector differential-pressure gauge is consistently high

2.24.1 | Pulse valve may not be pulsing properly. Refer to **Sections 2.17**.

2.24.2 | The in-line dust filter may be blocked. Clean or replace.

2.24.3 | Snubber fittings blocked with dust. Clean or replace.

2.24.4 | The sequence OFF time may need adjusting.

2.24.5 | Filter cartridge may need to be replaced.

3.0 | TROUBLESHOOTING – ELECTRICAL

Refer to **Section 2.0** to troubleshoot pneumatic and mechanical problems.

⚠ WARNING

Arc Flash and Shock Hazard.
Appropriate personal protection equipment (PPE) required prior to work on or near energized parts. Failure to comply can result in shocks, burns, injury, or death. All electrical work or any work done inside a control panel or junction box must be performed by a qualified electrician and comply with applicable codes.

Troubleshooting Notes: A wiring schematic is stowed inside the main electrical control panel (CP1). Refer to the schematic for troubleshooting the electrical system. Use a voltmeter capable of reading 120 VAC voltage and audible setting to check resistance.

3.1 | Green pushbutton light does not illuminate

3.1.1 | Machine is not plugged into a 120 VAC receptacle, or the receptacle does not have electricity.

3.1.1.1 | Plug machine power cord into receptacle.

3.1.1.2 | Check electrical receptacle for proper operation.

3.1.2 | Fuse filament is broken.

3.1.2.1 | Open the CP1 electrical panel door. CAUTION should be used when the panel is live.

3.1.2.2 | Ensure main circuit breaker is not tripped or off.

3.1.2.3 | Check 3A fuse FU1 to ensure it is not bad. Remove fuse and use voltmeter on the resistance setting and the audible ringing sound enabled, use the voltmeter to “ring” across the fuse to ensure the inside filament is not broken. Reinstall the fuse if the voltmeter rings.

3.1.2.4 | Change the voltmeter to AC setting and then measure voltage from wire 13 on fuse block FU1 to Terminal 2. There should be 120 VAC present.

3.1.3 | Dust collector dustbin is not installed correctly.

3.1.3.1 | Install the dustbin under the dust collector and securely clamp it in place using the provided clamps.

3.1.4 | Dust-collector dustbin switch is bad.

3.1.4.1 | With the dust collector bin locked in place correctly, check voltage between Terminals 10 and 2. If 120 VAC is not present, dust-collector bin switch has an issue. Check wiring and mechanical engagement.

3.1.5 | Green pushbutton light is faulty.

3.1.5.1 | Replace either the LED light inside the green pushbutton or the entire pushbutton light assembly.

3.2 | Dust-collector exhauster motor does not start when pressing the illuminated green (START) pushbutton

3.2.1 | Circuit breaker is tripped.

3.2.1.1 | Ensure main circuit breaker is not tripped or off. If circuit breaker will not reset, it may need to be replaced.

3.2.2 | Green start pushbutton faulty.

3.2.2.1 | With green start pushbutton pressed, check voltage between Terminals 11 and 2. If 120 VAC is not present, green start pushbutton has an issue. Check wiring and pushbutton.

3.2.3 | Red stop push button faulty.

3.2.3.1 | With the green start pushbutton pressed, check voltage between Terminals 12 and 2. 120 VAC should be present. Then, with the red pushbutton pressed, check voltage between Terminals 12 and 2. 120 VAC should not be present. If either case is not true, then the red stop pushbutton has an issue. Check wiring and pushbutton.

3.2.4 | Motor contactor is faulty

3.2.4.1 | With the green start pushbutton pressed and red stop pushbutton not pressed, check voltage between Terminal 12 and 2. 120 VAC should be present and motor contactor should be pulled in. If motor contactor is not pulled in, check for faulty contactor.

3.2.4.2 | With the green start pushbutton pressed and red stop pushbutton not pressed, use voltmeter to “ring” across the motor contactor Terminals 13 and 14. It should ring out. If it does not ring out, check for faulty contactor.

3.2.4.3 | If motor contactor engages after pressing the green start pushbutton, but the motor does not start, use voltmeter to “ring” across Terminals 1 and 2, then 3 and 4, and then 5 and 6. If any of these three pairs do not ring out, motor contactor may be faulty. If they all ring out, make sure motor wiring is correct and motor is not bad.

3.2.4.4 | Motor wired incorrectly. Remove cover plate on motor junction box (located directly on the motor housing). Check that the wiring is correct to the little wiring diagram (usually located directly on the motor housing, on the motor junction cover plate, or inside underneath the motor junction cover plate.

3.2.4.5 | Replace the motor.

3.3 | Lift legs do not move

3.3.1 | Motor does not have power

3.3.1.1 | With the dust-collector bin correctly locked in place, lift leg power should be available. If the lift legs do not move, check voltage between Terminals 10 and 2. If 120 VAC is not present, dust-collector bin switch has an issue. Check wiring and mechanical engagement. If 120 VAC is present, make sure the power cord is installed correctly on the lift-leg unit.

3.3.2 | Selector switch has an issue

3.3.2.1 | Check lift leg RJ45 connection at the motor. If okay, remove the control console on the blast cabinet and check that the wiring is correct on the back of the selector switch. Use voltmeter to “ring” across the contact block terminals as the switch is actuated left and right. If switch does not ring out, switch may be bad. Check opposite contact block on the selector switch for reverse motion.

3.3.2.1 | If step in Section 3.3.2.1 does not reveal an issue, check lift-leg motor power cable and motor. Motor or cable may be faulty.

3.3.3 | Lift-leg motor is faulty

3.3.3.1 | Replace lift-leg motor.

3.4 | Blasting does not begin when foot pedal is pressed.

3.4.1 | Door interlocks not engaged

3.4.1.1 | Cabinet door interlocks not engaging. Check adjustment.

3.4.1.2 | With dust-collector motor on and running, check left-hand door interlock switch. Use voltmeter to check that 120 VAC is present across Terminals 8 and 2 with the door closed, and that 120 VAC is not present with the door open. If 120 VAC is not present with the door closed, the switch has an issue. Check wiring and switch.

3.4.1.3 | With dust collector motor on and running and the left-hand door closed, check right-hand door interlock switch. Use voltmeter to check that 120 VAC is present across Terminals 6 and 2 with the door closed, and that 120 VAC is not present with the door open. If 120 VAC is not present with door closed, the switch has an issue. Check wiring and switch.

3.5 | Foot pedal not working

3.5.1 | With dust-collector motor on and running, press foot pedal. Use voltmeter to check that 120 VAC is present across Terminals 5 and 2 with the door closed, and 120 VAC is not present with the foot pedal not pressed. If 120 VAC is not present with the pedal pressed, the pedal has an issue. Check wiring and pedal.

3.6 | Blast solenoid valve not working

3.6.1 | With the dust collector on, both doors closed, and the foot pedal pressed, voltage should be on Terminals 5 and 2 and the blast solenoid valve should actuate ON. Using a metal screwdriver, place the stem on top of the valve where the screw is located that attaches the cable to the valve; a light magnetic feel should result as the screwdriver is slowly pull up and away from the cable screw. If not, the valve may be faulty.

3.6.2 | Press the manual valve button on the valve body to see if it allows air to pass. If air passes, check electrical wiring and check if the valve may be faulty. If no air passes, check air supply and check if the valve may be faulty.

3.7 | Poor visibility/dusty media

3.7.1 | Exhauster motor does not start

3.7.1.1 | Refer to **Section 2.1**.

3.8 | Cabinet LED light does not turn ON

3.8.1 | With dust-collector motor on and running, check voltage between Terminals 11 and 2. If 120 VAC is present, then the blast cabinet light should be on. If not, check wiring and that the fixture is not faulty.

3.9 | Blast machine does not pressurize when foot pedal is pressed – Pressure Systems

3.9.1 | Door interlocks not engaged.

3.9.1.1 | Cabinet door interlocks not engaging. Check adjustment, refer to cabinet manual.

3.9.1.2 | With dust-collector motor on and running, check left hand door interlock switch. Use voltmeter to check that 120 VAC is present across terminal 8 and 2 with the door closed, and that 120 VAC is not present with the door open. If 120 VAC is not present with the door closed, the switch has an issue. Check wiring and switch.

3.9.1.3 | With dust-collector motor on and running and the left hand door closed, check right hand door interlock switch. Use voltmeter to check that 120 VAC is present across terminal 6 and 2 with the door closed, and that 120 VAC is not present with the door open. If 120 VAC is not present with the door closed, the switch has an issue. Check wiring and switch.

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