

Portable Blast Cleaning System

Pinch Bar

GPX16-65P

Model

THE TOTAL SYSTEM SUPPLIER FOR PORTABLE SURFACE PREPARATION

BLASTRAC

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 which occur after this manual is printed. We will send you manual revisions that should be inserted in the manual in accordance with instructions which 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 U. S. Filter/Blastrac.

**BLASTRAC
WARRANTY POLICY**

This document is to be used as a guide in determining warranty policies and procedures for BLASTRAC® products. It is to be used in determining whether a warranty is justified and also as a procedural guide in completing a BLASTRAC 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 one hundred and eighty (180) days from the date of delivery; 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 plates, liners and seals.
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.

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Introduction:

The GPX-16-65 DC Porta Shot-Blast machine is powered by a V-465D Wisconsin gasoline engine. This engine can easily be converted to L.P. gas. The 65HP machine is capable of cutting up to 1/4 inch of concrete in one pass. It is driven by a Peerless hydraulic system controlled by lever arm action.

The GPX-16-65 DC has a 16 inch blast pattern using Nelco's patented blast wheel which eliminates hot spots and grooves. The blast wheel is a paddle wheel design that is pulley

driven by a mechanical clutch. The clutch engages at 1500 RPM and drives the blast wheel 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 after the clutch is engaged 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 2500 square feet per hour while achieving a brush blast.

Specifications:

- Drive Motor.....Hydrostatic Transmission
- Propane System.....Liquid
- Motor RPM.....2600 RPM
- Blasting Width.....16"
- Charging System.....12 volt
- Dust Collector.....2600 cfm pulse pressure
- Transmission.....
- Transaxle.....
- Dimensions.....L: 104" W: 62" H: 66"
- Weight.....3000 lbs.

Safety:

PLEASE READ THESE INSTRUCTIONS CAREFULLY AND COMPLETELY PRIOR TO OPERATING THIS EQUIPMENT.

1. Safety goggles and adequate ear protection must be worn by all personnel in the vicinity of this machine while it is in operation.
2. Never perform maintenance while machine 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 check list. 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!

Operation:

Operator Awareness:

The GPX-16-65 DC machine is designed to blast a concrete surface and reclaim all shot and dust. The Porta-Shot Blast 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 ten feet as the concrete or coated surface may be softer in different areas.

4. The maintenance check list is provided for blasting efficiency. This list should be completed after each day of blasting. You will save time and money by maintaining your 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.

6. The gap between the Blades and the Pinch Bar is very important. If your gap exceeds 3/16 inch, 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. They contain shot that would otherwise be thrown from the machine. If the seals are worn out, you will lose your seal and shot will fly out from the worn areas.

- 8. 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).
- 9. When coming to a stopping point, shut off the shot valve about five 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.)

ALWAYS BLAST IN FORWARD DIRECTION.

- 1. Complete the Operation/Maintenance check list.
- 2. Place the transmission control lever in the neutral (center) position.
- 3. Place the cam motor switch in the ON position.
- 4. Place the fuel select switch in the desired position (Gas/LP) if equipped.
- 5. Turn ignition switch to ON and start machine.
- 6. Pull throttle to the wide open position.
- 7. Push the transmission lever forward for reverse motion and backward for forward motion.

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

Operation Sequence:

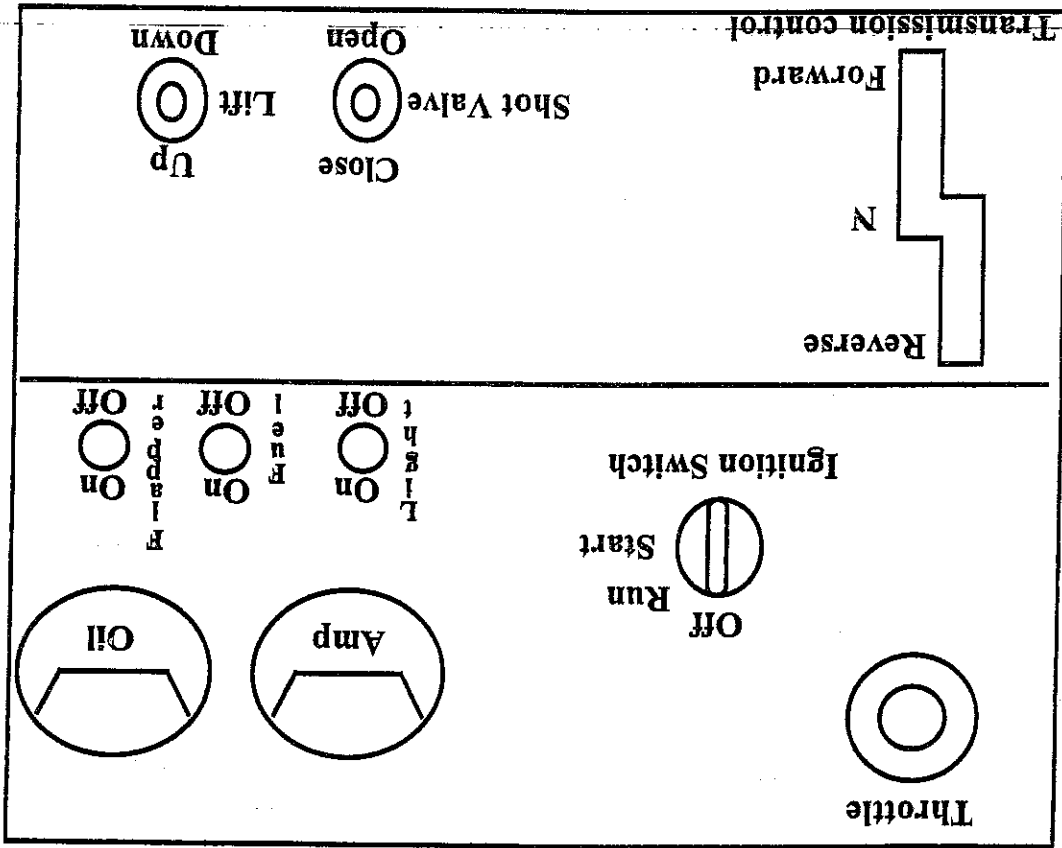


Figure 1: Control Panel

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

- The GPX-16-65 DC 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. **TWO SPEED TRANSMISSION:** This feature is designed to maintain efficiency. If you are operating on a flat surface and need a fast brush blast, put the machine in high gear. When operating on an incline or loading on the trailer, put the machine in low gear for more torque.
 3. **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.
 4. **PINCH BAR:** The pinch bar clearance must be checked before each operation. For best blasting results, adjust the pinch bar 1/8 inch clearance for all applications.

Operation Adjustments:

Maintenance

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 Drum	_____	Check for balance and excessive wear.
_____	Blades	_____	Check for excessive wear.
_____	Top Liner	_____	Check for excessive wear.
_____	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.
_____	Tires	_____	Check foam fill to be sure it hasn't broken down.
_____	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.
_____	Clutch	_____	Check lining.
_____	Steering Assembly	_____	Check chain tension.
_____	Belts	_____	Check quality and tension.
_____	Idle Assembly	_____	Check bearing.
_____	Dust Collector Latches	_____	Make sure latch firmly secures door.
_____	Cam Motor	_____	Make sure motor is on when blasting.

<u>Part Number</u>	<u>Description</u>
WP09-3716	Pinch Bar Lower O/S Back Side Liner.....
WP14-3706	Pinch Bar Inspection Plate.....
WP01-3715	Dovetail Blades (4 per set)
WP12-3715	Blade Keepers.....
0311-0011	Bolts.....

Figure 2: Part Reference

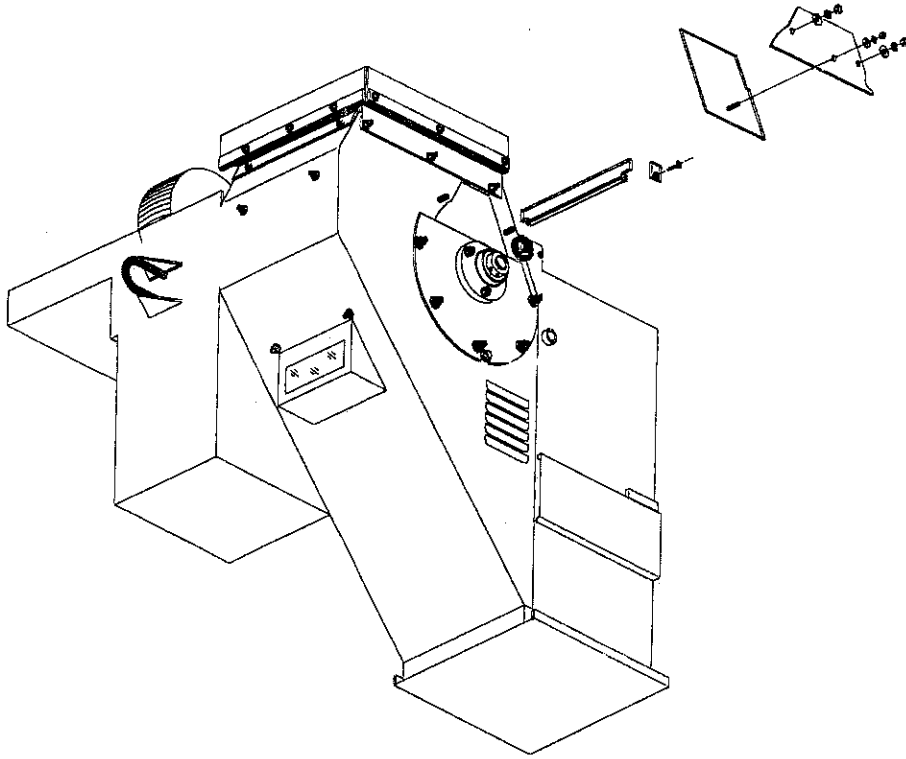


Figure 2: Blade Replacement

Blades:

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

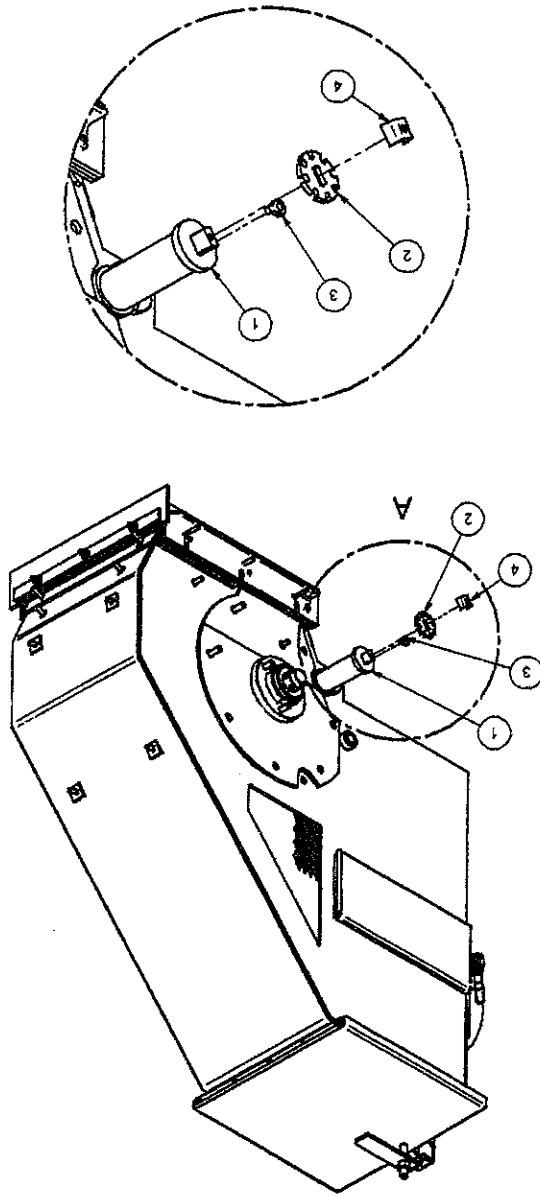
Caution: All electric power must be disconnected and all rotation parts completely stopped before attempting any maintenance procedure. Always observe Zero Motion Status before attempting any adjustments or maintenance.

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 bolts and blade keeper 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 blade keeper and bolt.
8. Inspect gap between blade and Pinch Bar.
9. Install inspection plate.

FIGURE 3

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1	1	WP033711	210-0035	PINCH BAR
2	1	08300042	220-0059	INDEXER/PINCH BAR
3	1	08300044	220-0061	RETAINER/OUTER PINCH BAR
4	1	08300093	220-0110	RETAINER/PINCH BAR INDEXER

DETAIL A



Pinch Bar Removal, Installation, Re-Positioning:
WARNING: ALL POWER MUST BE DISCONNECTED AND ALL ROTATING PARTS COMPLETELY STOPPED BEFORE ATTEMPTING ANY MAINTENANCE PROCEDURE.

Pinch Bar Re-positioning: (See Figure 3 for item descriptions and locations)

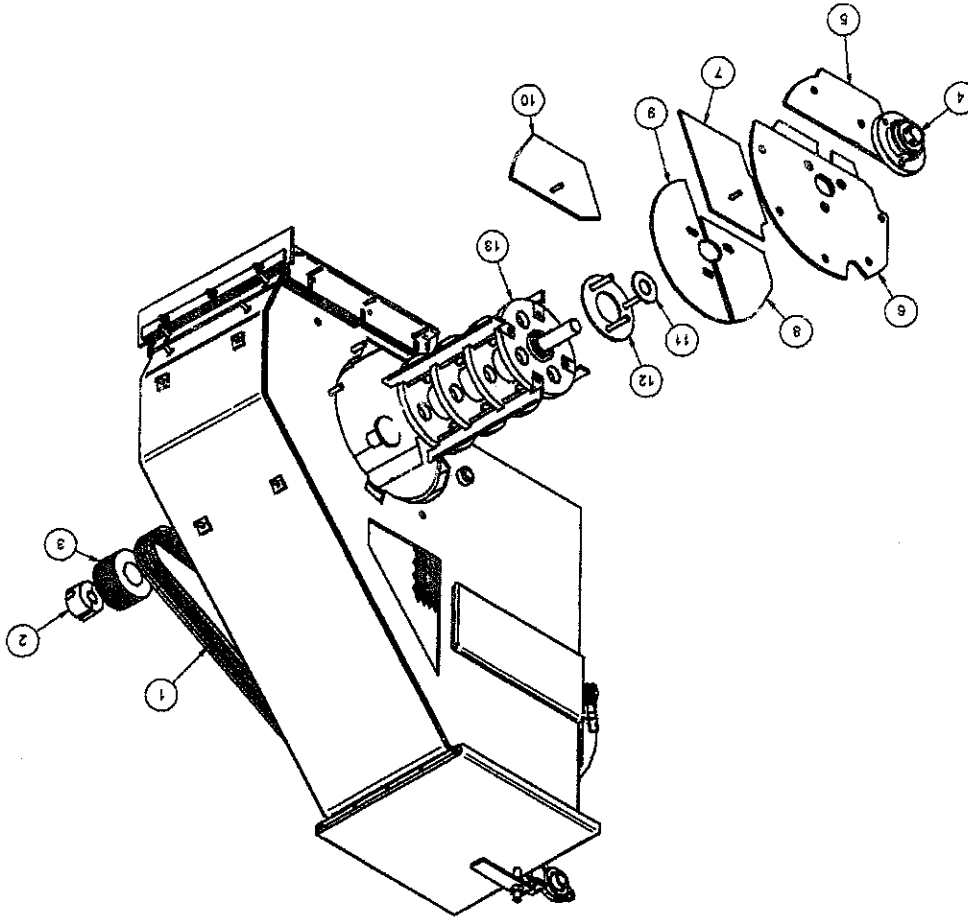
1. Remove Item #3, Retainer/Outer Pinch Bar.
2. Rotate pinch bar, item #1, one notch. If the distance from the pinch bar to the blast wheel blades is greater than 1/8" rotate the pinch bar another notch. Continue until distance is no greater than 1/8".
3. Reinstall Item #3.

Pinch Bar Removal/Installation: (See Figure 3 for item descriptions and locations)

1. Remove Item #3, Retainer/Outer Pinch Bar.
2. Remove Item #4, Retainer/Pinch Bar Indexer.
3. Remove Item #2, Indexer/Pinch Bar.
4. Insert slide hammer into the threaded hole in the end of the pinch bar, Item #1. **Note: Slide hammer is provided with all pinch bar machines.**
5. Withdraw the pinch bar from the blast head.
6. Insert new pinch bar and tap into place with hammer.
7. Reinstall Item #2.
8. Reinstall Item #4.
9. Reinstall Item #3.

Figure 4

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1	8	06100013		V-BELT/3VX-630
2	1	06300055	--	2517 X 1 7/16" T/L BUSHING
3	1	06150042		6GR3V 5.0-2517 T/L SHEAVE
4	1	02110015	--	BEARING/FLG 3 1.4375" B-3-BOLT
5	1	P000831	210-0012	ACCESS-PLATE/BLAST HOUSING
6	1	P000830	210-0011	COVER-PLATE/BLAST HOUSING
7	1	WP093716	210-0027	LINER/SIDE - REAR OUTSIDE LOWER SLL
8	1	WP053708	210-0024	LINER/SIDE - REAR UPPER OUTSIDE SLL
9	1	WP053704	210-0023	LINER/SIDE - FRONT INSIDE/OUTSIDE UPPER SLL
10	1	WP093707	210-0026	LINER/SIDE - FRONT OUTSIDE LOWER SLL
11	1	08300171	210-0017	SEAL/SHAFT - BEARING
12	1	P002623	210-0221	OUTSIDE BOLT RETAINER/3-BOLT FLANGE BEARING
13	1	WP123717	210-0215	BLASTWHEEL/DOVETAIL - 10" DIA



BLAST WHEEL REMOVAL AND INSTALLATION:

See Figure 4 for item locations and descriptions.

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, item #1, off of the blast wheel sheave using a flathead screwdriver.

2. Taper Lock and Sheave Assembly:

- a. Remove the two set screws from the taper lock, item #2.
 - b. Install one set screw in the hole which did not originally have a set screw.
 - c. Tighten the set screw until the taper lock "pops". If the taper lock does not "pop", tap the outside of it lightly with a hammer.
 - d. Slide the taper lock off of the shaft. If the assembly does not slide off of 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:

Remove the two Allen head set screws on each of the two bearing collars.

4. Outside Blast Wheel Bearing:

- a. Remove the three nuts holding the bearing, item #4.
- b. Pry the bearing off of the shaft.

5. Access Plate:

- a. Remove the two nuts which connect the access plate, item #5, to the housing.
- b. Remove the nut in the center of the plate which holds the outside rear/lower side liner in place.
- c. Remove the inspection plate.
- d. Remove the lower liner, item #7.

6. Cover Plate:

- a. Remove the five nuts which connect the cover plate, item #6, to the housing.
- b. Remove the cover plate.

7. Side Liners:

Remove the outside side liners, items #8 and #9. The side liners may be firmly in place and may require the use of a pry bar to be removed.

8. Blast Wheel:

- a. Slide the shaft seal, item #11, and the bolt retainer, item #12, off of the blast wheel shaft.
- b. Remove the blast wheel drum by pulling the drum shaft through the inside bearing.

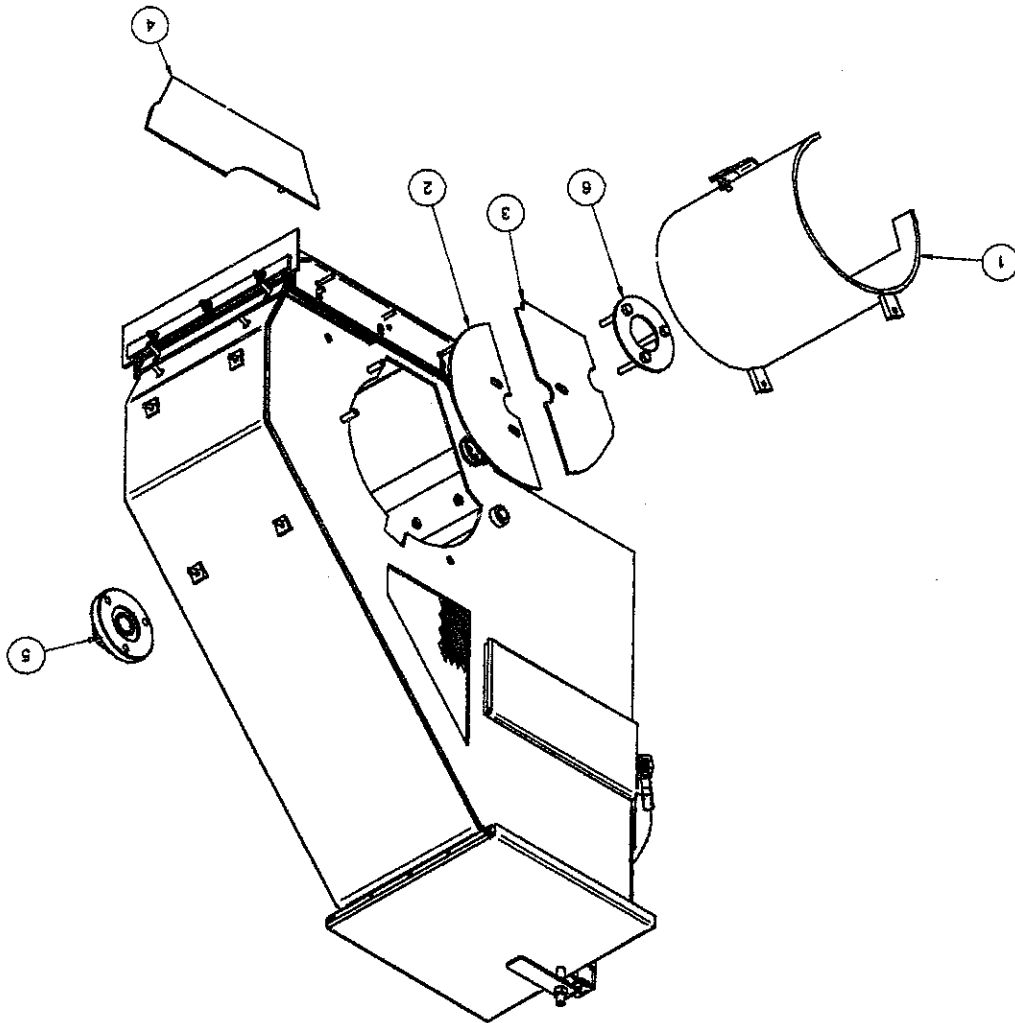
Note: If the drum shaft is resistant to coming through the bearing, you may use a block of wood and a hammer to force it through.

9. Blast Wheel Installation:

Reverse steps 1-8 to install a new blast wheel.

FIGURE #5

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1	1	WP113715	210-0030	LINER/TOP CURVED SLL
2	1	WP053704	210-0023	LINER/SIDE - FRONT INSIDE/OUTSIDE UPPER SLL
3	1	WP053712	210-0038	LINER/SIDE - REAR INSIDE UPPER SLL
4	1	WP093706	210-0025	LINER/SIDE - LOWER INSIDE SLL
5	1	02110015	--	BEARING/FLG3 1.4375" B 3-BOLT
6	1	P002823	210-0221	OUTSIDE BOLT RETAINER/3-BOLT FLANGE BEARING



Top Liner Removal:

See Figure 5 for item locations and descriptions.

Note: Before attempting to remove the Top Liner, steps 1-8 of Blast Wheel Removal must first be completed. In the event that the Top Liner has expanded too much to slide out, the best way to remove it is to cut it in half with a torch.

1. Remove the two bolts located at the top of the Top Liner, item #1. These bolts are accessible from the outside of the housing.

2. Remove the one nut located toward the front of the Top Liner. This nut is accessible from the inside of the blast housing.

3. Slide out top liner, or cut if necessary.

Inside Liner Removal:

See Figure 5 for item locations and descriptions.

Note: Before attempting to remove the Top Liner, steps 1-8 of Blast Wheel Removal must first be completed.

1. Remove nuts from bearing, item #5, and remove bearing.

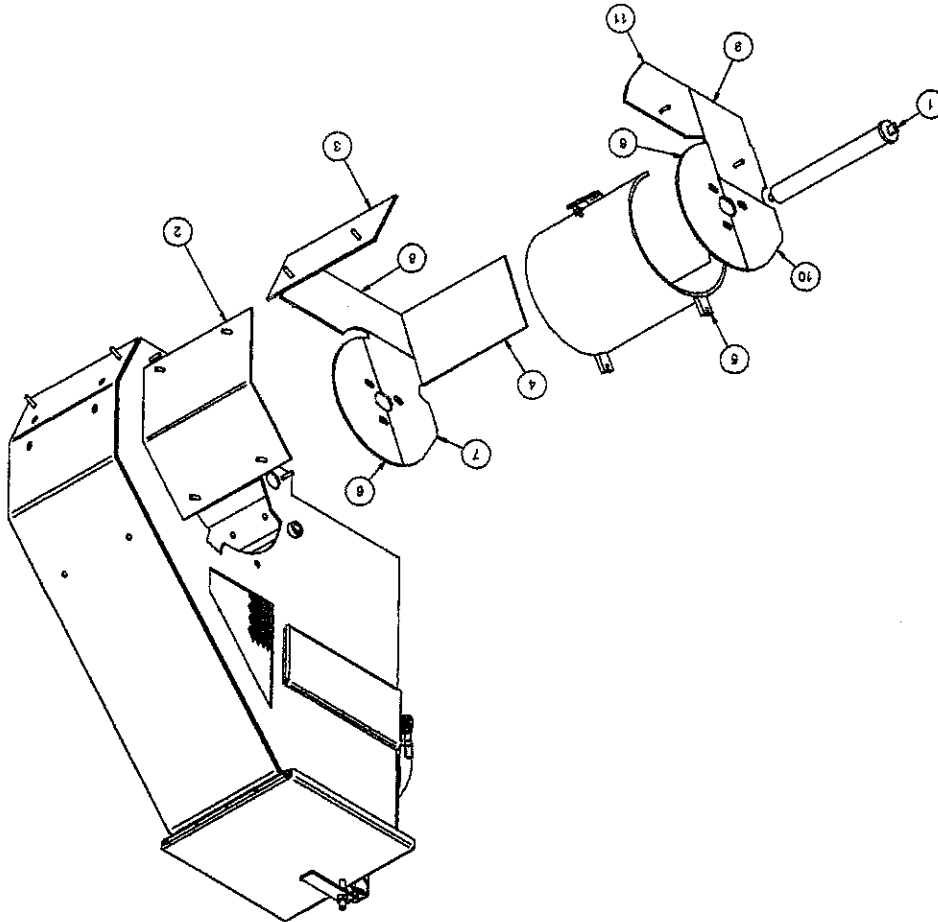
2. Remove the bolt retainer, item #6.

3. Remove the inside side liners, items #2 and #3.

4. Remove two nuts securing lower inside liner, item #4, and the liner can be removed.

Figure 6 - Liner Stack-Up

ITEM	QUANTITY	CATALOG NUMBER	DRAWING NUMBER	DESCRIPTION
1	1	WP033711	210-0035	PINCH BAR
2	1	WP043709	210-0021	LINER/UPPER FRONT SLL
3	1	WP043715	210-0022	LINER/FRONT LOWER SLL
4	1	WP103712	210-0029	LINER/BACK WALL SLL
5	1	WP113715	210-0030	LINER/TOP CURVED SLL
6	2	WP053704	210-0023	LINER/SIDE - FRONT INSIDE/OUTSIDE UPPER SLL
7	1	WP053712	210-0038	LINER/SIDE - REAR INSIDE UPPER SLL
8	1	WP083706	210-0025	LINER/SIDE - LOWER INSIDE SLL
9	1	WP083716	210-0027	LINER/SIDE - REAR OUTSIDE LOWER SLL
10	1	WP053708	210-0024	LINER/SIDE - REAR UPPER OUTSIDE SLL
11	1	WP093707	210-0026	LINER/SIDE - FRONT OUTSIDE LOWER SLL



Dust Collector Function:

This unit is equipped with an auto pulse dust collector that provides suction to separate the dust from the shot. Refer to Figure 7 for the location or items discussed in this section.

The central part of the dust collector is the filter chamber. Refer to Figure 8 for path of dust and air. Dust laden air enters the chamber from the blast head through the exhaust hose and into the dust collector inlet connection located on the left, front side of the dust collector. The dirty air passes through a plenum and flows through an array of nine vertically mounted, specially designed filter cartridges. Dust is captured on the surface of these filters allowing clean air to pass to the clean air portion of the dust collector where it exhausts to the open atmosphere through the silencer box.

The dust that was trapped on the external surface of the filters is periodically removed by pulsing the filters with a burst of compressed air released from the header tank by a diaphragm valve. The air is delivered via one of three blow-down tubes. This momentary pulse of air allows the dust to fall into the dust bins at the bottom of the filter chamber. Three filters are pulsed at a time, in sequence, determined by a timer board located in the control box located on the front of the dust collector, just above the inlet. This timer board is usually set to pulse a three filter bank every ten seconds. The timer board determines the time between pulses and the length of each pulse. Venturi valves are located above each filter for maximum filter cleaning efficiency.

FIGURE 7

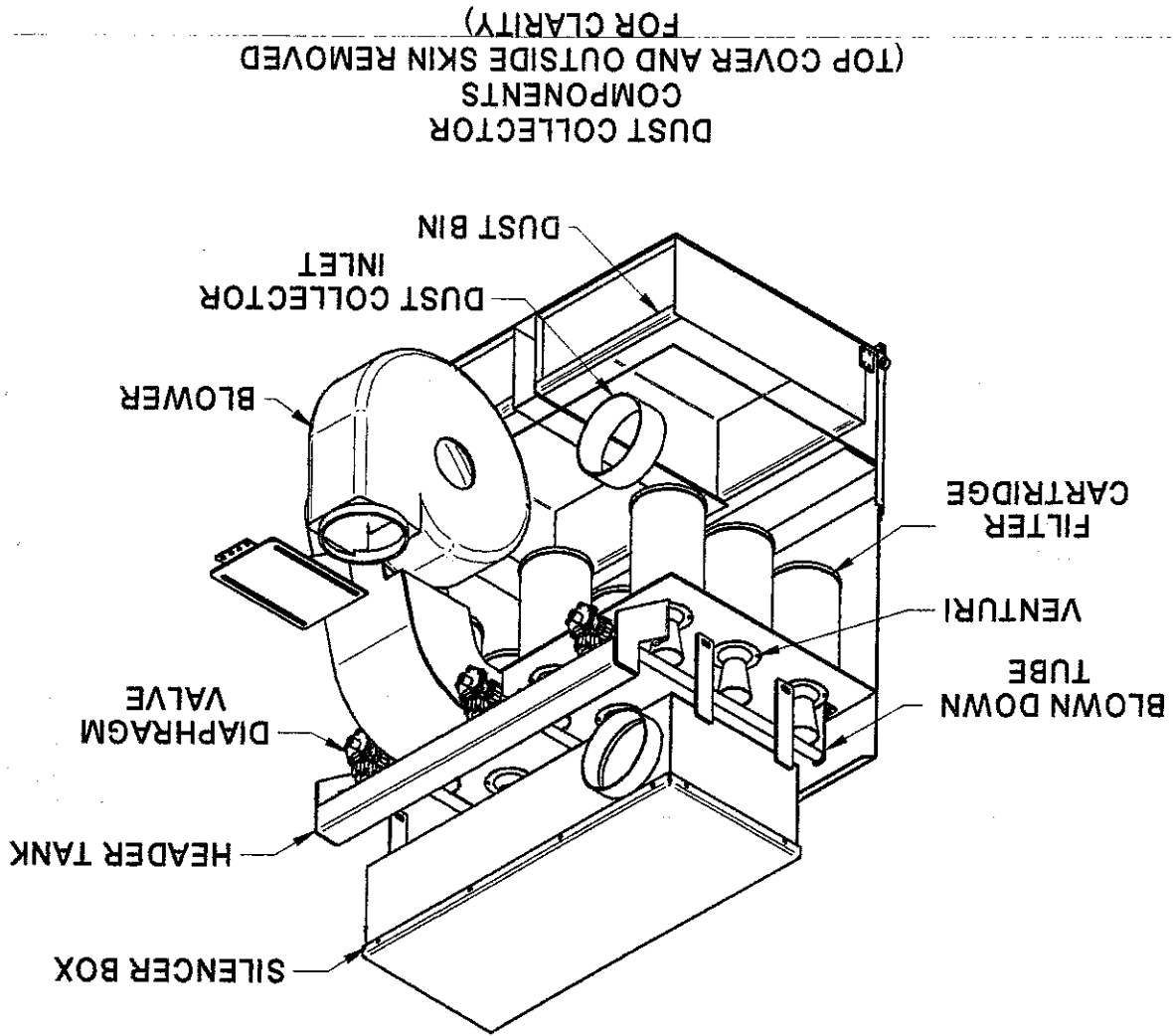
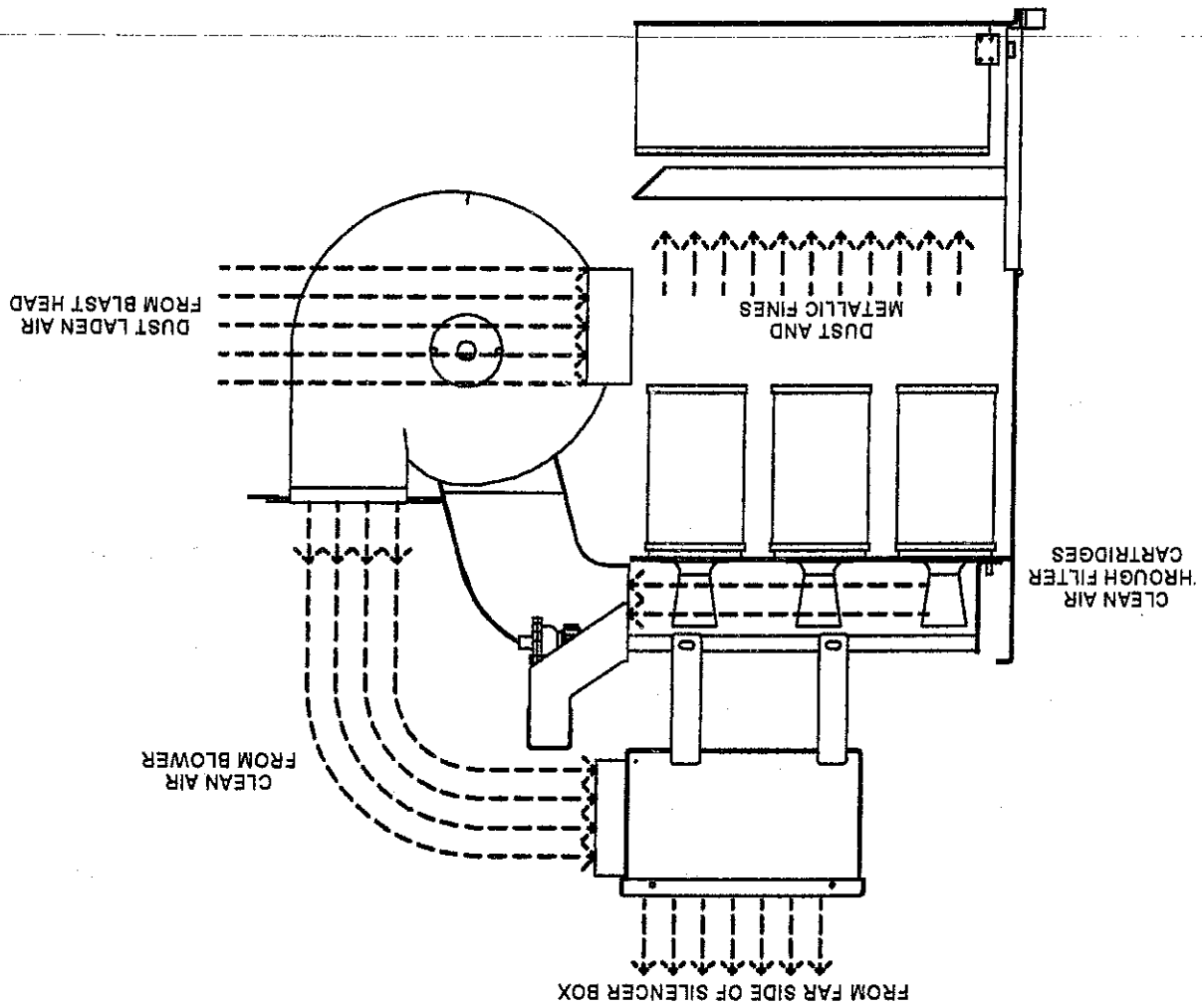


FIGURE 8



Dust Collector Maintenance:

The dust collector should be monitored on a regular basis. Bad or improper ventilation can lead to poor component life and premature wear on a number of ventilation related items on the equipment. Some of the more important areas to monitor, relative to the ventilation system, are:

- Filter cartridges should be kept in good condition.
- The hose connections to the blast head and the dust collector should be tight and held in place with metal clamps.
- The hose should be kept in good repair. Flattened spots, holes and wear spots should be corrected immediately. Replace hose if necessary.
- Leaks on the blower housing assembly seal and especially the dust collector access door seal should be minimized. The dust collector access door seal can be checked by feeling for air leaks around the seal and evidence of dust leaks.

Poor dust collector performance can have an adverse effect on the overall abrasive cleaning which in turn increases blast wheel and liner wear. An important fact that is often ignored or misunderstood is:

The steel abrasive causes minimum wear on the internal blast components. The dust and contaminants are the principal cause of component wear. A well-maintained dust collector can minimize abrasive contamination which helps reduce operating costs and increases the overall efficiency of the shot blasting system.

Filter Cartridge Removal:

WARNING: Prior to attempting to change or inspect the filter cartridges place GPX-16-65P on level surface to prevent movement. Verify that the ignition is in the off position and the key is removed.

Access to the filter cartridges is gained through the same door from which the dust is removed. To remove filter cartridges:

1. Remove the dust bins from the dust collector;
2. Remove wing nut from the bottom of the filter cartridge;
3. Slide filter cartridge down hanger rod;

To replace filter cartridges reverse steps 1-3 above.

Take care not to damage the filter cartridges during removal, installation or inspection.

Parts List for GPX-16-65 DC

Housing:	
Part Number	Description
WKIT-16650	Dovetail Blade Kit
WP02-3712	Front Seal
WP02-3710	Side Seal
WP15-3702	Inside Seal Bracket
WP15-3704	Front Seal Bracket
WP15-3707	Outside Seal Bracket
WP15-3706	Rear Seal Bracket
WP16-3712	Drag Brush
WP03-3711	Pinch Bar
WP10-3711	Pinch Bar Liner
WP10-3712	Pinch Bar Back Wall Liner
WP04-3715	Pinch Bar Front Lower Liner
WP04-3709	Front Upper Liner
WP05-3704	Upper Front Side Liner
WP05-3708	Dovetail Upper O/S Back Side Liner
WP05-3712	P/B I/S Rear Side Liner
WP09-3706	I/S Lower Side Liner
WP09-3707	O/S Front Lower Side Liner
WP09-3716	P/B Lower O/S Back Side Liner
WP11-3715	Pinch Bar Top Liner
WP12-3717	Dovetail Blast Wheel
WP13-3709	Pinch Bar Cover Plate
WP14-3706	Pinch Bar Inspection Plate
WP08-3708	Shot Screen
WP18-3708	3" Magnetic Shot Valve Plate
WP18-3713	Shot Valve Seal
WP20-3709	Shot Valve Shaft
WP24-3711	Dovetail Blast Wheel Shaft
0211-0015	1 7/16" 3 Bolt Flange Bearing
Dust Collector:	
Part Number	Description
WP21-3703	Flapper Set (6 per machine)
WP22-3701	Cam discs (6 per machine)
WP23-3706	Blower Shaft
0910-0003	14" Blower Housing
0920-0003	14" Blower Fan
0910-0004	15" Blower Housing
0920-0004	15" Blower Fan
0942-0002	Dust Collector Filter 831
0211-0003	1 1/8" 2 Bolt Flange

Item No.

Item No.

Parts List for GPX-16-65 DC

Dust Collector, Continued

<u>Part Number</u>	<u>Description</u>	<u>Item No.</u>
0211-0001	1/2" 2 Bolt Flange	10
0591-0001	Cam Motor 12V	11
0651-0002	Cam Shaft Sprocket 35A60	12
0651-0007	Cam Motor Sprocket 35BS12	13
0650-0001	#35 Chain (per foot)	14

Electric Control & Component:

<u>Part Number</u>	<u>Description</u>	<u>Item No.</u>
0510-0002	on/off Toggle Switch (Flapper, light & fuel)	1
0714-0006	Ignition Switch	2
0730-0001	Throttle Cable	3
0691-0002	Transmission Lever	4
0730-0011	Transmission Cable	5
0800-0001	Seat	6
0800-0002	Steering Wheel	7
0753-0022	Battery	8

Chassis:

<u>Part Number</u>	<u>Description</u>	<u>Item No.</u>
0660-0003	Transaxle Assy	1
0680-0002	Transmission Pump 1100	2
0661-0001	1 1/4" Axle Shaft	3
0222-0005	1 1/4" Axle Shaft Seal	4
0216-0002	1 1/4" R-20 Bearing	5
0640-0005	Rear Wheel	6
0640-0001	Front Wheel	7
0214-0003	Bearing	8
0215-0001	Bearing	9
0222-0001	Seal	10
0217-0001	Thrush Bearing 2 1/4"	11
0210-0004	Pillow Block Bearing for Steering Shaft	12
1665-0011	2 Bolt Flange Bearing For Counter Shaft	13
0651-0005	Front Wheel Fork Assy.	14
0651-0003	Steering Counter Shaft Sprocket 40A54	15
1665-0002	Steering Shaft Sprocket 40A14	16
1665-0002	16-65 Motor Assy	17
0681-0001	Gear Box 1 to 1 Ratio	18

Parts List for GPX-16-65 DC

<u>Item No.</u>	<u>Description</u>	<u>Part Number</u>
1	Double Control Valve SD 5/2	0471-0001
2	Shot Valve Cylinder D4	0461-0002
3	Front Lift Cylinder	0461-0007
4	Hydraulic Pump VTM	0481-0005

<u>Item No.</u>	<u>Description</u>	<u>Part Number</u>
1	Clutch 11.8	0616-0002
2	D-2400 3/4" Sheave	0615-0014
3	D-2400 1" Sheave	0615-0013
4	3gr 3v-5.0-1610 Sheave (Motor to Gear Box)	0615-0032
5	2gr 3v-5.0-1610 Sheave (Gear Box to Motor)	0615-0020
6	2gr 3v-6.0-1610 Sheave (Blwr/St to Hyd. Pmp)	0615-0022
7	6gr 3v-5.0-2517 Sheave (Blast Wheel)	0615-0042
8	2gr 3v 5.0-sh Idler Pulley (mtr to blower)	0614-0003
9	2gr 3v 4.12-sh Idler Pulley (mtr to gear bx.)	0614-0004
10	SHBB Idler Assembly	0218-0005
11	1gr 3v-5.0-1610 Sheave (Hydraulic Pump)	0615-0003
12	3v-630V-Belt (mtr to blast wheel) 6 per mach.	0610-0013
13	3v-900V-Belt (mtr to blower) 2 per mach.	0610-0019
14	3v-355V-Belt (blower to hyd. pump) 1 per mach.	0610-0004
15	3v-500V-Belt (mtr to gear box) 2 per mach.	0610-0009
16	A-19 (gear box to transmission) 2 per mach.	0612-0001

Belts & Pulleys:

Hydraulic Control:

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MAINTENANCE LOG

RIDERS-

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 1/4 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"/>

U. S. FILTER

BLASTRAC

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 PCBs, 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.

**LIMITED WARRANTY
FOR
NEW PEERLESS GEAR POWER TRAIN COMPONENTS**

A. Products Warranted
Peerless Gear and Machine Division of Tecumseh Products Company ("Tecumseh"), subject to the limitations contained below, will, at its option, repair or replace, without charge for parts or labor only, any part of a new Power Train Component (which as used herein means and includes the transaxle, gear box, transmission, differential and right angle drives, and any part of the Power Train Component), EXCEPT any new Power Train Component incorporated in equipment used for commercial or rental purposes, which is found upon examination by any Tecumseh Authorized Service Outlet or by Tecumseh's factory in Graton, Wisconsin, to be DEFECTIVE IN MATERIAL AND/OR WORKMANSHIP if received by Tecumseh or a Tecumseh Authorized Service Outlet for such examination within TWO YEARS from the date of sale to the original consumer purchaser for Peerless Series 820, 900, 910, 915/940, 930, 1100, 2600 transaxles and VST205 Hydro or within ONE YEAR from the date of sale to the original consumer purchaser for all other Peerless products not incorporated in equipment used for commercial or rental purposes. New Power Train Components incorporated in equipment used for commercial purposes are warranted in the same manner and to the same extent EXCEPT such Power Train Components are warranted for NINETY (90) DAYS ONLY, and must be received by Tecumseh or by a Tecumseh Authorized Service Outlet for such examination within 90 days from the date of sale to the original purchaser. New Power Train Components incorporated in equipment used for rental purposes are warranted for THIRTY (30) DAYS ONLY, and must be received by Tecumseh or by a Tecumseh Authorized Service Outlet within 30 days from the date of sale to the original purchaser.

B. Products And Items Not Warranted

1. Alterations or Modifications of Power Train Components.
2. Accidents, Normal Maintenance, Failure to follow the Original Equipment Manufacturer's Manual.
This warranty covers only parts of new Power Train Components which are found upon examination to be defective in material or workmanship as delivered to the original purchaser. This warranty does not cover defects caused by depreciation or damage caused in an instruction Manual for the operation of the Power Train Component and parts. The cost of normal maintenance and replacement of service items which are not defective shall be paid for by the original purchaser.

C. Securing Warranty Service

Warranty service can be arranged for by contacting either a Tecumseh Authorized Service Outlet (any Tecumseh Registered Service Dealer, Tecumseh Authorized Service Distributor, or Tecumseh Central Warehouse Distributor) or by contacting Tecumseh, c/o Service Manager, Engine and Transmission Group Service Division, 900 North Street, Graton, Wisconsin 53024. Warranty service can only be performed by a Tecumseh Authorized Service Outlet or by Tecumseh at its factory in Graton, Wisconsin. At the time of requesting warranty service, evidence must be presented of the date of sale to the original purchaser. The purchaser shall pay any charges for making service calls and/or for transporting the product to and from the place where the inspection and/or warranty work is performed. The purchaser shall be responsible for any damage or loss incurred in connection with the transportation of Power Train Components and/or parts of the Power Train Components submitted for inspection and/or warranty work.

D. Limitation of Damages and Implied Warranties

The foregoing EXPRESSED WARRANTY IS IN LIEU OF ALL OTHER EXPRESS WARRANTIES. Neither Tecumseh nor any of its affiliates makes any warranties, representations or promises, written or oral, as to the quality of the Power Train Component or any of its parts, other than as set forth herein. ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, TO THE EXTENT THAT EITHER MAY APPLY TO ANY PART(S) OF POWER TRAIN COMPONENTS, SHALL BE LIMITED IN DURATION TO THE PERIODS OF THE EXPRESSED WARRANTIES DEFINED IN PARAGRAPH A HEREOF. IN NO EVENT WILL TECUMSEH BE LIABLE FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES AND/OR EXPENSES. Some states do not allow limitations on how long an implied warranty lasts or the exclusion or limitation of incidental or consequential damages, so the above limitation(s) or exclusions(s) may not apply to you. This warranty gives you specific legal rights and you may also have other legal rights which vary from state to state.

E. No Dealer Warranty

Tecumseh neither assumes nor authorizes any other person, natural or corporate, to assume for Tecumseh any other obligations or liabilities in connection with or with respect to any part(s) of a Power Train Component. The seller or dealer of a Power Train Component has no authority, whatsoever, to make any representations or promises on behalf of Tecumseh or to modify the terms or limitations of Tecumseh's warranty in any way.



**TECUMSEH PRODUCTS COMPANY
PEERLESS GEAR DIVISION, Salem, Indiana**



Tecumseh Products Company
Engine and Transmission Group
Service Division
Graton, WI 53024
Telephone: 414/277-2700

For Service or Service Parts, contact any of our Tecumseh Authorized Service Dealers. You will find our dealers listed in the Yellow Pages of your telephone book under "Engines, Gasoline". If you have any difficulty at all, contact us.